

SECTION 03331 - CAST-IN-PLACE ARCHITECTURAL CONCRETE

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 1 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. This Section specifies cast-in-place architectural concrete including form facings, reinforcement accessories, concrete materials, concrete mixture design, placement procedures, and finishes.
- B. Related Sections include the following:
 - 1. Division 2 Section "Cement Concrete Pavement" for concrete pavement and flatwork finishes.
 - 2. Division 3 Section "Cast-in-Place Concrete" for material, fabrication, and installation requirements for steel reinforcement; and field quality control.
 - 3. Division 7 Section "Joint Sealants" for elastomeric joint sealants in contraction and other joints in cast-in-place architectural concrete.

1.3 DEFINITIONS

- A. Cast-in-Place Architectural Concrete: Formed concrete that is exposed to view on surfaces of completed structure or building and that requires special concrete materials, formwork, placement, or finishes to obtain specified architectural appearance.
- B. Cementitious Materials: Portland cement alone or in combination with one or more of the following: blended hydraulic cement, fly ash and other pozzolans, ground granulated blast-furnace slag, and silica fume; subject to compliance with requirements.
- C. Design Reference Sample: Sample designated by Architect in the Contract Documents that reflects acceptable surface quality and appearance of cast-in-place architectural concrete.

1.4 SUBMITTALS

- A. Product Data: For each type of product indicated.
- B. Design Mixtures: For each concrete mixture. Submit alternate design mixtures when

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characteristics of materials, Project conditions, weather, test results, or other circumstances warrant adjustments.

- C. Formwork Shop Drawings: Show formwork construction including form-facing joints, rustications, construction and contraction joints, form joint-sealant details, form tie locations and patterns, inserts and embedments, cutouts, cleanout panels, and other items that visually affect cast-in-place architectural concrete.
- D. Samples: For each of the following materials:
 - 1. Form-facing panel.
 - 2. Chamfers and rustications.

1.5 QUALITY ASSURANCE

- A. Manufacturer Qualifications: A firm experienced in manufacturing ready-mixed concrete products and that complies with ASTM C 94/C 94M requirements for production facilities and equipment.
 - 1. Manufacturer certified according to NRMCA's "Certification of Ready Mixed Concrete Production Facilities."
- B. Source Limitations for Cast-in-Place Architectural Concrete: Obtain each color, size, type, and variety of concrete material and concrete mixture from one manufacturer with resources to provide cast-in-place architectural concrete of consistent quality in appearance and physical properties.
- C. ACI Publications: Comply with the following unless modified by requirements in the Contract Documents:
 - 1. ACI 303.1, "Specification for Cast-in-Place Architectural Concrete."
- D. Concrete Testing Service: Engage a qualified independent testing agency to perform material evaluation tests and to design concrete mixtures.
- E. Mockups: Before casting architectural concrete, build mockups to verify selections made under sample submittals and to demonstrate typical joints, surface finish, texture, tolerances, and standard of workmanship. Build mockups to comply with the following requirements, using materials indicated for the completed Work:
 - 1. Build mockups in the location and of the size indicated or, if not indicated, as directed by Architect.
 - 2. Demonstrate curing, cleaning, and protecting of cast-in-place architectural concrete, finishes, and contraction joints, as applicable.
 - 3. In presence of Architect, damage part of the exposed-face surface for each finish, color, and texture, and demonstrate materials and techniques proposed for repair of tie holes and surface blemishes to match adjacent undamaged surfaces.

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4. Obtain Architect's approval of mockups before casting architectural concrete.
5. Approved mockups may become part of the completed Work if undisturbed at time of Substantial Completion.

PART 2 - PRODUCTS

2.1 FORM-FACING MATERIALS

- A. General: Comply with Division 3 Section "Cast-in-Place Concrete" for formwork and other form-facing material requirements.
- B. Form-Facing Panels for As-Cast Finishes: Exterior-grade plywood panels, nonabsorptive, that will provide continuous, true, and smooth architectural concrete surfaces, medium-density overlay, Class 1, or better, mill-applied release agent and edge sealed, complying with DOC PS 1.
- C. Chamfer Strips: Metal, rigid plastic, elastomeric rubber, or dressed wood, 3/4 by 3/4 inch, minimum (unlss otherwise indicated); nonstaining; in longest practicable lengths.
- D. Form Joint Tape: Compressible foam tape; pressure sensitive; AAMA 800, "Specification 810.1, Expanded Cellular Glazing Tape"; minimum 1/4 inch thick.
- E. Form Joint Sealant: Elastomeric sealant complying with ASTM C 920, Type M or S, Grade NS, that adheres to form joint substrates.
- F. Sealer: Penetrating, clear, polyurethane wood form sealer formulated to reduce absorption of bleed water and prevent migration of set-retarding chemicals from wood.
- G. Form-Release Agent: Commercially formulated colorless form-release agent that will not bond with, stain, or adversely affect architectural concrete surfaces and will not impair subsequent treatments of those surfaces.
- H. Form Ties: Factory-fabricated, internally disconnecting or removable ties designed to resist lateral pressure of fresh concrete on forms and to prevent spalling of concrete on removal. Do not leave holes on concrete surface.
 - 1.

2.2 STEEL REINFORCEMENT AND ACCESSORIES

- A. General: Comply with Division 3 Section "Cast-in-Place Concrete" for steel reinforcement and other requirements for reinforcement accessories.
- B. Bar Supports: Bolsters, chairs, spacers, and other devices for spacing, supporting, and fastening reinforcing bars and welded-wire fabric in place; manufacture according to CRSI's

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"Manual of Standard Practice."

