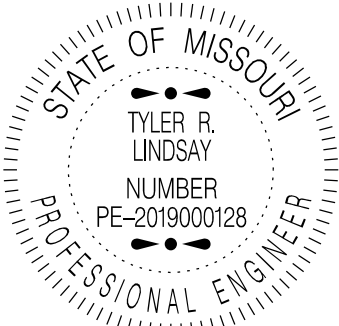


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 <p>TYLER R. LINDSAY NUMBER PE-2019000128</p> <p><i>Tyler R. Lindsay</i> 11/06/2024 11:37:41 AM TYLER R. LINDSAY - CIVIL MO-PE-2019000128</p>	<p><b>MISSOURI HIGHWAYS AND TRANSPORTATION COMMISSION</b> 105 W. CAPITOL AVE. JEFFERSON CITY, MO 65101 Phone (888) 275-6636</p>
	<p>If a seal is present on this sheet, JSP's has been electronically sealed and dated.</p>
	<p>JOB NO. J9P3690 Texas County, MO Date Prepared: 11/6/2024</p>
<p>Only the following items of the Job Special Provisions (Bridge) are authenticated by this seal: All</p>	

JOB SPECIAL PROVISIONS (BRIDGE)

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A. CONSTRUCTION REQUIREMENTS

**1.0 Description.** This provision contains general construction requirements for this project.

**2.0 Construction Requirements.** The plans and the asbestos and lead inspection report for the existing structure(s) are included in the contract in the bridge electronic deliverables zip file for informational purposes only.

**2.1** In order to assure the least traffic interference, the work shall be scheduled so that the bridge closure is for the absolute minimum amount of time required to complete the work. The bridge shall not be closed until material is available for continuous construction and the contractor is prepared to diligently pursue the work until the closed bridge is opened to traffic.

**2.2** Qualified special mortar shall be a qualified rapid set concrete patching material in accordance with [Sec 704](#). A qualified rapid set concrete patching material will not be permitted for half-sole repair, deck repair with void tube replacement, full depth repair, modified deck repair and substructure repair (formed) unless a note on the bridge plans specifies that a qualified special mortar may be used.

**2.3** The existing slab for the bridge(s) to be redecked was constructed as composite or non-composite as shown in the table below.

Bridge No.	Type of deck
L0713	Non-Composite

**2.4** Provisions shall be made to prevent any debris and material from falling into the waterway. If determined necessary by the engineer, any debris and material that falls below the bridge outside the previously specified limits shall be removed as approved by the engineer at the contractor's expense.

**2.5** Any damage sustained to the remaining structure as a result of the contractor's operations shall be repaired or the material replaced as approved by the engineer at the contractor's expense.

**2.6** Provisions shall be made to prevent damage to any existing utilities. Any damage sustained to the utilities as a result of the contractor's operations shall be the responsibility of the contractor. All costs of repair and disruption of service shall be as determined by the utility owners and as approved by the engineer.

**2.9** A washer shall be required under head and nut when any reaming is performed for bolt installation.

**2.10** SSPC-SP2 and SSPC-SP3 surface preparation shall be in accordance with the environmental regulations in [Sec 1081](#) and collection of residue shall be in accordance with [Sec 1081](#) for collection of blast residue. SSPC-SP6, SSPC-SP10 and SSPC-SP11 surface preparation shall be in accordance with the approved blast media and environmental regulations in [Sec 1081](#) and collection of blast residue shall be in accordance with [Sec 1081](#).

**3.0 Coating Information.**

**3.1 Straps Removal.** Exposed portions of straps for stay-in-place forms shall be removed prior to surface preparation. Straps need not be removed in areas that are not being painted. Flame

**JOB SPECIAL PROVISIONS (BRIDGE)**

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cutting will not be permitted. The contractor shall exercise care not to damage the existing structure during removal. Any damage sustained to the remaining structure as a result of the contractor's operations shall be repaired or the material replaced as approved by the engineer at the contractor's expense.

