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REVISION INFORMATION SHEET

ONTARIO PROVINCIAL STANDARDS FOR ROADS AND PUBLIC WORKS

VOLUME 6 PROVINCIAL-ORIENTED MATERIAL SPECIFICATIONS

MANUAL REVISION #8

NOVEMBER 2016

UPDATING ONTARIO PROVINCIAL STANDARDS FOR YOUR USE

Each roads and public works owner (Owner) is responsible for determining implementation dates and directions for use of Ontario Provincial Standards; therefore, manual holders are cautioned about immediately discarding superseded and cancelled standards.

A NOTE TO DESIGNERS OF MUNICIPAL CONTRACTS REGARDING APPENDICES

There are a number of OPS specifications published with appendices containing supplemental requirements that modify the specification. These specifications contain information written for use in provincial contracts. The appendices contain supplemental requirements that modify the provincial requirements so the specifications can be used in municipal contracts. The specifications are easily identified, as the table of contents for each specification lists the appendix containing the supplemental requirements (e.g., Supplemental Requirements for Using OPSS XXX in Municipal Contracts).

Designers of municipal contracts should review each specification to determine if the supplemental requirements should be invoked in their contracts. To ensure completeness of municipal Contract Documents, designers should invoke the appendices by referencing them in the Contract Documents.

ACCESSING AND OBTAINING ONTARIO PROVINCIAL STANDARDS

The Ontario Provincial Standards for Roads and Public Works (OPS) manuals and the latest published updates for each of the eight OPS manuals are available as follows:

- Available electronically on the OPS/MTO website. Online access to the current, updated, and archived standards; indexes; OPS User Notes; and publication Revision Information Sheets are available free of charge at the site.
(<http://www.raqs.mto.gov.on.ca/techpubs/ops.nsf/OPSHomepage>)
- Hard-copy format available from Publications Ontario by telephone at 1-800-668-9938 or online. Updates and OPS manuals are available for a cost-recovery fee.
(www.publications.serviceontario.ca)

- The eight OPS manuals of standards are available on one CD in PDF format. The OPS drawings published in Volumes 3 and 4 are available in AutoCAD format on a separate CD. These CDs are available from Publications Ontario or by telephone at 1-800-668-9938 or online for a cost-recovery fee. The updates are not available on CDs as an update package.
(www.publications.serviceontario.ca)

At the Publications Ontario web page, you can type "Ontario Provincial Standards," "OPS," "OPSS," or "OPSD" in the search box, and all related products for the Ontario Provincial Standards will be listed, click on the item you wish to purchase, add the item to your cart, then follow the instructions to complete your order. If trying to order an OPS product online from Publications Ontario and it is shown as Out of Stock, you can backorder the product by telephone at 1-800-668-9938.

In order to receive the Municipal Engineers Association (MEA) purchase price, MEA members should visit the MEA website (www.municipalengineers.on.ca/) for the MEA Publications Ontario order form for hard-copy manuals and CDs.

MTO employees should contact Simon Leung, Account Representative at Publications Ontario, by email (simon.leung@ontario.ca) to set up an account in order to receive the MTO purchase price for technical publications, including the Ontario Provincial Standards.

Links to Publications Ontario and the Ontario Provincial Standards on the MTO Library website are available on the OPS website (www.ops.on.ca). Also on this site under News and Activities are notices for updates and changes in OPS.

Questions should be directed by email to Ontario.Prov.Standards@ontario.ca.

YOU SHOULD REGISTER YOUR OPS MANUALS AND CDs

Users of OPS do not receive notices of OPS updates as they had in the past. Methods of notification from Publications Ontario for the future are being investigated, and you will be informed of them as they become available. In the interim, an email will be sent to OPS users who have registered their OPS manuals and CDs with OPS.

Owners of OPS manuals, who have not yet done so, are requested to register their OPS hard-copy manuals and CDs with OPS by email at Ontario.Prov.Standards@ontario.ca. The registration form and submission instructions are available on the OPS website (www.ops.on.ca), Miscellaneous Info, OPS Forms.

WAITING TO HEAR FROM YOU

If you have a suggestion to revise a standard or you have a standard that works in your ministry, municipality, or area, send it to the Head, OPS Administration, for review and possible inclusion into the Ontario Provincial Standards.

THIS MANUAL IS REVISED AS FOLLOWS:

Index Pages Volume 6

Remove the entire index and replace with the attached revised index.

Standard Specifications Volume 6

Superseded/Cancelled (Remove)		Revised/New (Insert)		Remarks
OPSS.PROV	Dated	OPSS.PROV	Dated	
		1102	Nov 2016	“MATERIAL SPECIFICATION FOR LIQUID ASPHALT USED IN SPRAYING, SEALING AND PRIMING APPLICATIONS” The PROV implemented in November 2016 replaces OPSS 1102 COMMON, November 2007 with no content changes.
		1103	Nov 2016	“MATERIAL SPECIFICATION FOR EMULSIFIED ASPHALT” See Summary of Revisions.
1151	April 2007	1151	Nov 2016	“MATERIAL SPECIFICATION FOR SUPERPAVE AND STONE MASTIC ASPHALT MIXTURES” See Summary of Revisions.
		1152	Nov 2016	“MATERIAL SPECIFICATION FOR SC-800 PATCHING MATERIAL” Section 1152.06, Equipment, deleted.
		1153	Nov 2016	“MATERIAL SPECIFICATION FOR EMULSIFIED ASPHALT PATCHING MATERIAL” See Summary of Revisions.
		1202	Nov 2016	“MATERIAL SPECIFICATION FOR BEARINGS - ELASTOMERIC PLAIN AND STEEL LAMINATED” See Summary of Revisions.
		1203	Nov 2016	“MATERIAL SPECIFICATION FOR BEARINGS - ROTATIONAL AND SLIDING SURFACE” See Summary of Revisions.

Superseded/Cancelled (Remove)		Revised/New (Insert)		Remarks
OPSS.PROV	Dated	OPSS.PROV	Dated	
1210	Nov 2014	1210	Nov 2016	“MATERIAL SPECIFICATION FOR DECK JOINT ASSEMBLIES” See Summary of Revisions.
1350	Nov 2014	1350	Nov 2016	“MATERIAL SPECIFICATION FOR CONCRETE - MATERIALS AND PRODUCTION ” See Summary of Revisions.
		1504	Nov 2016	“MATERIAL SPECIFICATION FOR STEEL BEAM GUIDE RAIL” The PROV implemented in November 2016 replaces OPSS 1504 COMMON, November 2010 with no content changes.
		1505	Nov 2016	“MATERIAL SPECIFICATION FOR CHANNEL COMPONENTS FOR STEEL BEAM GUIDE RAIL” The PROV implemented in November 2016 replaces OPSS 1505 COMMON, November 2010 with no content changes.
		2422	Nov 2016	“MATERIAL SPECIFICATION FOR HEAVY CLASS STEEL AND SECTIONAL STEEL POLES, BASE MOUNTED” See Summary of Revisions.
		2434	Nov 2016	“MATERIAL SPECIFICATION FOR HIGH PRESSURE SODIUM LUMINAIRES FOR UNDERPASS LIGHTING” See Summary of Revisions.
		2453	Nov 2016	“MATERIAL SPECIFICATION FOR SECTIONAL STEEL POLES” See Summary of Revisions.

Superseded/Cancelled (Remove)		Revised/New (Insert)		Remarks
OPSS.PROV	Dated	OPSS.PROV	Dated	
		2471	Nov 2016	“MATERIAL SPECIFICATION FOR SECTIONAL STEEL HIGH MAST LIGHTING POLES” See Summary of Revisions.
		2474	Nov 2016	“MATERIAL SPECIFICATION FOR ANCHORAGE ASSEMBLY – HIGH MAST LIGHTING POLE” See Summary of Revisions.

SUMMARY OF REVISIONS TO OPSS.PROV 1103

MATERIAL SPECIFICATION FOR EMULSIFIED ASPHALT

- Section 1103.02, References, updated
- Tables 1, 2, 3, 4, 8 revised
- Table 10 added.

SUMMARY OF REVISIONS TO OPSS.PROV 1151

MATERIAL SPECIFICATION FOR SUPERPAVE AND STONE MASTIC ASPHALT MIXTURES

- OPSS.PROV 1151 has been revised extensively. It is recommended that users read the entire specification, as there are major differences between this version of the specification and the previous version.

SUMMARY OF REVISIONS TO OPSS.PROV 1153

MATERIAL SPECIFICATION FOR EMULSIFIED ASPHALT PATCHING MATERIAL

- Section 1153.02, References, revised
- Section 1153.06, Equipment, deleted.

SUMMARY OF REVISIONS TO OPSS.PROV 1202

MATERIAL SPECIFICATION FOR BEARINGS - ELASTOMERIC PLAIN AND STEEL LAMINATED

- Section 1202.02, References, CSA Standards updated.
ASTM International standards updated.
AASHTO standards updated.
- Section 1202.04, Design and Submission Requirements, rewritten.
- Section 1202.05, Materials, rewritten.
- Subsection 1202.07.03, Identification, rewritten.
- Subsection 1202.07.04, Quality Control, cancelled
- Subsection 1202.07.05, Tolerances renumbered 1202.07.04 and rewritten.
- Section 1202.08, Quality Assurance, rewritten.
- Section 1202.09, Owner Purchase of Material, deleted.
- Table 1, Physical Requirements for Polyisoprene and Polychloroprene, Test for Ozone Property rewritten, Notes 2 & 3 added.

SUMMARY OF REVISIONS TO OPSS.PROV 1203

MATERIAL SPECIFICATION FOR BEARINGS-ROTATIONAL AND SLIDING SURFACE

- Section 1203.02, References,
CSA Standards updated.
ASTM International standards updated.
ANSI standard updated.
- Section 1203.04, Design and Submission Requirements, rewritten.
- Subsection 1203.05.01, Steel, rewritten.
- Subsection 1203.05.04, Elastomers, rewritten
- Section 1203.09, Owner Purchase of Material, deleted.

SUMMARY OF REVISIONS TO OPSS.PROV 1210

MATERIAL SPECIFICATION FOR DECK JOINT ASSEMBLIES

- Section 1210.02, References,
CSA Standards updated.
ASTM International standards updated.
Others deleted.
- Section 1210.04, Design and Submission Requirements, rewritten.
- Subsection 1210.05.06, Anti-Seize Compound, rewritten.
- Subsection 1210.07.05, Corrosion Protection, rewritten.
- Subsection 1210.07.07, Marking, retitled Identification and rewritten.
- Table 1, Preformed Seal Physical Requirements, rewritten.

SUMMARY OF REVISIONS TO OPSS.PROV 1350

MATERIAL SPECIFICATION FOR CONCRETE - MATERIALS AND PRODUCTION

- Clause 1350.04.01.01.01, Use of Admixtures, has been rewritten
- Clause 1350.04.02.01.04, Submission of Form B, submission requirements updated.
- Subsection 1350.05.05, Concrete, conditions for use of Self-Consolidating Concrete (SCC) updated.
- Clause 1350.07.04.02, Discharge Time, last sentence has been rewritten.
- Clause 1350.07.05.02, Sampling of Water, Admixtures, and Cementing Materials, address updated.
- Clause 1350.07.05.05, Acceptance and Field Adjustments of Plastic Concrete, has been rewritten.
- Clause 1350.07.05.10, Air Void System Parameters, third paragraph has been rewritten.
- Subsection 1350.07.06, Filling of Core Holes, source of material corrected.
- Subsection 1350.08.04, Acceptance of Admixtures, Water and Cementing Materials, has been rewritten.
- Table 3, Cores for Air Void System Determination, Concrete pavement category added.
- Table 9, Admixture Test Result Tolerances for Acceptance Purposes, added.

SUMMARY OF REVISIONS TO OPSS.PROV 2422

HEAVY CLASS STEEL AND SECTIONAL STEEL POLES, BASE MOUNTED

- Section 2422.02 References, CSA G40.20/G40.21, CSA S6, CSA W59, and AASHTO LTS updated.
- Subsection 2422.04.01 Design Requirements, fatigue requirements revised.
- Clause 2422.04.01.01, wind loading requirements revised.
- Clause 244.04.01.02, Ice Loading, added.
- Clause 2422.04.02.01, last paragraph, calculations added.
- Owner/Owner's representative changed to Contract Administrator throughout.
- Appendix 2422, information deleted.

SUMMARY OF REVISIONS TO OPSS.PROV 2434

HIGH PRESSURE SODIUM LUMINAIRES FOR UNDERPASS LIGHTING

- Section 2434.02 References; CSA C22.2 No. 89 updated; and CSA C863, ANSI C136.31, ASTM B 117, ASTM D 1654, IEC 60598, and IEC 62262 added.
- New section 2434.04 Design and Submission Requirements, added
- Section 2434.05, Materials, revised.
- New section 2434.07 Production, added.
- Subsection 2434.08.01 Inspection, revised.
- Existing subsection 2434.09.01 Technical Information to be provided in Quotations, deleted.
- Existing subsection 2434.09.02 Packaging and Shipment, renumbered to 2434.09.01 and revised.
- Existing subsection 2434.09.03 Measurement and Payment, renumbered to 2434.09.02 and revised.
- Existing Table 1, deleted.
- Appendix 2434, information deleted.

SUMMARY OF REVISIONS TO OPSS.PROV 2453

SECTIONAL STEEL POLES

- Section 2453.02 References, CSA G40.21, CSA S6, CSA W59, and ASTM A 123 updated.
- Clause 2453.04.01.01, wind loading requirements revised.
- Clause 2453.04.01.02, ice loading requirements revised.
- Owner/Owner's representative changed to Contract Administrator throughout.
- Appendix 2453, information deleted.

SUMMARY OF REVISIONS TO OPSS.PROV 2471

SECTIONAL STEEL HIGH MAST LIGHTING POLES

- Section 2471.02 References, CSA G40.20/G40.21, CSA S6, CSA W47.1, CSA W59, CSA W178.1, CSA W178.2, ASTM A 500, CGSB 48.9712, AASHTO LTS, ISO/IEC 17025, and Federal Standards 595 updated.
- Definitions for CWB, Engineer, NACE CIP and SSPC deleted.
- Subsection 2471.07.05 Identification Nameplates, a) to g) deleted.
- Subsection 2471.07.06, Quality Control, revised and reorganized.
- Appendix 2471, information deleted.

SUMMARY OF REVISIONS TO OPSS.PROV 2474

ANCHORAGE ASSEMBLY – HIGH MAST LIGHTING POLE

- Section 2474.02 References; CSA G40.20/G40.21, CSA G164, CSA W59, CSA W178.2, CGSB 48.9712, ASTM A 153, ASTM A 449, and ASTM A 563 updated.
- Existing section 2474.03 Definitions, deleted.
- Existing subsection 2474.04.01; renumbered to 2474.04.01.01, renamed, and revised.
- Subsection 2474.07.05, Quality Control, revised
- Subsection 2474.08.02 Inspection, revised.
- Appendix 2474, information deleted.

MANUAL REVISION RECORD

Provincial-Oriented

Volume 6 – Material Specifications

This record should remain in the manual at all times. Revisions are numbered sequentially. This sheet should be filled in after each revision has been placed into the manual. It will quickly indicate to users whether the contents of the manual are up-to-date.

REVISION NUMBER	REVISION DATE	ENTERED BY	REVISION NUMBER	DATE	ENTERED BY
1	APR 2010	Included in new manuals	27		
2	NOV 2012	Included in new manuals	28		
3	APRIL 2013	Included in new manuals	29		
4	NOV 2013	Included in new manuals	30		
5	NOV 2014	Included in new manuals	31		
6	APRIL 2015	Included in new manuals	32		
7	NOV 2015	Included in new manuals	33		
8	NOV 2016	Included in new manuals	34		
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**ONTARIO
PROVINCIAL
STANDARD
SPECIFICATION**

**VOLUME 6 INDEX
PROVINCIAL-ORIENTED
MATERIAL SPECIFICATIONS**

DATE	SPEC. NO. OPSS.PROV	TITLE
DIVISION 10 - AGGREGATES		
APR 2013	1002	Aggregates - Concrete
APR 2013	1003	Aggregates - Hot Mix Asphalt
NOV 2012	1004	Aggregates - Miscellaneous
APR 2013	1006	Aggregates - Surface Treatment
APR 2013	1010	Aggregates - Base, Subbase, Select Subgrade, and Backfill Material
DIVISION 11 - BITUMENS		
NOV 2014	1101	Performance Graded Asphalt Cement
NOV 2016	1102	Liquid Asphalt Used In Spraying, sealing and Priming Applications
NOV 2016	1103	Emulsified Asphalt
NOV 2016	1151	Superpave and Stone Mastic Asphalt Mixtures
NOV 2016	1152	SC-800 Patching Material
NOV 2016	1153	Emulsified Asphalt Patching Material
DIVISION 12 - SEALS, BEARINGS, WATERSTOPS		
NOV 2016	1202	Bearings – Elastomeric Plain and Steel Laminated
NOV 2016	1203	Bearings – Rotational and Sliding Surface
APR 2015	1205	Clay Seal
NOV 2016	1210	Deck Joint Assemblies
DIVISION 13 - CEMENT AND CONCRETE		
NOV 2014	1303	Admixtures for Concrete
NOV 2016	1350	Concrete - Materials and Production
DIVISION 14 - METAL		
NOV 2014	1440	Steel Reinforcement for Concrete
DIVISION 15 - SAFETY RELATED		
NOV 2016	1504	Steel Beam Guide Rail
NOV 2016	1505	Channel Components For Steel Beam Guide Rail
NOV 2014	1540	Standard Highway Fence Components
DIVISION 16 - WOOD AND PLASTICS		
NOV 2014	1601	Wood, Preservative Treatment, and Shop Fabrication



DATE	SPEC. NO. OPSS.PROV	TITLE
DIVISION 17 - COATINGS		
NOV 2014	1704	Paint Coating Systems for Structural Steel
DIVISION 18 - PIPES AND ASSOCIATED DRAINAGE ITEMS		
NOV 2014	1820	Circular and Elliptical Concrete Pipe
NOV 2015	1841	Notice to Users of OPSS.PROV 1841 (Non-Pressure Polyvinyl Chloride Pipe Products)
DIVISION 19 - ENVIRONMENTAL		
CURRENTLY NO SPECIFICATIONS		
DIVISION 20 - SIGNS AND SIGN SUPPORT		
CURRENTLY NO SPECIFICATIONS		
DIVISION 21 - CLOTHING, CLOTH, AND THE LIKE		
CURRENTLY NO SPECIFICATIONS		
DIVISION 22 - UNASSIGNED		
CURRENTLY NO SPECIFICATIONS		
DIVISION 23 - MISCELLANEOUS		
NOV 2014	2301	Impressed Current Cathodic Protection System for Bridge Structures
DIVISION 24 - ELECTRICAL		
NOV 2016	2422	Heavy Class Steel and Sectional Steel Poles, Base Mounted
NOV 2016	2434	High Pressure Sodium Luminaires For Underpass Lighting
NOV 2016	2453	Sectional Steel Poles
NOV 2016	2471	Sectional Steel High Mast Lighting Poles
NOV 2016	2474	Anchorage Assembly – High Mast Lighting Pole



**ONTARIO
PROVINCIAL
STANDARD
SPECIFICATION**

**METRIC
OPSS.PROV 1102
NOVEMBER 2016
(FORMERLY OPSS 1102, NOVEMBER 2007)**

Note: The PROV implemented in November 2016 replaces OPSS 1102 COMMON, November 2007 with no content changes.

**MATERIAL SPECIFICATION FOR
LIQUID ASPHALT USED IN SPRAYING,
SEALING, AND PRIMING APPLICATIONS**

TABLE OF CONTENTS

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1102.02	REFERENCES
1102.03	DEFINITIONS
1102.04	DESIGN AND SUBMISSION REQUIREMENTS - Not Used
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1102.07	PRODUCTION - Not Used
1102.08	QUALITY ASSURANCE
1102.09	OWNER PURCHASE OF MATERIAL

APPENDICES

1102-A	Commentary
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1102.01 SCOPE

This specification covers the requirements for different types and grades of liquid asphalt for use in highway construction and maintenance.

1102.01.01 Specification Significance and Use

This specification has been developed for use in provincial- and municipal-oriented Contracts. The administration, testing, and payment policies, procedures, and practices reflected in this specification correspond to those used by many municipalities and the Ontario Ministry of Transportation.

Use of this specification or any other specification shall be according to the Contract Documents.

1102.01.02 Appendices Significance and Use

Appendices are not for use in provincial contracts as they are developed for municipal use, and then, only when invoked by the Owner.

Appendices are developed for the Owner's use only.

Inclusion of an appendix as part of the Contract Documents is solely at the discretion of the Owner. Appendices are not a mandatory part of this specification and only become part of the Contract Documents as the Owner invokes them.

Invoking a particular appendix does not obligate an Owner to use all available appendices. Only invoked appendices form part of the Contract Documents.

The decision to use any appendix is determined by an Owner after considering their contract requirements and their administrative, payment, and testing procedures, policies, and practices. Depending on these considerations, an Owner may not wish to invoke some or any of the available appendices.

1102.02 REFERENCES

When the Contract Documents indicate that provincial-oriented specifications are to be used and there is a provincial-oriented specification of the same number as those listed below, references within this specification to an OPSS shall be deemed to mean OPSS.PROV, unless use of a municipal-oriented specification is specified in the Contract Documents. When there is not a corresponding provincial-oriented specification, the references below shall be considered to be to the OPSS listed, unless use of a municipal-oriented specification is specified in the Contract Documents.

When the Contract Documents indicate that municipal-oriented specifications are to be used and there is a municipal-oriented specification of the same number as those listed below, references within this specification to an OPSS shall be deemed to mean OPSS.MUNI, unless use of a provincial-oriented specification is specified in the Contract Documents. When there is not a corresponding municipal-oriented specification, the references below shall be considered to be the OPSS listed, unless use of a provincial-oriented specification is specified in the Contract Documents.

This specification refers to the following standards, specifications, or publications:

Ministry of Transportation Publications

MTO Laboratory Testing Manual:

LS-200	Penetration of Bituminous Materials
LS-201	Flash Point by Cleveland Open Cup
LS-202	Kinematic Viscosity of Asphalt
LS-204	Solubility of Bituminous Materials
LS-205	Ductility of Bituminous Materials

ASTM International

D 36-95 (2000) e1	Softening Point of Bitumen (Ring-and-Ball Apparatus)
D 140-01(2007)	Sampling Bituminous Materials
D 243-02	Residue of Specified Penetration
D 402-02	Distillation of Cut-back Asphaltic (Bituminous) Products
D 3143-98	Flash Point of Cut-back Asphalt with Tag Open-Cup Apparatus

1102.03 DEFINITIONS

For the purpose of this specification, the following definitions apply:

Liquid Asphalt means an asphalt cement mixed with volatile materials to increase the flow qualities of the asphalt cement.

1102.05 MATERIALS

1102.05.01 General

Liquid asphalt shall be of the type and grade specified in the Contract Documents and shall be supplied from a source approved by the Owner.

Under no circumstances shall the source of supply or the product be changed or partial or total supply allocated to another supplier without the prior approval of the Owner.

1102.05.02 Physical Requirements

Liquid asphalt shall be according to Tables 1, 2, 3, and 4.

1102.05.03 Shipment

The material shall be shipped in clean containers. Containers which are being reused shall be inspected, and cleaned, if required, prior to loading to ensure there is no contamination.

When shipment is by tank truck or railway tank car, the material shall arrive at the destination at a temperature at least 5 °C higher than the minimum spraying/mixing temperature specified in Table 5 and not more than the maximum temperature specified in Table 5.

1102.08 QUALITY ASSURANCE

1102.08.01 Compliance

Liquid asphalt shall be according to Tables 1, 2, 3, and 4 for the particular grade and type when tested according to the test methods designated in the tables.

1102.08.02 Inspection

The Owner may inspect shipping containers for cleanliness at any time.

1102.08.03 Sampling

Representative samples of material being supplied shall be taken, if specified in the Contract Documents, according to ASTM D 140 from either the supplier's plant or any shipment in the presence of the Contract Administrator. Samples taken prior to delivery shall be at no extra cost to the Owner.

1102.08.04 Testing

Samples may be tested by the Owner according to the tests listed in material requirements tables.

1102.08.05**Rejection**

Failure of any sample to conform to any of the material requirements shall be cause for rejection of the material. Rejected materials shall be replaced at no extra cost to the Owner.

1102.09**OWNER PURCHASE OF MATERIAL**

Liquid asphalt shall be measured by mass in tonnes as specified in the purchasing order. The tare of the hauling vehicle shall be determined for each load.

Payment at the price specified in the purchasing order shall be for the supply of the liquid asphalt delivered to the destination on the date and time specified.

The cost of all testing, except that performed in the Owner's laboratory, shall be included in the price.

TABLE 1
Rapid Curing Liquid Asphalts

Grade	RC-30		RC-70		RC-250		RC-800		RC-3000		Test Method
Requirements	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	
Tests on Liquid Asphalt											
Flash Point (Tag Open Cup), °C	--	--	--	--	27	--	27	--	27	--	ASTM D 3143
Kinematic Viscosity (at 60 °C), mm ² /s	30	60	70	140	250	500	800	1600	3000	6000	LS-202
Distillation Test Distillate (% of total distillate to 360 °C)											ASTM D 402
to 190 °C	15	--	10	--	--	--	--	--	--	--	
to 225 °C	55	--	50	--	35	--	15	--	--	--	
to 260 °C	75	--	70	--	60	--	45	--	25	--	
to 316 °C	90	--	85	--	80	--	75	--	70	--	
Residue from Distillation to 360 °C, Volume, % by Difference	50	--	55	--	65	--	75	--	80	--	
Tests on Residue from Distillation											
Penetration (at 25 °C, 100 g, 5 s), 0.1 mm	80	120	80	120	80	120	80	120	80	120	LS-200
Ductility (at 25 °C, 5 cm/min), cm (Note 1)	100	--	100	--	100	--	100	--	100	--	LS-205
Solubility, % by mass (Note 2)	99.5	--	99.5	--	99.5	--	99.5	--	99.5	--	LS-204
Notes:											
1. If the ductility at 25 °C is less than 100, the material is acceptable if the ductility at 15 °C is more than 100.											
2. Using trichloroethylene as solvent.											

TABLE 2
Medium Curing Liquid Asphalts

Grade	MC-30		MC-70		MC-250		MC-800		MC-3000		Test Method
Requirements	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	
Tests on Liquid Asphalt											
Flash Point (Tag Open Cup), °C	38	--	38	--	65	--	65	--	65	--	ASTM D 3143
Kinematic Viscosity (at 60 °C), mm ² /s	30	60	70	140	250	500	800	1600	3000	6000	LS-202
Distillation Test Distillate (% of total distillate to 360 °C)											ASTM D 402
to 225 °C	--	25	--	20	--	10	--	--	--	--	
to 260 °C	40	70	20	60	15	55	--	35	--	15	
to 316 °C	75	93	65	90	60	87	45	80	15	75	
Residue from Distillation to 360 °C, Volume, % by Difference	50	--	55	--	67	--	75	--	80	--	
Tests on Residue from Distillation											
Penetration (at 25 °C, 100 g, 5 s), 0.1 mm	120	250	120	250	120	250	120	250	120	250	LS-200
Ductility (at 25 °C, 5 m/min), cm (Note 1)	100	--	100	--	100	--	100	--	100	--	LS-205
Solubility, % by mass (Note 2)	99.5	--	99.5	--	99.5	--	99.5	--	99.5	--	LS-204
Notes:											
1. If the ductility at 25 °C is less than 100, the material is acceptable if the ductility at 15 °C is more than 100.											
2. Using trichloroethylene as solvent.											

TABLE 3
Slow Curing Liquid Asphalts

Grade	SC-70		SC-250		SC-800		SC-3000		Test Method
Requirements	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	
Tests on Liquid Asphalt									
Flash Point (Cleveland Open Cup), °C.	65	--	80	--	90	--	105	--	LS-201
Kinematic Viscosity (at 60 °C), mm ² /s	70	140	250	500	800	1600	3000	6000	LS-202
Distillation Test Distillate (% of total Distillate to 360 °C)	10	30	4	20	2	12	--	5	ASTM D 402
Tests on Residue from Distillation									
Kinematic Viscosity (at 60 °C), mm ² /s	4	70	8	100	20	160	40	350	LS-202
Solubility, % by mass (Note 1)	99.5	--	99.5	--	99.5	--	99.5	--	LS-204
Asphalt Residue of Specified Penetration and Test									
Residue of 100 Penetration, %	50	--	60	--	70	--	80	--	ASTM D 243
Ductility of 100 Penetration Residue (at 25 °C, 5 cm/min), cm (Note 2)	100	--	100	--	100	--	100	--	LS-205
Notes:									
1. Using trichloroethylene as solvent.									
2. If the ductility at 25 °C is less than 100, the material is acceptable if the ductility at 15 °C is more than 100.									

TABLE 4
MTO Primer and Mixed In Place (M.I.P.)

Grade	MTO Primer		M.I.P.		Test Method
Requirements	Min.	Max.	Min.	Max.	
Tests on Liquid Asphalt					
Flash Point (Tag Open Cup), °C.	--	--	27	--	ASTM D 3143
Kinematic Viscosity (at 60 °C), mm ² /s	20	35	120	180	LS-202
Distillation Test Distillate (% of total distillate to 360 °C), to 190 °C to 225 °C to 260 °C to 316 °C	 20 40 70 85	 80 -- -- --	 10 20 40 --	 -- -- -- --	ASTM D 402
Residue from Distillation to 360 °C Volume, % by Difference	50	--	80	--	
Tests on Residue					
Penetration (at 25 °C, 100 g, 5 s), 0.1 mm	80	200	--	--	LS-200
Ductility (at 25 °C, 5 cm/min), cm (Note 1)	100	--	--	--	LS-205
Softening point, °C	--	--	21	32	ASTM D 36
Solubility, % by mass (Note 2)	99.5	--	99.5	--	LS-204
Notes:					
1. If the ductility at 25 °C is less than 100, the material is acceptable if the ductility at 15 °C is more than 100.					
2. Using trichloroethylene as solvent.					

TABLE 5
Temperature Range of Liquid Asphalts for Spraying and Mixing

Grade	Temperature, °C			
	Spraying		Mixing	
	Min.	Max.	Min.	Max.
RC-30, MC-30	30	45	25	45
RC-70, MC-70, SC-70	60	70	55	70
RC-250, MC-250, SC-250	75	90	70	90
RC-800, MC-800, SC-800	90	105	80	105
RC-3000, MC-3000, SC-3000	115	130	110	130
MTO Primer	30	45	--	--
Mixed in Place	--	--	80	105

Appendix 1102-A, November 2007
FOR USE WHILE DESIGNING MUNICIPAL CONTRACTS

Note: This is a non-mandatory Commentary Appendix intended to provide information to a designer, during the design stage of a contract, on the use of the OPS specification in a municipal contract. This appendix does not form part of the standard specification. Actions and considerations discussed in this appendix are for information purposes only and do not supersede an Owner's design decisions and methodology.

Designer Action/Considerations

The designer should specify the following in the Contract Documents:

- Type and grade of liquid asphalt. (1102.05.01)
- Requirements for quality assurance sampling. (1102.08.03)

Typically the types of liquid asphalt listed in this specification are used for priming of granular base, granular sealing, in cold recycled mix, and in asphalt patching material.

The designer should ensure that the General Conditions of Contract and the 100 Series General Specifications are included in the Contract Documents.

Related Ontario Provincial Standard Drawings

None



MATERIAL SPECIFICATION FOR EMULSIFIED ASPHALT

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APPENDICES

1103-A	Commentary
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1103.01	SCOPE
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This specification covers the requirements for different types and grades of emulsified asphalt suitable for both roadway construction and as a straw mulch adhesive.

1103.01.01 Specification Significance and Use

This specification is written as a provincial-oriented specification. Provincial-oriented specifications are developed to reflect the administration, testing, and payment policies, procedures, and practices of the Ontario Ministry of Transportation.

Use of this specification or any other specification shall be according to the Contract Documents.

1103.01.02 Appendices Significance and Use

Appendices are not for use in provincial contracts as they are developed for municipal use, and then, only when invoked by the Owner.

Appendices are developed for the Owner's use only.

Inclusion of an appendix as part of the Contract Documents is solely at the discretion of the Owner. Appendices are not a mandatory part of this specification and only become part of the Contract Documents as the Owner invokes them.

Invoking a particular appendix does not obligate an Owner to use all available appendices. Only invoked appendices form part of the Contract Documents.

The decision to use any appendix is determined by an Owner after considering their Contract requirements and their administrative, payment, and testing procedures, policies, and practices. Depending on these considerations, an Owner may not wish to invoke some or any of the available appendices.

1103.02 REFERENCES

When the Contract Documents indicate that provincial-oriented specifications are to be used and there is a provincial-oriented specification of the same number as those listed below, references within this specification to an OPSS shall be deemed to mean OPSS.PROV, unless use of a municipal-oriented specification is specified in the Contract Documents. When there is not a corresponding provincial-oriented specification, the references below shall be considered to be to the OPSS listed, unless use of a municipal-oriented specification is specified in the Contract Documents.

This specification refers to the following standards, specifications, or publications:

Ontario Provincial Standard Specifications, Material

OPSS 1153 Emulsified Asphalt Patching Material

Ontario Ministry of Transportation Publications

MTO Laboratory Testing Manual:

LS-200	Penetration of Bituminous Materials
LS-204	Solubility of Bituminous Materials in Trichloroethylene
LS-205	Ductility of Bituminous Materials
LS-207	Float of Bituminous Materials
LS-208	Elastic Recovery by Durometer
LS-216	Determination of Residue by Distillation of Emulsified Asphalts
LS-217	Determination of Oil Portion of Distillate in Emulsified Asphalt Primers
LS-218	Particle Charge of Emulsified Asphalt and Emulsified Asphalt Primers
LS-219	Viscosity of Emulsified Asphalts
LS-220	Demulsibility of Emulsified Asphalts
LS-221	Settlement and Storage Stability of Emulsified Asphalt
LS-222	Cement Mixing of Emulsified Asphalts
LS-223	Sieve Test for Emulsified Asphalts
LS-224	Coating for Emulsified Asphalts
LS-226	Test for High Float Emulsified Asphalt

ASTM International

D 140/D 140M -15	Standard Practice for Sampling Bituminous Materials
D 1310-14	Standard Test Method for Flash Point and Fire Point of Liquids by Tag Open-Cup Apparatus
D 2939-03	Test Methods for Emulsified Bitumens Used As Protective Coating

D 6930-10	Standard Test Method for Settlement and Storage Stability of Emulsified Asphalts
D6998-11	Standard Practice for Evaluating Aggregate Coating Using Emulsified Asphalts
D36/D36M-14e1	Standard Test Method for Softening Point of Bitumen (Ring-and-Ball Apparatus)

1103.03 DEFINITIONS

For the purpose of this specification, the following definitions apply:

Emulsified Asphalt means asphalt cement mixed with water to increase the flow qualities of the asphalt cement.

1103.05 MATERIALS

1103.05.01 General

Emulsified asphalt shall be of the type and grade specified in the Contract Documents and shall be supplied from a source approved by the Owner. Under no circumstances shall the source of supply or the product be changed, or partial or total supply allocated to another supplier without prior written approval of the Owner.

1103.05.02 Physical Requirements

Emulsified asphalts shall consist of suitable paving asphalts dispersed in water and shall meet the requirements specified in Tables 1, 2, 3, 8, 9 and 10 and Figure 1. The addition of polymers or other additives after the manufacture of an emulsified asphalt shall not be permitted.