**3.2 Slab Drains and Stay-In-Place Forms.** The stay-in-place forms, slab drains and slab drain brackets shall not be recoated, overcoated or damaged during the painting operation. Any portion of the slab drain bracket that is blast cleaned shall be recoated with System G. Any damage sustained as a result of the contractor's operations shall be repaired or the material replaced as approved by the engineer at the contractor's expense.

**3.3 Existing Bridge Information.** The informational plans may be used by bidders in determining the amount of steel to be cleaned and painted/coated with the full understanding that the State accepts no responsibility for accuracy of the estimated tons of existing steel shown in the table below. The bidder's acceptance and use of the estimate shown below shall be no cause for claim for any final adjustment in the contract unit price for the work involved in repainting. Each bidder is expected to carefully examine the structure(s), investigate the condition of existing paint and prepare their own estimate of quantities involved before submitting a bid. Surface preparation and applying field coatings to the structural steel shall be based on the contract plan quantities. No final measurements will be made.

Bridge No.	Estimated Tons			Existing Paint System	Lead Based
	Coating System		Total		
	System G	Calcium Sulfonate			
L0713	104	0	104	S	Yes

**3.4 Environmental Contact.** Environmental Section may be contacted at the below address or phone number. The Missouri Department of Health may be contacted at (573) 751-6102.

MoDOT - Design Division - Environmental Section  
P.O. Box 270  
105 W. Capitol Ave., Jefferson City, MO 65102  
Telephone: (573) 526-4778

**3.5 Approved Smelter and Hazardous Waste Treatment, Storage and Disposal Facility.** The following is the approved smelter and hazardous waste treatment, storage and disposal facility:

Doe Run Company - Resource Recycling Division - Buick Facility  
Highway KK  
Boss, MO 65440  
Telephone: (573) 626-4813

**4.0 Method of Measurement.** No measurement will be made.

**5.0 Basis of Payment.** Payment for the above-described work will be considered completely covered by the contract unit price for other items included in the contract.

**B. RAPID SET CONCRETE PATCHING MATERIAL – VERTICAL AND OVERHEAD REPAIRS**

**JOB SPECIAL PROVISIONS (BRIDGE)**

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**1.0 Description.** This specification covers cementitious concrete, polymer-modified concrete and polymer concrete that are suitable for repairing concrete surfaces on bridges or concrete structures, particularly under fast setting or special conditions. The repairs would involve vertical or overhead applications. The work shall consist of removing, furnishing, preparing, and placing materials at locations as shown on the plans or as directed by the engineer.

**2.0 Material.** All materials shall be in accordance with MoDOT specifications and as noted herein.

**2.1 Aggregate. For Extending Commercial Mixture.** Coarse and fine aggregates shall be in accordance with [Sec 1005](#), except the requirements for gradation and percent passing the No. 200 sieve shall not apply. Coarse aggregate meeting Gradation E requirements shall be used for repairs greater than one inch (25 mm) in depth. Fine aggregate will be allowed for repairs less than one inch (25 mm). Aggregate specified, bagged, labeled and furnished by the rapid set concrete patching material manufacturer may also be used for mortar extension.

**2.2 Material Applications.** The contractor shall select and use the product most suitable for the work and field conditions in accordance with these specifications.

**2.3 Curing.** Rapid set concrete patching material shall be cured until the minimum compressive strength 1500 psi is attained using standard curing specifications, unless otherwise specified by the manufacturer.

**2.4 Qualification and Project Acceptance.**

**2.4.1 Inspection.** All materials shall be subject to inspection and sampling by MoDOT at the source of manufacture, intermediate shipping terminal or destination. MoDOT will be allowed free access to all facilities and records as required to conduct inspection and sampling.