Emulsified asphalts and polymer-modified emulsified asphalts shall be homogeneous after mixing and show no signs of separation within 14 Days of delivery.

1103.05.03 Straw Mulch Adhesive

Emulsified asphalt used as a straw mulch adhesive shall be a specially refined petroleum asphalt emulsified in water, of fluid consistency designed for cold spray applications, containing neither petroleum solvents nor other components toxic to plant life, and shall be according to Table 1.

1103.05.04 Shipping

The material shall be shipped in clean containers. Containers that are being reused shall be inspected and cleaned, if required, prior to loading to ensure there is no contamination.

When shipping is by tank truck or railway tank car, the material shall arrive at the destination at a temperature at least 5 °C higher than the minimum spraying temperature specified in Table 4 and not more than the maximum spraying temperature specified in Table 4.

When no spraying temperatures are specified in Table 4, the material shall arrive at a temperature meeting the manufacturer's requirements.

1103.08 QUALITY ASSURANCE

1103.08.01 Compliance

Emulsified asphalts shall be according to Tables 1, 2, 3, 8, 9 and 10 and Figure 1 for the particular type and grade when tested according to the test methods designated in the tables.

1103.08.02 Inspection

The Owner may inspect shipping containers for cleanliness at any time.

1103.08.03 Sampling

Representative samples of material being supplied may be taken, if specified in the Contract Documents, according to ASTM D 140 from either the supplier's plant or, any shipment in the presence of the Contract Administrator. Sample material taken prior to delivery shall be at no additional cost to the Owner.

1103.08.04 Testing

Samples may be tested by the Owner according to the tests listed in Tables 1, 2, 3, 8, 9, and 10.

1103.08.05 Rejection

Failure of any sample to conform to any of the material requirements shall be cause for rejection of the material, unless price adjustments are specified elsewhere in the Contract Documents. Rejected materials shall be replaced at no additional cost to the Owner.

TABLE 1
Anionic Emulsified Asphalts

Requirements	Type	Rapid Setting						Medium Setting				Slow Setting								Test Method
	Grade	RS-1		RS-2		RS-1HH		MS-1		MS-2		SS-1		SS-1H		SS-1HH		Straw Mulch Adhesive		
		Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	
Tests on Emulsion																				
Viscosity, Saybolt Furol Seconds : at 25 °C at 50 °C	20 --	100 --	-- 75	-- 300	20 --	60 --	20 --	60 --	-- 35	-- 400	20 --	60 --	20 --	60 --	20 --	60 --	17 --	40 --	LS-219	
Residue by Distillation, % by Mass	55	--	60	--	55	--	55	--	65	--	55	--	55	--	55	--	55	--	LS-216	
Settlement, %, 5 Days 7 Days	-- --	3 --	-- --	3 --	-- --	5 --	-- --	3 --	-- --	3 --	-- --	5 --	-- --	5 --	-- --	5 --	-- --	-- 5	LS-221	
Demulsibility, % 35 ml, 0.02 N CaCl2 50 ml, 0.1 N CaCl2	60 --	-- --	60 --	-- --	60 --	-- --	-- --	-- --	-- --	-- --	-- --	-- --	-- --	-- --	-- --	-- --	-- --	-- 2.0	LS-220	
Oil Portion of Distillate, % by Volume/Mass	--	--	--	--	--	1	--	--	--	10	--	--	--	--	--	1	--	--	LS-217	
Sieve Text, % by Mass	--	0.1	--	0.1	--	0.1	--	0.1	--	0.1	--	0.1	--	0.1	--	0.1	--	0.1	LS-223	
Cement Mixing Test, % by Mass	--	--	--	--	--	--	--	--	--	--	--	2.0	--	2.0	--	--	--	--	LS-222	
Particle Charge	NEGATIVE OR NEUTRAL																		LS-218	
Coating Ability and Water Resistance, %, Note 1	--	--	--	--	--	--	80	--	80	--	80	--	80	--	--	--	--	--	LS-224	
Fire Resistance	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	PASS	Note 2		
Tests on Residue																				
Penetration (at 25 °C, 100 g, 5 s), 0.1 mm	100	200	100	200	20	55	100	200	100	250	100	200	40	100	20	55	100	200	LS-200	
Ductility (at 25 °C, 5 cm/min), cm	60	--	60	--	40	--	40	--	40	--	40	--	40	--	40	--	40	--	LS-205	
Solubility in Trichloroethylene, % by Mass	97.5	--	97.5	--	97.5	--	97.5	--	97.5	--	97.5	--	97.5	--	97.5	--	97.5	--	LS-204	
Notes:																				
1. This requirement does not apply for tack coat or joint painting emulsified asphalts.																				
2. There shall be no flash or flare-up when the flame of a bunsen burner is held in contact with the surface of the material, as received, for a period of 10 seconds.																				

TABLE 2
Cationic Emulsified Asphalts

Requirements	Type	Rapid Setting						Medium Setting				Slow Setting						Slurry Seal		Test Method
	Grade	CRS-1		CRS-2		CRS-1HH		CMS-2		CMS-2H		CSS-1		CSS-1H		CSS-1HH		CSS-H		
		Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	
Tests on Emulsion																				
Viscosity, Saybolt Furol Seconds : at 25 °C at 50 °C	-- 50	-- 150	-- 100	-- 400	20 --	60 --	-- 50	-- 400	-- 50	-- 400	20 --	100 --	20 --	100 --	20 --	60 --	20 --	100 --	LS-219	
Residue by Distillation, % by Mass	62	--	67	--	55	--	65	--	65	--	57	--	57	--	55	--	57	--	LS-216	
Settlement, %, 5 Days	--	5	--	5	--	5	--	5	--	5	--	5	--	5	--	5	--	5	LS-221	
Demulsibility, % 35 ml 0.8% Dioctyl Sodium Sulfosuccinate Solution	40	--	40	--	40	--	--	--	--	--	--	--	--	--	--	--	--	--	LS-220	
Oil Portion of Distillate, % by Volume/Mass	--	3	--	3	--	1	--	10	--	10	--	5	--	5	--	1	--	--	LS-217	
Sieve Text, % by Mass	--	0.1	--	0.1	--	0.1	--	0.1	--	0.1	--	0.1	--	0.1	--	0.1	--	0.1	LS-223	
Cement Mixing Test, % by Mass	--	--	--	--	--	--	--	--	--	--	--	2.0	--	2.0	--	--	--	--	LS-222	
Particle Charge	POSITIVE																		LS-218	
Coating Ability and Water Resistance, % (Note 1)	--	--	--	--	--	--	80	--	80	--	80	--	80	--	--	--	--	--	LS-224	
Tests on Residue																				
Penetration (at 25 °C, 100 g, 5 s), 0.1 mm	100	250	100	250	20	55	100	250	40	125	100	250	40	125	20	55	40	125	LS-200	
Ductility (at 25 °C, 5 cm/min), cm	60	--	60	--	40	--	60	--	40	--	60	--	40	--	40	--	40	--	LS-205	
Solubility in Trichloroethylene, % by Mass	97.5	--	97.5	--	97.5	--	97.5	--	97.5	--	97.5	--	97.5	--	97.5	--	97.5	--	LS-204	
Notes:																				
1. This requirement does not apply for tack coat or joint painting emulsified asphalts.																				

TABLE 3
High Float Emulsified Asphalts

Requirements	Type	High Float														Test Method
	Grade	HFRS-2		HFMS-2(ON)		HF-100S		HF-150S		HF-250S		HF-150M		HF-1000M		
		Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	
Tests on Emulsion																
Viscosity, Saybolt Furol Seconds at 50 °C	75	400	50	300	35	150	35	150	35	150	50	--	50	--	LS-219	
Residue by Distillation, % by Mass	63	--	62	--	62	--	62	--	62	--	62	--	65	--	LS-226 LS-216	
Demulsibility, % 35 ml 0.02 N CaCl2 50 ml 0.10 N CaCl2 50 ml 0.02 N CaCl2	60 -- --	-- -- --	-- -- 40	-- -- --	-- 75 --	-- -- --	-- 75 --	-- -- --	-- -- --	-- -- --	-- -- --	-- -- --	-- -- --	-- -- --	LS-220	
Oil Portion of Distillate, % by Volume/Mass	--	--	0.5	3	0.5	4	0.5	4	1	6	1	6	1	7	LS-217	
Sieve Text, % by Mass	--	0.10	--	0.10	--	0.10	--	0.10	--	0.10	--	0.10	--	0.10	LS-223	
Particle Charge	--		Negative		--		--		--		--		--		LS-218	
Coating Test	--		(Note 1)		(Note 1)		(Note 1)		(Note 1)		(Note 2)		(Note 2)		ASTM D6998	
Storage Stability 24 h, % by Mass	--	1.0	--	1.5	--	1.5	--	1.5	--	1.5	--	1.5	--	1.5	ASTM D 6930	
Tests on Residue																
Penetration (at 25 °C, 100 g, 5 s), 0.1 mm	100	200	90	200	100	175	150	250	250	500	150	--	--	--	LS-226 LS-200	
Ductility (at 25 °C, 5 cm/min), cm	40	--	--	--	--	--	--	--	--	--	--	--	--	--	LS-205	
Solubility in Trichloroethylene, % by Mass	97.5	--	97.5	--	97.5	--	97.5	--	97.5	--	97.5	--	97.5	--	LS-204	
Float Test at 60 °C, s	1200	--	1200	--	1200	--	1200	--	1200	--	1200	--	1200	--	LS-226 LS-207	
Apparent Viscosity (at 60 °C), Pa·s	--	--	--	--	Requirements outlined on Figure 1							10	80 (Note 3)	2	8 (Note 3)	LS-226
Notes:																
1. Follow ASTM D6998, except that the mixture of aggregate and emulsified asphalt shall be mixed vigorously for 5 min. at the end of which period the aggregates shall be thoroughly and uniformly coated. The mixture shall then be completely immersed in tap water and the water poured off. The aggregate shall then be at least 90% coated.																
2. Follow ASTM D6998, except that the mixture of aggregate and emulsified asphalt shall be mixed vigorously for 5 min. then allowed to stand for 3 hours after which the mixture shall be capable of being mixed an additional 1 min. The mixture shall then be rinsed twice with approximately its own volume of tap water, without showing appreciable loss of bituminous film. After the second washing the aggregate shall be at least 90% coated.																
3. Viscosity limits (at 60 °C at 1.0 s-1) shown for mixing grades are tentative. Supplier to advise purchaser before delivery, if limits cannot be met.																

TABLE 4
Temperature for Spraying and Mixing Emulsified Asphalts, °C

Grade	Spraying		Mixing	
	Minimum	Maximum	Minimum	Maximum
RS-1, RS-1P, RS-1HH	30 (Note 1) 20 (Note 2)	70 70	-- --	-- --
RS-2, RS-2P	60 (Note 1)	80	--	--
MS-1	--	--	30	70
MS-2	--	--	30	70
SS-1	20	70	20	70
SS-1H, SS-1HH	20	70	20	70
HFRS-2	60	80	--	--
HFMS-2(ON), HFMS-2P(ON)	60	80	--	--
HF-100S, HF-100SP	60	80	--	--
HF-150S, HF-150SP	60	80	--	--
HF-250S	60	80	--	--
HF-150M, HF-150MP	--	--	40	80
HF-1000M	--	--	40	75
CRS-1, CRS-1P, CRS-1HH	60	80	--	--
CRS-2, CRS-2P	60	80	--	--
CMS-2	--	--	30	70
CMS-2H	--	--	30	70
CSS-1	--	--	30	70
CSS-1H	--	--	30	70
CSS-1HH	20	70	--	--
CSS-H (Slurry)	--	--	20	35
CQS-1HP	--	--	Manufacturer's Requirements	
Emulsified Asphalt Primer (EAP)	Manufacturer's Requirements		--	--
Solvent-Free Emulsified Asphalt	Manufacturer's Requirements		--	--
Notes: 1. For surface treatment. 2. For other uses.				

TABLE 5
Minimum Apparent Viscosity, HF-100S

Penetration at 25 °C 0.1 mm	Minimum Apparent Viscosity at 60 °C, Pa·s at 0.5 s⁻¹	Penetration at 25 °C 0.1 mm	Minimum Apparent Viscosity at 60 °C, Pa·s at 0.5 s⁻¹	Penetration at 25 °C 0.1 mm	Minimum Apparent Viscosity at 60 °C, Pa·s at 0.5 s⁻¹
75	1428	117	823	159	563
76	1405	118	815	160	559
77	1382	119	806	161	554
78	1360	120	798	162	550
79	1339	121	790	163	546
80	1318	122	782	164	542
81	1298	123	774	165	538
82	1279	124	766	166	534
83	1260	125	759	167	530
84	1241	126	751	168	526
85	1223	127	744	169	522
86	1205	128	737	170	518
87	1188	129	729	171	515
88	1172	130	723	172	511
89	1155	131	716	173	507
90	1139	132	709	174	504
91	1124	133	702	175	500
92	1109	134	696	176	496
93	1094	135	690	177	493
94	1080	136	683	178	490
95	1066	137	677	179	486
96	1052	138	671	180	483
97	1038	139	665	181	480
98	1025	140	659	182	476
99	1013	141	653	183	473
100	1000	142	648	184	470
101	988	143	642	185	467
102	976	144	637	186	464
103	964	145	631	187	461
104	953	146	626	188	458
105	941	147	621	189	455
106	930	148	615	190	452
107	920	149	610	191	449
108	909	150	605	192	446
109	899	151	600	193	443
110	889	152	595	194	440
111	879	153	591	195	437
112	869	154	586	196	435
113	860	155	581	197	432
114	850	156	576	198	429
115	841	157	572	199	426
116	832	158	567	200	424

Notes:

1. This table is based on the apparent viscosity of 1000 Pa·s at 0.5 s⁻¹ at 100 penetration, and 500 Pa·s at 0.5 s⁻¹ at 175 penetration.

TABLE 6
Minimum Apparent Viscosity, HF-150S

Penetration at 25 °C 0.1 mm	Minimum Apparent Viscosity at 60 °C, Pa·s at 0.5 s ⁻¹	Penetration at 25 °C 0.1 mm	Minimum Apparent Viscosity at 60 °C, Pa·s at 0.5 s ⁻¹	Penetration at 25 °C 0.1 mm	Minimum Apparent Viscosity at 60 °C, Pa·s at 0.5 s ⁻¹
125	164	155	136	200 - 201	109
126	163	156 - 157	135	202 - 203	108
127	162	158	134	204 - 205	107
128	161	159	133	206 - 208	106
129	160	160 - 161	132	209 - 210	105
130	158	162	131	211 - 212	104
131	157	163 - 164	130	213 - 215	103
132	156	165	129	216 - 217	102
133	155	166 - 167	128	218 - 220	101
134	154	168	127	221 - 222	100
135	153	169 - 170	126	223 - 225	99
136	152	171	125	226 - 227	98
137	151	172 - 173	124	228 - 230	97
138 - 139	150	174 - 175	123	231 - 233	96
140	149	176	122	234 - 236	95
141	148	177 - 178	121	237 - 239	94
142	147	179 - 180	120	240 - 242	93
143	146	181	119	243 - 245	92
144	145	182 - 183	118	246 - 248	91
145	144	184 - 185	117	249 - 251	90
146	143	186 - 187	116	252 - 254	89
147 - 148	142	188 - 189	115	255 - 258	88
149	141	190 - 191	114	259 - 261	87
150	140	192 - 193	113	262 - 265	86
151	139	194 - 195	112	266 - 268	85
152 - 153	138	196 - 197	111	269 - 272	84
154	137	198 - 199	110	273 - 275	83

Notes:

1. This table is based on the apparent viscosity of 140 Pa·s at 0.5 s⁻¹ at 150 penetration, and 90 Pa·s at 0.5 s⁻¹ at 250 penetration.

TABLE 7
Minimum Apparent Viscosity, HF-250S

Penetration at 25 °C 0.1 mm	Minimum Apparent Viscosity at 60 °C, Pa•s at 1.0 s⁻¹	Penetration at 25 °C 0.1 mm	Minimum Apparent Viscosity at 60 °C, Pa•s at 1.0 s⁻¹
225 - 227	57	311 - 317	37
228 - 231	56	318 - 323	36
232 - 234	55	324 - 331	35
235 - 237	54	332 - 338	34
238 - 240	53	339 - 346	33
241 - 244	52	347 - 354	32
245 - 248	51	355 - 363	31
249 - 251	50	364 - 372	30
252 - 255	49	373 - 382	29
256 - 259	48	383 - 392	28
260 - 264	47	393 - 404	27
265 - 268	46	405 - 416	26
269 - 273	45	417 - 428	25
274 - 277	44	429 - 442	24
278 - 282	43	443 - 457	23
283 - 287	42	458 - 473	22
288 - 293	41	474 - 490	21
294 - 298	40	491 - 509	20
299 - 304	39	510 - 525	19
305 - 310	38		

Notes:

1. This table is based on the apparent viscosity of 50 Pa•s at 1.0 s⁻¹ at 250 penetration, and 20 Pa•s at 1.0 s⁻¹ at 500 penetration.

TABLE 8
Polymer-Modified Emulsified Asphalts

Requirements	Type	Anionic				Cationic						High Float								Test Method
	Grade	RS-1P		RS-2P		CRS-1P		CRS-2P		CQS-1HP		HFMS-2P(ON)		HF-100SP		HF-150SP		HF-150MP		
		Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	
Tests on Emulsion																				
Viscosity, Saybolt Furol Seconds: at 25 °C at 50 °C	20 --	100 --	-- 75	-- 300	-- 25	-- 150	-- 75	-- 400	20 --	100 --	-- 50	-- 300	-- 35	-- 150	-- 35	-- 150	-- 50	-- --	LS-219	
Residue by Distillation to 204.4 °C, % by Mass	55	--	60	--	62	--	65	--	62	--	62	--	62	--	62	--	62	--	LS-216 LS-226	
Settlement, 24 h, % by Mass	--	1	--	1	--	1	--	1	--	1	--	--	--	--	--	--	--	--	LS-221	
Demulsibility, % 35 ml, 0.02 N CaCl2 35 ml, 0.8% Dioctyl Sodium Sulfo-Succinate Solution 50 ml 0.10 N CaCl2 50 ml 0.02 N CaCl2	60 -- -- --	-- -- -- --	60 -- -- --	-- -- -- --	-- 40 -- --	-- -- -- --	-- 40 -- --	-- -- -- --	-- -- -- --	-- -- -- --	-- -- -- 40	-- -- -- --	-- -- 75 --	-- -- 75 --	-- -- -- --	-- -- -- --	-- -- -- --	-- -- -- --	LS-220	
Oil Portion of Distillate, % by Volume/Mass	--	--	--	--	--	--	--	--	--	--	0.5	3	0.5	4	0.5	4	1	6		
Sieve Text, % by Mass	--	0.20	--	0.20	--	0.20	--	0.20	--	0.10	--	0.10	--	0.10	--	0.10	--	0.10		
Particle Charge	Negative or Neutral				Positive						Negative		--		--		--			
Coating Test	--		--		--		--		--		(Note 1)		(Note 1)		(Note 1)		(Note 2)		ASTM D 6998	
Storage Stability, 24 h, % by Mass	--	--	--	--	--	--	--	--	--	--	--	--	--	1.5	--	1.5	--	1.5	ASTM D 6930	
Tests on Residue																				
Penetration (at 25 °C, 100 g, 5 s), 0.1 mm	100	200	100	200	100	250	100	250	40	90	90	200	90	150	150	250	150	250	LS-200 LS-226	
Solubility in Trichloroethylene, % by Mass (Note 2)	97.5	--	97.5	--	97.5	--	97.5	--	97.5	---	97.5	---	97.5	--	97.5	--	97.5	--	LS-204	
Float Test at 60 °C, s	--	--	--	--	--	--	--	--	--	--	1200	--	1200	--	1200	--	1200	--	LS-226 LS-207	
Ash Content, % by Mass of Residue (Note 3)	--	1.0	--	1.0	--	1.0	--	1.0	--	1.0	--	1.0	--	1.0	--	1.0	--	1.0	ASTM D 2939	
Elastic Recovery (at 10 °C), %	55	--	55	--	55	--	55	--	50	--	55	--	55	--	50	--	50	--	LS-208	
Force Ductility at 800% Elongation, 5 cm/min. Pull Rate at 4 °C, kg	0.5	--	0.5	--	0.5	--	0.5	--	--	--	0.5	--	0.5	--	--	--	--	--	LS-205	
Softening Point, R&B, °C									57										ASTM D36	

Notes for Table 8:

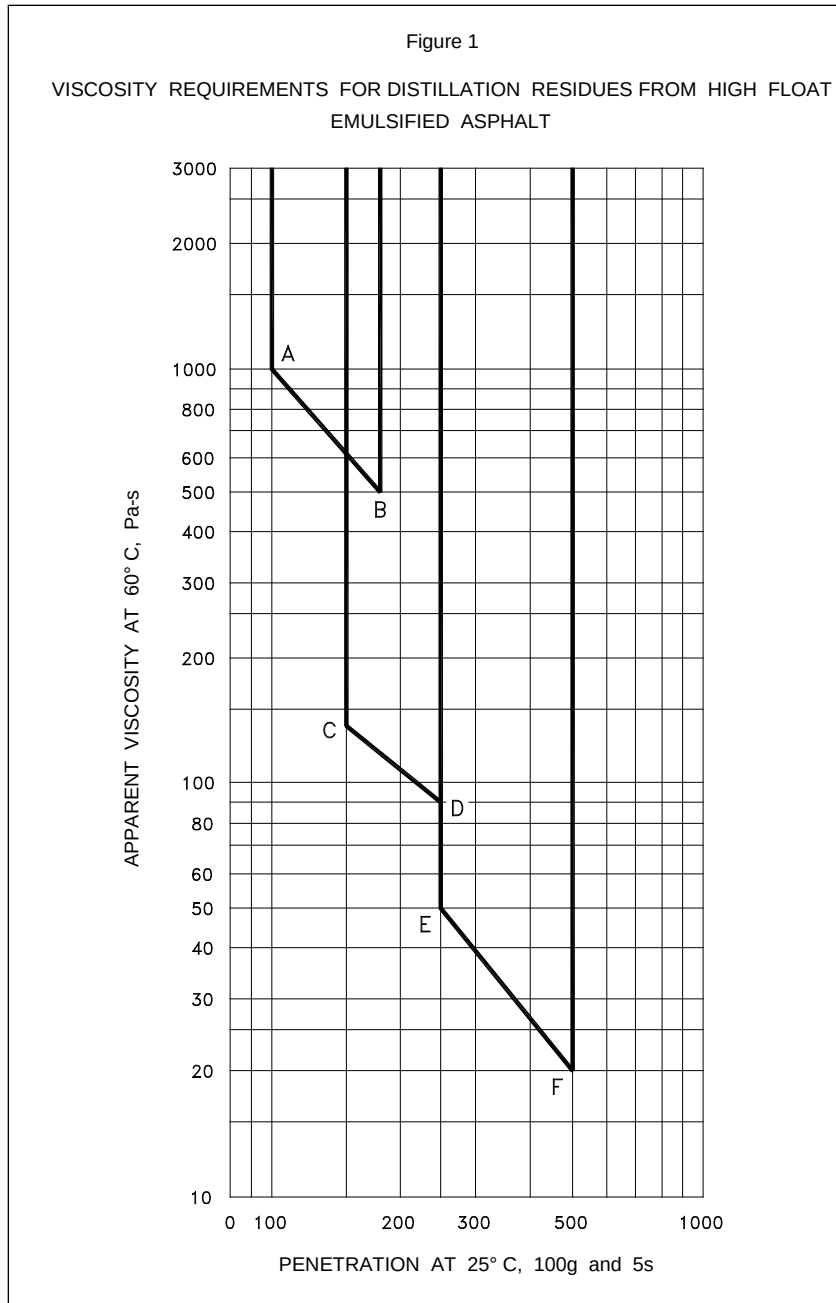
1. Follow ASTM D6998, except that the mixture of aggregate and emulsified asphalt shall be mixed vigorously for 5 min. at the end of which period the aggregates shall be thoroughly and uniformly coated. The mixture shall then be completely immersed in tap water and the water poured off. The aggregate shall then be at least 90% coated.
2. Follow ASTM D6998, except that the mixture of aggregate and emulsified asphalt shall be mixed vigorously for 5 min. then allowed to stand for 3 hours after which the mixture shall be capable of being mixed an additional 1 min. The mixture shall then be rinsed twice with approximately its own volume of tap water, without showing appreciable loss of bituminous film. After the second washing the aggregate shall be at least 90% coated.
3. The ash content shall be determined when the manufacturer indicates that the polymer additive is not soluble in trichloroethylene.

TABLE 9
Emulsified Asphalt Primer (EAP)

Requirements	Min.	Max.	Test Method
Viscosity, Saybolt Furol Seconds at 50 °C	35	150	LS-219
Residue by Distillation to 260 °C, % by Mass	40	--	LS-216
Oil Portion of Distillate, % by Volume/Mass	10	30	LS-217 (Note 1)
Particle Charge	Neutral		LS-218 (Note 2)
Flash Point, Tag Open Cup, °C	45	--	ASTM D 1310
Storage Stability, 24 h	No visible separation		ASTM D 6930 (Note 3)
Tests on Residue			
Penetration (at 25 °C, 100 g, 5 s), 0.1 mm	100	300	LS-200
Ductility (at 25 °C, 5 cm/min), cm (Note 4)	100	--	LS-205
Solubility in Trichloroethylene, % by Mass	97.5	--	LS-204
Notes:			
1. Since the total distillate exceeds 100 ml, follow LS-217 with the following modification: Prior to reaching 100 ml of distillate, carefully replace the first 100 ml graduated cylinder with a second one. After the distillation is complete, determine the volume of oil distillate in both cylinders and record the sum. Calculate the oil portion of the distillate as a percentage of the original weight of primer: $\% \text{ Oil} = (\text{Total Volume of oil distillate, ml} \times 100) / (200 \text{ g primer})$			
2. Follow LS-218 with the modification that the asphalt does not deposit due to an electrical charge on either the anode (positive electrode) or the cathode (negative electrode). Equal adherence to both electrodes due to the viscous nature of the material is not considered deposition.			
3. Follow ASTM D 6930 except storage stability shall be based on visual separation of 500 ml representative sample in the glass cylinder after 24 hours.			
4. If the ductility at 25 °C is less than 100 cm, the material shall be acceptable if its ductility at 15 °C is more than 100 cm.			

Table 10
Solvent-Free Emulsified Asphalt

Requirements	Min.	Max.	Test Method
Viscosity, Saybolt Furol Seconds at 25 °C	5	50	LS-219
Residue by Distillation to 260 °C, % by Mass	40	-	LS-216
Sieve Test, % by Mass	-	0.1	LS-223
Oil Portion of Distillate, % by Volume/Mass	-	0.5	LS-217 (Note 1)
Storage Stability, 24 h, %	No visible separation		ASTM D 6930 (Note 2)
Particle Charge	Negative or Neutral		LS-218
Tests on Residue			
Penetration (at 25 °C, 100 g, 5 s), 0.1 mm	40	150	LS-200
Ductility (at 25 °C, 5 cm/min), cm	40	--	LS-205
Solubility in Trichloroethylene, % by Mass	97.5	--	LS-204
Notes:			
1. Since the total distillate will exceed 100 ml, follow LS-217 with the following modification: Prior to reaching 100 ml of distillate, carefully replace the first 100 ml graduated cylinder with a second one. After the distillation is complete, determine the volume of oil distillate in both cylinders and record the sum. Calculate the oil portion of the distillate as a percentage of the original weight of solvent-free emulsified asphalt: $\% \text{ Oil} = (\text{Total Volume of oil distillate, ml} \times 100) / (200 \text{ g solvent-free emulsified asphalt})$			
2. Follow ASTM D 6930 except storage stability shall be based on visual separation of 500 ml representative sample in the glass cylinder after 24 hours.			



Notes:

- A. Grade of high float emulsified asphalt: HF-100S - A, B
 HF-150S - C, D
 HF-250S - E, F
- B. Viscosity shall be above the extrapolated line* designated by specified letters and between penetration limits contained in vertical lines extending upwards from these points.
 * See Tables 5, 6, and 7 for acceptable values.
- C. Viscosity value shall be reported at the shear rate: 0.5 s^{-1} for grades HF-100S and HF-150S
 1.0 s^{-1} for grade HF-250S

Appendix 1103-A, November 2016
FOR USE WHILE DESIGNING MUNICIPAL CONTRACTS

Note: This is a non-mandatory Commentary Appendix intended to provide information to a designer, during the design stage of a contract, on the use of the OPS specification in a municipal contract. This appendix does not form part of the standard specification. Actions and considerations discussed in this appendix are for information purposes only and do not supersede an Owner's design decisions and methodology.

Designer Action/Considerations

No information provided here.

Related Ontario Provincial Standard Drawings

No information provided here.



MATERIAL SPECIFICATION FOR SUPERPAVE AND STONE MASTIC ASPHALT MIXTURES

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APPENDICES

1151-A	Commentary
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1151.01	SCOPE
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This specification covers the requirements for the materials, equipment, and processes for proportioning and mixing hot mix asphalt (HMA) including warm mix asphalt, recycled mixes, and mixes for miscellaneous work according to the Superpave and SMA mix design methodology.

1151.01.01 Specification Significance and Use

This specification is written as a provincial-oriented specification. Provincial-oriented specifications are developed to reflect the administration, testing, and payment policies, procedures, and practices of the Ontario Ministry of Transportation.

Use of this specification or any other specification shall be according to the Contract Documents.

1151.01.02 Appendices Significance and Use

Appendices are not for use in provincial contracts as they are developed for municipal use, and then, only when invoked by the Owner.

Appendices are developed for the Owner's use only.

Inclusion of an appendix as part of the Contract Documents is solely at the discretion of the Owner. Appendices are not a mandatory part of this specification and only become part of the Contract Documents as the Owner invokes them.

Invoking a particular appendix does not obligate an Owner to use all available appendices. Only invoked appendices form part of the Contract Documents.

The decision to use any appendix is determined by an Owner after considering their contract requirements and their administrative, payment, and testing procedures, policies, and practices. Depending on these considerations, an Owner may not wish to invoke some or any of the available appendices.

1151.02 REFERENCES

When the Contract Documents indicate that provincial-oriented specifications are to be used and there is a provincial-oriented specification of the same number as those listed below, references within this specification to an OPSS shall be deemed to mean OPSS.PROV, unless use of a municipal-oriented specification is specified in the Contract Documents. When there is not a corresponding provincial-oriented specification, the references below shall be considered to be to the OPSS listed, unless use of a municipal-oriented specification is specified in the Contract Documents. This specification refers to the following standards, specifications, or publications:

Ontario Provincial Standard Specifications, Construction

OPSS 313 Hot Mix Asphalt - End Result

Ontario Provincial Standard Specifications, Material

OPSS 1001 Aggregates - General
OPSS 1003 Aggregates - Hot Mix Asphalt
OPSS 1101 Performance Graded Asphalt Cement

Ontario Ministry of Transportation Publications

Designated Sources for Materials (DSM) Manual

MTO Laboratory Testing Manual:

LS-200 Penetration of Bituminous Materials
LS-282 Quantitative Extraction of Asphalt Cement and Analysis of Extracted Aggregate from Bituminous Paving Mixtures
LS-284 Recovery of Asphalt from Solution by Abson Method or Rotavapor
LS-292 Quantitative Determination of Asphalt Cement Content by Ignition and Analysis of Remaining Aggregate from Bituminous Paving Mixtures
LS-309 Superpave Mix Design
LS-311 Stone Mastic Asphalt Mix Design
LS-316 Mix Check
LS-318 Practice for Warm Mix Asphalt (WMA) Mix Design
LS-602 Sieve Analysis of Aggregates

LS-603 Resistance to Degradation of Coarse Aggregate by Abrasion and Impact in the Los Angeles Abrasion Machine

American Association of State Highway and Transportation Officials (AASHTO)

M 325-08 Standard Specification for Designing Stone Matrix Asphalt (SMA)
T 305-14 Determination of Draindown Characteristics in Uncompacted Asphalt Mixtures

National Asphalt Pavement Association (NAPA)

QIS 122 Designing and Constructing SMA Mixtures — State-of-the-Practice

1151.03 DEFINITIONS

For the purpose of this specification, the definitions in OPSS 313, OPSS 1101, and the following definitions apply:

AMRL means the AASHTO Materials Reference Laboratory.

Anti-Stripping Treatment (AST) means a treatment used to minimize stripping of asphalt cement from HMA aggregates, and can be either AST-AGG or AST-AC.

Aggregate Anti-Stripping Treatment (AST-AGG) means an AST applied directly to the HMA aggregates prior to incorporating them into the mix or dryer at the HMA plant.

Asphalt Cement Anti-Stripping Treatment (AST-AC) means an AST added directly to the asphalt cement to be used in the mix, prior to incorporating it into the mixer at the HMA plant.

CCIL means the Canadian Council of Independent Laboratories.

Coarse Aggregate means that portion of aggregate material retained on the 4.75 mm sieve, when tested according to LS-602.

Deleterious Material means materials other than reclaimed asphalt pavement, and that includes but is not limited to the following: ceramic, clay brick, clay tile, glass, gypsum, gypsum plaster, plastic, reclaimed concrete material, wallboard, and wood.

Fine Aggregate means that portion of aggregate material passing the 4.75 mm sieve when tested according to LS-602.

Maximum Aggregate Size means one sieve size larger than the nominal maximum aggregate size.

Mix Design means the design of the proportions of aggregates, asphalt cement, and additives, when uniformly mixed, results in an acceptable HMA in accordance with the specified method.

Nominal Maximum Aggregate Size (NMAS) means one sieve size larger than the first sieve to retain more than 10% by mass.

Primary Control Sieve (PCS) means the sieve defining the break point between fine and coarse-graded mixtures for each nominal maximum aggregate size.

RAP Content means the amount of RAP expressed as a percentage by mass of the mix.

1151.04 DESIGN AND SUBMISSION REQUIREMENTS

1151.04.01 Design Requirements

1151.04.01.01 General

A laboratory that has current CCIL Type A Certification, AMRL, or AMRL equivalent certification shall be used to conduct all mix designs and mix checks.

Superpave mixes shall be designed using the procedures specified in LS-309, with the exception of WMA mixes. WMA mixes shall be designed using the procedures specified in LS-318 at the anticipated WMA production temperature.

Superpave materials, mix designs, and the JMF shall be according to the requirements specified in Tables 1, 2, 3 and 4 for the HMA mix type specified in the Contract Documents.

SMA mixes shall be designed using the procedures specified in LS-311. SMA materials, mix designs, and the JMF shall be according to the requirements specified in Tables 1, 4, and 5 for the SMA mix type specified in the Contract Documents. Cellulose or mineral fibres shall be used as a stabilizing additive in dosage rates of 0.3% or 0.4%, respectively, by mass of the total mixture. Regardless of the type of fibre used, the manufacturer's recommendations for any product used shall be followed.

The composition of the HMA may be modified as permitted in Table 6.

RAP and RST as processed and ready for use in a HMA shall be tested using LS-282 or LS-292 to determine the average percentage asphalt cement and the average gradation for the extracted RAP and RST aggregates.

Density testing of aggregates, RAP, and RST shall be conducted for the purpose of developing the mix design for each mix type in the Contract. Such testing shall be performed during production of each aggregate, RAP and RST, or during stockpiling of the materials at the HMA plant.

In addition, if the composition of the mix is modified by including RAP or RST or both, the high and low grade of PGAC required shall be lowered by 6 °C when:

$$[(\text{percent RAP by mass total mixture}) + 10 \times (\text{percent RST by mass total mixture})] > 20 \%$$

The JMF selected for use shall produce HMA that meets all the requirements specified in the Contract Documents.

1151.04.01.02 Changes to the Job-Mix Formula and the Mix Design

Changes to the JMF shall be permitted subject to the conditions specified in the Contract Documents.

A new mix design shall be completed according to the Mix Design clause, when:

- a) A material is eliminated.
- b) A new material is added.
- c) A material source is changed.
- d) The net impact of all adjustments to the original JMF exceeds any of the maximum field adjustments according to OPSS 313.
- e) The allowable time period has been exceeded and the use of the mix design has not been extended.

1151.04.01.03 Anti-Stripping Treatments

1151.04.01.03.01 General

AST shall treat the mix components at the greater of the dosages specified in the Aggregate Anti-Stripping Treatment clause, the Asphalt Cement Anti-Stripping Treatment clause, or as specified elsewhere in the Contract Documents.

1151.04.01.03.02 Moisture Sensitivity

Moisture sensitivity shall meet the tensile strength ratio requirements specified in Tables 3 and 4.

1151.04.01.03.03 Aggregate Anti-Stripping Treatment

1151.04.01.03.03.01 General

Irrespective of any moisture sensitivity testing that shows that AST-AGG is not required, hydrated lime or an approved AST-AGG from the DSM listing for Aggregates: Surface Friction Courses shall be used in all mixes consisting of more than 75% quartzite and dolomitic sandstone aggregates, or combinations thereof.

Irrespective of any moisture sensitivity testing that shows that AST-AGG is not required, the AST-AGG dosage and type shown in the DSM listing for Aggregates: Surface Friction Courses shall be the minimum used for all aggregates to be incorporated into SMA and Superpave 12.5FC 2.

1151.04.01.03.03.02 Hydrated Lime

When hydrated lime is used as the AST-AGG, the dosage shall be the greater of:

- a) The amount determined to meet the moisture sensitivity requirements, or
- b) One percent by mass of total dry aggregate, or
- c) The listed dosage from the DSM listing for Aggregates: Surface Friction Courses.

1151.04.01.03.03.03 Alternate Aggregate Anti-Stripping Treatment

When an alternate is used as the AST-AGG in place of hydrated lime, the dosage shall be the greater of:

- a) The amount determined to meet the moisture sensitivity requirements; or
- b) The listed dosage from the DSM listing for Aggregates: Surface Friction Courses.

1151.04.01.03.04 Asphalt Cement Anti-Stripping Treatment

When AST-AGG is not required in the mix, AST shall be used in the mix if:

- a) Mix moisture sensitivity testing indicates an AST is required; or
- b) The Contract Documents note that an AST is required.

The amount of AST to be used in the mix shall be the greater of:

- a) The amount required to meet the moisture sensitivity requirements; or

- b) The listed minimum dosage from the DSM listing for Anti-Stripping Treatments.

1151.04.02 Submission Requirements

1151.04.02.01 Mix Design

A copy of all mix design and JMF documents, signed, dated, and certified correct by the person accountable for the engineering and management responsibility for the laboratory that conducted the work, shall be submitted to the Contract Administrator. The mix design shall include a statement that the mix exceeds 75% if the percentage of the mix comprising quartzite and dolomitic sandstone aggregates, or combinations thereof, is more than 75%. The flow number test results shall be submitted with the mix design, or up to 1 month after submission of the original WMA mix design.

The mix design shall be valid for a maximum of 14 months from when the mix design was prepared. To extend use of the mix design for each calendar year past the initial 14 months, a One Point Mix Check for the properties listed in Table 7, using the methodology in LS-316 as applicable, shall be submitted to the Contract Administrator. The mix must meet the requirement and tolerances given in Table 7.

The mix shall not be placed until the Contract Administrator gives written confirmation that the submitted mix design documents and JMF meet the Contract requirements. Within 4 Business Days following the delivery of all required documentation, the Contract Administrator shall provide written confirmation that the mix design and all samples meet the Contract requirements or advise of any requirements that have not been met.

Confirmation of conformance to Contract requirements of the submitted mix design does not constitute any guarantee that the mix can be produced or constructed or both to Contract requirements, and does not relieve the Contractor of the responsibility for ensuring the specified quality of Materials and workmanship.

1151.04.02.02 Material Samples

At the written request of the Contract Administrator, one set of material samples representative of those used for mix design shall be submitted to the laboratory specified in the Contract Documents. The materials shall be delivered within 2 Days of the request made by the Contract Administrator or within 2 Days of submission of the mix design to the Contract Administrator, whichever is later.

For the One Point Mix Check, new samples for aggregate density determination shall be submitted within 2 Days of submission of the mix check to the Contract Administrator.

Each material sample shall be packaged separately and each filled sample container shall not exceed a mass of 30 kg.

The sample quantities are specified in Table 8.

1151.04.02.03 Warm Mix Asphalt

For WMA, the following information shall be submitted to the Contract Administrator in writing with the mix design:

- a) The WMA technology to be used.
- b) Complete name and address of the WMA supplier.
- c) The type and dosage of WMA additives, if applicable, and how the additives are incorporated.
- d) The WMA technology supplier's established recommendations for usage.

1151.05 MATERIALS

1151.05.01 Asphalt Cement

Asphalt cement shall be performance graded asphalt cement according to OPSS 1101.

1151.05.02 Aggregates

Aggregates shall be according to OPSS 1003.

1151.05.02.01 Reclaimed Asphalt Pavement and Roof Shingle Tabs

The aggregate contained in the RAP or RST or both, where permitted in a HMA, shall be according to the aggregate requirements of OPSS 1003 for the mix type specified in the Contract Documents. Any materials used to keep the ground RST material from clumping shall be approved by Owner.

RST, when permitted in a HMA, shall meet the requirements of Table 9.

RAP and RST that are contaminated with deleterious material shall not be used and shall be removed from the work. RAP and RST shall be stockpiled conforming to the stockpiling requirements for coarse aggregates according to OPSS 1001, except that when the material is stockpiled on a compacted granular pad, the top 75 mm of the pad shall be the coarse aggregate that is required for a new (virgin) mixture of the tendered hot mix item.

The use of RAP and RST that are obtained from existing stockpiles that do not have a foundation conforming to the above paragraph shall be permitted provided that the bottom 0.3 m of the stockpile is not incorporated into the work.

Process control sampling and testing of the RAP and RST shall be as specified in the Contract Documents.

When RST is used in the HMA, it shall be processed solely from manufactured shingle scrap and shall be free of all contamination.

1151.05.03 Silicone

Silicone oil, when added to the asphalt cement, shall be less than five parts per million of asphalt cement.

1151.05.04 Filler

Filler shall be according to OPSS 1003.

1151.05.05 Fibres

Fibres shall be either cellulose or mineral fibres, and appropriate for use in the SMA mix design, such as those detailed in QIS 122. The use of rock wool, asbestos and fiberglass, other than that contained in RST, is prohibited.

1151.07 PRODUCTION

1151.07.01 Anti-Stripping Treatments

1151.07.01.01 Asphalt Cement Anti-Stripping Treatments

If the AST-AC is added by the asphalt cement supplier at the refinery depot, the Contract Administrator shall be provided with the AST-AC and PGAC documentation from the asphalt cement supplier in the form of a weigh bill or bill of lading, confirming the type and concentration of the AST-AC for each tanker of asphalt cement.

If the AST-AC is added at the HMA plant, the Contract Administrator shall be provided with documentation from the HMA plant confirming the type and concentration of the AST-AC, accompanied by an approved statement of calibration for the metering device and a continuous record of the process prior to placement of mix containing AST-AC for each batch of asphalt cement with AST-AC added.

1151.07.01.02 Aggregate Anti-Stripping Treatments

Aggregate treated and stored from a previous construction season may be used only after the Contract Administrator agrees to a written proposal that verifies the effectiveness of the stored aggregate. The proposal shall include the sampling protocol used and test results from those samples that show that the aggregates meet the moisture sensitivity requirements of this specification.

When hydrated lime or an alternative AST-AGG is used, it shall be added to all aggregates requiring AST by one of the following processes:

a) Blending During Aggregate Production

Hydrated lime or an alternative AST-AGG can be mixed with aggregate at the pit or quarry prior to delivery of the aggregate to the HMA plant. The mixing shall be sufficient to ensure uniform and complete adhesion of the AST-AGG to the aggregate.

b) Blending At the HMA Plant

The AST-AGG may be homogeneously mixed with aggregate prior to entering the dryer at the HMA plant. The HMA plant shall be equipped with suitable pumps, mixers and spray bars for introducing the required quantity of AST-AGG to the aggregates. Mixing shall be accomplished with a pugmill or a drum-type mixer.

Regardless of the process or mixing equipment used, the process shall result in the production of aggregates that are uniformly and homogeneously coated with the quantity of the AST-AGG specified in the Contract Documents, and that are free of clumps and balls prior to entering the dryer at the HMA plant.

1151.07.02 Preparation of the Mixture

Proportioning and mixing of materials shall be of sufficient accuracy and duration to produce a uniform homogeneous mixture in which all particles of the aggregate are thoroughly and uniformly coated.

The maximum temperature of the mixture after it is discharged from the mixing chamber shall not exceed the maximum specified mixing temperature from the mix design by more than 20 °C, to a maximum of 170°C. For WMA, the maximum temperature of the mixture after it is discharged from the mixing chamber shall not exceed the maximum specified mixing temperature of the unmodified asphalt cement by more than 20 °C, to a maximum of 170°C.

TABLE 1
Aggregate Gradation

HMA Type	Percentage Passing by Dry Mass of Aggregates									
	Sieve Size mm									
	50.0	37.5	25.0	19.0	12.5	9.5	4.75	2.36	1.18	0.075
Superpave 4.75	-	-	-	-	100	95-100	90-100	-	30-60	6-12
Superpave 9.5	-	-	-	-	100	90-100	32-90	32-67	-	2-10
Superpave 12.5, 12.5FC 1 and 12.5FC 2	-	-	-	100	90-100	45-90	50-65 (Note 1)	39-58 (Note 1)	-	2-10
Superpave 19.0	-	-	100	90-100	23-90	-	-	23-49	-	2-8
Superpave 25.0	-	100	90-100	19-90	-	-	-	19-45	-	1-7
Superpave 37.5	100	90-100	15-90	-	-	-	-	15-41	-	0-6
SMA 9.5	-	-	-	-	100	70-95	30-50	20-30	(Note 2)	8-12
SMA 12.5	-	-	-	100	90-100	50-80	20-35	16-24		8-11
SMA 19.0	-	-	100	90-100	50-88	25-60	20-28	16-24		8-11

Notes:

1. For mixes that have been identified as coarse graded, the allowable range of percentage by mass passing the 4.75 mm sieve shall be 45-55, and for the 2.36 mm sieve the allowable range will be 28-58.
2. For the SMA 9.5 mm, the maximum percentage passing the 1.18 mm, 0.600 mm, and 0.300 mm sieves is 21, 18, and 15 respectively.

TABLE 2
Superpave Gradation Primary Control Sieve Points

HMA Type	Primary Control Sieve mm	PCS Control Point at % Passing
Superpave 4.75	-	-
Superpave 9.5	2.36	47
Superpave 12.5, 12.5FC 1, and 12.5FC 2	2.36	39
Superpave 19.0	4.75	47
Superpave 25.0	4.75	40
Superpave 37.5	9.5	47

**TABLE 3
Superpave HMA Properties**

Traffic Category (Note 1)	% of Theoretical Maximum Specific Gravity			VMA % minimum						VFA (Note 2) %	Dust to Binder Ratio (Note 3)	Minimum Tensile Strength Ratio %
				Nominal Maximum Aggregate Size mm								
	N _{initial}	N _{design}	N _{max}	37.5	25.0	19.0	12.5	9.5	4.75			
A	≤ 91.5	96.0	≤ 98.0	11.0	12.0	13.0	14.0	15.0	16.0	70-80 (Note 4)	0.6-1.2	80
B	≤ 90.5									65-78		
C	≤ 89.0 (Note 5)									65-75 (Note 6)		
D												
E												

Notes:

1. Traffic category as specified in the Contract Documents.
2. For Traffic categories C, D, and E Superpave 9.5 mixes shall have a VFA range of 73 to 76%, while Superpave 4.75 mixes shall have a VFA range of 75 to 78%.
3. For Superpave 4.75 mixes, the dust-to-binder ratio shall be 0.9 to 2.0. Superpave mixes with gradations that pass beneath the PCS Control Point in Table 2, the dust-to-binder ratio shall be 0.8 to 1.6.
4. For Traffic category A, Superpave 25.0 mixes shall have a VFA range of 67 to 80%.
5. The percent of Theoretical Maximum Specific Gravity at N_{initial} of ≤ 89.5 shall be permitted at the Contractor's option with the understanding that the contractor may be exposed to quality issues related to constructability including, but not limited to, mix tenderness and stability for paving equipment.
6. Superpave 37.5 mixes shall have a VFA range of 64 to 75%.

**TABLE 4
Properties for all SMA Mix Types**

% Air Voids (Note 1)	VMA %	VCA of the Compacted Mixture %	Maximum Draindown at Production Temperature (Note 2) %	Minimum Tensile Strength Ratio %
4.0	17	Less than the VCA in the dry rodded condition.	0.3	70

Notes:

1. SMA mixes shall be designed with 100 gyrations, unless the mix aggregates has an L.A. Abrasion value according to LS-603 of greater than 30%, then the SMA mix shall be designed with 75 gyrations.
2. Tested according to AASHTO T 305.

TABLE 5
SMA Minimum Asphalt Content for
Aggregates With Varying Bulk Specific Gravities

Combined Aggregate Bulk Relative Density	Minimum Asphalt Content Based on Mass, %
2.40	6.8
2.45	6.7
2.50	6.6
2.55	6.5
2.60	6.3
2.65	6.2
2.70	6.1
2.75	6.0
2.80	5.9
2.85	5.8
2.90	5.7
2.95	5.6
3.00	5.5

TABLE 6
Maximum Reclaimed Asphalt Pavement Content

Traffic Category (Note 1)	Binder Course 150 mm or More Below Pavement Surface	Binder Course Within 150 mm of Pavement Surface	Surface Course Excluding SMA Surface Mixes	SMA Surface Course (Note 2)
A, B	40%	40%	20%	0%
C, D	40%	20%	20%	0%
E	40%	20%	20%	0%

Notes:

1. Traffic category as specified in the Contract Documents.
2. The use of up to 3% RST by mass of mix is permitted in SMA surface course.
3. 0.10% RST may be substituted for each 1.0% RAP permitted in the mix.

TABLE 7
One Point Mix Check Requirements

Mix and Aggregate Property	Requirements
Gradation of component aggregates	For information only
Bulk Relative Density (BRD) of (blended) coarse aggregate and (blended) fine aggregate, and the resulting BRD of the combined aggregate	For information only
Bulk Relative Density and Maximum Relative Density of Mix	For information only
Air voids at N_{design}	$\pm 0.5\%$ from submitted mix design
VMA	$\pm 1.0\%$ from submitted mix design and not less than contract design minimum
VFA	Within specified mix design range
% G_{mm} at N_{initial}	Not more than contract design maximum
% G_{mm} at N_{max}	Not more than contract design maximum
Dust Proportion	Within specified mix design range
Tensile Strength Ratio	Not less than 0.8

TABLE 8
Sample Quantities for Mix Design Monitoring

Material	Quantity (Note 1)
Asphalt cement	4 litres evenly split between 2 containers
Aggregate	75 to 100 kg of each type
RAP	75 to 100 kg required when RAP contained in the mix
Fines material passing 75 μm sieve	5 to 10 kg when the mix is to be produced with a plant that returns fines to the mixture
Mineral Filler	5 to 10 kg sample for SMA mixes
RST	10 to 15 kg required when RST contained in the mix
Any other material samples including anti-stripping agents and fibres to be used in HMA	Quantity large enough to allow for a complete mix design
Note: 1. Each material sample receptacle shall have a maximum mass of 30 kg.	

TABLE 9
Requirements for Roof Shingle Tabs

Contents		Requirement
Percent Cellulose or Mineral Fibres by Mass of RST		15-25
Percent Asphalt Cement Content Based on Mass (Note 1)		20-30
Percentage Passing by Dry Mass of Aggregate (Note 2)	9.5 mm sieve	100
	4.75 mm sieve	90-100
	600 µm sieve	45-60
	75 µm sieve	15-25
Notes: 1. Asphalt cement recovered from the RST shall have a minimum penetration of 18 dmm according to LS-200 and LS-284. 2. As determined according to LS-282 or LS-292.		

Appendix 1151-A, Commentary for OPSS.PROV 1151, November 2016

Note: This appendix does not form part of the standard specification. It is intended to provide information to the designer on the use of this specification in the Contract.

Designer Action/Considerations

No information provided here.

Related Ontario Provincial Standard Drawings

No information provided here.



MATERIAL SPECIFICATION FOR SC-800 PATCHING MATERIAL

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APPENDICES

1152-A	COMMENTARY
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1152.01	SCOPE
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This specification covers the requirements for the manufacturing of SC-800 patching material.

1152.01.01 Specification Significance and Use

This specification is written as a provincial-oriented specification. Provincial-oriented specifications are developed to reflect the administration, testing, and payment policies, procedures, and practices of the Ontario Ministry of Transportation.

Use of this specification or any other specification shall be according to the Contract Documents.

1152.01.02 Appendices Significance and Use

Appendices are not for use in provincial contracts as they are developed for municipal use, and then, only when invoked by the Owner.

Appendices are developed for the Owner's use only.

Inclusion of an appendix as part of the Contract Documents is solely at the discretion of the Owner. Appendices are not a mandatory part of this specification and only become part of the Contract Documents as the Owner invokes them.

Invoking a particular appendix does not obligate an Owner to use all available appendices. Only invoked appendices form part of the Contract Documents.

The decision to use any appendix is determined by an Owner after considering their contract requirements and their administrative, payment, and testing procedures, policies, and practices. Depending on these considerations, an Owner may not wish to invoke some or any of the available appendices.

1152.02 REFERENCES

When the Contract Documents indicate that provincial-oriented specifications are to be used and there is a provincial-oriented specification of the same number as those listed below, references within this specification to an OPSS shall be deemed to mean OPSS.PROV, unless use of a municipal-oriented specification is specified in the Contract Documents. When there is not a corresponding provincial-oriented specification, the references below shall be considered to be to the OPSS listed, unless use of a municipal-oriented specification is specified in the Contract Documents.

This specification refers to the following standards, specifications, or publications:

Ontario Provincial Standard Specifications, Material

OPSS 1003	Aggregates - Hot Mix Asphalt
OPSS 1102	Liquid Asphalt
OPSS 1151	Superpave and Stone Mastic Asphalt Mixtures

Ontario Ministry of Transportation Publications

MTO Laboratory Testing Manual:

LS-282	Method of Test for Quantitative Extraction of Asphalt Cement and Analysis of Extracted Aggregate from Bituminous Paving Mixtures
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1152.03 DEFINITIONS

For the purpose of this specification, the following definition applies:

SC-800 Patching Material means a mixture of SC-800 liquid asphalt and mineral aggregate for patching holes, depressions, and distressed areas in existing pavements.

1152.04 DESIGN AND SUBMISSION REQUIREMENTS

1152.04.01 Design Requirements

The SC-800 patching material mixture composition selected shall meet all the requirements of this specification and shall maintain its effective properties in stockpile for a minimum period of eight months from the date of supply.

1152.04.02 Submission Requirements

The SC-800 patching material mixture composition shall be submitted to the Contract Administrator 7 Days before the start of production. The following items shall also be included in the submission:

- a) The SC-800 supplier, facility type, and location from which the SC-800 is being supplied.
- b) Test results for the SC-800 that demonstrate compliance to the requirements of the Liquid Asphalt subsection.
- c) The aggregate supplier and location from which the aggregates are being supplied.
- d) Type of aggregate and test results for the aggregates that demonstrate compliance to the requirements of the Aggregates subsection.
- e) Percent of SC-800 in the mixture, by mass, and test results that demonstrate compliance to the requirements of the Composition of Mixture subsection.
- f) Residual asphalt content, percent by mass of SC-800 patching mixture, when tested according to LS-282, in the mixture.

1152.05 MATERIALS

1152.05.01 Liquid Asphalt

The liquid asphalt shall be SC-800 and shall be according to OPSS 1102.

1152.05.02 Aggregates

The aggregates for SC-800 patching material shall be according to the requirements for Superpave 12.5 as specified in OPSS 1003.

1152.05.03 Composition of Mixture

The patching mixture shall contain between 4.0 and 6.0% of SC-800 by mass. The mixture shall be according to the gradation limits specified for Superpave 12.5 in OPSS 1151.

1152.07 PRODUCTION

1152.07.01 Preparation of Liquid Asphalt

The SC-800 liquid asphalt shall be heated at the asphalt plant to a temperature of $105^{\circ}\text{C} \pm 10^{\circ}\text{C}$.

1152.07.02 Preparation of Mixture

The mixture shall be prepared according to OPSS 1151 except that the discharge temperature of the mixture shall be $105\text{ }^{\circ}\text{C} \pm 10\text{ }^{\circ}\text{C}$.

1152.07.03 Tolerances

The test results according to LS-282 shall indicate that the composition of the mixture meets the following tolerances with respect to the submitted mixture composition:

SC-800, Residual: $\pm 0.3\%$

Retained 4.75 mm sieve: $\pm 5.0\%$

Passing 75 μm sieve: $\pm 2.0\%$

Appendix 1152-A, November 2016
FOR USE WHILE DESIGNING MUNICIPAL CONTRACTS

Note: This is a non-mandatory Commentary Appendix intended to provide information to a designer, during the design stage of a contract, on the use of the OPS specification in a municipal contract. This appendix does not form part of the standard specification. Actions and considerations discussed in this appendix are for information purposes only and do not supersede an Owner's design decisions and methodology.

Designer Action/Considerations

No information provided here.

Related Ontario Provincial Standard Drawings

No information provided here.



**MATERIAL SPECIFICATION FOR
EMULSIFIED ASPHALT PATCHING MATERIAL**

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1153.06	EQUIPMENT – Not Used
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1153.08	QUALITY ASSURANCE - Not Used
1153.09	OWNER PURCHASE OF MATERIAL - Not Used

APPENDICES

1153-A	Commentary
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1153.01	SCOPE
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This specification covers the requirements for the manufacturing of emulsified asphalt patching material.

1153.01.01 Specification Significance and Use

This specification is written as a provincial-oriented specification. Provincial-oriented specifications are developed to reflect the administration, testing, and payment policies, procedures, and practices of the Ontario Ministry of Transportation.

Use of this specification or any other specification shall be according to the Contract Documents.

1153.01.02 Appendices Significance and Use

Appendices are not for use in provincial contracts as they are developed for municipal use, and then, only when invoked by the Owner.

Appendices are developed for the Owner's use only.

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The decision to use any appendix is determined by an Owner after considering their contract requirements and their administrative, payment, and testing procedures, policies, and practices. Depending on these considerations, an Owner may not wish to invoke some or any of the available appendices.

1153.02 REFERENCES

When the Contract Documents indicate that provincial-oriented specifications are to be used and there is a provincial-oriented specification of the same number as those listed below, references within this specification to an OPSS shall be deemed to mean OPSS.PROV, unless use of a municipal-oriented specification is specified in the Contract Documents. When there is not a corresponding provincial-oriented specification, the references below shall be considered to be to the OPSS listed, unless use of a municipal-oriented specification is specified in the Contract Documents.

This specification refers to the following standards, specifications, or publications:

Ontario Provincial Standard Specifications, Material

OPSS 1003 Aggregates - Hot Mix Asphalt
OPSS 1151 Superpave and Stone Mastic Asphalt Mixtures

Ontario Ministry of Transportation Publications

MTO Laboratory Testing Manual:
LS-282 Method of Test for Quantitative Extraction of Asphalt Cement and Analysis of Extracted
Aggregate from Bituminous Paving Mixtures

1153.04 DESIGN AND SUBMISSION REQUIREMENTS

1153.04.01 Design Requirements

The emulsified asphalt patching material mixture composition selected shall meet all of the requirements of this specification and shall maintain its effective properties in stockpile for a minimum period of eight months from the date of supply.

1153.04.02 Submission Requirements

The emulsified asphalt patching material mixture composition shall be submitted to the Contract Administrator 7 Days before the start of the production. The following items shall also be included in the submission:

- a) Type and grade of asphalt emulsion, supplier and facility type and location from which the asphalt emulsion is being supplied.
- b) Test results for the asphalt emulsion that demonstrate compliance to the requirements of the Asphalt Emulsion subsection.
- c) The aggregate supplier and location from which the aggregates are being supplied.
- d) Type of aggregate and test results for the aggregate that demonstrate compliance to the requirements of the Aggregates and Composition of Emulsified Asphalt Patching Materials subsections.
- e) Percent of residual asphalt content, percent by mass of patching mixture, when tested according to LS-282, in the mixture demonstrating compliance to the requirements of the Composition of the Mixture subsection.

1153.05 MATERIALS

1153.05.01 Asphalt Emulsion

The asphalt emulsion type for emulsified asphalt patching material shall be selected to ensure compatibility with the aggregates to be used.

1153.05.02 Aggregates

Aggregates for emulsified asphalt patching material shall consist of a blend of coarse and fine aggregate such that not less than 85% of the portion passing a 4.75 mm sieve is natural sand.

The aggregates for emulsified asphalt patching material shall consist of clean, hard, durable particles according to the physical requirements for Superpave 12.5 as specified in OPSS 1003.

1153.05.03 Composition of Emulsified Asphalt Patching Material

The patching mixture shall contain between 3.7 to 5.5% residual asphalt content by mass. The percent residual asphalt shall be expressed as a percentage of the total mix.

Gradation of aggregates used in the patching mixture shall be according to the gradation limits specified in Table 1.

1153.07 PRODUCTION

1153.07.01 Composition of the Mixture

The mineral aggregates and asphalt emulsion shall be combined and mixed to provide a uniformly coated and homogeneous product according to Table I.

1153.07.02 Preparation of the Mixture

Emulsion temperature: 20 - 60 °C

Mix temperature as discharged from the plant: As specified by the emulsion supplier

Mixing cycle: 40 - 60 seconds

TABLE 1
Gradation of the Mixture

MTO Sieve Designation	Percentage Passing By Mass
16.0 mm	100
13.2 mm	98 - 100
9.5 mm	85 - 100
4.75 mm	50 - 85
2.36 mm	35 - 65
1.18 mm	25 - 50
600 µm	15 - 40
300 µm	7 - 25
150 µm	2 - 13
75 µm	0 - 7

Appendix 1153-A, November 2016
FOR USE WHILE DESIGNING MUNICIPAL CONTRACTS

Note: This is a non-mandatory Commentary Appendix intended to provide information to a designer, during the design stage of a contract, on the use of the OPS specification in a municipal contract. This appendix does not form part of the standard specification. Actions and considerations discussed in this appendix are for information purposes only and do not supersede an Owner's design decisions and methodology.

Designer Action/Considerations

No information provided here.

Related Ontario Provincial Standard Drawings

No information provided here.



**ONTARIO
PROVINCIAL
STANDARD
SPECIFICATION**

**METRIC
OPSS.PROV 1202
NOVEMBER 2016**

**MATERIAL SPECIFICATION FOR
BEARINGS - ELASTOMERIC PLAIN AND STEEL LAMINATED**

TABLE OF CONTENTS

1202.01	SCOPE
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1202.05	MATERIALS
1202.06	EQUIPMENT - Not Used
1202.07	PRODUCTION
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1202.09	OWNER PURCHASE OF MATERIAL – Not Used

APPENDICES

1202-A	Commentary
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1202.01	SCOPE
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This specification covers the requirements for Materials, design, and fabrication of plain and steel-laminated elastomeric bearings for bridges and for approach slab bearings and ballast wall bearings.

1202.01.01 Specification Significance and Use

This specification is written as a provincial-oriented specification. Provincial-oriented specifications are developed to reflect the administration, testing, and payment policies, procedures, and practices of the Ontario Ministry of Transportation.

Use of this specification or any other specification shall be according to the Contract Documents.

1202.01.02 Appendices Significance and Use

Appendices are not for use in provincial contracts as they are developed for municipal use, and then, only when invoked by the Owner.

Appendices are developed for the Owner's use only.

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The decision to use any appendix is determined by an Owner after considering their Contract requirements and their administrative, payment, and testing procedures, policies, and practices. Depending on these considerations, an Owner may not wish to invoke some or any of the available appendices.

1202.02 REFERENCES

When the Contract Documents indicate that provincial-oriented specifications are to be used and there is a provincial-oriented specification of the same number as those listed below, references within this specification to an OPSS shall be deemed to mean OPSS.PROV, unless use of a municipal-oriented specification is specified in the Contract Documents. When there is not a corresponding provincial-oriented specification, the references below shall be considered to be to the OPSS listed, unless use of a municipal-oriented specification is specified in the Contract Documents.

This specification refers to the following standards, specifications, or publications:

Ontario Ministry of Transportation Publications

Laboratory Testing Manual:

LS-427	Method of Test for Compressive Deformation of Plain Bearings
LS-428	Method of Test for Compressive Deformation of Laminated Bearings
LS-429	Method of Test for Parallelism of Steel Laminates of Laminated Bearings

Structural Manual:

Division 1 - Exceptions to the Canadian Highway Bridge Design Code CAN/CSA S6 for Ontario

CSA Standards

S6-14	Canadian Highway Bridge Design Code
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ASTM International

D 395-16	Standard Test Methods for Rubber Property - Compression Set
D 412-15a	Standard Test Methods for Vulcanized Rubber and Thermoplastic Elastomers - Tension
D 429-14	Standard Test Methods for Rubber Property - Adhesion to Rigid Substrates
D 573-04 (2015)	Standard Test Method for Rubber - Deterioration in an Air Oven
D 1149-16	Standard Test Method for Rubber Deterioration - Cracking in an Ozone Controlled Environment
D 2240-15	Standard Test Method for Rubber Property - Durometer Hardness
D 4014-03 (2012)	Standard Specification for Plain and Steel-Laminated Elastomeric Bearings for Bridges

American Association of State Highway and Transportation Officials (AASHTO)

M251-06 (2016) Plain and Laminated Elastomeric Bridge Bearings

1202.03 DEFINITIONS

For the purpose of this specification, the following definitions apply:

Effective Elastomer Thickness means the sum of the thickness of all layers of elastomer, excluding outer layers of laminated bearings.

Elastomer means a compound containing virgin natural polyisoprene (natural rubber) or virgin polychloroprene (neoprene).

Laminated Bearing means a bearing composed of elastomer laminates separated by and fully bonded to steel plates.

Plain Bearing means a bearing, which consists wholly of elastomer.

Plan Dimension means the dimensions of an object, when viewed perpendicular to the top of the object.

Proposal means a Contractor's submission for which engineering design is required that provides a written:

- a) Alternative to requirements specified by the Owner in the Contract Documents;
- b) Course of action or undertaking by the Contractor as delegated by the Owner in the Contract Documents.

1202.04 DESIGN AND SUBMISSION REQUIREMENTS

1202.04.01 Design Requirements

1202.04.01.01 Design

The bearings, including any fasteners or dowels, shall be designed according to CAN/CSA S6 and the Structural Manual, Division 1.

1202.04.01.02 Elastomer Thickness

The effective elastomer thickness for plain bearings shall be greater than or equal to 15 mm and less than or equal to 25 mm.

1202.04.01.03 Steel Thickness

The thickness of the internal steel plates for laminated bearings shall be greater than 3 mm and less than 5 mm.

1202.04.02 Submission Requirements

1202.04.02.01 General

Within 30 Days of the Contract award, the name and address of the supplier and manufacturer of the bearings shall be submitted in writing to the Contract Administrator.

Proposals shall bear the seal and signature of the design and checking Engineers.

When another authority is involved, all submissions shall be made a minimum of 5 weeks prior to the commencement of work.

1202.04.02.02 Working Drawings

At least 1 week prior to commencement of bearing fabrication, 1 hardcopy set and 1 electronic PDF copy of Working Drawings for the bearings shall be submitted to the Contract Administrator for information purposes only. An Engineer shall affix his or her seal and signature on the Working Drawings verifying that the drawings are consistent with the Contract Documents and sound engineering practices.

A sealed and signed copy of these drawings shall be kept on site prior to and during the installation of the bearings.

These drawings shall clearly indicate the following:

- a) Specified bearing design data (Dead Load and Total Load at SLS and ULS, movement at SLS, rotation at SLS).
- b) The number and thickness of internal steel plates.
- c) Compressive stiffness.
- d) Shear stiffness at 20 °C and -40° C.
- e) Bearing alphanumeric identification.

1202.04.02.03 Manufacturer's Certification

Upon completion of fabrication and prior to installation of the bearings, with the exception of approach slab bearings and ballast wall bearings, a certificate of compliance signed by the manufacturer, shall be submitted to the Contract Administrator. The certificate of compliance shall include test results according to Table 1 and shall state that the fabricated bearings are according to the Working Drawings and Contract Documents.

1202.05 MATERIALS

1202.05.01 General

Reclaimed material shall not be incorporated in the finished bearing.

1202.05.02 Materials for Elastomeric Plain and Steel Laminated Bearings

1202.05.02.01 Steel

Internal steel plates for laminated bearings shall be rolled mild steel with a minimum yield strength of 230 MPa.

1202.05.02.02 Elastomers

Elastomers shall be according to the following:

- a) Virgin natural polyisoprene or virgin polychloroprene elastomer shall be the only raw polymers permitted.
- b) The physical properties of any polyisoprene and polychloroprene used shall be according to the requirements of Table 1.

1202.05.02.03 Compressive Deformation

Compressive deformation of laminated elastomeric bearings shall not exceed 0.05 of the effective elastomer thickness when tested according to LS-428 and this specification.

Compressive deformation of plain elastomeric bearings shall not exceed 0.06 of the effective elastomer thickness when tested according to LS-427 and this specification.

1202.05.03 Approach Slab Bearings and Ballast Wall Bearings

The physical properties of elastomer used for the manufacture of approach slab bearings or ballast wall bearings shall be according to the following:

- a) Hardness, when tested according to ASTM D 2240 shall be 55 ± 5 Shore A.
- b) Minimum tensile strength shall be 15 MPa, when tested according to ASTM D 412, Method A.
- c) Minimum ultimate elongation shall be 400%, when tested according to ASTM D 412, Method A.

1202.07 PRODUCTION

1202.07.01 Plain Bearings

Plain bearing pads shall be moulded individually, cut from moulded strips or slabs of the required thickness, or extruded and cut to length.

1202.07.02 Laminated Bearings

Laminated bearings shall be moulded under pressure as a single unit and heated in moulds that have a smooth surface finish.

Steel plates shall be according to the following:

- a) All steel plates shall be of uniform thickness.
- b) Internal steel plates shall be free from sharp edges.
- c) Steel plates shall be completely bonded on all surfaces to the elastomeric material during molding. The cover on the vertical side surfaces shall be 6 mm. The cover on the top and bottom surfaces shall be 5 mm, except that no cover is required over pintle holes.
- d) When pintles are specified in the Contract Documents, the depth of pintle holes shall be such that the pintle engages only one steel plate through the entire thickness of the plate.