**2.4.2 Qualification.** Prior to use, rapid set concrete patching materials need to be qualified.

**2.4.2.1 Requested Information.** The manufacturer shall submit with samples of the materials, a written request to Construction and Materials with the following information:

- (a) New Products Evaluation Form
- (b) Brand name of the product.
- (c) Certification that the material meets this specification.
- (d) Certified test results from an independent laboratory showing compliance with this specification.
- (e) Specific preparation instructions of repair area.
- (f) Specific mixing, handling and curing instructions.
- (g) Application type (i.e., vertical or overhead).

**2.4.2.2 Field Evaluation.** Final approval will be granted when the following requirements are met:

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- (a) MoDOT report documenting two years of field performance on MoDOT system. The report will contain the placement date, field observations (semi annual), description of field performance and photographs of in-place material.
- (b) A manufacturer's representative shall be present during placement of the material to provide technical expertise.

**2.4.2.2.3 Disqualification.** If during the two year observation period the repair area(s) fails the product will not be added to the qualified list.

**2.5 Qualified List.** The listing of qualified products are available from Construction and Materials or on MoDOT's web site. New certified test results and samples shall be submitted any time the manufacturing process or the material formulation is changed. The material will be subject to removal from the qualified list if there is evidence of unsatisfactory performance or a change in manufacturing process or formulation, or when random sampling and testing of material offered for use indicates nonconformity with any of the requirements herein specified.

**2.6 Certification.** The contractor shall supply a manufacturer's certification to the engineer for each lot of material furnished. The certification shall include the name of the manufacturer, a manufacturer certification statement that the material supplied is the same as that qualified and listing the date of qualification.

**2.7 Acceptance.** Acceptance of the material will be based on the use of a qualified product, the manufacturer's certification that the material supplied is the same as that approved and upon the results of such tests as may be performed by the engineer.

**3.0 Mixture.** Unless otherwise specified, rapid set concrete patching material shall be approved commercial mixtures meeting [Sections 3.1 – 3.1.3.](#) Rapid set concrete patching materials shall be specifically designed for the application needed.

**3.1 Commercial Mixtures.** Rapid set concrete patching material in its sacked form and mixtures when properly prepared in accordance with the manufacturer's specifications, shall meet the minimum test requirements given in Table 1. Mixtures may be supplied, as required, as a patching mortar or as a patching mortar with aggregate extension. If the material is to be supplied with extender aggregate, this shall also pass the required tests in Table 1 using the maximum allowed amount of extender aggregate.

**3.1.1 Mixture Requirements.** Rapid set concrete patching material shall be single packaged dry mix requiring the addition of water or other liquid component just prior to mixing. The material shall not contain soluble chlorides as an ingredient of manufacture. The material shall be placed in accordance to the manufacturer's recommendations.

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<b>Table 1 (English Unit)</b>				
<b>Physical Test Property</b>	<b>Specification</b>	<b>Requirement for cementitious concrete</b>	<b>Requirement for polymer-modified concrete</b>	<b>Requirement for polymer concrete</b>
Bond Strength by Slant Shear	ASTM C882/C928 <sup>2</sup>	min. 1000 psi @ 24hrs. & min. 1500 psi @ 7 days	n/a	min. 1000 psi @ 24hrs. & min. 1500 psi @ 7 days
Linear Coefficient of Thermal Expansion <sup>1</sup> (for bagged mortar only, without extension aggregate)	ASTM C531	n/a	n/a	4 – 8 X 10 <sup>-6</sup> in/in/deg F
Resistance to Rapid Freezing & Thawing	AASHTO T161 or ASTM C666	80% min. using Procedure B <sup>3</sup> (300 Cycles)	80% min. using Procedure B <sup>3</sup> (300 Cycles)	n/a
Compressive Strength	AASHTO T22 or ASTM C39	1500 psi @ 3 hr & 3000 psi @ 24 hr	1500 psi @ 3 hr & 3000 psi @ 24 hr	n/a
Rapid Chloride Permeability	AASHTO T277 or ASTM C1202	1000 coulombs @ 28 days	1000 coulombs @ 28 days	1000 coulombs @ 28 days
Length Change	AASHTO T 160 or ASTM C157	In water Storage (+0.15) In air storage (-0.15)	In water storage (+0.15) In air storage (-0.15)	n/a
Color		gray	gray	gray

<sup>1</sup> Not required for extended mixtures if the mortar passes this requirement.