Elastomer laminates shall be of uniform thickness.

1202.07.03 Identification

Each laminated elastomeric bearing shall be marked with the date of manufacture (i.e., yyyy-mm-dd) and an individual alphanumeric identification. The alphanumeric identification shall consist of the designated identification letter of the supplier and source followed by the letter I for polyisoprene or C for polychloroprene and a five-digit number. Bearings shall be sequentially numbered. The characters shall be not less than 10 mm in height, stamped or engraved into two adjacent sides, with the indentations or protrusions not less than 1 mm in width and 1 mm in depth.

Plain, approach slab and ballast wall bearings shall be marked every 1 m with the name of manufacturer, the date of manufacture, and the lot number.

1202.07.04 Tolerances

Bearing thickness ≤ 40 mm	0 to + 3 mm
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Bearing thickness > 40 mm	0 to + 6 mm
-----------------------------	-------------

Bearing plan dimension	0 to + 6 mm
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Thickness of individual layers of elastomer	$\pm 20\%$
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Deviation from plane parallel to theoretical surface:

Top and bottom	1 in 200
Sides	1 in 100

Steel laminates tested according to LS-429.	$0.25 T_e$
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Cover to embedded steel on vertical side surfaces	-1 to + 4 mm
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Cover to embedded steel on top and bottom surfaces	-1 to +2 mm
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Pintle hole diameter	0 to + 2 mm
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Position of pintle holes relative to each other	± 2 mm
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1202.08 QUALITY ASSURANCE

1202.08.01 General

Bearings shall be acceptable if they meet the requirements of this specification.

12.02.08.02 Acceptance of Physical Properties of Elastomers for Laminated and Plain Bearings

Bearing physical properties shall be acceptable if they meet the requirements of Table 1 of this specification.

1202.08.02.01 Retesting of Physical Properties of Elastomers for Laminated and Plain Bearing

The Contractor may request, in writing, retesting the physical properties of elastomers for any sample within five Business Days of receiving notification of rejection of the lot. Retesting shall be done on the remaining piece of sample representing the failed acceptance test result. The results of the retest shall be used for acceptance determination and shall be binding on both parties. If the retesting results in rejection of the lot, the Contractor shall bear the cost of the retesting. If the retesting results in the material passing all test criteria, the retesting charge shall be paid by the Owner.

1202.08.03 Acceptance of Compressive Deformation

1202.08.03.01 Compressive Deformation of Laminated Bearings

The method of testing bearings shall be according to LS-428. The increment in compressive deformation of laminated bearings shall not exceed 0.05 of the effective rubber thickness, when the bearing load is increased from an initial pressure of 1.5 MPa to a pressure of 7 MPa.

1202.08.03.02 Compressive Deformation of Plain Bearings

The method of testing of plain bearings shall be according to LS-427. The increment in compressive deformation of plain bearings shall not exceed 0.06 of the thickness of the bearing when the bearing load is increased from an initial pressure of 20% of the average pressure to the average pressure, and not greater than 7 MPa.

1202.08.03.03 Compressive Deformation Retesting

The Contractor may request, in writing, retesting of compressive deformation within five Business Days of receiving notification of rejection of the lot. Retesting shall be done on the same sample. The results of the retest shall be used for acceptance determination and shall be binding on both parties. If the retesting results in rejection of the lot, the Contractor shall bear the cost of the retesting. If the retesting results in the material passing all test criteria, the retesting charge shall be paid by the Owner.

1202.08.04 Acceptance of Approach Slab Bearings and Ballast Wall Bearings

Approach slab bearings and ballast wall bearings shall be acceptable if properties meet the requirements of this specification.

TABLE 1
Physical Requirements for Polyisoprene and Polychloroprene

Property	Test	Requirements	
		Polyisoprene	Polychloroprene
Shear modulus G_{RT} , MPa @ 20 °C (Note 1)	ASTM D 4014, Annex A1, as modified by AASHTO M251	0.80 ± 0.15	0.80 ± 0.15
Shear modulus G_{LT} , MPa @ - 40 °C (Note 2)	ASTM D 4014, Annex A1, as modified by AASHTO M251	Not more than 3 times the value at room temperature $G_{LT} \leq 3 G_{RT}$	Not more than 3 times the value at room temperature $G_{LT} \leq 3 G_{RT}$
Tensile strength, MPa	ASTM D 412, Method A	minimum 17.0	minimum 17.0
Ultimate elongation, %	ASTM D 412, Method A	minimum 400	minimum 400
Heat resistance	ASTM D 573	70 h at 70 °C	70 h at 100 °C
Change in hardness, Shore A	ASTM D 2240	maximum + 10	maximum + 15
Change in tensile strength, %	ASTM D 412, Method A	maximum - 25	maximum - 15
Change in ultimate elongation, %	ASTM D 412, Method A	maximum - 25	maximum - 40
Compression set, % (Note 3)	ASTM D 395, Method B	22 h at 70 °C maximum 25	22 h at 100 °C maximum 35
Ozone Resistance	ASTM D 1149, Method B, Procedure B1 20% strain, 40 ± 2 °C	25 pphm, 48 h no cracks	100 pphm, 100 h no cracks
Peel bond test, N/mm	ASTM D 429, Method B	minimum 7.0	minimum 7.0
Note: 1. Shear Modulus shall be determined at ambient temperature in accordance with ASTM D 4014 Annex A1 modified as follows: the initial cycles shall be taken to a strain of 0.7 and on the last cycle the shear modulus shall be determined at 0.5 strain. 2. Shear Modulus testing shall be performed with the test specimen in an enclosed freezer unit capable of maintaining the specified conditioning temperature. A ± 25 percent strain cycle shall be applied for a period of 100 seconds. The first three-quarter cycle of strain shall be discarded and the stiffness shall be determined by the slope of the force deflection curve for the next half cycle of loading. 3. All test specimens of steel laminated bearings used for compression set test ASTM D 395, Method B, shall be prepared from the representative bearing pads and may consist of a single layer or multiple layers of elastomer.			

Appendix 1202-A, November 2016
FOR USE WHILE DESIGNING MUNICIPAL CONTRACTS

Note: This is a non-mandatory Commentary Appendix intended to provide information to a designer, during the design stage of a contract, on the use of the OPS specification in a municipal contract. This appendix does not form part of the standard specification. Actions and considerations discussed in this appendix are for information purposes only and do not supersede an Owner's design decisions and methodology.

Designer Action/Considerations

No information provided here.

Related Ontario Provincial Standard Drawings

No information provided here.



**MATERIAL SPECIFICATION FOR
BEARINGS-ROTATIONAL AND SLIDING SURFACE**

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1203.01 SCOPE

This specification covers the requirements for Materials, design, and fabrication of rotational and sliding surface bearings for bridges.

1203.01.01 Specification Significance and Use

This specification is written as a provincial-oriented specification. Provincial-oriented specifications are developed to reflect the administration, testing, and payment policies, procedures, and practices of the Ontario Ministry of Transportation.

Use of this specification or any other specification shall be according to the Contract Documents.

1203.01.02 Appendices Significance and Use

Appendices are not for use in provincial contracts as they are developed for municipal use, and then, only when invoked by the Owner.

Appendices are developed for the Owner's use only.
Inclusion of an appendix as part of the Contract Documents is solely at the discretion of the Owner.

Appendices are not a mandatory part of this specification and only become part of the Contract Documents as the Owner invokes them.

Invoking a particular appendix does not obligate an Owner to use all available appendices. Only invoked appendices form part of the Contract Documents.

The decision to use any appendix is determined by an Owner after considering their contract requirements and their administrative, payment, and testing procedures, policies, and practices. Depending on these considerations, an Owner may not wish to invoke some or any of the available appendices.

1203.02 REFERENCES

When the Contract Documents indicate that provincial-oriented specifications are to be used and there is a provincial-oriented specification of the same number as those listed below, references within this specification to an OPSS shall be deemed to mean OPSS.PROV, unless use of a municipal-oriented specification is specified in the Contract Documents. When there is not a corresponding provincial-oriented specification, the references below shall be considered to be to the OPSS listed, unless use of a municipal-oriented specification is specified in the Contract Documents.

This specification refers to the following standards, specifications, or publications:

Ontario Provincial Standard Specifications, Construction

OPSS 911 Coating Structural Steel

Ontario Provincial Standard Specifications, Material

OPSS 1202 Bearings - Elastomeric Plain and Steel-Laminated

Ontario Ministry of Transportation Publications

Structural Manual:
Division 1, Exceptions to the Canadian Highway Bridge Design Code CAN/CSA S6 for Ontario

CSA Standards

B95-1962 (R2002)	Surface Texture (Roughness, Waviness and Lay)
G40.20-13/40.21-13	General Requirements for Rolled or Welded Structural Quality Steel /Structural Quality Steel
S6-14	Canadian Highway Bridge Design Code
S157-05 (R2015)	Strength Design in Aluminium
W48-14	Filler Metals and Allied Materials for Metal Arc Welding
W59-13	Welded Steel Construction (metal Arc Welding)

ASTM International

A 240/A 240M-16	Standard Specification for Chromium and Chromium-Nickel Stainless Steel Plate, Sheet and Strip for Pressure Vessels and for General Applications
B 36/B 36M-13	Standard Specification for Brass Plate, Sheet, Strip, and Roller Bar
B 137-95(2014)	Standard Test Method for Measurement of Coating Mass Per Unit Area on Anodically Coated Aluminium
B 487-85(2013)	Standard Test Method for Measurement of Metal and Oxide Coating Thickness by Microscopical Examination of a Cross Section
D 395-16	Standard Test Method for Rubber Property - Compression Set
D 412-15a	Standard Test Methods for Vulcanized Rubber and Thermoplastic Elastomers - Tension
D 429-14	Standard Test Methods for Rubber Property - Adhesion to Rigid Substrates
D 638-14	Standard Test Method for Tensile Properties of Plastics
D 792-13	Standard Test Methods for Density and Specific Gravity (Relative Density) of Plastics by Displacement
D 2240-15	Standard Test Method for Rubber Property - Durometer Hardness
D 4894-15	Standard Specification for Polytetrafluoroethylene (PTFE) Granular Molding and Ram Extrusion Materials
F 2329/F 2329M-15	Standard Specification for Zinc Coating, Hot-Dip, Requirements for Application to Carbon and Alloy Steel Bolts, Screws, Washers, Nuts, and Special Threaded Fasteners
F 3125/F 3125M-15a	Standard Specification for High Strength Structural Bolts, Steel and Alloy Steel, Heat Treated, 120 ksi (830 MPa) and 150 ksi (1040 MPa) Minimum Tensile Strength, Inch and Metric Dimensions

American National Standards Institute (ANSI)

B4.1-1967 (R2009)	Preferred Limits and Fits for Cylindrical Parts
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U.S. Military Specifications

SAE AS 8660	Silicone Compound Nato Code Number S-736
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1203.03

DEFINITIONS

For the purpose of this specification, the following definitions apply:

Disc Bearing means a bearing consisting of a single moulded disc of unreinforced elastomer confined by upper and lower steel bearing plates and restricted from horizontal movement by limiting rings and a centrally located shear restriction mechanism.

Elastomer means a compound containing virgin natural polyisoprene (natural rubber) for confined elastomeric bearings or polyether urethane polymer for disc bearings.

Plan Dimension means the dimensions of an object, when viewed perpendicular to the top of the object.

Pot Bearing means a bearing consisting of a metal piston supported by a single moulded disc of unreinforced elastomer that is confined within a metal cylinder.

Product Drawings means drawings prepared by the manufacturer that have been approved by the Owner for use with the product.

Proposal means a Contractor's submission for which engineering design is required that provides a written:

- a) Alternative to requirements specified by the Owner in the Contract Documents;
- b) Course of action or undertaking by the Contractor as delegated by the Owner in the Contract Documents.

PTFE means polytetrafluoroethylene polymer.

Spherical Bearing means a bearing consisting of a curved spherical metal surface in contact with and sliding on a matching curved polytetrafluoroethylene polymer (PTFE) surface.

Substructure means the abutments, piers, columns, and other components of a bridge below the bearings.

Superstructure means all parts of a bridge above the bearings.

1203.04 DESIGN AND SUBMISSION REQUIREMENTS

1203.04.01 Design Requirements

1203.04.01.01 Design

All components of the bearings, including fasteners, shall be designed according to the requirements of the CAN/CSA S6 and Structural Manual, Division 1.

Bearings subject to uplift shall limit the separation of the bearing components to the value specified in the Contract Documents.

1203.04.01.02 Translations and Rotation

Provision for rotation about any horizontal axis shall be by means of a single disc of confined elastomer for pot bearings, a single disc of polyether urethane polymer compound for disc bearings, and a spherical sliding surface of stainless steel or anodized aluminium alloy against PTFE for spherical bearings.

The rotational capacity about any horizontal axis shall be the rotation caused by ultimate limit states loads plus 1.2°.

The rotational capacity about the vertical axis through the centre of the bearing shall be $\pm 1^\circ$.

Brass sealing rings shall have a rectangular cross-section.

The depth of the pot wall shall be such that a minimum vertical distance of 2.5 mm remains between the top of the pot wall and the closest point of contact of the sealing rings with the pot wall upon rotating the piston about any horizontal axis to the maximum rotation at ultimate limit states (ULS) plus 1.2°.

The pot and piston surfaces in contact with the confined elastomer shall be lubricated with silicone grease. The bearing shall be sealed by a one-piece continuous preformed closed-cell compressible ring against entry of dirt, dust, and moisture between the elastomer and the pot and piston contact surfaces. Any joint in the ring shall be bonded and the strength shall be at least equal to the strength of the ring.

For disc bearings, the upper and lower plates in contact with the elastomer shall be provided with outer limiting rings to restrict the horizontal movement of the elastomer and a centrally located shear restriction mechanism.

1203.04.01.03 Sliding Surfaces

1203.04.01.03.01 Geometric Requirements

The metal surface shall overlap the PTFE by at least 5 mm at extremes of movement. The metal surface shall be positioned above the PTFE element except for guides for lateral restraint.

1203.04.01.03.02 Polytetrafluoroethylene Polymer Layer

Except when used as mating surfaces for guides for lateral restraint, the PTFE resin shall be virgin material and shall be used as unfilled sheets and shall contain spherical reservoirs for lubricant pressed into its surface.

Material used as mating surface for guides for lateral restraint shall not be dimpled or lubricated.

1203.04.01.03.03 Lubrication

All PTFE surfaces except those that act as mating surfaces for guides for lateral restraint or that are subject to a contact pressure of less than 5 MPa shall be permanently lubricated with silicone grease.

1203.04.01.03.04 Contact Pressure

The average contact pressure at serviceability limit state loads for filled PTFE elements used to face mating surfaces for guides for lateral restraint shall not exceed the following:

- a) PTFE filled with up to 15% by mass of glass fibres, 45 MPa.
- b) Lead filled PTFE in a bronze matrix, 60 MPa.

1203.04.01.04 Guides for Lateral Restraint

Unless the guide bars are machined to form an integral part of the top plate, they shall be recessed not less than 5 mm into the plate to which they are attached and fastened with bolts.

The translational elements of guides for lateral restraint shall be faced with stainless steel and shall provide lateral restraint by sliding against mating surfaces faced with PTFE. Lead filled PTFE shall be at least 2 mm thick and shall be mechanically fastened and bonded to the substrate. Glass filled or virgin PTFE shall be recessed and bonded to the substrate.

1203.04.01.05 Top and Base Plates

The top and base plates that are permanently attached to the structure shall be provided with the bearings.

1203.04.01.06 Fasteners and Anchorage

Fasteners used to attach the bearing to the top and base plates and the anchorage devices shall be capable of resisting lateral loads specified in the bearing design data tables contained in the Contract Documents.

The beneficial effect of friction shall be neglected in proportioning the fasteners and anchors.

1203.04.01.07 Bearing Assembly Replacement

The entire bearing assembly, except for the top plate used to attach it to the superstructure and the base plate used to anchor it to the substructure but including both contact surfaces of the sliding interface, shall be replaceable without damage to the structure and without removal of any concrete, welds, or anchorages permanently attached to the structure and without lifting the superstructure more than 5 mm. Bearings shall not be recessed into plates that are permanently attached to the structure.

1203.04.01.08 Durability

Bearings shall be designed to prevent moisture and dirt from entering the internal surfaces.

Contact between dissimilar metals that could have corrosion potential and between the aluminium alloy and concrete shall be prevented by use of suitable insulation.

1203.04.01.09 Concrete Bearing Pressure

For bearings subject to compressive loading, the top plate and the base plate shall be designed to ensure the average concrete bearing pressure does not exceed 24 MPa at the ultimate limit states providing the following:

- a) Concrete on which the plate is supported has a specified nominal 28-Day compressive strength of at least 30 MPa.
- b) Edges of the plates are located a minimum of 100 mm from the edge of the concrete.
- c) The largest dimension of plate does not exceed 1 000 mm.

Alternatively, the top plate and the base plate of the bearing shall be designed to ensure the factored bearing resistance of concrete specified in CAN/CSA S6 and the Structural Manual, Division 1, is not exceeded.

1203.04.02 Submission Requirements

1203.04.02.01 General

Within 30 Days of the Contract award, the name and address of the supplier of the bearings shall be submitted in writing to the Contract Administrator.

Proposals shall bear the seal and signature of the design and checking Engineers.

When another authority is involved, all submissions shall be made a minimum of 5 weeks prior to the commencement of work.

1203.04.02.02 Working Drawings

At least 1 week prior to commencement of bearing fabrication, 1 hardcopy and 1 electronic PDF copy of Working Drawings for the bearings shall be submitted to the Contract Administrator for information purposes only. An Engineer shall affix his or her seal and signature on the Working Drawings verifying that the drawings are consistent with the Contract Documents.

The Working Drawings shall be according to the Contract Documents and Product Drawings.

The Working Drawings shall clearly indicate all material properties, dimensions, connection attachments, fasteners and accessories, the bearing alphanumeric identification, and the load capacity at the serviceability and ultimate limit states as follows:

- a) Maximum vertical permanent and total load.
- b) Maximum lateral load and corresponding vertical load.
- c) Maximum rotational capacity about any horizontal axis and about the vertical axis at the centre of the bearing.

The bearing supplier shall have a copy of the Working Drawings at the manufacturing plant prior to and during the bearing fabrication.

1203.04.02.03 Manufacturer's Certification

Upon completion of fabrication and prior to installation of the bearings, a certificate of compliance signed by the manufacturer shall be submitted to the Contract Administrator. The certificate of compliance shall state that the fabricated bearings are according to the Working Drawings, Product Drawings, and Contract Documents.

1203.05 MATERIALS

1203.05.01 Steel

Steel components shall be according to CSA G40.20/40.21, Grade 300W, except for components permanently attached to steel superstructures, which shall be Grade 350 A.

Stainless steel for sliding surfaces shall have a minimum corrosion resistance according to ASTM A 240/A 240M, Type 304.

Steel fasteners shall be Grade A325M according to ASTM F 3125/F 3125M and hot-dipped galvanized according to ASTM F 2329/F 2329M. For guide bars, alternative steel fasteners and corrosion protection systems shall be as specified in the Contract Documents.

Stud shear connectors shall be according to CSA W59 Annex H, Type B.

1203.05.02 Aluminium Alloy

Aluminium alloy shall be according to CAN/CSA S157.

1203.05.03 Brass

Brass sealing rings for confined elastomer bearings shall be according to ASTM B 36/B 36M, half-hard.

1203.05.04 Elastomers

Polyisoprene shall be according to Table 1 of OPSS 1202 except shear modulus requirements. The hardness shall be 50 ± 5 Shore A when tested according to ASTM D 2240.

Polyether urethane polymer shall be according to Table 1 of this specification.

1203.05.05 Polytetrafluoroethylene Polymer

Material used in sliding surfaces shall be virgin PTFE according to ASTM D 4894. The PTFE shall be unfilled and according to Table 2.

Material used as the mating surface for guides for lateral restraint may be one of the following:

- a) Unfilled PTFE.
- b) PTFE filled with up to 25% by mass of glass fibres.
- c) Lead filled PTFE in a bronze matrix.

1203.05.06 Lubricant

Lubricant shall be silicone grease according to SAE AS 8660.

1203.05.07 Adhesives

Adhesives for bonding PTFE to metal shall produce a bond with a minimum peel strength of 4 N/mm. Adhesives shall not degrade in the service environment.

1203.07 PRODUCTION

1203.07.01 Welding

Welding of structural quality steels shall be according to CSA W59.

All welding shall be done with electrodes certified by the Canadian Welding Bureau to the requirements of CSA W48.

The stainless steel sheets that come in contact with PTFE shall be one piece continuously welded around the perimeter to its backing plate to prevent ingress of moisture. The weld shall be clean, uniform, and without overlaps and located outside the area in contact with PTFE.

1203.07.02 Fasteners

The threaded portion of the bolts shall be coated with silicone grease prior to installation.

1203.07.03 Anchors

The top and base plate anchorage to concrete shall be by studs approved by the Owner that are fusion welded to the plates.

1203.07.04 Machining

Metal to metal contact surfaces shall be machined or fine ground. The pots and pistons for confined elastomer bearings and the upper and lower plates with limiting rings for disc bearings shall be machined from solid metal plate or castings. The concave and convex plates for spherical bearings shall be machined from solid metal plate or castings.

There shall be no openings or discontinuities in the metal surfaces in contact with the elastomer or PTFE.

1203.07.05 Roughness of Metal Surfaces

The roughness of sliding stainless steel metallic surfaces in contact with PTFE, measured according to CSA B95, shall not be greater than 0.25 µm arithmetic average for plane surfaces and 0.50 µm arithmetic average for spherical surfaces. The roughness of anodized aluminium metallic surfaces shall not be greater than 0.40 µm arithmetic average.

The roughness of metal surfaces in contact with elastomer measured according to CSA B95 shall not be greater than 3.0 µm arithmetic average.

1203.07.06 Attachment of Polytetrafluoroethylene Polymer

Virgin or glass filled PTFE elements shall be recessed in a rigid backing material and shall be bonded over the entire area with an adhesive. The rigid backing material shall be grit blasted prior to applying the adhesive.

Lead filled PTFE shall be mechanically fastened and bonded to the backing plates.

The PTFE elements used as mating surfaces for guides for lateral restraint shall extend to within 10 mm from the ends of the backing plates.

1203.07.07 Anodizing

Aluminium alloy surfaces shall be anodized using the sulphuric acid process and shall meet the following:

Physical Property of Sealed Anodic Coating	Units	Test Method	Requirements
Thickness, t	µm	ASTM B 487	25 minimum
Mass, w Apparent density, d	mg/ cm ² g/ cm ³	ASTM B 137	5.8 minimum 2.32 minimum
The apparent density shall be determined as: $d = \frac{10 w}{t}$			

1203.07.08 Corrosion Protection

All exposed metal corners that receive corrosion protection shall have a 3 mm rounding. All exposed metal surfaces of the bearings, except stainless steel and components permanently attached to steel superstructures, shall be protected against corrosion by a low volatile organic compound coating system according to OPSS 911. The continuous weld attaching the stainless steel sheet shall be ground smooth and have the same corrosion protection as the bearing. Steel fasteners shall be galvanized or as specified in the Contract Documents.

For corrosion protection purposes, bearing components permanently attached to steel superstructures shall be considered part of the structural steel.

1203.07.09 Identification

Each bearing shall be marked with the date of manufacture (i.e., yyyy-mm-dd) and an individual alphanumeric identification. The alphanumeric identification shall consist of the designated identification letter of the supplier and source followed by a sequential five digit number. The characters shall be stamped or engraved into two adjacent sides and shall be clearly legible after installation. The characters shall not be less than 10 mm in height with the indentations not less than 1 mm in width and 0.5 mm in depth.

1203.07.10 Tolerances

The deviation from flatness of PTFE surfaces shall not exceed:

- a) 0.2 mm, when the diameter or diagonal is equal to or less than 800 mm.
- b) 0.00025 of the diameter or diagonal, when the diameter or diagonal is greater than 800 mm.

The deviation from flatness of stainless steel or aluminium alloy surfaces in contact with PTFE for plane surfaces and from the theoretical surface for spherical surfaces shall not exceed:

- a) 0.0003 LH mm for a rectangular PTFE element.
- b) 0.0006 RH mm for a circular PTFE element

where:

L = the greater plan dimension for a rectangular bearing,
R = the radius of a circular bearing, and,
H = the free height of PTFE element

For confined elastomer bearings, the tolerance of fit between the piston and the pot shall be + 0.75 to + 1.25 mm. The inside diameter of the pot cylinder shall be the same as the nominal diameter of the elastomer and shall be machined to a tolerance of:

- a) 0 to + 0.125 mm for diameters up to and including 500 mm.
- b) 0 to + 0.175 mm for diameters over 500 mm.

For disc bearings, the gap between the edge of the polyether urethane polymer disc and the inside face of the limiting ring shall be $1.25\% \pm 0.25\%$ of the diameter of the disc.

The plan dimensions of the recess for PTFE shall be the same as the nominal plan dimensions of the PTFE and shall be machined to a tolerance of 0 to + 0.2% of the diameter or diagonal.

Overall bearing plan dimension	± 3 mm
Overall bearing height	± 3 mm
Machined surface dimensions	± 0.4 mm

Elastomer:

- | | |
|----------|---|
| Diameter | a) 0.0 to -1.5 mm for diameters ≤ 500 mm |
| | b) 0.0 to -2.0 mm for diameters > 500 mm |

Thickness	0.0 to + 1.0 mm	
Brass rings:		
Difference between internal diameter of brass ring and diameter of recess in the moulded elastomer		0 to + 0.5 mm
Difference between sum of thicknesses of brass rings and recess depth in the moulded elastomer		0 to + 0.25 mm
Recessed Guide Bars - American Standard Clearance Locational Fit Class LC3 according to ANSI B4.1.		
Guides for Lateral Restraint -	Gap between metal restraints surfaces and mating PTFE elements mm	0.50 mm $\pm$ 0.25
PTFE plan dimension	0 to - 0.2% of diameter or diagonal	
PTFE thickness	0 to + 10.0% of thickness	
Depth of recess for PTFE	0 to + 0.3 mm	

TABLE 1
Physical Requirements for Polyether Urethane Polymer

Physical Property	ASTM Test Methods	Requirements	
		Minimum	Maximum
Hardness, Scale D	D 2240	60	64
Tensile Stress, MPa @ 100% elongation @ 200% elongation	D 412	14 26	-- --
Tensile Strength, MPa	D 412	35	--
Ultimate Elongation, %	D 412	220	--
Compression Set, % 22 h @ 70 °C	D 395	--	40

TABLE 2
Physical Requirements for Polytetrafluoroethylene Polymer

Physical Property	ASTM Test Method	Requirement
Tensile Strength, MPa	D 638	minimum 20
Elongation, %	D 638	minimum 200
Relative Density	D 792	2.16 ± 0.03

Appendix 1203-A, November 2016
FOR USE WHILE DESIGNING MUNICIPAL CONTRACTS

Note: This is a non-mandatory Commentary Appendix intended to provide information to a designer, during the design stage of a contract, on the use of the OPS specification in a municipal contract. This appendix does not form part of the standard specification. Actions and considerations discussed in this appendix are for information purposes only and do not supersede an Owner's design decisions and methodology.

Designer Action/Considerations

No information provided here.

Related Ontario Provincial Standard Drawings

No information provided here.



MATERIAL SPECIFICATION FOR DECK JOINT ASSEMBLIES

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APPENDICES

1210-A	Commentary
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1210.01	SCOPE
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This specification covers the requirements for Materials, design, and fabrication of deck joint assemblies.

1210.01.01 Specification Significance and Use

This specification is written as a provincial-oriented specification. Provincial-oriented specifications are developed to reflect the administration, testing, and payment policies, procedures, and practices of the Ontario Ministry of Transportation.

Use of this specification or any other specification shall be according to the Contract Documents.

1210.01.02 Appendices Significance and Use

Appendices are not for use in provincial contracts as they are developed for municipal use, and then, only when invoked by the Owner.

Appendices are developed for the Owner's use only.

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1210.02 REFERENCES

When the Contract Documents indicate that provincial-oriented specifications are to be used and there is a provincial-oriented specification of the same number as those listed below, references within this specification to an OPSS shall be deemed to mean OPSS.PROV, unless use of a municipal-oriented specification is specified in the Contract Documents. When there is not a corresponding provincial-oriented specification, the references below shall be considered to be to the OPSS listed, unless use of a municipal-oriented specification is specified in the Contract Documents.

This specification refers to the following standards, specifications, or publications:

Ontario Provincial Standard Specifications, Construction

OPSS 920 Deck Joint Assemblies, Preformed Seals, Joint Fillers, Joint Seals, Joint Sealing Compounds, and Waterstops - Structures

Ontario Provincial Standard Specifications, Material

OPSS 1202 Bearings - Elastomeric Plain and Steel Laminated
OPSS 1203 Bearings - Rotational and Sliding Surface

Ontario Ministry of Transportation Publications

Structural Manual:
Division 1, Exceptions to the Canadian Highway Bridge Design Code CAN/CSA S6 for Ontario

CSA Standards

G30.18-09 (R2014)	Carbon Steel Bars for Concrete Reinforcement
G40.20-13/G40.21-13	General Requirements for Rolled or Welded Structural Quality Steel/Structural Quality Steel
S6-14	Canadian Highway Bridge Design Code
W47.1-09 (R2014)	Certification of Companies for Fusion Welding of Steel
W59-13	Welded Steel Construction (Metal Arc Welding)
W186-M1990 (R2012)	Welding of Reinforcing Bars in Reinforced Concrete Construction

ASTM International

A 123/A123M-15	Standard Specification for Zinc (Hot-Dip Galvanized) Coatings on Iron and Steel Products
A 153/A153M-16	Standard Specification for Zinc Coating (Hot-Dip) on Iron and Steel Hardware

A 240/A 240M-16	Standard Specification for Chromium and Chromium-Nickel Stainless Steel Plate, Sheet and Strip for Pressure Vessels and for General Application
D 412-15a	Standard Test Methods for Vulcanized Rubber and Thermoplastic Elastomers - Tension
D 471-16a	Standard Test Method for Rubber Property - Effect of Liquids
D 573- 04(2015)	Standard Test Method for Rubber Deterioration in an Air Oven
D 832-07 (2012)	Standard Practice for Rubber Conditioning for Low Temperature Testing
D 1149-16	Standard Test Method for Rubber Deterioration - Cracking in an Ozone Controlled Environment
D 2240-15	Standard Test Method for Rubber Property - Durometer Hardness
F 835-13	Standard Specification for Alloy Steel Socket Button and Flat Countersunk Head Cap Screws
F 2329/F 2329M-15	Standard Specification for Zinc Coating, Hot-Dip, Requirements for Application to Carbon and Alloy Steel Bolts, Screws, Washers, Nuts, and Special Threaded Fasteners
F3125/F3125M-15a	Standard Specification for High Strength Structural Bolts, Steel and Alloy Steel, Heat Treated, 120 ksi (830 MPa) and 150 ksi (1040 MPa) Minimum Tensile Strength, Inch and Metric Dimensions

1210.03 DEFINITIONS

For the purpose of this specification, the following definitions apply:

Armouring means an edging to the deck joint comprising of a steel angle or steel plate permanently attached to the concrete dam corners.

Armouring Angle means the expansion joint angle at the gap.

Bearing means a structural device that transmits load while permitting translation or rotation or both.

Elastomer means a compound containing virgin polychloroprene (neoprene).

Manufacturer means a fabrication company that is certified according to CSA W47.1, Division 1 or 2.

Nosing Angle means the angle that forms the outside edges of the joint blackout.

Preformed Seal means an extruded elastomer that, when retained in recesses in the deck joint assembly, prevents the passage of water and other materials.

Separation Beam means a steel section which conveys wheel loads that spans between support bars.

Support Bar means a member upon which a traffic bearing separation beam rests.

1210.04 DESIGN AND SUBMISSION REQUIREMENTS

1210.04.01 Design Requirements

1210.04.01.01 General

Deck joint assemblies shall be designed to function satisfactorily under the critical combinations of loads, translations, and rotations according to CAN/CSA S6 and the Structural Manual, Division 1.

1210.04.01.02 Modular Expansion Joints

Loading for modular joints shall be as specified in the Structural Manual, Division 1.

Modular joints shall be equipped with a mechanism capable of ensuring all openings of the joint are of uniform width as follows:

- a) Stiffness of the mechanism shall not exceed 8.5 kN per metre along the length of the expansion joint.
- b) The width of individual openings shall not vary by more than 6 mm along the length of the joint.
- c) The range of widths of openings shall not vary by more than 6 mm.

Field splices in modular joints are not permitted.

1210.04.01.03 Fasteners and Anchorage

Fasteners and anchorage devices shall be designed to transfer all the static and dynamic loads from each side of the deck joint assembly to the structure.

1210.04.01.04 Preformed Seal

All deck joint assemblies and the bearings in modular deck joint assemblies shall be designed so that the entire preformed seal is replaceable without damage to the structure and without removal of any concrete, welds, or anchorages permanently attached to the structure.

Seals shall not be bent in a vertical plane more than 30° at any one location.

1210.05 MATERIALS

1210.05.01 Bearings

All material forming parts of the bearing component of the deck joint assembly shall be according to OPSS 1202 and OPSS 1203.

Virgin polytetrafluoroethylene element shall have a minimum thickness of 1.5 mm.

1210.05.02 Preformed Seal

The preformed seal shall be manufactured from an elastomer with physical requirements according to Table 1.

Manufacturer's storage and handling requirements shall be followed. The seal shall not be exposed to ultraviolet rays for more than 3 Days prior to installation.

1210.05.03 Steel

Mild steel components shall be according to CSA G40.20/G40.21, Grade 300 W.

Stainless steel shall have a minimum corrosion resistance according to ASTM A 240/A 240M.

Steel fasteners other than stainless steel shall be according to ASTM F 3125/F 3125M (Grade A325M) or ASTM F 835.

1210.05.04 Anchors

Anchors shall be headed type stud shear connectors according to CSA W59, Appendix H.

1210.05.05 Reinforcing Steel Bars

Reinforcing steel bars shall be according to CAN/CSA G30.18, Grade 400W.

1210.05.06 Anti-seize Compound

Anti-seize compound shall be LOCTITE Moly 50 manufactured by Henkel Corporation or an alternative acceptable to the Owner.

1210.05.07 Injection Hose System for Deck Joint Assembly

The injection hose system shall be installed on the deck joint assembly for both nosing and armouring angles. This system shall be long enough to extend between the barrier or parapet walls on each side of the structure, including the sidewalks and curbs.

The nosing and armouring angles shall not contain bleeder holes.

1210.07 PRODUCTION

1210.07.01 General

The deck joint assembly manufacturer shall have a copy of the deck joint assembly Working Drawings specified in OPSS 920 at the manufacturing plant during the deck joint assembly fabrication.

1210.07.02 Welding

Welding of structural quality steels shall be according to CSA W59.

Welding of stainless steel shall be according to OPSS 1203.

Welding of reinforcing steel bars shall be according to CSA W186.

1210.07.03 Fasteners

All steel bolts shall be coated with zinc phosphate.

The threaded portion of bolts and the underside of the bolt heads shall be coated with an anti-seize compound prior to installation.

1210.07.04 Steel Fabrication

Machining shall be carried out after welding, whenever possible.

All rough flame cut surfaces and metal-to-metal contact surfaces shall be machined ground smooth.