<sup>2</sup> ASTM C882 shall be performed on non-water based materials. ASTM C928 shall be performed on water-based materials.

<sup>3</sup> Procedure A may be used in lieu of Procedure B

**3.1.2 Construction Requirements.** The manufacturer shall provide with the bagged mixture, specifications for the mixing procedure, amount and kind of liquid to be added, and the amount of aggregate extension allowed, if any. All mixing, handling and curing practices recommended by the manufacturer shall be followed and will be considered a part of these specifications.

**3.1.3 Removal from Qualified List.** All mixtures shall be approved before use. Reoccurring failures of any mixture for any reason will be cause for removal from the qualified list.

**3.2 Vertical Repair.** A qualified rapid set concrete patching material approved for vertical use may be used when specified on the plans and as approved by the engineer. The engineer will make field cylinders to verify the 1500 psi (10 MPa) minimum strength. The material shall adhere to the concrete surface without sagging.

**3.3 Overhead Repair.** A qualified rapid set concrete patching material approved for overhead use may be used when specified on the plans and as approved by the engineer. The material

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shall be placeable in layers of at least 1 inch on overhead applications without the use of formwork or anchoring devices. The material shall adhere to the concrete surface without sagging. The engineer will make field cylinders to verify the 1500 psi (10 MPa) minimum strength.

**4.0 Construction Requirements.**

**4.1 Mixing.** Rapid set concrete patching material shall be mixed and finished according to the manufacturer's recommendation.

**4.2 Preparation of Repair Area.** Deteriorated, damaged or defective concrete as shown on the plans, required by the specifications or as directed by the engineer, shall be removed. All exposed reinforcement shall be thoroughly cleaned as shown on the plans, required by the specifications or as directed by the engineer. Unless otherwise specified by the commercial mixture manufacturer, the existing surface shall be damp and all free water shall be removed prior to placement of the required material.

**4.3 Bonding Agent.** A bonding agent may be used if recommended by the rapid set concrete patching material manufacturer.

**5.0 Method of Measurement.** No measurement will be made for rapid set concrete patching material.

**6.0 Basis of Payment.** Rapid set concrete patching material will be paid for at the contract unit price for other items and will be considered full compensation for all labor, equipment and material to complete the described work.

C. RAPID SET CONCRETE PATCHING MATERIAL – HORIZONTAL REPAIRS

**1.0 Description.** This specification covers cementitious concrete, polymer-modified concrete and polymer concrete that are suitable for repairing concrete surfaces on bridges or roadways, particularly under fast setting or special conditions. The repairs would involve horizontal applications. The work shall consist of removing, furnishing, preparing, and placing materials at locations as shown on the plans or as directed by the engineer.

**2.0 Material.** All materials shall be in accordance with MoDOT specifications and as noted herein.

**2.1 Aggregate For Extending Commercial Mixture.** Coarse and fine aggregates shall be in accordance with [Sec 1005](#), except the requirements for gradation and percent passing the No. 200 sieve shall not apply. Coarse aggregate meeting Gradation E requirements shall be used for repairs greater than one inch (25 mm) in depth. Fine aggregate will be allowed for repairs less than one inch (25 mm). Aggregate specified, bagged, labeled and furnished by the rapid set concrete patching material manufacturer may also be used for mortar extension.

**2.2 Material Applications.** The contractor shall select and use the product most suitable for the work and field conditions in accordance with these specifications.

**2.3 Curing.** Rapid set concrete patching material shall be cured until the minimum compressive strength 3200 psi is attained using standard curing specifications, unless otherwise specified by the manufacturer.

**2.4 Qualification and Project Acceptance.**

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**2.4.1 Inspection.** All materials shall be subject to inspection and sampling by MoDOT at the source of manufacture, intermediate shipping terminal or destination. MoDOT will be allowed free access to all facilities and records as required to conduct inspection and sampling.

**2.4.2 Qualification.** Prior to use, rapid set concrete patching material shall be qualified. In order to become qualified, a material shall have completed testing through AASHTO's National Transportation Product Evaluation Program (NTPEP). The manufacturer shall contact the AASHTO/NTPEP coordinator to obtain the testing location for the rapid setting concrete patching material.

**2.4.2.1 Requested Information.** The manufacturer shall submit with samples of the materials, a written request to Construction and Materials with the following information:

- (a) Brand name of the product.
- (b) Certification that the material meets this specification.
- (c) NTPEP test results showing compliance with this special provision.
- (d) Specific mixing, handling and curing instructions.
- (e) Application type (i.e., bridge or roadway).

**2.4.2.2 Qualified List.** Upon approval by the engineer, the brand name and manufacturer will be placed on a qualified list of rapid set concrete patching materials. The listing of qualified materials is available from Construction and Materials or on MoDOT's web site. New certified test results and samples shall be submitted any time the manufacturing process or the material formulation is changed. The material will be subject to removal from the qualified list if there is evidence of unsatisfactory performance or a change in manufacturing process or formulation, or when random sampling and testing of material offered for use indicates nonconformity with any of the requirements herein specified.

**2.4.3 Provisional Approval.** Provisional approval may be granted provided the following requirements have been met:

- (c) New Products Evaluation Form
- (d) Certified test results from an independent laboratory showing compliance with this special provision.
- (e) Documentation prepared by MoDOT covering two years of field performance on MoDOT's system. MoDOT will need to approve the location of the test site. Documentation will contain the placement date, field observations (semi annual), description of field performance and photographs of in-place material.
- (f) During placement the manufacturer's representative shall be present on the project to provide technical expertise.

**2.4.3.1 Disqualification.** If during the two year observation period the repair area(s) fails provisional approval will not be granted. Repair area(s) experiencing any cracking, debonding or spalling will be considered a failure.



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**2.4.3.2 Length of Provisional Approval.** Provisional approval will be granted for three years or until NTPEP testing is completed.

**2.5 Certification.** The contractor shall supply a manufacturer's certification to the engineer for each lot of material furnished. The certification shall include the name of the manufacturer, a manufacturer certification statement that the material supplied is the same as that qualified and listing the date of qualification.

**2.6 Acceptance.** Acceptance of the material will be based on the use of a qualified or provisionally approved material, the manufacturer's certification that the material supplied is the same as that approved and upon the results of such tests as may be performed by the engineer.

**3.0 Mixture.** Unless otherwise specified, rapid set concrete patching material shall be approved commercial mixtures meeting [Sections 3.1 – 3.1.3](#) or deck repair cementitious mortar meeting [Section 3.2](#). Rapid set concrete patching materials shall be specifically designed for the application needed.

**3.1 Commercial Mixtures.** Rapid set concrete patching material in its sacked form and mixtures when properly prepared in accordance with the manufacturer's specifications, shall meet the minimum test requirements given in Table 1. Mixtures may be supplied, as required, as a patching mortar or as a patching mortar with aggregate extension. If the material is to be supplied with extender aggregate, this shall also pass the required tests in Table 1 using the maximum allowed amount of extender aggregate.

**3.1.2 Mixture Requirements.** Rapid set concrete patching material shall be single packaged dry mix requiring the addition of water or other liquid component just prior to mixing. The material shall be capable of ½ inch (13 mm) to full depth repair and require no bonding agent. The material shall not contain soluble chlorides as an ingredient of manufacture. The material shall be placed in accordance to the manufacturer's recommendations.