Re-entrant corners that are cut shall be free from notches and shall have the largest practical radius with a minimum radius of 14 mm. Bearing surfaces shall be in contact over the full area of the mating surfaces.

1210.07.05 Corrosion Protection

All structural steel components of the deck joint assembly shall be hot dip galvanized according to ASTM A 123/A 123M after fabrication. Hardware shall be galvanized according to ASTM F 2329/F 2329M.

1210.07.06 Preformed Seal

The preformed seal shall exceed the required length by 1 m to provide a sample to be submitted for testing.

1210.07.07 Identification

Each deck joint section shall be marked with the date of manufacture (i.e., yyyy-mm-dd-), and an individual alphanumeric identification. The alphanumeric identification shall consist of the identification letters of the supplier and source, followed by a sequential number. The characters shall be die stamped into an exposed surface at the gutter line at the barrier wall or curb. The characters shall not be less than 10 mm high with the indentations not less than 0.5 mm in width and 0.2 mm in depth.

The preformed seal shall be clearly and indelibly marked at one metre intervals indicating manufacturer, lot number, date of manufacture (i.e., yyyy-mm-dd), and model number.

1210.07.08 Designation of Lifting Points

The lifting points shall be clearly marked on the deck joint assembly.

TABLE 1
Preformed Seal Physical Requirements

Preformed Seal Physical Requirements Property	Physical Requirements	Test Procedure
Tensile Strength	Minimum 13.5 MPa	ASTM D 412 Test Method A
Ultimate Elongation	Minimum 250%	ASTM D 412 Test Method A
Hardness,	55 Shore A, + 7, -5	ASTM D 2240
Oven Aging Test, 70 h @ 100 °C Change in Tensile Strength	Maximum 20%	ASTM D 573 ASTM D 412 Test Method A
Change in Elongation	Maximum 20%	ASTM D 412 Test Method A
Change in Hardness	Maximum 10 points	ASTM D 2240
Permanent set at break	Maximum 10%	ASTM D 412 Test Method A
Low Temperature Crystallization Hardness, Shore A 7 d @ -10 °C Change in Hardness	Maximum 15 points	ASTM D 832 ASTM D 2240
Oil Swell, ASTM Oil No. 3, 70 h @ 100 °C Weight Change	Maximum 45%	ASTM D 471
Ozone Resistance, 20% Strain, 150 pphm in air 70 h @ 40 °C	No cracks	ASTM D 1149 Method B, Procedure B1
Notes:		
A. All tests shall be made on specimens prepared from the preformed seals.		

Appendix 1210-A, November 2016
FOR USE WHILE DESIGNING MUNICIPAL CONTRACTS

Note: This is a non-mandatory Commentary Appendix intended to provide information to a designer, during the design stage of a contract, on the use of the OPS specification in a municipal contract. This appendix does not form part of the standard specification. Actions and considerations discussed in this appendix are for information purposes only and do not supersede an Owner's design decisions and methodology.

Designer Action/Considerations

No information provided here.

Related Ontario Provincial Standard Drawings

No information provided here.



MATERIAL SPECIFICATION FOR CONCRETE - MATERIALS AND PRODUCTION

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APPENDICES

1350-A	Commentary
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1350.01 SCOPE

This specification covers the requirements for materials and methods for proportioning, mixing, transporting, field testing, acceptance, and payment adjustments of concrete material, including provisions for referee testing of compressive strength, air void system parameters, and rapid chloride permeability of high performance concrete and silica fume overlays.

1350.01.01 Specification Significance and Use

This specification is written as a provincial-oriented specification. Provincial-oriented specifications are developed to reflect the administration, testing, and payment policies, procedures, and practices of the Ontario Ministry of Transportation.

Use of this specification or any other specification shall be according to the Contract Documents.

1350.01.02

Appendices Significance and Use

Appendices are not for use in provincial contracts as they are developed for municipal use, and then, only when invoked by the Owner.

Appendices are developed for the Owner's use only.

Inclusion of an appendix as part of the Contract Documents is solely at the discretion of the Owner. Appendices are not a mandatory part of this specification and only become part of the Contract Documents as the Owner invokes them.

Invoking a particular appendix does not obligate an Owner to use all available appendices. Only invoked appendices form part of the Contract Documents.

The decision to use any appendix is determined by an Owner after considering their contract requirements and their administrative, payment, and testing procedures, policies, and practices. Depending on these considerations, an Owner may not wish to invoke some or any of the available appendices.

1350.02

REFERENCES

When the Contract Documents indicate that provincial-oriented specifications are to be used and there is a provincial-oriented specification of the same number as those listed below, references within this specification to an OPSS shall be deemed to mean OPSS.PROV, unless use of a municipal-oriented specification is specified in the Contract Documents. When there is not a corresponding provincial-oriented specification, the references below shall be considered to be to the OPSS listed, unless use of a municipal-oriented specification is specified in the Contract Documents.

This specification refers to the following standards, specifications, or publications:

Ontario Provincial Standard Specifications, Material

OPSS 1002	Aggregates - Concrete
OPSS 1301	Cementing Materials
OPSS 1302	Water
OPSS 1303	Air Entraining and Chemical Admixtures for Concrete

Ontario Ministry of Transportation Publications

Designated Sources for Materials (DSM)

Laboratory Testing Manual:

LS-100	Method of Rounding-off Data and Other Numbers
LS-101	Method for Calculation of Per Cent Within Limits
LS-407	Method of Test for Compressive Strength of Moulded Cylinders
LS-413	Method of Test for Non-Volatile Content of Chemical Admixtures, Latex Admixtures and Curing Compounds
LS-414	Method of Test for Relative Density of Chemical Admixtures, Air Entraining Admixtures, Latex Admixtures and Curing Compounds
LS-415	Method of Test for pH of Aqueous Solutions by Glass Electrode
LS-426	Method of Testing Compressive Strength of High Performance Concrete Cylinders
LS-431	Method of Test for Microscopical Determination of Air Void System Parameters in Hardened Concrete, for Conformance Testing
LS-432	Method of Test for Microscopical Determination of Air Void System Parameters in Hardened Concrete

- LS-433 Method of Test for Electrical Indication of Concrete's Ability to Resist Chloride Ion Penetration
 LS-435 Method of Test for Linear Shrinkage of Concrete

MTO Forms:

- PH-CC-322 Concrete Construction Report
 PH-CC-340 Field Sample Data Sheet - Concrete
 PH-CC-433A Concrete Mix Design Submission Form A
 PH-CC-433B Concrete Mix Design Submission Form B
 PH-CC-434 Sample Letter to Contractor - Concrete Mix Design

CSA Standards

- A23.2-1C Sampling Plastic Concrete*
 A23.2-3C Making and Curing Concrete Compression and Flexural Test Specimens*
 A23.2-4C Air Content of Plastic Concrete by the Pressure Method*
 A23.2-5C Slump and Slump Flow of Concrete*
 A23.2-6C Density, Yield, and Cementing Materials Factor of Plastic Concrete*
 A23.2-14C Obtaining and Testing Drilled Cores for Compressive Strength Testing*
 A23.2-17C Temperature of Freshly Mixed Hydraulic Cement Concrete*
 A23.2-1D Moulds for Forming Concrete Test Cylinders Vertically*
 A3004-B6 Physical Test Methods for Cementitious Materials for Use in Concrete and Masonry **
 A3001 Cementitious Materials for Use in Concrete**
 * [Part of A23.1-14/A23.2-14 - Concrete Materials and Methods of Concrete Construction/Methods of Test and Standard Practices for Concrete]
 ** [Part of A3000-13 - Cementitious Materials Compendium]

1350.03 DEFINITIONS

For the purpose of this specification, the following definitions apply:

High Performance Concrete (HPC) means concrete with a minimum specified 28-Day compressive strength of at least 50 MPa that includes silica fume and may include other supplementary cementing materials, and having specified rapid chloride permeability at 28 to 32 Days of 1,000 coulombs or less.

High Strength Concrete means concrete with a minimum specified 28-Day compressive strength of 40 MPa or greater.

Stationary Mixer means a non-mobile mixer installed at a plant for the purpose of mixing concrete.

Steel Reinforcement means all types of steel reinforcement for concrete, including reinforcing steel bars, stainless steel reinforcing bars, splice bars, welded steel wire fabric, and prestressing strands and bars.

Tremie Concrete means a concrete mix specifically designed to be placed under water by means of a tremie.

1350.04 DESIGN AND SUBMISSION REQUIREMENTS

1350.04.01 Design Requirements

1350.04.01.01 General

The concrete mix shall be designed to provide adequate strength and durability for the intended use and to meet the requirements as specified in the Contract Documents.

1350.04.01.01.01 Use of Admixtures

Water reducer Type A or D according to OPSS 1303 shall be used in all concrete, except in applications where plant addition of superplasticizer is permitted, in which case water reducer may be used at the Contractor's option.

Retarding of concrete set shall be provided when specified in the Contract Documents. If no retarding of set is specified, retarders may be used at the Contractor's option to delay setting of concrete for a maximum of 3 hours. Longer periods of set retardation shall be used only when specified in the Contract Documents.

Accelerators shall be used only when specified in the Contract Documents.

Superplasticizers shall be used in concrete containing silica fume and concrete in expansion joint end dams as specified in the Contract Documents. Superplasticizers may be used in other applications at the Contractor's option providing the superplasticized concrete meets the contract requirements and there is no evidence of segregation or inadequate consolidation.

Where rapid chloride permeability is an acceptance requirement, superplasticizers may be added at the Contractor's option to the concrete at the plant or at the site. In all other applications superplasticizer shall be added to the concrete at the site.

Type S admixtures listed on the DSM may be used and concrete containing Type S admixture shall meet all requirements of this specification.

1350.04.02 Submission Requirements

1350.04.02.01 Mix Design

1350.04.02.01.01 General

A complete mix design submission shall be provided for concrete of each specified compressive strength that is to be placed in the work, for each of the following:

- a) Cast-in-place concrete.
- b) Slip formed concrete.
- c) Mixes with different sources of materials.
- d) Mixes with different admixtures.
- e) Precast concrete.
- f) Special purpose or unique mixes.

A complete mix design submission shall be provided for each specific concrete mix prior to the placement of that mix in the work. A complete mix design submission consists of the following:

- a) A completed MTO form PH-CC-433A (Form A).
- b) A completed MTO form PH-CC-433B (Form B).
- c) Mix design-supporting documentation.

Form A and Form B shall identify all materials to be used in the concrete. No material shall be used in the concrete without the knowledge of the Owner.

If the same mix design (i.e., same materials and sources in the same proportions) is to be supplied by multiple plants, submission of separate mix designs and separate supporting documentation is not required.

The mix shall not be placed until the Contract Administrator provides written confirmation that Form A and the mix design supporting information meet the requirements as specified in the Contract Documents. Within 4 Business Days following the delivery of all required documentation by the Contractor, the Contract Administrator shall provide the Contractor with a completed MTO form PH-CC-434 indicating the above confirmation or advising the Contractor of any requirements that have not been met.

1350.04.02.01.02 Changes to Mix Design Submission

The following adjustments to the submitted mix design may be made without having to submit a new mix design or supporting data:

- a) Total cementing material content: $\pm 5\%$ of quantity stated on Form B.
- b) Supplementary cementing materials: $+0/-5\%$ of quantity stated on Form B.
- c) Admixtures: Variation within range of dosage stated on Form B.
- d) Water: Variation within range stated on Form B.

Removal of a material from the mix or addition of retarding admixture Type B or D according to OPSS 1303 requires submission of a new mix design, but does not require submission of supporting test data.

A new mix design, including supporting documentation, shall be provided prior to placing concrete, if the Contractor proposes to change the mix in any of the following ways:

- a) Changing sources of materials used in the concrete.
- b) Substituting a material or product for another from the same source.
- c) Adding any material to the concrete that was not on the original mix design, except retarding admixture Type B or D according to OPSS 1303.
- d) Adjusting the quantities of the stated materials in the concrete outside of the ranges provided above.

The submission process for new or modified mix designs is the same as for the original mix design, except that when supporting documentation is not required, the confirmation by the Contract Administrator shall be provided within 1 Business Day.

1350.04.02.01.03 Submission of Form A

At least 7 Business Days prior to the placement of concrete, an accurately completed Form A shall be submitted to the Contract Administrator.

Each mix design submitted shall be identified by the Contractor with a mix design number consisting of the following:

- a) 8-digit Contract number, followed by
- b) 2 digits indicating the specified compressive strength of concrete, followed by

- c) 2 digits indicating the number of the submission for that Contract (e.g., 01 for the first mix design of a specified strength, 02 for the second, and so on) followed, if applicable, by
- d) 1 digit indicating the number of revisions of a mix design submitted previously (e.g., 1 for first revision, 2 for second revision, and so on).

1350.04.02.01.04 Submission of Form B

Prior to the placement of concrete of a given mix design, the Contractor shall ensure that for each Form A submitted, a corresponding Form B is accurately completed by the concrete supplier and submitted directly to the Regional Head of Quality Assurance with a copy to the MTO Concrete Section electronic mix design depository.

The Form B shall bear the mix design number assigned by the Contractor to the corresponding Form A.

1350.04.02.01.05 Mix Design Supporting Documentation

Form A shall be accompanied by all material quality test data and other information for the mix design and for component materials required by the Contract Documents. All required supporting test data and certificates shall be less than 12 months old at the time the concrete mix design is submitted.

Supporting documentation shall include the following:

- a) A currently valid Certificate of Ready Mixed Concrete Production Facilities as issued by the Ready Mixed Concrete Association of Ontario (RMCAO) for any plant to be used on the Contract.
- b) The range of concrete production rates required for the work.
- c) A certificate or letter verifying the compatibility of the admixtures to be used in the concrete, if admixtures are supplied from different manufacturers.
- d) Water test results, if water other than municipal drinking water is used, demonstrating compliance with the requirements as specified in the Contract Documents.
- e) A certificate verifying the cement is free from early stiffening tendencies when tested according to CAN/CSA A3004-B6, if non-agitating trucks are used.
- f) Any other requirements specified elsewhere in the Contract Documents.

Documentation applicable to multiple mix designs need only be submitted once for a Contract.

1350.04.02.02 Certification of Ready Mixed Concrete Production Facilities

For multi-year Contracts, the Contractor shall submit annually for all plants supplying concrete to the work, verification that the plant continues to hold a valid Certificate of Ready Mixed Concrete Production Facilities, as issued by the RMCAO.

1350.05 MATERIALS

1350.05.01 Cementing Materials

Cementing materials shall be according to OPSS 1301 and CAN/CSA A3001, except:

- a) For all concrete other than silica fume overlays and HPC, Portland cement shall be used. A portion of it may be replaced by supplementary cementing material; however, silica fume or blended cement containing silica fume shall not be used.
- b) For silica fume overlays and HPC, blended hydraulic cement containing silica fume shall be used. A portion of it may be replaced by Portland cement Type GU or supplementary cementing materials or both.

Supplementary cementing material shall be ground granulated blast furnace slag or fly ash or a combination of the two materials and shall be restricted to the following proportions by mass of the total cementing material:

- a) Slag up to 25%.
- b) Fly ash up to 10%, except for silica fume overlays and HPC where up to 25% is permitted.
- c) A mixture of slag and fly ash up to 25%, except the amount of fly ash shall not exceed 10% by mass of the total cementing materials, in concrete other than silica fume overlays and HPC.

For tremie concrete, the minimum cementing material content shall be 415 kg per cubic metre of concrete.

1350.05.02 Aggregates

Aggregates shall be according to OPSS 1002.

1350.05.03 Water

Water used for production shall be according to OPSS 1302.

1350.05.04 Admixtures for Concrete

Air entraining, chemical, and superplasticizing admixtures for concrete shall be according to OPSS 1303.

1350.05.05 Concrete

Target values for air content and slump shall be identified for all plastic concrete on mix design Forms A and B.

The plastic concrete shall meet the following requirements:

- a) Concrete shall be free of lumps and segregation and shall have consistent air content and slump throughout each load.
- b) Plastic air content shall meet the requirements as shown in Table 1.
- c) Slump shall meet the requirements of Table 1. The maximum allowable slump, including tolerance, shall be 100 mm, except for tremie concrete, which shall be 180 mm.

When superplasticizer is to be added to the concrete according to the Use of Admixtures clause, the following shall apply:

- i. For superplasticizers added at the plant, the Contractor shall identify target slump for the concrete after the addition of superplasticizer. The tolerance on measurement of concrete slump after addition of superplasticizer shall be ± 30 mm and the maximum slump including tolerance shall not exceed 230 mm.

- ii. For superplasticizers added at the site, the Contractor shall identify target slumps for the concrete both prior to and after the addition of superplasticizer. The tolerance on measurement of concrete slump prior to the addition of superplasticizer shall be ± 20 mm and the maximum slump including tolerance shall not exceed 100 mm. The tolerance on measurement of concrete slump after addition of superplasticizer shall be ± 30 mm and the maximum slump, including tolerance, shall not exceed 230 mm.
- d) The concrete temperature at the time of discharge from the truck shall be at or between 10 and 28 °C, with the exception of HPC and silica fume overlays, which shall be at or between 10 and 25 °C.

The hardened concrete shall meet the following requirements:

- a) Concrete compressive strength shall be as specified in the Contract Documents.
- b) Rapid chloride permeability of HPC and silica fume overlays at 28 to 32 Days shall be less than or equal to 1,000 coulombs.
- c) Air void system parameters as determined on the hardened concrete shall meet the following requirements:
 - i. Each core shall have a minimum air content of 3.0 %.
 - ii. Each core shall have a maximum spacing factor of 0.230 mm, except for HPC and silica fume overlays for which each core shall have a maximum spacing factor of 0.250 mm.

Self-Consolidating Concrete (SCC) will be considered on an individual basis subject to the Owner's approval. If permitted for use, SCC shall be according to the Owner's current specification for SCC. A copy of the specification can be obtained from:

Ontario Ministry of Transportation,
Materials Engineering and Research Office,
145 Sir William Hearst Avenue,
Downsview, Ontario M3M 0B6.

1350.06 EQUIPMENT

1350.06.01 Batching Plant

The batching plant and equipment shall be certified by the RMCAO prior to producing concrete for the work, including concrete for any trial batches, and shall meet the requirements for certification throughout the production of concrete.

1350.06.02 Delivery Equipment

Delivery equipment shall be truck mixers, agitator trucks, or non-agitating equipment. Use of non-agitating equipment shall be restricted to delivery for placement of concrete base or concrete pavement.

Truck mixers shall consist of concrete mixers mounted on a truck or other vehicle used for the complete mixing of concrete ingredients after they have been batched at the plant. All truck mixers shall be certified by RMCAO and shall display valid certification stickers.

Agitator trucks shall consist of drums or containers mounted on trucks or other vehicles in which completely mixed concrete is kept sufficiently agitated during delivery to prevent segregation.

Non-agitating equipment shall consist of containers mounted on trucks for delivering completely mixed concrete. The body of the container shall be smooth, watertight, made of steel, and equipped with gates that permit control of the discharge of the concrete.

1350.07 PRODUCTION

1350.07.01 General

Concrete shall be produced at a batching plant. Use of mobile mixers is not permitted. A back-up plant shall be identified for all post-tensioned deck placements.

When multiple plants supply concrete for the same component, all plants, including primary and back-up, shall produce the same mix design using the same aggregates, cementing materials, and admixtures.

The supplementary cementing material shall be weighed separately from the cement, except when the cement and supplementary cementing materials are supplied in blended form.

The entire contents of the mixer shall be discharged and the mixer completely emptied of wash water prior to loading of a new concrete batch. When a truck mixer is used for complete mixing, it shall not be loaded beyond its maximum mixing capacity.

Cementing materials shall not be added by bags or sacks or from a storage facility remote from the ready mix plant.

1350.07.02 Temperature Control

Any method of heating aggregates shall be such as to produce uniform conditions, without local hot spots.

Frozen lumps of aggregate shall not be added to the concrete.

When ice is used as part of mixing water, the ice shall be measured by mass and shall be completely melted by the time concrete mixing is completed.

1350.07.03 Mixing Time and Mixing Rate

The minimum mixing time for concrete shall be as recommended by the equipment manufacturer or the minimum time required to produce concrete meeting the requirements of this specification, whichever is greater.

When a stationary mixer is used for partial mixing of concrete prior to transferring to a truck mixer, the mixing time shall be no more than is required to intermingle the ingredients. After transfer to a truck mixer, further mixing at the designated mixing speed shall be carried out.

After completion of mixing, the truck mixer drum shall be rotated at the designed agitating speed until discharge of concrete commences.

1350.07.04 Delivery

1350.07.04.01 General

Concrete that is transported in non-agitating equipment shall be covered. Concrete delivered by means of agitator trucks or truck mixers shall be transported after completion of mixing.

1350.07.04.02 Discharge Time

When concrete is transported to the site by means of agitating or mixing equipment, discharge of the concrete shall be completed within 1.5 hours after introduction of the mixing water to the cement and aggregates, except when the air temperature exceeds 28 °C and the concrete temperature exceeds 25 °C, the concrete shall be discharged within 1 hour after the introduction of the mixing water.

When concrete is transported by means of non-agitating equipment, discharge shall be completed within 30 minutes after introduction of the mixing water to the cement and aggregates.

Use of retarders or other admixtures does not change the specified concrete discharge time.

1350.07.04.03 Delivery Ticket

Each load shall be accompanied by a delivery ticket. The following information shall be printed on each ticket at the plant using an automated printing device:

- a) Name and location of plant.
- b) Date, including year, month, and day.
- c) Contract number.
- d) Truck number.
- e) Time of batching concrete. Where an electronic ticketing system is not used, time shall be stamped by a time clock within 5 minutes of batching.
- f) Mix design number assigned by the Contractor or the supplier's unique mix design number verified to correspond to the mix design number assigned by the Contractor.
- g) Specified minimum 28-Day compressive strength of concrete.

In addition, the following shall be recorded in writing on the delivery ticket:

- a) The amount of any material added after batching.
- b) Rejection of a load or part thereof, if applicable.
- c) Time truck arrived at the job site.
- d) The time the truck finished discharging..

1350.07.05 Material Sampling and Testing

1350.07.05.01 Contractor Sampling for Quality Control Purposes

The Contractor may obtain samples of plastic concrete for quality control purposes. The Contractor shall not carry out sampling or destructive testing of hardened concrete in the work for quality control purposes without obtaining the written permission of the Owner in advance. The Owner's denial of permission shall not relieve the Contractor of responsibility for the quality of concrete placed or to be placed in the work.

1350.07.05.02 Sampling of Water, Admixtures, and Cementing Materials

The Contractor shall obtain samples of all cementing materials, admixtures, and water (when other than municipal drinking water is used) according to the frequencies as shown in Table 8, for testing by the Owner.

The Contractor shall deliver samples of admixtures and water to the Regional Quality Assurance laboratory.

The Contractor shall deliver samples of cementing materials to:

Head, Concrete Section
Ontario Ministry of Transportation
Room 15,
145 Sir William Hearst Avenue,
Downsview, ON M3M 0B6

Samples of admixtures and water shall be protected from freezing and high temperatures. Cementing materials samples shall be protected from moisture.

1350.07.05.03 Testing of Plastic Concrete

Field sampling and testing of concrete shall be performed by a person holding either of the following certifications:

- a) CCIL Certified Concrete Testing Technician, or
- b) ACI Concrete Field Testing Technician, Grade 1.

This person shall have a valid original card issued by the certifying agency in their possession at all times.

Samples for determining acceptance of concrete for air and slump shall be grab samples taken according to CSA A23.2-1C after approximately 10% of the load has been discharged. The discharge shall be stopped and no additional concrete shall be discharged or placed into the work until samples have been tested and found acceptable. If the test results indicate that the concrete does not meet the specified requirements and adjustments permitted in the Acceptance and Field Adjustments of Plastic Concrete clause cannot produce acceptable concrete, the remainder of the load shall be rejected.

Temperature shall be measured according to CSA A23.2-17C. Slump shall be measured according to CSA A23.2-5C. Air content shall be measured according to CSA A23.2-4C. The air meter shall be calibrated at least once a year according to CSA A23.2-4C and a copy of the calibration certificate shall be with the air meter and available for review when requested by the Contract Administrator.

1350.07.05.04 Frequency of Testing Slump, Air Content, and Temperature

For all concrete, quality control testing consisting of slump, air content, and temperature determinations shall be carried out on each load or batch of concrete until satisfactory control is established. Satisfactory control shall be established each Day. It is established when concrete from 5 consecutive loads or batches is within the specified requirements without field adjustments as defined in the Acceptance and Field Adjustments of Plastic Concrete clause. If any field adjustments are required, testing on each load shall be continued until 5 consecutive loads or batches meet the requirements with no field adjustment. After satisfactory control has been established, testing shall be carried out on every third load. If testing indicates that a load does not meet the requirements, testing shall resume on each load until satisfactory control is established.

If multiple plants supply concrete, satisfactory control shall be established for each plant.

In addition to the above, air content, slump, and temperature tests shall be carried out whenever compressive test cylinders are cast.

1350.07.05.05 Acceptance and Field Adjustments of Plastic Concrete

The Contractor shall be responsible for all quality control inspection and testing required to ensure that plastic concrete included in the work is according to the submitted mix design and meets the specified requirements for air content, slump, temperature, delivery time, and uniformity.

Concrete which does not meet the specified requirements for air content, slump, temperature, delivery time or uniformity shall be rejected and not used in work.

Slump of concrete shall be measured prior to and after the addition of superplasticizer. When superplasticizer is permitted to be added at the plant according to the Use of Admixtures clause, the slump shall be measured after the addition of superplasticizer. Air content shall be measured after any addition of superplasticizer.

For non-superplasticized concrete, when the measured slump is higher than that specified and there is time available to discharge the concrete within the specified time limit, the Contractor shall be permitted to retest the slump once using the unused portion of the same concrete sample. Slump shall be retested within 5 minutes of the completion of the original test.

For superplasticized concrete, when the measured slump is higher than that specified and there is time available to discharge the concrete within the specified time limit, the Contractor shall be permitted to wait and retest the slump using a new sample of concrete when superplasticizer is plant added and rapid chloride permeability is an acceptance requirement, or superplasticizer is added on site and the measured slump prior to addition of superplasticizer is within specified limits.

When the measured plastic air content exceeds the upper test limit and there is time available within the discharge time limit specified, the Contractor shall be permitted to rotate the load at agitation speed and re-test the air content. The use of additives to reduce the air content shall not be permitted.

When a truck mixer is used, the following field adjustments may be carried out prior to acceptance of the load:

1. When the measured air content is low, air-entraining admixture may be added.
2. When the measured or estimated slump is low, the following adjustments may be made:
 - a) For concrete mixes that do not include superplasticizer, water may be added:
 - i. Prior to discharge of concrete from the truck has started, or
 - ii. When the measured slump of concrete is lower than the maximum targeted range.
 - b) For concrete mixes with site-added superplasticizer:
 - i. Water may be added before superplasticizer is added at the site. Water additions may be done prior to discharge of concrete from the truck has started or when the measured slump of concrete is lower than the maximum targeted range,
 - ii. No water shall be added after the addition of a superplasticizer. Additional doses of superplasticizer may be added.
 - c) For concrete mixes with plant added superplasticizer:
 - i. No water shall be added.

- ii. Superplasticizer may be added.

No field adjustments shall be carried out after concrete has been accepted, with the exception of superplasticized concrete. For superplasticized concrete, addition of a superplasticizer to increase the slump to assist in placing shall be permitted.

When any material is added to the concrete, the load of concrete shall be mixed for 30 revolutions or more at the designated mixing speed to ensure that the concrete is uniformly mixed. The load shall be re-tested for acceptance.

1350.07.05.06 Visual Acceptance of Plastic Concrete

The Contractor shall visually inspect plastic concrete during discharge and placement to identify the presence of any segregation or lumps.

If any segregation is identified, the Contractor shall immediately reject the entire load of concrete.

Any visible lumps present in the concrete shall be removed before concrete is placed in the work. If more than 3 visible lumps are present in a load of concrete, the remainder of the load shall be immediately rejected and no further concrete from that truckload shall be placed in the work.

If more than three truckloads during the day's work are observed to contain more than 3 lumps per truck, concrete placement shall be stopped at the end of the Day or at the end of the placement of the specific structure component, whichever comes first.

No further concrete shall be placed until all of the following occur:

- a) The Contractor has provided an explanation of the reasons for the lumps and identified the steps that shall be taken to eliminate the reoccurrence of lumps in future work.
- b) A trial batch has been carried out in the presence of the Contract Administrator and the Contract Administrator has verified that the concrete is free of lumps.
- c) The Contract Administrator has granted written approval for placement to proceed.

1350.07.05.07 Within-Batch Uniformity of Plastic Concrete

When required by the Contract Administrator, determination of the within-batch uniformity of the plastic concrete shall be carried out by testing air content, slump, and density according to CSA A23.2-4C, 5C, and 6C, respectively. The Contractor shall be granted 24 hours' notice when density testing is required as part of within-batch uniformity determination. No advance notice shall be granted for carrying out the slump and air portion of the uniformity testing.

Tests shall be carried out on samples of concrete obtained when approximately 10%, 50%, and 90% of the batch has been discharged while the mixer is being emptied at normal operating rate. The minimum size of sample shall be 30 litres. Between samples, the mixer shall not be allowed to turn in the mixing direction.

The acceptance and rejection limits for uniformity shall be as shown in Table 2. When the result of each test is equal to or less than the acceptance limit, the concrete is uniform. When the result of any single test is greater than the rejection limit, the concrete is considered to be non-uniform.

If the result of any single test exceeds the acceptance limit and is not greater than the rejection limit, all tests shall be made on the next consecutive batch or load delivered by that mixing equipment.

If, after testing one additional batch or load, the test result is greater than the acceptance limit, the concrete is non-uniform.

When the concrete is non-uniform and the mixing equipment is a stationary mixer, no more concrete shall be produced in it until within batch uniformity has been demonstrated. If the unit is a truck mixer, the truck mixer shall not be used again.

1350.07.05.08 Submission of Plastic Concrete Test Results

After each Day's work, a copy of the delivery ticket for each load of concrete and a daily summary shall be submitted to the Contract Administrator. The daily summary shall include air contents, slumps prior to and after any additions, concrete temperature, and all adjustments made to each load of concrete, including volume of any water or superplasticizer added, and shall identify rejected material.

1350.07.05.09 Compressive Strength

1350.07.05.09.01 General

Prior to placing concrete, an estimate of concrete volumes for each minimum specified 28-Day compressive strength shall be provided to the Contract Administrator. Acceptance method A shall be used when the quantity of concrete of a specified minimum strength is 100 m³ or more. Acceptance method B shall be used for concrete in expansion joints, tremie concrete, or when the quantity of concrete of a specified minimum strength is less than 100 m³. The Contract Administrator shall confirm the method(s) to be used.

1350.07.05.09.02 Acceptance Method A

The Contract Administrator shall determine the lot and subplot size after discussion with the Contractor and before any concrete is placed. Each lot shall contain concrete of one specified minimum 28-Day strength. There shall be only one lot of each specified strength of concrete; however, if the quantity of concrete of one specified strength is greater than 5,000 m³, the Contract Administrator shall consider requests to divide the concrete into two lots based on placement in separate structures or in different construction seasons.

Each lot shall be divided into sublots of approximately 10 m³ to a maximum of 100 m³. Sublot sizes shall be established based on the estimated concrete quantity such that each lot contains a minimum of 10 sublots. One set of acceptance and one set of referee cylinders shall be made from each subplot. The loads of concrete to be sampled shall be selected by the Contract Administrator on a random basis.

In addition to acceptance cylinders cast on a random basis, the Contractor shall also cast test cylinders as required by the Contract Administrator. The results from these cylinders shall be used for assessment of structural adequacy, for information purposes, or for other uses by the Owner.

1350.07.05.09.03 Acceptance Method B

One set of acceptance and referee cylinders, each shall be cast for every 20 m³ of concrete placed or one set per day, whichever is more frequent.

1350.07.05.09.04 Test Cylinders

The Contractor shall cast, cure, and transport cylinders for compressive strength testing by the Owner.

Every time a set of acceptance cylinders is cast, a second set of cylinders shall be cast for referee testing purposes, unless otherwise specified in the Contract Documents.

Concrete test cylinders for compressive strength testing for acceptance and for referee testing purposes, where required, shall be cast, cured, and transported according to CSA A23.2-3C. Referee cylinders shall be cured and transported to the Regional Quality Assurance Laboratory, along with the acceptance cylinders. A set of cylinders for concrete made with aggregate of nominal maximum size larger than 19 mm shall consist of two 150 mm diameter x 300 mm long cylinders. For all other concrete, a set of cylinders shall consist of three 100 mm diameter x 200 mm long cylinders.

Concrete test cylinders for early strength determination shall be cast, cured, and transported as specified in the Contract Documents.

No referee cylinders shall be cast when cylinders are prepared for determination of early strength or are requested by the Owner, for information purposes.

All concrete test cylinders shall be cast in moulds. The moulds shall be single use moulds according to CSA A23.2-1D and made of plastic with a lid. The lids shall be chemically and physically compatible with the concrete and shall provide watertight closure for the moulds.

Test information shall be recorded on MTO form PH-CC 322, a copy of which shall be submitted with each set of the concrete cylinders.

The Contractor shall continuously record and monitor temperature immediately adjacent to the cylinders during the field-curing period. The maximum time interval for recording the temperature shall be every 15 minutes.

1350.07.05.09.05 Submission of Cylinder Curing Records

Cylinder curing temperature records shall be submitted to the Contract Administrator at the completion of the field-curing period.

1350.07.05.10 Air Void System Parameters

Cores for evaluation of air void system parameters shall be required for the categories of concrete shown in Table 3.

The Contractor shall remove cores from the hardened concrete for testing by the Owner. Cores shall be taken at random locations specified by the Contract Administrator. All cores shall be removed when the concrete is between 7 to 10 Days of age, and cores from bridge decks shall be removed prior to application of any waterproofing membrane.

The lot sizes, core size, and number of cores shall be as shown in Table 3. When two cores are required for a lot, the lot shall be divided into two, and one core shall be removed at a random location within each half of the lot. For concrete barriers and barrier walls on structures, the cores shall be removed from the lower sloped portion of the wall at the designated locations. For parapet walls, the cores shall be removed from the lower one-third of the wall at the designated locations. Steel reinforcement and other embedded material shall be avoided when possible while coring and the Contractor shall use a covermeter to establish reinforcement location, prior to coring.

For concrete patches and refacing where the total area of patches or refacing on a structure is less than 20 m², no cores shall be required, but one 100 x 200 mm cylinder shall be cast and tested.

The Contract number, lot number, and exact location of each individual core shall be marked legibly on the core with durable ink. The cores shall be delivered to the Regional Quality Assurance laboratory with a transmittal form and Form A of the concrete mix design for the component.

1350.07.05.11 Rapid Chloride Permeability

Cores for evaluation of rapid chloride permeability shall be required for HPC and silica fume overlays as shown in Table 4. Cores for evaluation of rapid chloride permeability may also be required for other concrete as specified in the Contract Documents.

The Contractor shall remove cores from the hardened concrete for testing by the Owner.

One core shall be removed at the random location specified by the Contract Administrator and the second core shall be removed at a location no more than 1 m from the location of the first core. Cores shall not contain steel reinforcement or other embedded material. All cores shall be removed when the concrete is between 7 to 10 Days of age and cores from bridge decks shall be removed prior to application of any waterproofing membrane.

The lot sizes, core sizes, and number of cores shall be as shown in Table 4. If the total quantity of a component is less than shown in the Table 4, the minimum number of cores specified in Table 4 shall be removed.

Each core shall be placed in a plastic bag, sealed to prevent loss of moisture, and delivered to the Regional Quality Assurance laboratory within 24 hours of coring with a transmittal form and Form A of the concrete mix design for the component.

1350.07.06 Filling of Core Holes

Each core hole shall be filled immediately after coring with a proprietary patching material from the Owner's pre-qualified product list. The patching material shall be comparable to the surrounding concrete in terms of strength and permeability. The patching material shall be mixed, handled, and cured according to the manufacturer's instructions. Immediately prior to filling, the inside surface of each core hole shall be cleaned of the paste left from the coring operation by nylon brushing and all free water shall be removed. The patch shall be finished flush with the surface of the surrounding concrete. All excess material shall be removed from the surface of the concrete.

1350.08 QUALITY ASSURANCE

1350.08.01 Acceptance of Concrete Compressive Strength

1350.08.01.01 General

Lots for compressive strength shall be as identified in the Acceptance Method A or Acceptance Method B clause, as applicable.

Compressive strength shall be determined according to LS-407 and LS-426.

The compressive strength result of a subplot shall be the average of the set of 3 acceptance cylinders made from the subplot, rounded to one decimal place, except for concrete made with aggregate of nominal maximum size larger than 19 mm where the subplot result shall be the average of 2 cylinders.

The individual test results shall be forwarded to the Contractor, as they become available. The Contractor shall forward individual test results and monthly summaries to the concrete supplier.

When any individual strength test result falls below the specified minimum 28-Day strength by more than 4.0 MPa, the Contract Administrator may require the Contractor to take and test 100 mm diameter concrete cores to determine whether individual sections of concrete are structurally adequate and whether remedial work or removal is required. When required, cores shall be removed in groups of 3 at

locations specified by the Contract Administrator. Cores shall be removed, moisture conditioned, and tested for compressive strength according to CSA A23.2-14C.

Where required, determination of structural adequacy is independent of and in addition to any payment reduction. Core results shall not replace cylinder results in any bonus or penalty calculations. Where extensive design calculation is required in order to confirm structural adequacy, the Contractor shall reimburse the Owner for all costs incurred up to a maximum of \$2,000.00 per occurrence.

1350.08.01.02 Acceptance Method A

Acceptance of concrete compressive strength for each lot shall be based on the mean and standard deviation of the compressive strength results of all sublots contained in the lot.

The mean and standard deviation of the results and forecast potential bonus or penalty, if any, shall be submitted to the Contractor at monthly intervals.

The Contract Administrator shall calculate the percent within limits (PWL) according to LS 101, using the specified compressive strength as the lower limit.

When the lot PWL is greater than 95%, the Contractor shall receive a bonus, in $\$/m^3$, as calculated by the following:

$$\text{Bonus} = \text{PWL} - 95$$

When the lot PWL is greater than or equal to 90% and less than or equal to 95%, there shall be no bonus or penalty due to concrete compressive strength.

When the lot PWL is less than 90% and greater than or equal to 50%, the Contractor shall be assessed a penalty, in $\$/m^3$, as calculated by the following:

$$\text{Penalty} = 90 - \text{PWL}$$

When the lot PWL is less than 50%, the lot is unacceptable and is subject to removal and replacement. The Contractor may submit an alternative in writing for the Owner's consideration for unacceptable lots. If the Contract Administrator determines that an unacceptable lot may remain in the work, it shall be subject to the calculated penalty.

For the purpose of penalty or bonus, the quantity of concrete in each lot shall be calculated by the Contract Administrator as the sum of the following:

- a) The payment quantity for items paid by unit price per cubic metre of concrete.
- b) The theoretical quantity indicated in the Contract Documents for items paid by lump sum, provided the actual quantity is within $\pm 3\%$ of the theoretical quantity.
- c) The quantity of concrete in each lot shall be calculated from the quantities indicated in the Contract Drawings for items, where these quantities are listed.
- d) The quantity based on the neat lines called for in the Contract Drawings, where none of the above methods are applicable.

1350.08.01.03 Acceptance Method B

Concrete compressive strength shall be considered acceptable when it meets all of the following:

- a) The average of all groups of 3 consecutive compressive strength tests shall be equal to or greater than the specified strength.
- b) No individual strength test shall be more than 4.0 MPa below the specified strength.

Unacceptable concrete shall be subject to removal and replacement.

The Contractor may submit an alternative in writing for the Owner's consideration for unacceptable concrete.

1350.08.01.04 Referee Testing Based on Duplicate Cylinders

The referee testing process for concrete compressive strength is based on duplicate cylinders cast at the same time as the acceptance cylinders.

Referee testing of compressive strength for a subplot may only be invoked by the Contractor within 5 Business Days of receiving the test results for that subplot.

The referee laboratory shall be designated by the Owner based on the applicable roster. Referee test results shall be forwarded to the Contractor, as they become available.

If the difference between the referee test result and the acceptance test result is less than the confirmation value, the acceptance test result is then confirmed and the acceptance test result shall be used in the determination of acceptance and payment for the concrete. If the difference between the referee test result and the acceptance test result is greater than the confirmation value, the acceptance test result is then not confirmed and the acceptance test result shall be disregarded and not used in the determination of acceptance and payment. The confirmation value for confirming the acceptance test result shall be the greater of 10% of the specified strength or 10% of the strength of the acceptance cylinders, expressed to one decimal place.

If the referee test result is more than 4.0 MPa below the specified strength, the result shall be reviewed to determine if structural adequacy is in question and, if so, the relevant provisions of this specification shall be followed.

When acceptance results are eliminated from the analysis as a result of referee process, the concrete shall be assessed based on the available strength results for the lot.

If acceptance test results from multiple sublots are eliminated such that there are fewer than 4 acceptance test results available for the lot, Acceptance Method B shall be used for acceptance of the concrete.

1350.08.01.04.01 Referee Testing Cost

The cost of compressive strength referee testing shall be as specified in the Contract Documents.

When the referee result confirms the acceptance test result, the Contractor shall be charged the cost of compressive strength referee testing. When the referee result does not confirm the acceptance test result, the Owner shall bear the cost.

1350.08.02 Acceptance of Air Void System in Hardened Concrete

1350.08.02.01 General

The lots for air void system shall be as shown in Table 3.

One half of each core shall be tested to determine the acceptability of concrete. The core shall be tested according to LS-432. The other half of each core shall be retained by the Owner for audit purposes.

Individual test results shall be forwarded to the Contractor, as they become available.

1350.08.02.02 Basis of Acceptance

For a lot to be considered acceptable, each core shall have air content of 3.0% or more and spacing factor of 0.230 mm or less in all concrete, except for silica fume overlays and HPC where the spacing factor shall be 0.250 mm or less. Acceptable lots shall be subject to full payment or bonus payment.

An unacceptable lot is a lot represented by one or two cores that fail to meet the air void system parameters. Unacceptable lots shall be removed and replaced except where the Owner permits the work to remain in place. The removal and replacement of unacceptable lots shall be at no additional cost to the Owner. The replacement lots shall be evaluated for acceptance on the same basis as the original lot. When the Owner permits the work to remain in place, it shall be subject to the calculated penalty and shall not be eligible for bonus.

For the purpose of calculating a bonus or penalty, the Contract Administrator shall round-off spacing factor test data to two decimal places and air content test data to one decimal place according to LS-100 and shall determine the quantity of concrete in lots using the dimensions as specified in the Contract Documents.

When two cores are tested per lot, the bonus payment for an acceptable lot shall be calculated by averaging bonus values corresponding to individual core results. When one core is tested per lot, the bonus payment for an acceptable lot shall be the bonus value corresponding to the core.

Bonus payment for a lot represented by 2 cores shall be calculated according to the following:

$$B = (B1 + B2)/2$$

Where: B = bonus in $\$/m^3$ of concrete in the lot
B1 and B2 = bonus for cores 1 and 2 in $\$/m^3$ of concrete in the lot from Table 5

Bonus for acceptable lot = lot quantity (m^3) x B

Payment for unacceptable lots shall be calculated by averaging the pay factors corresponding to individual core results. Where one core in an unacceptable lot meets the specified requirements for air void system, the core shall be assigned a pay factor of 100%. When only one core is tested per lot, the payment for an unacceptable lot shall be the pay factors corresponding to the individual core result.

Payment for unacceptable lot represented by two cores shall be calculated according to the following:

$$P = (P1 + P2)/2$$

Where: P = pay factor for the lot (%)
P1 and P2 = pay factor for cores 1 and 2 in % as shown in Table 6 or 7, as applicable

Payment reduction for a lot = lot quantity/tender quantity x tender lump sum price x ((100-P)/100)

Where: Lot quantity and tender quantity are in cubic metres

1350.08.02.03 Referee Testing

Referee testing of air void system parameters may only be invoked by the Contractor within 5 Business Days of receiving the test result.

When referee testing is invoked, all core samples representing a lot shall be referee tested and the acceptance test results discarded. The lot referee test results shall replace the acceptance test result in the acceptance requirements of this specification.

Referee testing shall be carried out on the same half of the core sample that was tested for acceptance.

Cores shall be tested according to LS-431. Referee test results shall be forwarded to the Contractor, as they become available.

1350.08.02.03.01 Referee Testing Cost

The cost of air void system referee testing shall be as specified in the Contract Documents.

When the referee results indicate that the refereed lot is acceptable, the Owner shall bear the cost. When the referee results indicate that the refereed lot is not acceptable, the Contractor shall be charged the cost of the air void system referee testing.

1350.08.03 Acceptance of Rapid Chloride Permeability

1350.08.03.01 General

The lots for rapid chloride permeability shall be as shown in Table 4.

Cores shall be tested according to LS-433. Acceptance testing shall be carried out at 28 to 32 Days. For HPC, two 50 mm long samples shall be cut from one of the cores representing a lot and tested to determine the acceptance of the lot. The other core shall be retained for referee testing.

For silica fume overlays, one 50 mm sample shall be cut from each of 2 cores. Two samples for the lot shall be tested to determine the acceptance of the lot. The remaining 2 cores shall be retained for referee testing.

Individual test results shall be forwarded to the Contractor, as they become available.

1350.08.03.02 Basis of Acceptance

Acceptance of rapid chloride permeability shall be based on the average of results obtained on cores representing a lot. Lots with an average value of rapid chloride permeability exceeding 1,000 coulombs and less than or equal to 2,000 coulombs shall be accepted with a price reduction. Lots with rapid chloride permeability value exceeding 2,000 coulombs shall be considered unacceptable. Unacceptable concrete shall be removed and replaced at the Contractor's expense.

For the purpose of calculating penalty, the Contract Administrator shall determine the quantity of concrete in the lots using the dimensions as specified in the Contract Documents.

The payment reduction shall be calculated and applied as follows:

$$Pa = (C-1000)/5$$

Where: Pa = payment reduction in $\$/m^3$
 C = average rapid chloride permeability of a lot

Payment reduction per lot = lot quantity (m^3) x Pa

1350.08.03.03 Referee Testing

Referee testing of rapid chloride permeability may only be invoked by the Contractor within 5 Business Days of receipt of the acceptance test result.

For HPC, referee testing shall be carried out on two 50 mm samples obtained from the reserved core representing the lot for which referee testing was invoked and the results shall be averaged to obtain the test result for the lot. For silica fume overlay, referee testing shall be carried out on two 50 mm samples cut from the two reserved cores representing the lot for which referee testing was invoked and the results shall be averaged to obtain the test result for the lot.

Cores shall be tested according to LS-433.

Referee test results shall be forwarded to the Contractor, as they become available.

When the referee result is greater than the acceptance test result or no more than 200 Coulombs below the acceptance test result, the acceptance test result is then confirmed and shall remain valid. When the referee test result for the lot is more than 200 Coulombs below the acceptance test result, the acceptance test result is then not confirmed and the referee test result shall replace the acceptance test result in the acceptance requirements of this specification.

1350.08.03.03.01 Referee Testing Cost

The cost of referee testing shall be as specified in the Contract Documents.

When the referee result confirms the acceptance test result, the Contractor shall be responsible for the cost of rapid chloride permeability referee testing. When the referee result does not confirm the acceptance test result, the Owner shall bear the cost.

1350.08.04 Acceptance of Admixtures, Water and Cementing Materials

1350.08.04.01 Admixtures

1350.08.04.01.01 General

Air entraining admixtures shall be tested by the Owner for pH and relative density. Chemical and superplasticizing admixtures shall be tested by the Owner for relative density and non-volatile content. Testing shall be according to LS-413, LS-414, and LS-415, as applicable.

One 750 ml admixture sample shall be used for acceptance testing. The other 750 ml admixture sample shall be reserved for referee testing.

Individual test results shall be forwarded to the Contractor, as they become available.

1350.08.04.01.02 Basis of Acceptance

Relative density, pH and non-volatile content shall be according to OPSS 1303. Admixtures represented by sample test results that fail to fall within the specified tolerances for pH, relative density, or non-volatile content shall be deemed unacceptable and no further concrete shall be produced with that supply of admixture.

For each admixture represented by sample test results that exceed the tolerances specified by OPSS 1303 and before any additional concrete can be placed, the Contractor shall remove and replace the admixture with a new supply of admixture meeting the requirements of OPSS 1303.

For each sample of air-entraining admixture that exceeds the tolerances for relative density, or pH, or both, as shown in Table 9, in addition to the removal and replacement of the admixture represented by the sample, a payment reduction of \$5000 shall be assessed.

For each chemical admixture sample that exceeds the tolerances for relative density, or non-volatile content or both, as shown in Table 9, in addition to the removal and replacement of the admixture represented by the sample, a payment reduction of \$5000 shall be assessed.

For each superplasticizing admixture sample that exceeds the tolerances for relative density, or non-volatile content or both, as shown in Table 9, in addition to the removal and replacement of the admixture represented by the sample, a payment reduction of \$5000 shall be assessed.

Notwithstanding the above, concrete made with admixtures that do not meet the specified requirement may be subject to additional financial penalty or removal if the deficiency has the capacity to adversely impact the short or long term performance of the concrete.

1350.08.04.01.03 Referee Testing

Referee testing of admixtures may only be invoked by the Contractor within 5 Business Days of receiving the test results. Referee testing shall be carried out on the reserved referee sample.

The referee laboratory shall be designated by the Owner based on the applicable roster. Referee samples shall be transported from the Regional Quality Assurance laboratory to the Referee Laboratory by the Owner, and testing shall be carried out according to LS-413, LS-414, and LS-415, as applicable.

Referee test results shall be forwarded to the Contractor, as they become available.

The referee test results shall replace the original results.

The cost of referee testing shall be as specified in the Contract Documents.

When the referee results indicate that the refereed sample is acceptable, the Owner shall bear the cost. When the referee results indicate that the refereed sample is not acceptable, the Contractor shall be charged the cost of the admixture referee testing.

1350.08.04.02 Water Other than Municipal Drinking Water

1350.08.04.02.01 General

Samples of water, other than municipal water, shall be tested by the Owner according to OPSS 1302.

One 1-litre water sample shall be used for acceptance testing. The other 1-litre water sample shall be reserved for referee testing.

Individual test results shall be forwarded to the Contractor, as they become available.

1350.08.04.02.02 Basis of Acceptance

Water that fails the requirements of OPSS 1302 shall be deemed unacceptable and the source of water represented by the failed samples shall not be used for making of concrete.

Concrete made with water that does not meet the specified requirements is unacceptable and may be subject to financial penalty or removal if there is potential for the short-term or long-term performance of the concrete to be adversely affected.

1350.08.04.02.03 Referee Testing

Referee testing of water may only be invoked by the Contractor within 5 Business Days of receiving the test results. Referee testing shall be carried out on the reserved referee sample.

The referee laboratory shall be designated by the Owner based upon the applicable roster. Referee samples shall be transported from the Regional Quality Assurance laboratory to the Referee Laboratory by the Owner, and testing shall be carried out according to OPSS 1302.

Referee test results shall be forwarded to the Contractor, as they become available.

The referee test results shall replace the original result.

The cost of referee testing shall be as specified in the Contract Documents.

When the referee results indicate that the refereed sample is acceptable, the Owner shall bear the cost. When the referee results indicate that the refereed sample is not acceptable, the Contractor shall be charged the cost of the water referee testing.

1350.08.04.03 Cementing Materials

1350.08.04.03.01 General

Cementing materials shall be tested by the Owner for fineness, soundness by autoclave, initial time of set, compressive strength, and slag activity index or pozzolanic strength activity index, as applicable, according to CSA A 3000.

One 10-kilogram sample shall be taken and divided into two 5-kilogram samples. One 5-kilogram sample shall be used for acceptance testing. The second 5-kilogram sample shall be reserved for referee testing.

Individual test results shall be forwarded to the Contractor as they become available.

1350.08.04.03.02 Basis of Acceptance

Cementing materials that do not comply with the requirements of OPSS 1301 and CAN/CSA A3001 shall not be used for making of concrete.

Concrete made with cementing materials that do not meet the specified requirements is unacceptable and may be subject to financial penalty or removal if there is potential for the short-term or long-term performance of the concrete to be adversely affected.

1350.08.04.03.03 Referee Testing

Referee testing of cementing materials may only be invoked by the Contractor within 5 Business Days of receiving the test results. Referee testing shall be carried out on the reserved referee sample.

Referee testing shall be carried out according to CSA A 3000 by the Owner's laboratory or an independent laboratory acceptable to the Contractor and the Owner in the presence of the Contractor or his designate.

Referee results shall be reported to the Contractor, as they are available.

The referee test results shall replace the original result.

The cost of referee testing shall be as specified in the Contract Documents.

When the referee results indicate that the refereed sample is acceptable, the Owner shall bear the cost. When the referee results indicate that the refereed sample is not acceptable, the Contractor shall be charged the cost of the cementing material referee testing.

TABLE 1
Slump and Air Content of Plastic Concrete

Component	Slump mm (Note 1)	Air Content in Plastic Concrete %
Cast-In-Place, Slip formed Concrete Barriers	Target slump ± 10	Target air ± 1.5
Tremie Concrete	Target slump ± 30	When required 5.0 ± 1.5
All Other Concrete	Target slump ± 20	Target air ± 1.5
Note: 1. When the use of superplasticizer is permitted, requirements shall be as specified in the Concrete clause.		

TABLE 2
Determination of Within-Batch Uniformity of the Concrete

Test	Range Between Highest and Lowest Values of 3 Test Samples	
	Acceptable If Equal to or Less Than	Rejectable If More Than
Density, kg/m ³	32	50
Air Content in Plastic Concrete, %	0.7	1.0
Slump, mm	30	50

TABLE 3
Cores for Air Void System Determination

Category	Lot Size	Core Size	Number of Cores Per Lot
Sidewalk on Structure and Curb on Structure	500 lineal metres per stage.	100 mm diameter and 200 mm long.	2
Median on Structure	500 lineal metres per stage.		
Parapet or Barrier Wall on Structure	500 lineal metres per structure per stage.		
Toe Wall	500 lineal metres per stage.		
Bridge Deck-Thin Slab Deck	500 m ² per stage.		
Bridge Deck-Post-Tensioned Deck	300 m ² per stage.		
Abutment, Wingwall, Cast-In-Place Retaining Wall	1 abutment, wingwall, cast-in-place retaining wall or a stage thereof.		
Pier	1 pier. (Note 1)		
Arches and Spandrels	Between piers or between pier and abutment.		
Culvert	1,000 m ² of floor area of cast-in-place concrete culvert. (Note 2)		
	All cast-in-place concrete associated with a precast culvert.		
Approach Slab	500 m ² per stage.		
Sidewalk and Curb With Gutter	500 lineal metres. (Note 3)	100 mm diameter and a minimum of 125 mm long.	2
Concrete Barrier	Cast-in-place, slip formed: 1,000 lineal metres. (Note 3) Cast-in- place, formed, including transitions: 250 lineal metres. (Note 3)	100 mm diameter and 200 mm long.	2
Concrete Patches and Refacing	Approximately equal in size and not greater than 100 m ² for each individual structure.	150 mm diameter and 100 mm long.	1
Overlays	300 m ² per placement per individual structure.	150 mm diameter and 100 mm long.	1
Concrete Pavement and Concrete Base	Covered by OPSS 350		
Notes: 1. A pier consists of columns and a pier cap. 2. The total floor area of a component shall be added together and then divided into lots of specified size. Where a culvert has no floor, the area of the upper surface shall be used as the basis of determining lots. 3. The total length of a component shall be added together and then divided into lots of specified size.			

TABLE 4
Cores for Rapid Chloride Permeability Determination

Category	Lot Size	Core Size	Number of Cores Per Lot
Sidewalk on Structure and Curb on Structure	500 lineal metres per stage.	100 mm diameter and a minimum 125 mm long.	2
Median on Structure	500 lineal metres per stage.		
Parapet or Barrier Wall on Structure	500 lineal metres per stage.		
Bridge Deck	500 m ² per stage.		
Abutment, Wingwall, Cast-In-Place Retaining Wall	1 abutment, wingwall, cast-in-place retaining wall or a stage thereof.		
Pier	1 pier. (Note 1)		
Arches and Spandrels	Between piers or between pier and abutment.		
Overlays	300 m ² per placement for each individual structure.	100 mm diameter and 70 mm long. (Note 2)	4
Notes: 1. A pier consists of columns and a pier cap. 2. Where overlay thickness is less than 70 mm, the Contractor shall make cylinders for testing of rapid chloride permeability.			

TABLE 5
Bonuses for Air Void System Parameters in All Hardened Concrete
\$/m³

		Air Content, %																															
		3.9	4.0	4.1	4.2	4.3	4.4	4.5	4.6	4.7	4.8	4.9	5.0	5.1	5.2	5.3	5.4	5.5	5.6	5.7	5.8	5.9	6.0	6.1	6.2	6.3	6.4	6.5	6.6	6.7	6.8	6.9	7.0
Spacing Factor , mm	<0.100	0	1	2	3	4	4	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	4	4	3	2	1	0
	0.100	0	1	2	3	4	4	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	4	4	3	2	1	0
	0.110	0	1	2	3	4	4	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	4	4	3	2	1	0	
	0.120	0	1	2	3	4	4	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	4	4	3	2	1	0	
	0.130	0	1	2	3	4	4	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	4	4	3	2	1	0	
	0.140	0	1	2	3	4	4	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	4	4	3	2	1	0	
	0.150	0	1	2	3	4	4	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	4	4	3	2	1	0	
	0.160	0	1	2	3	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	3	2	1	0	
	0.170	0	1	2	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	2	1	0	
	0.180	0	1	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	1	0
0.190	0	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	0	
0.200	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
Notes:																																	
A. For silica fume overlays and HPC, when a core has an air content of 3% or higher and a spacing factor of 0.250 mm or lower, but its air void system parameters are outside the range shown in Table 5, it shall be assigned a value of 0 \$/m ³ for the purpose of calculating a bonus.																																	
B. For all other concrete, when a core has an air content of 3% or higher and a spacing factor of 0.230 mm or lower, but its air void system parameters are outside the range shown in Table 5, it shall be assigned a value of 0 \$/m ³ for the purpose of calculating a bonus.																																	

TABLE 6
Pay Factor for Air Void System Parameters of Hardened Concrete for Concrete Other Than Silica Fume Overlays and HPC
Pay Factor in % of Tender Item Price Per Lot

	Air Content, %																				
	1.0	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	1.9	2.0	2.1	2.2	2.3	2.4	2.5	2.6	2.7	2.8	2.9	>2.9
<0.100	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
0.100	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
0.110	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
0.120	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
0.130	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
0.140	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
0.150	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
0.160	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
0.170	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
0.180	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
0.190	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
0.200	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
0.210	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
0.220	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
0.230	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
0.240	50	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95
0.250	48	50	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95
0.260	45	48	50	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93
0.270	43	45	48	50	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90
0.280	40	43	45	48	50	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88
0.290	38	40	43	45	48	50	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86
0.300	36	38	40	43	45	48	50	52	55	57	59	62	64	67	69	71	74	76	79	81	83
0.310	33	36	38	40	43	45	48	50	52	55	57	59	62	64	67	69	71	74	76	79	81
0.320	31	33	36	38	40	43	45	48	50	52	55	57	59	62	64	67	69	71	74	76	79
0.330	29	31	33	36	38	40	43	45	48	50	52	55	57	59	62	64	67	69	71	74	76
0.340	26	29	31	33	36	38	40	43	45	48	50	52	55	57	59	62	64	67	69	71	74
0.350	24	26	29	31	33	36	38	40	43	45	48	50	52	55	57	59	62	64	67	69	71
0.360	21	24	26	29	31	33	36	38	40	43	45	48	50	52	55	57	59	62	64	67	69
0.370	19	21	24	26	29	31	33	36	38	40	43	45	48	50	52	55	57	59	62	64	67
0.380	17	19	21	24	26	29	31	33	36	38	40	43	45	48	50	52	55	57	59	62	64
0.390	14	17	19	21	24	26	29	31	33	36	38	40	43	45	48	50	52	55	57	59	62
0.400	12	14	17	19	21	24	26	29	31	33	36	38	40	43	45	48	50	52	55	57	59
0.410	9	12	14	17	19	21	24	26	29	31	33	36	38	40	43	45	48	50	52	55	57
0.420	7	9	12	14	17	19	21	24	26	29	31	33	36	38	40	43	45	48	50	52	55
0.430	5	7	9	12	14	17	19	21	24	26	29	31	33	36	38	40	43	45	48	50	52
0.440	2	5	7	9	12	14	17	19	21	24	26	29	31	33	36	38	40	43	45	48	50
0.450	0	2	5	7	9	12	14	17	19	21	24	26	29	31	33	36	38	40	43	45	48
>0.450	0	0	2	5	7	9	12	14	17	19	21	24	26	29	31	33	36	38	40	43	45

Note:

- A. When a core in an unacceptable lot has an air content of 3% or higher and a spacing factor of 0.230 mm or lower, the core shall be assigned a value of 100% for the purpose of calculating a penalty.
- B. Thick line between 0.230 and 0.240 mm spacing factor indicates maximum acceptable spacing factor.

TABLE 7
Pay Factor for Air Void System Parameters of Hardened Concrete for HPC and Silica Fume Overlays
Pay Factor in % of Tender Item Price Per Lot

	Air Content, %																					
	1.0	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	1.9	2.0	2.1	2.2	2.3	2.4	2.5	2.6	2.7	2.8	2.9	>2.9	
Spacing Factor, mm	<0.100	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
	0.100	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
	0.110	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
	0.120	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
	0.130	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
	0.140	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
	0.150	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
	0.160	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
	0.170	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
	0.180	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
	0.190	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
	0.200	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
	0.210	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
	0.220	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
	0.230	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
	0.240	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
	0.250	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95	100
	0.260	50	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95	95
	0.270	47	50	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93	95
	0.280	45	47	50	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90	93
	0.290	42	45	47	50	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88	90
	0.300	39	42	45	47	50	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86	88
	0.310	36	39	42	45	47	50	52	55	57	59	62	64	67	69	71	74	76	79	81	83	86
	0.320	33	36	39	42	45	47	50	52	55	57	59	62	64	67	69	71	74	76	79	81	83
	0.330	30	33	36	39	42	45	47	50	52	55	57	59	62	64	67	69	71	74	76	79	81
	0.340	27	30	33	36	39	42	45	47	50	52	55	57	59	62	64	67	69	71	74	76	79
	0.350	24	27	30	33	36	39	42	45	47	50	52	55	57	59	62	64	67	69	71	74	76
	0.360	21	24	27	30	33	36	39	42	45	47	50	52	55	57	59	62	64	67	69	71	74
	0.370	19	21	24	27	30	33	36	39	42	45	47	50	52	55	57	59	62	64	67	69	71
	0.380	16	19	21	24	27	30	33	36	39	42	45	47	50	52	55	57	59	62	64	67	69
	0.390	13	16	19	21	24	27	30	33	36	39	42	45	47	50	52	55	57	59	62	64	67
	0.400	10	13	16	19	21	24	27	30	33	36	39	42	45	47	50	52	55	57	59	62	64
	0.410	7	10	13	16	19	21	24	27	30	33	36	39	42	45	47	50	52	55	57	59	62
	0.420	5	7	10	13	16	19	21	24	27	30	33	36	39	42	45	47	50	52	55	57	59
	0.430	3	5	7	10	13	16	19	21	24	27	30	33	36	39	42	45	47	50	52	55	57
	0.440	0	3	5	7	10	13	16	19	21	24	27	30	33	36	39	42	45	47	50	52	55
	0.450	0	0	3	5	7	10	13	16	19	21	24	27	30	33	36	39	42	45	47	50	52
	>0.450	0	0	0	3	5	7	10	13	16	19	21	24	27	30	33	36	39	42	45	47	50
Notes:																						
A. When a core in an unacceptable lot has an air content of 3% or higher and a spacing factor of 0.250 mm or lower, the core shall be assigned a value of 100% for the purpose of calculating a penalty.																						
B. Thick line between 0.250 and 0.260 mm spacing factor indicates maximum acceptable spacing factor.																						

TABLE 8
Admixtures, Water, and Cementing Materials - Minimum
Frequencies for Sampling and Testing

Material	Use or Type of Construction	Minimum Sampling Frequency (Note 1)	Minimum Sample Size (Note 2)
Air Entraining and Chemical and Superplasticizing Admixtures	All concrete.	One sample shall be taken at the beginning of concrete placement in each calendar year, no more than 30 Days prior to concrete placement.	Two samples shall be taken. Each shall be at least 750 ml.
Water Other Than Municipal Drinking Water	All concrete.	One additional sample shall be taken during the calendar year.	Two samples shall be taken. Each shall be at least 1 litre.
Cementing Materials: Portland Cement, Ground Granulated Blast Furnace Slag, Fly Ash, and Blended Silica Fume Cement	Concrete pavement and base.	One sample per Contract or one sample per each 10, 000 m³ of concrete, whichever is more frequent.	10 kg of each cementing material used.
	Precast components.	One sample per calendar year.	
	All other concrete.	One sample per Contract or one sample per each 5,000 m³ of concrete, whichever is more frequent.	
Notes:			
1. Additional samples shall be taken every time there is a change in material source.			
2. Admixture and water samples shall be contained in a 1 litre bottle of a suitable plastic with a lid. Cementing material samples shall be contained in a canvas bag with plastic insert, accompanied by MTO form PH-CC-340.			

TABLE 9
Admixture Test Result Tolerances for Acceptance Purposes

Test Result	Air Entraining Admixtures	Chemical and Superplasticizing Admixtures
Relative Density	a) ± 0.010 where the value of relative density shown on DSM is 1.050 or less b) $\pm X$ where the value of relative density shown on DSM is greater than 1.050; Where $X = (\text{relative density shown on DSM} - 1.000) / 5$	
Non-volatile Content	Not required	$\pm 3.0\%$ of the value shown on DSM *
pH	± 2.0 of the value shown on DSM	Not required
* Example: If value shown on DSM is 10.0 %, no payment reduction will be applied if the result is between 7.0% and 13.0 %.		

Appendix 1350-A, November 2016
FOR USE WHILE DESIGNING MUNICIPAL CONTRACTS

Note: This is a non-mandatory Commentary Appendix intended to provide information to a designer, during the design stage of a contract, on the use of the OPS specification in a municipal contract. This appendix does not form part of the standard specification. Actions and considerations discussed in this appendix are for information purposes only and do not supersede an Owner's design decisions and methodology.

Designer Action/Considerations

No information provided here.

Related Ontario Provincial Standard Drawings

No information provided here



**ONTARIO
PROVINCIAL
STANDARD
SPECIFICATION**

**METRIC
OPSS.PROV 1504
NOVEMBER 2016**
(Formerly OPSS 1504, November 2010)

Note: The PROV implemented in November 2016 replaces OPSS 1504 COMMON, November 2010 with no content changes.

**MATERIAL SPECIFICATION FOR
STEEL BEAM GUIDE RAIL**

TABLE OF CONTENTS

1504.01	SCOPE
1504.02	REFERENCES
1504.03	DEFINITIONS - Not Used
1504.04	DESIGN AND SUBMISSION REQUIREMENTS - Not Used
1504.05	MATERIALS
1504.06	EQUIPMENT - Not Used
1504.07	PRODUCTION
1504.08	QUALITY ASSURANCE - Not Used
1504.09	OWNER PURCHASE OF MATERIAL

APPENDICES

1504-A	Commentary
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1504.01 SCOPE

This specification covers the requirements for steel beam guide rail, terminal sections, fabricated bases, and installation hardware.

1504.01.01 Specification Significance and Use

This specification has been developed for use in provincial- and municipal-oriented Contracts. The administration, testing, and payment policies, procedures, and practices reflected in this specification correspond to those used by many municipalities and the Ontario Ministry of Transportation.

Use of this specification or any other specification shall be according to the Contract Documents.

1504.01.02 Appendices Significance and Use

Appendices are not for use in provincial contracts as they are developed for municipal use, and then, only when invoked by the Owner.

Appendices are developed for the Owner's use only.

Inclusion of an appendix as part of the Contract Documents is solely at the discretion of the Owner. Appendices are not a mandatory part of this specification and only become part of the Contract Documents as the Owner invokes them.

Invoking a particular appendix does not obligate an Owner to use all available appendices. Only invoked appendices form part of the Contract Documents.

The decision to use any appendix is determined by an Owner after considering their contract requirements and their administrative, payment, and testing procedures, policies, and practices. Depending on these considerations, an Owner may not wish to invoke some or any of the available appendices.

1504.02 REFERENCES

When the Contract Documents indicate that provincial-oriented specifications are to be used and there is a provincial-oriented specification of the same number as those listed below, references within this specification to an OPSS shall be deemed to mean OPSS.PROV, unless use of a municipal-oriented specification is specified in the Contract Documents. When there is not a corresponding provincial-oriented specification, the references below shall be considered to be to the OPSS listed, unless use of a municipal-oriented specification is specified in the Contract Documents.

When the Contract Documents indicate that municipal-oriented specifications are to be used and there is a municipal-oriented specification of the same number as those listed below, references within this specification to an OPSS shall be deemed to mean OPSS.MUNI, unless use of a provincial-oriented specification is specified in the Contract Documents. When there is not a corresponding municipal-oriented specification, the references below shall be considered to be the OPSS listed, unless use of a provincial-oriented specification is specified in the Contract Documents.

This specification refers to the following standards, specifications, or publications:

CSA Standards

G40.20/G40.21-04 (R2009)	General Requirements for Rolled or Welded Structural Quality Steel/Structural Quality Steels
G164-M92 (R2003)	Hot Dip Galvanizing of Irregularly Shaped Articles
W59-03 (R2008)	Welded Steel Construction (Metal Arc Welding) (Metric Version)

ASTM International

A 307-07 Carbon Steel Bolts and Studs, 60,000 PSI Tensile Strength

1504.05 MATERIALS

1504.05.01 Rail and Terminal Sections

Rail elements shall have a minimum yield strength of 345 MPa.

After fabrication, all rail elements and terminal sections shall be hot dip galvanized according to CAN/CSA G164.

1504.05.02 Fabricated Steel Bases

Steel bases shall be fabricated according to CSA G40.20/G40.21. After fabrication, steel bases shall be hot dip galvanized according to CAN/CSA G164.

1504.05.03 Installation Hardware

All bolts, nuts, and washers shall be according to ASTM A 307 and hot dip galvanized according to CAN/CSA G164.