<b>Table 1 (English Unit)</b>				
<b>Physical Test Property</b>	<b>Specification</b>	<b>Requirement for cementitious concrete</b>	<b>Requirement for polymer-modified concrete</b>	<b>Requirement for polymer concrete</b>
Bond Strength by Slant Shear <sup>1</sup>	ASTM C882/C928 <sup>3</sup>	min. 1000 psi @ 24hrs.& min. 1500 psi @ 7 days	n/a	min. 1000 psi @ 24hrs.& min. 1500 psi @ 7 days
Linear Coefficient of Thermal Expansion <sup>1, 2</sup> (for bagged mortar only, without extension aggregate)	ASTM C531	n/a	n/a	4 – 8 X 10-6 in/in/deg F
Resistance to Rapid Freezing & Thawing <sup>1</sup>	AASHTO T161 or ASTM C666	80% min. using Procedure B <sup>5</sup> (300 Cycles)	80% min. using Procedure B <sup>5</sup> (300 Cycles)	n/a

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Compressive Strength <sup>1</sup>	AASHTO T22 or ASTM C39	3200 psi @ 3 hr & 4000 psi @ 7 days	3200 psi @ 3 hr & 4000 psi @ 7 days	n/a
Rapid Chloride Permeability <sup>1</sup>	AASHTO T277 or ASTM C1202	<u>Bridge Decks</u> 1000 coulombs @ 28 days <u>Roadway</u> 2000 coulombs @ 28 days	<u>Bridge Deck</u> 1000 coulombs @ 28 days <u>Roadway</u> 2000 coulombs @ 28 days	<u>Bridge Deck</u> 1000 coulombs @ 28 days <u>Roadway</u> 2000 coulombs @ 28 days
Length Change <sup>1, 4</sup>	AASHTO T 160 or ASTM C157	In water Storage (+0.15) In air storage (-0.15)	In water storage (+0.15) In air storage (-0.15)	n/a
Color		gray	gray	gray

<sup>1</sup>The commercial mix test values can be located in the AASHTO's National Transportation Product Evaluation Program (NTPEP) reports for Laboratory Evaluations of Rapid Set Concrete Patching Materials. Data for provisionally approved materials is located at the Construction and Materials Division.

<sup>2</sup>Not required for extended mixtures if the mortar passes this requirement.

<sup>3</sup> ASTM C882 shall be performed on non-water based materials. ASTM C928 shall be performed on water-based materials.

<sup>4</sup> As modified by ASTM C928.

<sup>5</sup> Procedure A may be used in lieu of Procedure B

**3.1.2 Construction Requirements.** The manufacturer shall provide with the bagged mixture, specifications for the mixing procedure, amount and kind of liquid to be added, and the amount of aggregate extension allowed, if any. All mixing, handling and curing practices recommended by the manufacturer shall be followed and will be considered a part of these specifications.

**3.1.3 Removal from Qualified List.** All mixtures shall be approved before use. Reoccurring failures of any mixture for any reason will be cause for removal from the qualified list.

**3.2 Deck Repair Concrete.** A qualified rapid set concrete patching material indicated for horizontal use and intended for patching concrete bridge decks may be used when specified on the plans and as approved by the engineer. If this option is selected, the contractor shall provide a trial mix to determine the total cure time needed to achieve a compressive strength of 3200 psi (22 MPa). Compressive specimens shall be prepared in accordance with current MoDOT test methods and cured to simulate actual field conditions. Testing of compressive specimens shall be performed by methods and at facilities acceptable to the engineer. The repaired deck shall not be opened to traffic until at least 4 hours after the last placement of deck repair concrete, the established cure time has elapsed and until such concrete has achieved a compressive strength of 3200 psi (22 MPa). A new trial mix may be required if the engineer determines the field conditions vary substantially from trial mix conditions. The engineer will make field cylinders to verify the 3200 psi (22 MPa) minimum strength.

**4.0 Construction Requirements.**

**4.1 Mixing.** Rapid set concrete patching material shall be mixed and finished according to the manufacturer's recommendation.