1504.07 PRODUCTION

1504.07.01 Steel Beam Guide Rail and Terminal Sections

Steel beam guide rail shall consist of rail elements fabricated to develop continuous beam strength with a cross-section as specified in the Contract Documents.

Bolt holes in rail elements, terminal sections, and fabricated bases shall be perpendicular to the surface and shall not deviate more than 1.0 mm in any direction from the true location. Rail element and terminal section ends shall be cut square.

After fabrication, prefabricated curved steel rail elements shall be galvanized according to CAN/CSA G164.

Steel beam guide rail components furnished under this specification shall be interchangeable with similar components regardless of the source or manufacturer.

1504.07.02 Marking

As a minimum, each rail element shall be marked with the following information:

- a) Name, trademark, or brand of the manufacturer.
- b) Standard designation 1504. M180A2 will be accepted as an equivalent standard designation.
- c) Identification symbols or code for heat.
- d) Week number and year of production.

Markings shall be clearly and permanently stamped in the valley of the centre corrugation, placed at a location clear of the splice overlap, and shall not be obscured after installation. The height of the letters and numerals shall be within the range of 19 to 32 mm.

1504.07.03 Welding

All welds shall be according to CSA W59 and shall be continuous.

1504.09 OWNER PURCHASE OF MATERIAL

1504.09.01 Measurement and Payment

For measurement purposes, a count shall be made of the number of steel beam guide rail elements delivered and accepted.

For measurement purposes, a count shall be made of the number of terminal sections delivered and accepted.

For measurement purposes, a count shall be made of the number of fabricated steel bases for guide rail posts delivered and accepted.

Installation hardware shall be measured in the units specified in the purchasing order, delivered and accepted.

Payment at the price specified in the purchasing order shall be for the supply of steel beam guide rail elements, terminal sections, fabricated steel bases, and installation hardware delivered to the destination or destinations at the dates and times specified.

The cost of all testing, except that performed in the Owner's laboratory, shall be included in the price.

Appendix 1504-A, November 2010
FOR USE WHILE DESIGNING MUNICIPAL CONTRACTS

Note: This is a non-mandatory Commentary Appendix intended to provide information to a designer, during the design stage of a contract, on the use of the OPS specification in a municipal contract. This appendix does not form part of the standard specification. Actions and considerations discussed in this appendix are for information purposes only and do not supersede an Owner's design decisions and methodology.

Designer Action/Considerations

The designer should ensure that the General Conditions of Contract and the 100 Series General Specifications are included in the Contract Documents.

Related Ontario Provincial Standard Drawings

OPSD 912.101	Guide Rail System, Steel Beam, Rail, Component
OPSD 912.104	Guide Rail System, Steel Beam, Steel Post with Wooden Offset Block, Component
OPSD 912.105	Guide Rail System, Steel Beam, Base Plate, Component



**ONTARIO
PROVINCIAL
STANDARD
SPECIFICATION**

**METRIC
OPSS.PROV 1505
NOVEMBER 2016**
(Formerly OPSS 1505,
November 2010)

Note: The PROV implemented in November 2016 replaces OPSS 1505 COMMON, November 2010 with no content changes.

**MATERIAL SPECIFICATION FOR
CHANNEL COMPONENTS FOR STEEL BEAM GUIDE RAIL**

TABLE OF CONTENTS

1505.01	SCOPE
1505.02	REFERENCES
1505.03	DEFINITIONS - Not Used
1505.04	DESIGN AND SUBMISSION REQUIREMENTS - Not Used
1505.05	MATERIALS
1505.06	EQUIPMENT - Not Used
1505.07	PRODUCTION
1505.08	QUALITY ASSURANCE - Not Used
1505.09	OWNER PURCHASE OF MATERIAL

APPENDICES

1505-A	Commentary
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1505.01	SCOPE
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This specification covers the requirements for steel channel and installation hardware.

1505.01.01 Specification Significance and Use

This specification has been developed for use in provincial- and municipal-oriented Contracts. The administration, testing, and payment policies, procedures, and practices reflected in this specification correspond to those used by many municipalities and the Ontario Ministry of Transportation.

Use of this specification or any other specification shall be according to the Contract Documents.

1505.01.02 Appendices Significance and Use

Appendices are not for use in provincial contracts as they are developed for municipal use, and then, only when invoked by the Owner.

Appendices are developed for the Owner's use only.

Inclusion of an appendix as part of the Contract Documents is solely at the discretion of the Owner. Appendices are not a mandatory part of this specification and only become part of the Contract Documents as the Owner invokes them.

Invoking a particular appendix does not obligate an Owner to use all available appendices. Only invoked appendices form part of the Contract Documents.

The decision to use any appendix is determined by an Owner after considering their contract requirements and their administrative, payment, and testing procedures, policies, and practices. Depending on these considerations, an Owner may not wish to invoke some or any of the available appendices.

1505.02 REFERENCES

When the Contract Documents indicate that provincial-oriented specifications are to be used and there is a provincial-oriented specification of the same number as those listed below, references within this specification to an OPSS shall be deemed to mean OPSS.PROV, unless use of a municipal-oriented specification is specified in the Contract Documents. When there is not a corresponding provincial-oriented specification, the references below shall be considered to be to the OPSS listed, unless use of a municipal-oriented specification is specified in the Contract Documents.

When the Contract Documents indicate that municipal-oriented specifications are to be used and there is a municipal-oriented specification of the same number as those listed below, references within this specification to an OPSS shall be deemed to mean OPSS.MUNI, unless use of a provincial-oriented specification is specified in the Contract Documents. When there is not a corresponding municipal-oriented specification, the references below shall be considered to be the OPSS listed, unless use of a provincial-oriented specification is specified in the Contract Documents.

This specification refers to the following standards, specifications, or publications:

CSA Standards

G164-M92 (R2003) Hot Dip Galvanizing of Irregularly Shaped Articles
S136-07 Cold Formed Steel Structural Members

ASTM International

A 307-07 Carbon Steel Bolts and Studs, 60,000 PSI Tensile Strength

1505.05 MATERIALS

1505.05.01 Cold Rolled Channel

Channels shall be cold rolled steel sections according to CSA S136 and have a minimum yield strength of 345 MPa. After fabrication, sections shall be hot dip galvanized according to CAN/CSA G164.

1505.05.02 Installation Hardware

All bolts, nuts, and washers shall be according to ASTM A 307 and be hot dip galvanized according to CAN/CSA G164.

1505.07 PRODUCTION

1505.07.01 Fabrication Tolerances and Workmanship

Bolt holes in steel channels shall be perpendicular to the surface and shall not deviate more than 1.0 mm in any direction from the true location. Steel channel ends shall be cut square.

After fabrication, curved steel channels shall be hot dip galvanized according to CAN/CSA G164.

1505.07.02 Marking

As a minimum, each steel channel section shall be marked with the following information:

- a) Name, trademark, or brand of the manufacturer.
- b) Standard designation 1505.
- c) Identification symbols or code for heat.
- d) Week number and year of production.

Markings shall be clearly and permanently stamped in the valley of the steel channel, placed at a location clear of the splice overlap, and shall not be obscured after installation. The height of the letters and numerals shall be within the range of 19 to 32 mm.

1505.09 OWNER PURCHASE OF MATERIAL

1505.09.01 Measurement and Payment

For measurement purposes, a count shall be made of the number of steel channel sections delivered and accepted.

Installation hardware shall be measured in the units specified in the purchasing order, delivered and accepted.

Payment at the price specified in the purchasing order shall be for the supply of steel channels and installation hardware delivered to the destination or destinations at the dates and times specified.

The cost of all testing, except that performed in the Owner's laboratory, shall be included in the price.

Appendix 1505-A, November 2010
FOR USE WHILE DESIGNING MUNICIPAL CONTRACTS

Note: This is a non-mandatory Commentary Appendix intended to provide information to a designer, during the design stage of a contract, on the use of the OPS specification in a municipal contract. This appendix does not form part of the standard specification. Actions and considerations discussed in this appendix are for information purposes only and do not supersede an Owner's design decisions and methodology.

Designer Action/Considerations

The designer should ensure that the General Conditions of Contract and the 100 Series General Specifications are included in the Contract Documents.

Related Ontario Provincial Standard Drawings

OPSD 912.102 Guide Rail System, Steel Beam, Channel, Component



**MATERIAL SPECIFICATION FOR
HEAVY CLASS STEEL AND
SECTIONAL STEEL POLES, BASE MOUNTED**

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APPENDICES

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2422.01 SCOPE

This specification covers the requirements for base mounted galvanized heavy class steel and sectional steel poles 6.0, 7.5, 9.0, and 10.50 metres in height.

2422.01.01 Specification Significance and Use

This specification is written as a provincial-oriented specification. Provincial-oriented specifications are developed to reflect the administration, testing, and payment policies, procedures, and practices of the Ontario Ministry of Transportation.

Use of this specification or any other specification shall be according to the Contract Documents.

2422.01.02

Appendices Significance and Use

Appendices are not for use in provincial contracts as they are developed for municipal use, and then, only when invoked by the Owner.

Appendices are developed for the Owner's use only.

Inclusion of an appendix as part of the Contract Documents is solely at the discretion of the Owner. Appendices are not a mandatory part of this specification and only become part of the Contract Documents as the Owner invokes them.

Invoking a particular appendix does not obligate an Owner to use all available appendices. Only invoked appendices form part of the Contract Documents.

The decision to use any appendix is determined by an Owner after considering their contract requirements and their administrative, payment, and testing procedures, policies, and practices. Depending on these considerations, an Owner may not wish to invoke some or any of the available appendices.

2422.02

REFERENCES

When the Contract Documents indicate that provincial-oriented specifications are to be used and there is a provincial-oriented specification of the same number as those listed below, references within this specification to an OPSS shall be deemed to mean OPSS.PROV, unless use of a municipal-oriented specification is specified in the Contract Documents. When there is not a corresponding provincial-oriented specification, the references below shall be considered to be to the OPSS listed, unless use of a municipal-oriented specification is specified in the Contract Documents.

This specification refers to the following standards, specifications, or publications:

Ontario Ministry of Transportation Publications

Structural Manual

CSA Standards

G40.20-13/G40.21-13 General Requirements for Rolled or Welded Structural Quality Steel/ Structural Quality Steel

G164-M92 (R2003) Hot Dip Galvanizing of Irregularly Shaped Articles

S6-14 Canadian Highway Bridge Design Code

W59-13 Welded Steel Construction (Metal Arc Welding)

American Association of State Highway and Transportation Officials (AASHTO)

LTS-5-M Standard Specifications for Structural Supports for Highway Signs, Luminaires and Traffic Signals, 5th Edition, Interim Revisions (2010)

2422.03

DEFINITIONS

For the purpose of this specification, the following definitions apply:

Product Drawings means drawings prepared by the manufacturer that have been approved by the Owner for use with the product.

2422.04 DESIGN AND SUBMISSION REQUIREMENTS

2422.04.01 Design Requirements

All poles shall be designed to support the required traffic signal and lighting system components and shall be according to CSA S6 and MTO Structural Manual. All poles shall be according to CSA S6 and AASHTO LTS-5-M for fatigue requirements, AASHTO Fatigue Importance Category 2.

2422.04.01.01 Wind Loading

Wind loading shall be based on the maximum wind pressure for Ontario according to CSA S6.

2422.04.01.02 Ice Loading

Ice loading shall be based on the maximum ice loading for Ontario according to CSA S6.

2422.04.01.03 Geometric Parameters

Latitude of design and fabrication details is at the discretion of the supplier and is subject to approval of the design by the Owner.

2422.04.01.04 Supported Load Parameters

Design calculations shall employ force and dimensions for various items of equipment to be mounted on the poles as shown in Table 1.

2422.04.01.05 Heavy Class Steel and Sectional Steel Pole

Heavy class steel and sectional steel poles used for traffic signal or combination traffic signal and lighting system shall be capable of bearing the loads associated with configurations shown in Table 2.

2422.04.01.06 Location of Equipment

Mast arms shall be to be solidly attached to the pole at a height above the pole base plate as given by:

$$H_A = 5,650 \text{ mm} - H$$

where: H_A = mast arm height above the pole base plate
 H = mast arm height from Table 1

Where more than one mast arm is considered, the shorter arm shall be attached to the pole at a point 300 mm above that of the longer arm.

Pedestrian heads shall be mounted at a height of 2,750 mm above the pole base plate.

Luminaire brackets shall be mounted at a point 150 mm from the top of the pole.

2422.04.02 Submission Requirements

2422.04.02.01 Product Drawings

The heavy class steel and sectional steel pole manufacturer shall submit the product drawings and the design assumptions and calculations for the poles to the Contract Administrator.

As a minimum, the product drawings shall include the following information:

- a) Material properties and standards.
- b) Dimensions.
- c) Hardware requirements.
- d) Plans, elevations, sections, and details to show pole structural details.
- e) Anchor bolt locations.
- f) Welds.
- g) Joining method for heavy class steel poles sections.

The product drawings and calculations shall bear the seals and signatures of the design and design-checking Engineers.

2422.04.02.02 Working Drawings

Working Drawings shall be prepared for the fabrication of heavy class steel and sectional steel poles.

Three sets of Working Drawings shall be submitted to the Contract Administrator at least 14 Days prior to the commencement of fabrication of the heavy class steel and sectional steel poles for information purposes only. An Engineer shall affix his or her seal and signature on the Working Drawings verifying that the Working Drawings are consistent with the Contract Documents and sound engineering practices.

Where multi-discipline engineering work is depicted on the same Working Drawing and a single Engineer is unable to seal and sign the Working Drawing for all aspects of the work, the drawing shall be signed and sealed by as many additional Engineers as necessary.

As a minimum, the Working Drawings shall include the following information:

- a) Detailed dimensions.
- b) Plans, elevations, sections, and details to show pole structural details.
- c) Equipment layout.
- d) Anchor bolt locations.
- e) Exact pole weight.
- f) Detailed bill of materials.
- g) Details of equipment nameplates.

A copy of the Working Drawings shall be retained at the fabricator's plant during and after the heavy class steel and sectional steel pole fabrication.

2422.05 MATERIALS

2422.05.01 General

All steel used in the production of poles shall be according to CAN/CSA G40.21, Grade 300WT, for pole shafts, base plates, and gussets.

All galvanized steel shall be according to CSA G164.

All welding shall be according to CSA W59.

2422.07 PRODUCTION

2422.07.01 General

General requirements for electrical work shall be as specified in the Contract Documents.

All welds, except for fillet welds, shall be ground smooth.

The pole base plate for any height of pole shall be made with mounting holes suitable for the anchor rod or anchorage assembly. The pole base plate shall be reinforced with four welded gussets equally spaced around the pole or with a welded collar or combination of both welded collar and gussets.

The underside of the anchor base shall be true, distortion free, and perpendicular to the centreline of the pole shaft after fabrication.

A waterproof, removable galvanized steel top cap shall be furnished with the pole. The cap shall blend with the general pole design to present a neat overall appearance. The cap shall be rigidly secured to the top of the pole by a hexagonal head stainless steel set screw.

Wiring apertures at the bracket mounting level and at the handhole shall be accurately positioned on the pole. The wiring apertures shall provide a smooth cable entrance.

For lighting applications, a wiring aperture, complete with rubber grommet, shall be provided.

Handholes, complete with covers, shall be reinforced with a steel handhole frame of such strength and cross-section that the strength of the pole is not reduced.

2422.07.02 Heavy Class Steel Poles

The poles, as specified in the Contract Documents, shall be round or octagonal in cross-section and shall taper uniformly inwards from the base for the height of the pole.

Poles shall have one or two longitudinal automatically electrically welded joints from top to bottom.

The maximum permitted number of circumferential (transverse) welded joints shall be as shown in Table 3.

The pole sections shall be joined by an electrical weld before galvanizing.

Sweep shall not exceed 3.2 mm per 4.57 m, and the overall sweep shall not be greater than:

$$(\text{Pole height (m)} / 4.57 \text{ m}) \times 3.2 \text{ mm}$$

In all cases, the base shall telescope the butt end of the pole and be secured with one continuous weld on the inside of the base at the end of the pole and another continuous weld on the outside at the top of the base. All welding at base shall be made in such a manner as to ensure that the welded connection shall develop the same strength of the adjacent pole section to resist any bending action.

2422.07.03 Heavy Class Sectional Steel Poles

The pole sections shall be of round tapered construction so that a number of sections may be assembled by means of an overlapping press fit to form a tapered steel pole of the height specified in the Contract Documents.

Each section shall have one longitudinal automatically electrically welded joint from top to bottom.

Each section shall be stencilled with O-L (nominal overlap requirement) and graduations in one-inch increments.

2422.07.04 Ground Bar

A ground bar with a bronze ground connector suitable for No. 6 AWG wire shall be welded to the inside of each pole. The bronze ground connector shall be attached to the ground bar before shipment.

2422.07.05 Marking

Each pole shall have identification marking located approximately 300 mm above the top of the handhole showing the following:

- a) Manufacturer's name or trade mark.
- b) Height of pole.
- c) Gauge of steel.
- d) Bolt circle diameter.
- e) Designation OPSS 2422.
- f) Date of manufacture (i.e., yyyy-mm-dd).

This marking shall be on a corrosion-resistant metal plate securely attached to the surface of the pole.

2422.07.06 Packaging and Shipping

Each pole shall be shipped complete with hardware suitably packaged to ensure that all parts are delivered as an entity.

The Contract Administrator shall be notified of the shipping date 3 Business Days prior to delivery.

2422.08 QUALITY ASSURANCE

2422.08.01 Inspection

All work is subject to an inspection by the Contract Administrator prior to shipment.

The supplier shall notify the Contract Administrator of the date that the fabrication of the poles is to commence.

The Contract Administrator shall have free access to the place of fabrication of the poles for the purpose of inspecting and examining plant records and certificates while work on the poles is being performed; materials used; process of fabrication, including welding and galvanizing; and to make any tests as may be considered necessary.

2422.09**OWNER PURCHASE OF MATERIAL****2422.09.01****Working Drawings**

Within 30 Days of receipt of a purchasing order to supply heavy class steel and sectional steel poles, the supplier shall submit 4 copies of pole Working Drawings, as described in the Submission Requirements subsection, to the Owner, for approval.

Working Drawings shall be given final approval by the Owner, if found to be acceptable, or shall be marked with deficiencies, if unacceptable.

Unacceptable drawings shall be returned to the supplier for correction. The supplier shall resubmit 4 copies of corrected Working Drawings within 14 Days. When the resubmitted drawings are acceptable to the Owner, they shall be given final approval.

One copy of the final approved drawings shall be returned to the supplier along with written notification to commence fabrication. Within 14 Days of receipt of the notification to commence fabrication, the supplier shall submit 4 copies of all final approved Working Drawings to the Owner.

Fabrication of the equipment shall not commence until the supplier has received final approved Working Drawings and written notification to commence fabrication from the Owner. All fabrication shall conform to the dimensions indicated on the final approved Working Drawings.

The supplier shall advise the Owner of the shipping date 3 Business Days prior to delivery.

2422.09.02**Measurement and Payment**

For measurement purposes, a count shall be made of the number of heavy class steel and sectional steel poles supplied and accepted.

Payment at the price specified in the purchasing order shall be for the supply of the heavy class steel and sectional steel poles delivered to the destination on the date and time specified.

The cost of all testing, except that performed by the Owner, shall be included in the price.

TABLE 1
Supported Load Parameters

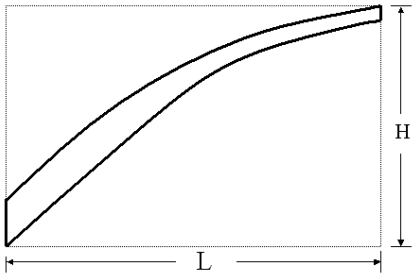
Item of Equipment	Dimensions mm	Projected Area m ²	Weight N
Roadway Lighting Luminaire (Ovuloid)	990 L x 380 H	0.22	107
Roadway Lighting Bracket (Aluminum)	2400 L x 1200 H (tapered)	0.15	112
Double Arm Brackets (Aluminum)	400 L x 42 Dia. (2 per set)	0.04	24
Mast Arm (Aluminum) 	610 L x 250 H (tapered)	0.04	78
	1200 L x 530 H (tapered)	0.10	91
	1800 L x 610 H (tapered)	0.15	114
	2400 L x 840 H (tapered)	0.19	65
	3000 L x 610 H (tapered)	0.23	94
	3600 L x 840 H (tapered)	0.38	113
	4600 L x 1070 H (tapered)	0.47	216
	5500 L x 910 H (tapered)	0.70	324
	6100 L x 1070 H (tapered)	0.79	307
	6700 L x 1150 H (tapered)	0.85	354
	7600 L x 1140 H (tapered)	1.10	504
Traffic Signal Heads (Aluminum: 4-Section)	1650 H x 610 W	1.01	123
Pedestrian Heads (Aluminum: 2-Section)	690 H x 345 W	0.23	78
Traffic Signs	Varies: see Table 2	1.50	23

TABLE 2
Heavy Class Steel and Sectional Steel Pole Configurations

Pole Height m	Luminaire and Bracket set	Longest Mast Arm with Head m	Maximum Mast Arm Total Length (Note 1) m	Number of Pedestrian Heads (Note 2)	Traffic Signs (Note 3) m ²
10.5	1	7.6	13.1	2	0.75
9.0	1	7.6	13.1	2	0.75
7.5	1	7.6	13.1	2	0.75
6.0	0	7.6	13.1	2	0.75
Notes: 1. Mast arm total length applies to the sum of the lengths of two mast arms at 90-degree orientation. 2. Two pedestrian heads at 90-degree orientation include a set of double arm brackets for each. 3. Traffic signs shall be split to give 0.25 m ² mounted on the mast arm beside the signal head and 0.5 m ² mounted at 2.75 m height above the pole base plate.					

TABLE 3
Circumferential Welded Joints

Pole Height m	Maximum Number of Welds
6.0	1
7.5	1
9.0	1
10.5	2

Appendix 2422-A: November 2016
FOR USE WHILE DESIGNING MUNICIPAL CONTRACTS

Note: This is a non-mandatory Commentary Appendix intended to provide information to a designer, during the design stage of a contract, on the use of the OPS specification in a municipal contract. This appendix does not form part of the standard specification. Actions and considerations discussed in this appendix are for information purposes only and do not supersede an Owner's design decisions and methodology.

Designer Action/Considerations

No information provided here.

Related Ontario Provincial Standard Drawings

No information provided here.



MATERIAL SPECIFICATION FOR HIGH PRESSURE SODIUM LUMINAIRES FOR UNDERPASS LIGHTING

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APPENDICES

2434-A	Commentary
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2434.01 SCOPE

This specification covers the requirements for underpass luminaires with integral ballast for use with 70 to 400 watt high pressure sodium lamps.

2434.01.01 Specification Significance and Use

This specification is written as a provincial-oriented specification. Provincial-oriented specifications are developed to reflect the administration, testing, and payment policies, procedures, and practices of the Ontario Ministry of Transportation.

Use of this specification or any other specification shall be according to the Contract Documents.

2434.01.02 Appendices Significance and Use

Appendices are not for use in provincial contracts as they are developed for municipal use, and then, only when invoked by the Owner.

Appendices are developed for the Owner's use only.

Inclusion of an appendix as part of the Contract Documents is solely at the discretion of the Owner. Appendices are not a mandatory part of this specification and only become part of the Contract Documents as the Owner invokes them.

Invoking a particular appendix does not obligate an Owner to use all available appendices. Only invoked appendices form part of the Contract Documents.

The decision to use any appendix is determined by an Owner after considering their contract requirements and their administrative, payment, and testing procedures, policies, and practices. Depending on these considerations, an Owner may not wish to invoke some or any of the available appendices.

2434.02 REFERENCES

When the Contract Documents indicate that provincial-oriented specifications are to be used and there is a provincial-oriented specification of the same number as those listed below, references within this specification to an OPSS shall be deemed to mean OPSS.PROV, unless use of a municipal-oriented specification is specified in the Contract Documents. When there is not a corresponding provincial-oriented specification, the references below shall be considered to be to the OPSS listed, unless use of a municipal-oriented specification is specified in the Contract Documents.

This specification refers to the following standards, specifications, or publications:

CSA Standards

C22.2 No. 89-15	Swimming-Pool Luminaires, Submersible Luminaires and Accessories
C863-16	Energy Efficiency of High-Intensity Discharge (HID) and Low-Pressure Sodium (LPS) Lamp Ballasts

ASTM International

B 117-11	Standard Practice for Operating Salt Spray (Fog) Apparatus
D 1654-08	Standard Test Method for Evaluation of Painted or Coated Specimens Subjected to Corrosive Environments

American National Standards Institute (ANSI)

C136.31-2010	Roadway and Area Lighting Equipment - Luminaire Vibration
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International Electrotechnical Commission (IEC)

60598 (2014-05)	Luminaires
62262 (2002-02)	Degrees of Protection Provided by Enclosures for Electrical Equipment Against External Mechanical Impacts (IK code)

2434.04 DESIGN AND SUBMISSION REQUIREMENTS

2434.04.01 Submission Requirements

2434.04.01.01 Working Drawings

Three copies of Working Drawings shall be submitted to the Contract Administrator a minimum of 14 Days prior to the commencement of fabrication.

As a minimum, the Working Drawings shall include the following information:

- a) All mechanical details, including dimensions, layouts, weights, shield details, and mounting arrangements for components.
- b) All electrical details and certified test reports, including wiring diagrams and component ratings.
- c) All photometric information and certified test reports regarding the luminaires, including, but not limited to lamp position, photometric data sheets, and photometric test reports.
- d) Certified Test Reports for UL/CSA listing, IP rating, IK rating, and ANSI C136.31 vibration.

2434.04.01.02 Photometric Test Results

Photometric test results for the luminaires supplied shall be submitted to the Contract Administrator and include the following data:

- a) Isolux curves and mounting height correction factors.
- b) Utilization charts or graphs.
- c) Candlepower distribution curves indicating peak intensity.
- d) Luminous intensity tables to Illuminating Engineering Society format (I-tables).
- e) Luminaire efficiency values.
- f) Luminous outputs above and below horizontal.
- g) Lamp lumen outputs and wattages.

2434.04.01.03 Luminaire Test Results

Certified test results for the luminaires supplied shall be submitted to the Contract Administrator and include the following data:

- a) UL/CSA Listing Report according to CSA C22.2 No. 89.
- b) Minimum IP65 Rating according to IEC 60598.
- c) Minimum IK08 Rating according to IEC 62262.
- d) 1.5G Vibration Test Report according to ANSI C136.31.

2434.05**MATERIALS****2434.05.01****Electrical Components**

All electrical components and assembled luminaires shall be according to CSA C22.2 No. 89.

Ballasts, lamp sockets, ground connectors, internal wiring, and all other components shall be suitable for the supply voltage as specified in the Contract Documents and the maximum temperature encountered in totally enclosed, outdoor, weatherproof luminaires.

Ballasts shall be constant wattage auto-transformer or isolated secondary transformer type for grounded systems. Auto-transformer type ballasts shall have a maximum tolerance of 12% variation in lamp wattage for a 5% variation in line voltage. Isolated secondary transformer type ballasts shall have a maximum tolerance of 12% variation in lamp wattage for a 10% variation in line voltage.

Ballasts shall be Class H, 180 °C insulation; 60 hertz; and low temperature, -35 °C with a power factor not less than 0.90.

The minimum nominal secondary open circuit voltage of the ballast for various lamps shall be sufficient to provide reliable starting at -35 °C.

Ballasts shall be suitable for the lamp's nominal operating voltage. Terminal blocks shall be held rigidly and shall provide a positive connection for terminating the field wiring.

The current crest factor of the ballast shall not exceed 1.8 for high pressure sodium lamps.

Energy efficiency of lamp ballasts shall be according to CAN/CSA C863.

All wiring within fixture shall have a minimum temperature rating of 125 °C.

2434.05.02**Mechanical Components**

The luminaire shall be comprised of a polycarbonate, aluminum, or stainless steel enclosure with a specular reflector and a glass prismatic refractor. Enclosure shall meet a scribe creepage rating of 7 according to ASTM D 1654, when tested for 5,000 hours according to ASTM B 117.

The luminaire shall be provided with a 20 mm threaded duct entry in each end of the enclosure and a cable entry hole in the rear of the enclosure together with a suitable waterproof gasket.

The luminaire shall have continuous captive gasket between the door and enclosure and between the refractor and the enclosure to provide a weatherproof seal.

All fixture hardware shall be Type 316 stainless steel and shall be captive. Proper dielectric insulation shall be provided between luminaire housing and fixture hardware of dissimilar metals, to prevent galvanic reaction.

The luminaire shall be provided with a ground terminal or lug for a single conductor #12 AWG stranded copper wire.

All unused cable and duct entry holes shall be plugged with approved filler caps.

The lamp socket shall be a porcelain-enclosed, nickel-plated brass shell rated for 4,000 volts, and spring-loaded centre contact. The lamp holder shall have an electrically insulated lamp stabilizer and shall hold the lamp's outer envelope to precise alignment with suitable means for vibration damping.

The refractor shall be heat-resistant and non-discolouring, with high resistance to breakage from thermal shock. It shall be securely attached to the housing by hinges and a safety device to hold it in the open position.

The reflector shall be fabricated of polished, chemically brightened, anodized aluminum not subject to distortion and shall be readily removable.

The luminaire shall be accessible with tool-less entry.

The luminaire shall not be subject to damage by vibration when closed and in the operating position.

2434.05.03 Marking

A permanent non-corrosive nameplate shall be attached to the exterior of the luminaire and located so that the marking is clearly visible after installation. The nameplate shall indicate the manufacturer's name or trademark, catalogue number, lamp wattage, and nominal voltage.

A permanent label shall be attached to the interior of the luminaire indicating the manufacturer's name or trademark, catalogue number, date of manufacture, and the American National Standards Institute (ANSI) or Illuminating Engineering Society (IES) photometric classification and distribution type; the suitable supply voltage and frequency; the lamp type; the lamp wattage; and the nominal operating voltage of the lamp so that it is clearly visible during maintenance operations.

A label including a wiring diagram shall be attached to each ballast showing the ballast schematic wiring diagram and shall be visible during maintenance operations.

For asymmetrical luminaires with adjustable optical systems, a permanent embossed identification mark shall be located on the luminaire that is clearly visible and identifiable as an orientation mark.

2434.07 PRODUCTION

2434.07.01 Ballast Assemblies

Ballast assemblies shall be factory pre-wired with all connections clearly marked and identified.

2434.07.02 Lamp Socket Positions

The lamp socket position shall be pre-set and legibly marked at the factory for the specified distribution.

2434.08 QUALITY ASSURANCE

2434.08.01 Inspection

The supplier shall notify the Contract Administrator of the date that the fabrication of the luminaires is to commence.

The Contract Administrator shall have access to the place of fabrication for the purpose of inspecting and examining plant records, certificates, materials used, fabrication process, and to make any tests as may be considered necessary, while the work is being performed.

All luminaires are subject to an inspection by the Contract Administrator prior to shipment.

2434.09**OWNER PURCHASE OF MATERIAL****2434.09.01****Packaging and Shipment**

The supplier shall provide 3 copies of the luminaire ballast engineering data and shielding data such as material type, gauge thickness, and mounting arrangement to the Owner.

Each luminaire shall be shipped complete with hardware suitably packaged to ensure that all parts are delivered as an entity. A complete parts list shall be included in the shipment. All cartons shall be marked with the ANSI or IES luminaire classification and distribution types.

The supplier is responsible for loading, delivery, and off-loading of luminaires to designated areas. Luminaires shall be subject to inspection during and on completion of off-loading. If any damage to the luminaires is encountered during the inspection, the supplier shall be responsible for the necessary corrective measures subject to the approval of the Owner.

The supplier shall advise the Owner 3 Working Days prior to the shipping date of the intent to deliver and confirm that arrangements for off-loading have been made.

2434.09.02**Measurement and Payment**

For measurement purposes, a count shall be made of the number of the underpass luminaires delivered and accepted.

Payment at the price specified in the purchasing order shall be full compensation for the supply and delivery of the underpass lighting luminaires to the destination at the date and time specified.

The cost of all testing, except that performed in the Owner's laboratory, shall be included in the price.

Appendix D 2434-A, November 2016
FOR USE WHILE DESIGNING MUNICIPAL CONTRACTS

Note: This is a non-mandatory Commentary Appendix intended to provide information to a designer, during the design stage of a contract, on the use of the OPS specification in a municipal contract. This appendix does not form part of the standard specification. Actions and considerations discussed in this appendix are for information purposes only and do not supersede an Owner's design decisions and methodology.

Designer Action/Considerations

No information provided here.

Related Ontario Provincial Standard Drawings

No information provided here.



MATERIAL SPECIFICATION FOR SECTIONAL STEEL POLES

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2453.01 SCOPE

This specification covers the requirements for sectional steel poles.

2453.01.01 Specification Significance and Use

This specification is written as a provincial-oriented specification. Provincial-oriented specifications are developed to reflect the administration, testing, and payment policies, procedures, and practices of the Ontario Ministry of Transportation.

Use of this specification or any other specification shall be according to the Contract Documents.

2453.01.02

Appendices Significance and Use

Appendices are not for use in provincial contracts as they are developed for municipal use, and then, only when invoked by the Owner.

Appendices are developed for the Owner's use only.

Inclusion of an appendix as part of the Contract Documents is solely at the discretion of the Owner. Appendices are not a mandatory part of this specification and only become part of the Contract Documents as the Owner invokes them.

Invoking a particular appendix does not obligate an Owner to use all available appendices. Only invoked appendices form part of the Contract Documents.

The decision to use any appendix is determined by an Owner after considering their contract requirements and their administrative, payment, and testing procedures, policies, and practices. Depending on these considerations, an Owner may not wish to invoke some or any of the available appendices.

2453.02

REFERENCES

When the Contract Documents indicate that provincial-oriented specifications are to be used and there is a provincial-oriented specification of the same number as those listed below, references within this specification to an OPSS shall be deemed to mean OPSS.PROV, unless use of a municipal-oriented specification is specified in the Contract Documents. When there is not a corresponding provincial-oriented specification, the references below shall be considered to be to the OPSS listed, unless use of a municipal-oriented specification is specified in the Contract Documents.

This specification refers to the following standards, specifications, or publications:

Ontario Ministry of Transportation Publications

Ontario Traffic Manual (OTM):
Book 12 - Traffic Signals

Structural Manual

CSA Standards

G40.21-13	General Requirements for Rolled or Welded Structural Quality Steel/Structural Quality Steel
S6-14	Canadian Highway Bridge Design Code
W59-13	Welded Steel Construction (Metal Arc Welding)

ASTM International

A 123/A 123M-15	Zinc (Hot-Dip Galvanized) Coatings on Iron and Steel Products
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American Association of State Highway and Transportation Officials (AASHTO)

LTS-5-M	Standard Specifications for Structural Supports for Highway Signs, Luminaires, and Traffic Signals, 5 th Edition, Interim Revisions (2010)
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2453.03 DEFINITIONS

For the purpose of this specification, the following definitions apply:

Product Drawings means drawings prepared by the manufacturer that have been approved by the Owner for use with the product.

2453.04 DESIGN AND SUBMISSION REQUIREMENTS

2453.04.01 Design Requirements

All poles shall be designed to support the required traffic signal and lighting system components and shall be according to CSA S6 and MTO Structural Manual. All poles shall be according to CSA S6 and AASHTO LTS-5-M for fatigue requirements, AASHTO Fatigue Importance Category 2.

2453.04.01.01 Wind Loading

Wind loading shall be based on the maximum wind pressure for Ontario according to CSA S6.

2453.04.01.02 Ice Loading

Ice loading shall be based on the maximum ice loading in Ontario according to CSA S6.

2453.04.01.03 Geometric Parameters

Latitude of design and fabrication details is at the discretion of the supplier and is subject to approval of the design by the Owner.

2453.04.01.04 Supported Load Parameters

Design calculations shall employ force and dimensions for various items of equipment to be mounted on the poles as shown in Table 1.

2453.04.01.05 Sectional Steel Poles

Sectional steel poles used for traffic signal or combination of traffic signal and lighting system shall be base mounted and shall be capable of bearing the loads associated with configurations shown in Table 2.

Direct buried sectional steel poles shall be capable of bearing the loads associated with the equipment shown in Table 3.

Flasher/sign poles shall be capable of bearing the loads associated with the equipment shown in Table 4.

2453.04.01.06 Location of Equipment

Mast arms shall be solidly attached to the pole at a height above the pole base plate as given by:

$$H_A = 5,650 \text{ mm} - H$$

Where:

H_A = mast arm height above the pole base plate

H = mast arm height from Table 1

When more than one mast arm is considered, the shorter arm shall be attached to the pole at a point 300 mm above that of the longer arm.

Pedestrian heads shall be mounted as specified in the Contract Documents.

Luminaire brackets shall be mounted at a point 150 mm from the top of the pole.

2453.04.02 Submission Requirements

2453.04.02.01 Product Drawings

The sectional steel pole manufacturer shall submit the product drawings and the design assumptions and calculations for the poles to the Contract Administrator.

As a minimum, the product drawings shall include the following information:

- a) Material properties and standards.
- b) Dimensions.
- c) Hardware requirements.
- d) Plans, elevations, sections, and details to show pole structural details.
- e) Anchor bolt locations.
- f) Welds.
- g) Joining method for sectional steel poles sections.

The product drawings and calculations shall bear the seals and signatures of the design and design-checking Engineers.

2453.04.02.02 Working Drawings

Working Drawings shall be prepared for the fabrication of sectional steel poles.

Three sets of Working Drawings shall be submitted to the Contract Administrator at least 14 Days prior to the commencement of fabrication of the sectional steel poles for information purposes only. An Engineer shall affix his or her seal and signature on the Working Drawings verifying that the Working Drawings are consistent with the Contract Documents and sound engineering practices.

When multi-discipline engineering work is depicted on the same Working Drawing and a single Engineer is unable to seal and sign the Working Drawing for all aspects of the work, the drawing shall be signed and sealed by as many additional Engineers as necessary.

As a minimum, the Working Drawings shall include the following information:

- a) Detailed dimensions.
- b) Plans, elevations, sections, and details to show pole structural details.
- c) Equipment layout.
- d) Anchor bolt locations.

- e) Exact pole weight.
- f) Detailed bill of materials.
- g) Details of equipment nameplates.

2453.05 MATERIALS

2453.05.01 General

All steel used in the production of poles shall be according to CAN/CSA G40.21, Grade 300WT, Category 2, for pole shafts, base plates, and gussets.

All welding shall be according to CSA W59.

2453.07 PRODUCTION

2453.07.01 General

General requirements for electrical work shall be as specified in the Contract Documents.

The pole base plate for any height of pole shall be made with mounting holes suitable for the anchor rod or anchorage assembly.

The underside of the anchor base shall be true, distortion free, and perpendicular to the centreline of the pole shaft after fabrication.

A waterproof, removable galvanized steel top cap shall be furnished with the pole. The cap shall blend with the general pole design to present a neat overall appearance. The cap shall be rigidly secured to the top of the pole by a hexagonal head stainless steel set screw.

Wiring apertures at the bracket mounting level and at the handhole shall be accurately positioned on the pole.

All wiring apertures shall provide a smooth cable entrance and be complete with rubber grommets.

Handholes, complete with covers, shall be reinforced with a steel handhole frame of such strength and cross-section that the strength of the pole is not reduced.

2453.07.01.01 Galvanizing

All components shall be hot dip galvanized according to ASTM A 123.

2453.07.02 Steel Sections

2453.07.02.01 General

The following covers types and lengths of sectional steel poles:

- a) Base mounted: 7.00, 8.70, and 10.50 m
- b) Direct buried: 5.25, 7.00, 8.70, 10.25, and 12.00 m
- c) Flasher/sign: 3.30 m

Pole sections shall be of round tapered construction so that a number of sections may be assembled by means of an overlapping press fit to form a tapered steel pole of the desired length.

Each section shall have one longitudinal automated electrically welded joint from top to bottom.

Each section shall be stencilled with O-L and graduations in one inch increments. O-L represents the nominal overlap requirement for each section.

2453.07.02.02 Base Mounted and Direct Buried Poles, 5.25 m and Longer

For lighting applications, a wiring aperture, complete with 28.5 mm ID rubber grommet shall be drilled 300 mm from the top of the pole.

Each base mounted pole shall be supplied with a reinforced 180 x 300 mm handhole, complete with cover. Each direct buried pole shall be supplied with a reinforced 100 x 200 mm handhole, complete with cover. A 6 x 38 x 250 mm long plate shall be welded inside the pole opposite the handhole. A ground connector shall be mounted on the plate. The ground connector shall be suitable for No. 6 AWG wire.

The centre of the handhole on base mounted poles shall be 1.1 m from the bottom of the pole and on direct buried poles the centre of the handhole shall be 2.75 m from the bottom of the pole.

Base mounted poles shall have a steel plate anchor base with 4 holes on a 449 mm bolt circle, suitable for mounting on 32 mm diameter studs.

Direct buried sectional steel poles shall have 65 x 300 mm wiring apertures on each side of the pole, the centre of the apertures shall be 1.25 m from the bottom of the pole.

2453.07.02.03 Flasher Poles

The flasher pole shall be comprised of two pole sections totalling 2.3 m in length with a 1.2 m length of 50 mm IPS Schedule 40 pipe inserted 230 mm into the top and welded in place to provide a total length of 3.3 m.

The top end of the extension shall be threaded and the thread cleaned after galvanizing.

Each pole shall be supplied with a 75 x 100 mm handhole, complete with cover. The bottom edge of the handhole shall be 150 mm from the bottom of the pole.

A ground terminal shall be provided in the handhole.

The flasher pole shall be supplied with a steel plate anchor base with 4 holes on a 150 mm bolt circle, suitable for mounting on 16 mm diameter studs.

2453.07.03 Marking

Each pole shall have identification marking located approximately 100 mm above the top of the handhole showing the following:

- a) Manufacturer's name or trademark.
- b) Length.
- c) Designation OPSS 2453.
- d) Manufacturer's catalogue number.

e) Date of manufacture (i.e., yyyy-mm-dd).

This marking shall be on a corrosion-resistant metal plate securely attached to the surface of the pole.

2453.07.04 Ground Bar

A ground bar with a bronze ground connector suitable for No. 6 AWG wire shall be welded to the inside of each pole. The bronze ground connector shall be attached to the ground bar before shipment.

2453.07.05 Packaging and Shipping

Each pole shall be shipped complete with hardware suitably packaged to ensure that all parts are delivered as an entity.

The Contract Administrator shall be advised of the shipping date 3 Business Days prior to delivery.

2453.08 QUALITY ASSURANCE

2453.08.01 Inspection

All work is subject to an inspection by the Contract Administrator prior to shipment.

The supplier shall notify the Contract Administrator of the date that the fabrication of the poles is to commence.

The Contract Administrator shall have free access to the place of fabrication of the poles for the purpose of inspecting and examining plant records and certificates while work on the poles is being performed; materials used; process of fabrication, including welding and galvanizing; and to make any tests as may be considered necessary.

2453.09 OWNER PURCHASE OF MATERIAL

2453.09.01 Working Drawings and Shipment

Within 30 Days of receipt of a purchasing order to supply sectional steel poles, the supplier shall submit 3 copies of pole Working Drawings, as described in the Submission Requirements subsection, to the Owner.

The supplier shall advise the Owner of the shipping date 3 Business Days prior to delivery.

2453.09.02 Measurement and Payment

For measurement purposes, a count shall be made of the number of sectional steel poles supplied and accepted.

Payment at the price specified in the purchasing order shall be for the supply of the sectional steel poles delivered to the destination on the date and time specified.

The cost of all testing, except that performed by the Owner, shall be included in the price.

TABLE 1
Supported Load Parameters

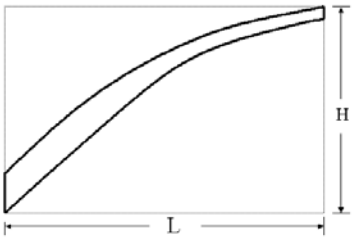
Item of Equipment	Dimensions mm	Projected Area m ²	Weight N
Roadway Lighting Luminaire (Ovuloid)	990 L x 380 H	0.22	107
Roadway Lighting Bracket (Aluminum)	2400 L x 1200 H (tapered)	0.15	112
Double Arm Brackets (Aluminum)	400 L x 42 Dia. (2 per set)	0.04	24
Mast Arm (Aluminum) 	610 L x 250 H (tapered)	0.04	78
	1200 L x 530 H (tapered)	0.10	91
	1800 L x 610 H (tapered)	0.15	114
	2400 L x 840 H (tapered)	0.19	65
	3000 L x 610 H (tapered)	0.23	94
	3600 L x 840 H (tapered)	0.38	113
	4600 L x 1070 H (tapered)	0.47	216
	5500 L x 910 H (tapered)	0.70	324
Traffic Signal Heads (Aluminum: 4-Section)	1650 H x 610 W	1.01	123
Pedestrian Heads (Aluminum: 2-Section)	690 H x 345 W	0.23	78
Traffic Signs	Varies: see Table 2	1.50	23

TABLE 2
Base Mounted Sectional Steel Pole Configurations

Pole Height m	Luminaire and Bracket set	Longest Mast Arm with Head m	Maximum Mast Arm Total Length (Note 1) m	Number of Pedestrian Heads (Note 2)	Traffic Signs (Note 3) m ²	Street Name Sign (Note 4) m ²
7.00	1	5.5	11.0	2	0.75	0.97
8.70	1	5.5	11.0	2	0.75	0.97
10.50	1	5.5	11.0	2	0.75	0.97

Notes:

1. Mast arm total length applies to the sum of the lengths of two mast arms at 90-degree orientation.
2. Two pedestrian heads at 90-degree orientation include a set of double arm brackets for each.
3. Traffic signs shall be split to give 0.25 m² mounted on the mast arm beside the signal head and 0.5 m² mounted at 2.75 m height above the pole base plate.
4. Street name or roadway identification sign shall have a maximum height of 0.45 m and a maximum length of 2.10 m. The sign shall be mounted on each mast arm or pole and the distance between the centre of the sign and the surface of the pole shall not exceed half the length (L) of the mast arm. Pole mounted street name signs shall be mounted at the same height as the mast arm mounted signs or at the top of the pole, whichever is less.

TABLE 3
Direct Buried Sectional Steel Pole Configurations

Pole Height m	Luminaire and Bracket (Note 1) set	Supply Control Cabinet Type 1 (Note 2) each
5.25	2	N/A
5.25	N/A	2
7.00	2	N/A
7.00	N/A	2
8.70	2	N/A
8.70	N/A	2
10.25	2	N/A
10.25	N/A	2
12.00	2	N/A
12.00	N/A	2
Notes: 1. See Table 1. 2. Each supply control cabinet shall have maximum dimensions of 865 mm H x 465 mm W x 250 mm D and a maximum weight of 700 N.		

TABLE 4
Flasher/Sign Pole Configurations

Pole Height m	Beacons (Note 1) each	Traffic Signal Head (3 display sections) (Note 1) each	Traffic Signs m²
3.3	2	N/A	0.5
3.3	N/A	1	0.5
Note: 1. Each beacon or traffic signal display shall be a 300 mm display according to OTM Book 12 and the total weight of the beacons or the three section traffic signal head shall be a maximum of 200 N.			

Appendix 2453-A, November 2016
FOR USE WHILE DESIGNING MUNICIPAL CONTRACTS

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Designer Action/Considerations

No information provided here.

Related Ontario Provincial Standard Drawings

No information provided here.



MATERIAL SPECIFICATION FOR SECTIONAL STEEL HIGH MAST LIGHTING POLES

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APPENDICES

2471-A	Commentary
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2471.01 SCOPE

This specification covers the requirements for base mounted sectional steel high mast lighting poles 25, 30, 35, 40, and 45 metres in height with a multisided cross-section.

2471.01.01 Specification Significance and Use

This specification is written as a provincial-oriented specification. Provincial-oriented specifications are developed to reflect the administration, testing, and payment policies, procedures, and practices of the Ontario Ministry of Transportation.

Use of this specification or any other specification shall be according to the Contract Documents.

2471.01.02 Appendices Significance and Use

Appendices are not for use in provincial contracts as they are developed for municipal use, and then, only when invoked by the Owner.

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2471.02 REFERENCES

When the Contract Documents indicate that provincial-oriented specifications are to be used and there is a provincial-oriented specification of the same number as those listed below, references within this specification to an OPSS shall be deemed to mean OPSS.PROV, unless use of a municipal-oriented specification is specified in the Contract Documents. When there is not a corresponding provincial-oriented specification, the references below shall be considered to be to the OPSS listed, unless use of a municipal-oriented specification is specified in the Contract Documents.

This specification refers to the following standards, specifications, or publications:

Ontario Provincial Standard Specifications, Construction

OPSS 906	Structural Steel
OPSS 911	Coating Structural Steel Systems

Ontario Ministry of Transportation Publications

Structural Manual
Designated Sources for Materials (DSM)

CSA Standards

B95-1962 (R2002)	Surface Texture (Roughness, Waviness and Lay)
G40.20-13/G40.21-13	General Requirements for Rolled or Welded Structural Quality Steel/Structural Quality Steel
G164-M92 (R2003)	Hot Dip Galvanizing of Irregularly Shaped Articles
S6-14	Canadian Highway Bridge Design Code
W47.1-09 (R2014)	Certification of Companies for Fusion Welding of Steel
W59-13	Welded Steel Construction (Metal Arc Welding)
W178.1-14	Certification of Welding Inspection Organizations
W178.2-14	Certification of Welding Inspectors

ASTM International

A 500/A 500M-13 Standard Specification for Cold-Formed Welded and Seamless Carbon Steel Structural Tubing in Rounds and Shapes

Canadian General Standards Board (CGSB)

48.9712-2014 Non-Destructive Testing - Qualification and Certification of NDT Personnel

American Association of State Highway and Transportation Officials (AASHTO)

LTS-5-M Standard Specifications for Structural Supports for Highway Signs, Luminaires and Traffic Signals, 5th Edition, Interim Revisions (2010)

International Organization for Standardization/International Electrotechnical Commission (ISO/IEC)

17025:2005 General Requirements for the Competence of the Testing and Calibration Laboratories

Others

Federal Standard 595C Color Standards

2471.03 DEFINITIONS

For the purpose of this specification, the following definitions apply:

Multisided means having either eight or twelve sides as specified in the Contract Documents.

2471.04 DESIGN AND SUBMISSION REQUIREMENTS

2471.04.01 Design Requirements

Sectional steel high mast lighting poles shall be according to CSA S6; MTO Structural Manual; AASHTO LTS-5M; and as specified in the Contract Documents. Each pole shall be capable of supporting a total maximum load of 2,000 kg with a combined effective projected area of all the luminaires, shroud, and shields not exceeding 4.0 m².

2471.04.02 Submission Requirements

2471.04.02.01 Working Drawings

Working Drawings shall be prepared for the fabrication of the sectional steel high mast lighting poles.

Three sets of Working Drawings shall be submitted to the Contract Administrator 14 Days prior to commencement of fabrication of the sectional steel high mast lighting poles, for information purposes only. An Engineer shall affix his or her seal and signature on the Working Drawings verifying that the Working Drawings are consistent with the Contract Documents and sound engineering practices.

Where multi-discipline engineering work is depicted on the same Working Drawing and a single Engineer is unable to seal and sign the Working Drawings for all aspects of the work, the drawing shall be signed and sealed by as many additional Engineers as necessary.

A copy of the Working Drawings shall be retained at the fabricator's plant during and after pole fabrication.

The Working Drawings shall contain all information necessary to fabricate the sectional steel high mast lighting poles including:

- a) Dimensioned drawings, including lengths, sizes, cross-sections, and details of the sectional steel pole, and exact weights of pole sections.
- b) Final forces for field assembly of pole sections.
- c) Details for the mounting supports of the winch assembly, the head frame assembly, and the electrical panel assembly.
- d) Details of access opening and of access door.
- e) Welding details, including welding procedures to be used for each joint.
- f) Detailed bill of materials.
- g) Details of identification nameplates.

2471.04.02.02 Mill Test Certificates

Mill test certificates shall be submitted according to OPSS 906.

2471.04.02.03 Welding Procedures

Welding procedure data sheets for each joint configuration to be welded shall be prepared according to CSA W59, stamped with CWB's acceptance, and available for review during fabrication of the sectional steel high mast lighting poles. Three sets of welding procedures shall be submitted to the Contract Administrator 14 Days prior to commencement of fabrication of the sectional steel high mast lighting poles, for information purposes only.

2471.04.02.04 Welder's Qualification

Welders shall have valid CWB issued qualification cards indicating the welding processes and the positions for which they are qualified to weld. Prior to the commencement of fabrication, three copies of the Welders' and Welding Operators' current qualification cards shall be submitted to the Contract Administrator.

2471.05 MATERIALS

2471.05.01 Steel

All structural steel shall be CSA G40.20/G40.21, Grade 350 WT, Category 3.

Steel for tenon pipe shall be CSA G40.20/G40.21, Grade 300W, or A 500M Grade C.

For pole masts, silicon content shall be less than or equal to 0.06%.

2471.05.02 Electrodes

Electrodes and flux used for welding shall have a low hydrogen content and shall be as specified in the fabricator's CWB approved welding procedures.

2471.05.03 Paint Coatings

Paint coatings shall be according to OPSS 911 and the Contract Documents.

The colour of the finish coat shall be equivalent to 16307 grey according to Federal Standard 595C.

2471.07 PRODUCTION

General requirements for electrical work shall be as specified in the Contract Documents.

Fabrication shall be according to CSA S6 and CSA W59 and the Working Drawings.

2471.07.01 Tolerances

Fabrication shall be according to the dimensions on the sealed and signed Working Drawings.

The dimensions of the assembled high mast lighting pole shall be within the following tolerances:

- a) Overall height of pole mast: 5 mm for every 1 m in height.
- b) Cross-sectional width of shaft across flats:
 - i) 1.0%, for widths less than 500 mm,
 - ii) 0.75% for widths greater than 500 mm.
- c) Maximum sweep of the pole mast on its overall length measured from a chord joining the extremities and the centreline of the mast shall not exceed 0.2% of its overall length.
- d) Maximum deviation from straight of the shaft wall on any 3 m length of pole mast shall not exceed 5 mm.
- e) Offset between the centreline of the top section of the pole and the centreline of the bottom section of the pole shall not exceed 150 mm.
- f) Offset between the centreline of the base plate and the centre of the pole mast at base shall not exceed 5 mm.
- g) Wall thickness shall be within the tolerance permitted in CSA G40.20/G40.21 and ASTM A 500M.

2471.07.02 Fabrication

The pole mast shall be cold formed from steel plate and each section shall be fabricated with one or two continuous longitudinal welds. If two welds are used, they shall be on opposite sides of the pole shaft.

One circumferential shop splice per section shall be permitted. Where possible, the shop splice shall be completed prior to forming the pole cross-section.

In the area of the lap splice there shall be no protrusions preventing proper alignment of one section with the next. Any excess weld material shall be removed by grinding to form a smooth surface maintaining a uniformly tapered section.

Each pole shall be supplied with a reinforced handhole complete with a cover. The cover shall have provision for padlocking and shall be fitted with a silicone rubber gasket such that, upon locking, the cover shall be tightly fitted to the handhole.

Each pole shall be supplied with the appropriate mounting plate, brackets, and other attachments required for the installation of the raising and lowering equipment. The mounting plate, brackets, and other attachments shall be attached to the shaft wall by welds as specified in the Contract Documents. Nuts for securing the electrical panel shall be welded to the back of the mounting plate at each mounting hole as specified in the Working Drawings.

The head frame shall be assembled to the pole by means of a tenon mounting system. The tenon shall be compatible with the head frame and raising and lowering device.

In the tenon mounting system, a circular plate with nominal thickness of 12 mm shall be welded to the top of pole as specified in the Contract Documents. The plate shall have a circular opening through its centre, equal to the outside diameter of the tenon, through which the tenon shall be inserted.

The pole section joints shall be slip fitted connections as specified in the Contract Documents. Joint details shall not interfere with the raising or lowering of the luminaire assembly.

The maximum overlap shall be such that the height of the completed mast complies with the permitted overall tolerances.

Shop trial-assembly shall be carried out to check the fit of the sections. The manufacturer shall determine the necessary compressive assembly forces and lap lengths to be achieved during the pre-assembly operation to ensure the final field assembly shall meet the requirements of the Contract Documents. Sections shall be match-marked to facilitate the field assembly. The markings shall be permanent and the location, size, and marking medium shall not interfere with the slip joint.

All cut edges of the base plate shall have a surface finish not greater than 1,000 as defined in CSA B95. All corners shall be ground to a radius of 3 mm.

2471.07.03 Welding

All welding shall be according to CSA W59, including its provisions for cyclically loaded structures, and shall be undertaken by a manufacturer certified by CWB according to CSA W47.1, division 2.1 or better.

During fabrication, upon request the Contractor shall make available to the Contract Administrator the CWB approved qualification cards for each, Welder and Welding Operator to be employed on the work.

Welds for circumferential splices shall be full strength complete joint penetration.

The longitudinal seam welds shall be single V and shall be made from the outside of the structure. Throat thickness shall be according to CSA W59, to ensure a minimum of 60% joint penetration.

Welds within the lap of the slip joints plus an additional 150 mm extending from the slip joint shall be full strength complete penetration groove welds, and shall be ground smooth.

The section of weld that does not meet the acceptance standards shall be removed, re-welded, and re-examined.

2471.07.04 Coating

2471.07.04.01 Galvanizing

All steel components of sectional steel high mast lighting poles shall be hot dip galvanized according to OPSS 911.

2471.07.04.02 Paint Coating

After galvanizing and prior to paint coating, each component of the sectional steel high mast lighting pole shall be checked for continuity and smoothness of the galvanized coating. Any deficiencies in galvanized coating shall be corrected according to OPSS 911.

Components specified to be paint coated shall then be paint coated after surface preparation according to OPSS 911, using one of the approved paint systems for coating galvanized surfaces from the ministry's DSM. The dry film thickness of galvanized coating after surface preparation by sweep blasting shall be at least 87 µm.

During trial-assembly care shall be taken not to damage the coatings of the pole. Any damage to the coatings that occur during the trial-assembly or any other operations shall be repaired according to OPSS 911.

2471.07.05 Identification Nameplate

Each sectional steel high mast lighting pole shall have an identification nameplate as specified in the Contract Documents.

The nameplate shall be made of stainless steel and shall be securely attached to the outside upper part of the handhole cover by rivets. A neoprene or rubber gasket shall be placed between the handhole cover and the nameplate to prevent corrosion effects.

2471.07.06 Quality Control

The Contract Administrator shall be notified of the fabrication, testing, and delivery dates.

A certificate of compliance shall be issued by the manufacturer certifying that the sectional steel high mast lighting poles comply with the Contract Documents, and submitted to the Contract Administrator.

2471.07.06.01 Certification

2471.07.06.01.01 Welding Inspection Company

The company undertaking welding inspection shall be certified under the Bridges category according to CSA W178.1. The certification shall encompass at least the following methods: visual, radiograph, ultrasonic, dye penetrant, and magnetic particle.

2471.07.06.01.02 Welding inspectors for Visual Inspection and Non-Destructive Testing

Visual inspection of the sectional steel high mast lighting poles shall be performed by welding inspectors certified by CWB according to CSA W178.2. The certification shall be to Level II or III.

Non-destructive testing of the sectional steel high mast lighting poles shall be performed by an ultrasonic or radiographic technician or both, certified to Level II or Level III according to CGSB 48.9712.

2471.07.06.01.03 Coating Inspectors

Each coating inspector shall have:

- a) Successfully completed National Association of Corrosion Engineers Coating Inspection Program (NACE CIP) Level 1 and Level 2 with a minimum of 3 years of proven coating inspection experience;

or,

- b) Successfully completed NACE CIP Level 1, or be a graduate of the MTO's Coating Course and be working under the direct technical supervision of a currently certified NACE CIP Level 3 inspector.

2471.07.06.02 Inspection, Testing, and Reporting

2471.07.06.02.01 Welding Inspection and Testing

The manufacturer's welding inspector shall inspect and test the sectional steel high mast lighting poles as follows:

a) Visual Inspection

The fabrication of steel components shall be visually inspected to ensure material, dimensions, fit-up, and welding are according to specifications. Certification of conformance by the welding inspector for each phase of the fabrication shall be based on the applicable Working Drawings, codes, and specifications.

The welding inspector shall witness the trial assembly of the pole sections to ensure compliance with the Contract Documents.

When the sectional steel high mast lighting poles have been delivered to the Working Area and prior to installation, the manufacturer's inspector with the required credentials shall inspect them to ensure that all the components of the high mast lighting poles are according to the Contract Documents.

b) Non-Destructive Testing

All full penetration groove welds, including shaft to base welds, circumferential splices in shaft and welds at slip joints, shall be 100% examined. Longitudinal welds at the bottom of the shaft shall be tested 100% for a length of 2.0 m from the base plate. All testing of groove welds shall be by radiographic or ultrasonic test method and shall be according to CSA W59 for cyclically loaded structures. Any repair welds shall be tested by appropriate methods as determined by the manufacturer's Engineer.

2471.07.06.02.02 Coating Inspection

The manufacturer's coating inspector shall inspect each phase of the cleaning and coating work for compliance with the Contract Documents prior to proceeding to the next phase. Acceptance of the surface preparation and coating thickness measurements shall be according to OPSS 911, CSA G164, and the applicable SSPC standards.

2471.07.06.02.03 Reporting

Prior to installation of the poles, the Contractor shall submit 2 copies of the manufacturer's inspection reports, containing the results of all the inspection and testing performed during welding, fabrication and coating work, to the Contract Administrator. The inspection report shall be completed and certified by the manufacturer's inspector and signed and sealed by the manufacturer's Engineer.

2471.08 QUALITY ASSURANCE

Sectional steel high mast lighting poles are subject to inspection by the Contract Administrator at any time during the course of fabrication and installation.

Welding is subject to inspection by the Contract Administrator using both visual and non-destructive testing procedures and techniques according to CSA W59 for cyclically loaded structures.

The surface preparation and coating of sectional high mast steel lighting poles are subject to inspection by the Contract Administrator during the coating work. Acceptance of the work shall be based on the applicable OPS specification and SSPC Standards.

Appendix 2471-A, November 2016
FOR USE WHILE DESIGNING MUNICIPAL CONTRACTS

Note: This is a non-mandatory Commentary Appendix intended to provide information to a designer, during the design stage of a contract, on the use of the OPS specification in a municipal contract. This appendix does not form part of the standard specification. Actions and considerations discussed in this appendix are for information purposes only and do not supersede an Owner's design decisions and methodology.

Designer Action/Considerations

No information provided here.

Related Ontario Provincial Standard Drawings

No information provided here.



**MATERIAL SPECIFICATION FOR
ANCHORAGE ASSEMBLY - HIGH MAST LIGHTING POLE**

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2474.01	SCOPE
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This specification covers the requirements of anchorage assemblies for the 25, 30, 35, 40, and 45 m base mounted sectional steel high mast lighting poles.

2474.01.01 Specification Significance and Use

This specification is written as a provincial-oriented specification. Provincial-oriented specifications are developed to reflect the administration, testing, and payment policies, procedures, and practices of the Ontario Ministry of Transportation.

Use of this specification or any other specification shall be according to the Contract Documents.

2474.01.02 Appendices Significance and Use

Appendices are not for use in provincial contracts as they are developed for municipal use, and then, only when invoked by the Owner.

Appendices are developed for the Owner's use only.

Inclusion of an appendix as part of the Contract Documents is solely at the discretion of the Owner. Appendices are not a mandatory part of this specification and only become part of the Contract Documents as the Owner invokes them.

Invoking a particular appendix does not obligate an Owner to use all available appendices. Only invoked appendices form part of the Contract Documents.

The decision to use any appendix is determined by an Owner after considering their contract requirements and their administrative, payment, and testing procedures, policies, and practices. Depending on these considerations, an Owner may not wish to invoke some or any of the available appendices.

2474.02 REFERENCES

When the Contract Documents indicate that provincial-oriented specifications are to be used and there is a provincial-oriented specification of the same number as those listed below, references within this specification to an OPSS shall be deemed to mean OPSS.PROV, unless use of a municipal-oriented specification is specified in the Contract Documents. When there is not a corresponding provincial-oriented specification, the references below shall be considered to be to the OPSS listed, unless use of a municipal-oriented specification is specified in the Contract Documents.

This specification refers to the following standards, specifications, or publications:

CSA Standards

G40.20-13/G40.21-13	General Requirements for Rolled or Welded Structural Quality Steel/Structural Quality Steel
G164-M92 (R2003)	Hot Dip Galvanizing of Irregularly Shaped Articles
W59-13	Welded Steel Construction (Metal Arc Welding)
W178.2-14	Certification of Welding Inspectors

ASTM International

A 153/A 153M-16	Zinc Coating (Hot-Dip) on Iron and Steel Hardware
A 449-14	Hex Cap Screws, Bolts and Studs, Steel, Heat Treated, 120/105/90 ksi Minimum Tensile Strength, General Use
A 563-15	Carbon and Alloy Steel Nuts

Canadian General Standards Board

48.9712-2014	Non-Destructive Testing - Qualification and Certification of NDT Personnel
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2474.04 DESIGN AND SUBMISSION REQUIREMENTS

2474.04.01 Submission Requirements

2474.04.01.01 Working Drawings

Six sets of Working Drawings shall be submitted to the Contract Administrator a minimum 14 Days prior to the commencement of fabrication. An Engineer shall affix his or her seal and signature on the Working Drawings verifying that the drawings are consistent with the Contract Documents and sound engineering practices.

When multi-discipline engineering work is depicted on the same Working Drawing and a single Engineer is unable to seal and sign the Working Drawing for all aspects of the work, the drawing shall be signed and sealed by as many additional Engineers, as necessary.

As a minimum, the Working Drawings for anchorage assemblies shall include the following information:

- a) Dimensioned drawings, including plans, elevations, sections of the anchor rods, nuts, top and bottom plates, and their exact weights.
- b) Mill test certificates reports of all steel being used.

2474.05 MATERIALS

2474.05.01 Steel

Anchor rods shall be made of new billet steel round bar, quenched and tempered medium carbon steel, with a minimum yield strength of 517 MPa and a minimum tensile strength of 725 MPa, and shall satisfy Charpy V Notch test requirements of 20 joules at minus 30 °C.

The length, number, and size of the anchor rods shall be as specified in the Contract Documents.

Other general requirements shall be according to ASTM A 449 for anchor rods and ASTM A 563 for anchor rod nuts.

Anchor assembly top and bottom plates shall be made of PL10 x 100 mm according to CSA G40.20/G40.21, Grade 300W.

2474.05.02 Anchorage Setting Templates

The anchorage setting template shall be made of 20 mm thick plywood or hard wood or metal. Metal templates shall be a minimum of 12 gauge steel.

2474.07 PRODUCTION

2474.07.01 General

All fabrication shall be according to dimensions specified in the Working Drawings and as specified in the Contract Documents.

Anchorage assembly shall be supplied complete, as specified in the Contract Documents. Each assembly shall be supplied complete with anchor rods, hexagonal nuts, hardened steel washers, and steel top and bottom plates.

Each anchorage assembly shall be supplied with one anchorage setting template for positioning of the anchor rods to suit the required bolt circle diameter of the pole.

2474.07.02 Tolerance

Dimensions, threads, and hexagonal nuts tolerances shall be according to ASTM A 563, Grade DH. Exposed nuts are to be tapped oversized according to ASTM A 563 to allow for the thickness of the zinc coating on the rod threads.

2474.07.03 Welding

Hexagonal nuts shall be welded to the top and bottom plates according to CSA W59.

2474.07.04 Coating

The anchorage assembly shall be completely galvanized according to CAN/CSA G164M or ASTM A 153.

The exposed hexagonal nuts and washers shall be galvanized according to CAN/CSA G164M or ASTM A 153.

2474.07.05 Quality Control

Certification from the manufacturer shall be submitted to the Contract Administrator certifying that the anchorage assembly is according to the strength and material requirements as specified in the Contract Documents.

An inspector retained by the manufacturer shall inspect and test the anchorage assemblies. The inspector shall be certified for testing bridges according to CSA W178.2. The certification shall be either Level 2 or Level 3 for the methods used as specified in CAN/CGSB 48.9712.

The inspector shall inspect the place of manufacture of the anchorage assemblies while work on the units is being performed and shall inspect and examine the plant records and certificates, the materials used, and the fabrication process and shall conduct any tests as it may be considered necessary.

Two copies of the completed inspection report shall be submitted to the Contract Administrator. Inspection reports shall be completed and certified by the inspector.

When the anchorage assemblies have been delivered to the Working Area and prior to installation, the inspector shall inspect the anchorage assemblies to ensure that they meet all the Contract requirements.

2474.07.06 Testing

Visual inspection of the anchorage assemblies shall be performed by welding inspectors certified by the Canadian Welding Bureau under CSA W178.2 at a Level 3 category or working under a Level 2 inspector.

2474.07.07 Packaging and Shipment

Each anchorage assembly shall be shipped complete with hardware suitably packaged to ensure that all parts are delivered as an entity. A complete parts list shall be included in the shipment.

The supplier shall be responsible for loading, delivery, and off-loading of the anchorage assemblies to the designated areas. Anchorage assemblies shall be subject to inspection during and on completion of off-loading. If any damage is encountered during the off-loading inspection, the supplier shall be responsible for the necessary corrective measures subject to the approval of the Owner.

2474.08 QUALITY ASSURANCE

2474.08.01 Welding

All welding shall be subject to a visual inspection. Procedures and techniques for visual testing shall be according to CSA W59, Clause 7 and 8.

If faulty welding or material is encountered during the inspection procedures, the manufacturer shall submit corrective measures to the Contract Administrator for approval.

2474.08.02 Inspection

The Contract Administrator shall be notified a minimum of 3 Business Days prior to the start of fabrication, testing, and delivery.

The Contract Administrator shall have free access to the place of manufacture of the anchorage assemblies for the purpose of inspecting and examining plant records and certificates; materials used; process of manufacturing, including welding and galvanizing; and to make any tests as may be considered necessary, while the anchorage assembly is being fabricated.

All anchorage assemblies may be subject to an inspection by the Contract Administrator prior to shipment.

2474.09 OWNER PURCHASE OF MATERIAL

2474.09.01 Measurement and Payment

For measurement purposes, a count shall be made of the number of anchorage assemblies supplied and accepted.

Payment at the price specified in the purchasing order shall be for the supply of the anchorage assemblies delivered to the destination on the date and time specified.

The cost of all testing, except that performed by the Owner, shall be included in the price.

Appendix 2474-A, November 2016
FOR USE WHILE DESIGNING MUNICIPAL CONTRACTS

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