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**4.2 Preparation of Repair Area.** Deteriorated, damaged or defective concrete as shown on the plans, required by the specifications or as directed by the engineer, shall be removed. All exposed reinforcement shall be thoroughly cleaned as shown on the plans, required by the specifications or as directed by the engineer. Unless otherwise specified by the commercial mixture manufacturer, the existing surface shall be damp and all free water shall be removed prior to placement of the required material.

**4.3 Bonding Agent.** A bonding agent may be used if recommended by the rapid set concrete patching material manufacturer.

**5.0 Method of Measurement.** No measurement will be made for rapid set concrete patching material.

**6.0 Basis of Payment.** Rapid set concrete patching material will be paid for at the contract unit price for other items and will be considered full compensation for all labor, equipment and material to complete the described work.

D. DEFLECTION AND HAUNCHING

**1.0 Description.** The contractor shall determine haunching based on field measurements, existing bridge plans and/or adjusted dead load deflections based on the difference between the new and existing dead load weights. A spreadsheet showing adjusted girder or beam deflections due to the weight of the new deck and barriers is included in the contract in the bridge electronic deliverables zip file.

**2.0 Construction Requirements.** In order to properly form the haunches for the new deck, the contractor shall survey top of deck elevations above each girder or beam including centerline of roadway and along each girder or beam line (top or bottom flange) prior to deck removal followed by surveying elevations of the girders or beams (top or bottom flange) after deck removal.

**3.0 Method of Measurement.** No measurement will be made.

**4.0 Basis of Payment.** Payment for the above-described work will be considered completely covered by the contract unit price for other items included in the contract.

E. NON-DESTRUCTIVE TESTING

**1.0 Description.** This work shall consist of performing non-destructive testing on the welds of all existing top flange cover plates.

**2.0 Construction Requirements.**

**2.1** After the concrete deck is removed, the steel that is to remain will be inspected by the engineer. In addition to this inspection, the welds and adjacent base metal at the ends of the top cover plates shall have non-destructive (magnetic particle) testing performed. Non-destructive testing shall be performed by an acceptable testing agency. The contractor shall submit to the engineer and Bridge Division ([Fabrication@modot.mo.gov](mailto:Fabrication@modot.mo.gov)) the following documentation for each individual performing non-destructive testing (NDT): their certifications, current eye exam and the NDT company written practice, including the Level III individual certification used for written practice. Personnel performing the tests shall be qualified for SNT-TC-1A Level II.

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**2.2** The length of weld to be tested and the base metal, one inch either side of the weld, shall be cleaned of all rust prior to the testing. On cover plates with square ends, the weld shall be tested one inch from each corner along the ends of the cover plate plus 6 inches back along the side from each corner of the plate. On cover plates with tapered ends, the weld shall be tested along the end of the cover plate, along tapered edges and 6 inches back along the cover plate from end of taper.

**2.3** If fatigue cracks are found, the cracks are expected to be very small and may be located in the base metal at the toe of the welds. Any cracks discovered by testing, regardless of length, shall be marked and reported to the engineer. All repairs shall be made by a certified welder in accordance with [Sec 712.6](#). Any repair work and retesting of the repair work required, as a result of this inspection, will be paid for in accordance with [Sec 109](#). This shall not relieve the contractor from responsibility to repair any damage caused by this work at the contractor's expense. Any delay or inconvenience caused by this inspection requirement will be non-compensable and effect on time of performance non-excusable.

**3.0 Method of Measurement.** Measurement of non-destructive testing will be to the nearest linear foot. The extent of non-destructive testing may vary from the estimated quantities, but the contract unit price shall prevail regardless of the variation. Final measurements will not be made except for authorized changes during construction, or where appreciable errors are found in the contract quantity. The revision or correction will be computed and added to or deducted from the contract quantity.

**4.0 Basis of Payment.** Accepted quantities of non-destructive testing will be paid for at the contract unit price. Payment for the above described work, including all material, equipment, labor and any other incidental work necessary to complete this item, will be considered completely covered by the contract unit price for Non-Destructive Testing.