2.3 CONCRETE MATERIALS

- A. Cementitious Material: Use the following cementitious materials, of the same type, brand, and source, throughout Project:
 - 1. Blended Hydraulic Cement: ASTM C 595, Type IS, portland blast-furnace slag cement.
- B. Normal-Weight Aggregates: ASTM C 33, Class 5S coarse aggregate or better, graded. Provide aggregates from a single source.
 - 1. Maximum Coarse Aggregate Size: 1/2 inch .
 - 2. Gradation: Uniformly graded.
- C. Normal-Weight Fine Aggregate: ASTM C 33, manufactured or natural sand, from same source for entire Project.
- D. Water: Potable, complying with ASTM C 94/C 94M except free of wash water from mixer washout operations.

2.4 ADMIXTURES

- A. Color Pigment: ASTM C 979, synthetic mineral-oxide pigments or colored water-reducing admixtures; color stable, free of carbon black, nonfading, and resistant to lime and other alkalis.
 - 1. Color: As selected by Architect from manufacturer's full range. 1-25lb. bag per 1 yard.

2.5 CURING MATERIALS

- A. Moisture-Retaining Cover: ASTM C 171, polyethylene film or white burlap-polyethylene sheet.
- B. Waterborne, Membrane-Forming Curing Compound: ASTM C 309, Type 1, Class B.
 - 1. For integrally colored concrete, curing compound shall be pigmented type approved by color pigment manufacturer.

2.6 REPAIR MATERIALS

- A. Bonding Agent: ASTM C 1059, Type II, nonredispersible, acrylic emulsion or styrene butadiene.

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- B. Epoxy Bonding Adhesive: ASTM C 881, two-component epoxy resin, capable of humid curing and bonding to damp surfaces, of class suitable for application temperature and of grade to suit requirements.
 - 1. Types I and II, non-load bearing, for bonding hardened or freshly mixed concrete to hardened concrete.

2.7 CONCRETE MIXTURES, GENERAL

- A. Prepare design mixtures for each type and strength of cast-in-place architectural concrete proportioned on basis of laboratory trial mixture or field test data, or both, according to ACI 301.
 - 1. Use a qualified independent testing agency for preparing and reporting proposed design mixtures based on laboratory trial mixtures.
- B. Proportion concrete mixtures as follows:
 - 1. Compressive Strength (28 Days): 3000 psi .
 - 2. Maximum Water-Cementitious Materials Ratio: 0.46.
 - 3. Slump Limit: 6 inches, plus or minus 1 inch.
- C. Cementitious Materials: For cast-in-place architectural concrete exposed to deicers, limit percentage, by weight, of cementitious materials other than portland cement according to ACI 301 requirements.
- D. Limit water-soluble, chloride-ion content in hardened concrete to 0.06 percent by weight of cement.
- E. Admixtures: Use admixtures according to manufacturer's written instructions.
- F. Color Pigment: Add color pigment to concrete mixture according to manufacturer's written instructions and to result in hardened concrete color consistent with approved mockup.

2.8 CONCRETE MIXING

- A. Ready-Mixed Architectural Concrete: Measure, batch, mix, and deliver concrete according to ASTM C 94/C 94M and furnish batch ticket information.
 - 1. Clean equipment used to mix and deliver cast-in-place architectural concrete to prevent contamination from other concrete.
 - 2. When air temperature is between 85 and 90 deg F, reduce mixing and delivery time from 1-1/2 hours to 75 minutes; when air temperature is above 90 deg F, reduce mixing and delivery time to 60 minutes.

PART 3 - EXECUTION

3.1 FORMWORK

- A. General: Comply with Division 3 Section "Cast-in-Place Concrete" for formwork, embedded items, and shoring and reshoring.
- B. In addition to ACI 303.1 limits on form-facing panel deflection, limit cast-in-place architectural concrete surface irregularities, designated by ACI 347R as abrupt or gradual, as follows:
 - 1. Class A, 1/8 inch .
- C. Fabricate forms to result in cast-in-place architectural concrete that complies with ACI 117, "Specifications for Tolerances for Concrete Construction and Materials."
- D. Fabricate forms for easy removal without hammering or prying against concrete surfaces. Provide crush or wrecking plates where stripping may damage cast-in-place surfaces. Provide top forms for inclined surfaces steeper than 1.5 horizontal to 1 vertical. Kerf wood rustications, keyways, reglets, recesses, and the like, for easy removal.
 - 1. Seal form joints and penetrations at form ties with form joint tape or form joint sealant to prevent cement paste leakage.
 - 2. Do not use rust-stained steel form-facing material.
- E. Chamfer exterior corners and edges of cast-in-place architectural concrete.
- F. Clean forms and adjacent surfaces to receive concrete. Remove chips, wood, sawdust, dirt, and other debris just before placing concrete.
- G. Retighten forms and bracing before placing concrete, as required, to prevent mortar leaks and maintain proper alignment.
- H. Coat contact surfaces of forms with form-release agent, according to manufacturer's written instructions, before placing reinforcement.

3.2 REINFORCEMENT AND INSERTS

- A. General: Comply with Division 3 Section "Cast-in-Place Concrete" for fabricating and installing steel reinforcement. Securely fasten steel reinforcement and wire ties against shifting during concrete placement.
- B. Set wire ties with ends directed into concrete, not toward exposed concrete surfaces.

3.3 REMOVING AND REUSING FORMS

- A. Formwork for sides of beams, walls, columns, and similar parts of the Work that does not support weight of concrete may be removed after cumulatively curing at not less than 50 deg F for 24 hours after placing concrete, if concrete is hard enough to not be damaged by form-removal operations and curing and protection operations are maintained.
 - 1. Schedule form removal to maintain surface appearance that matches approved mockups.
 - 2. Cut off and grind glass-fiber-reinforced plastic form ties flush with surface of concrete.
- B. Clean and repair surfaces of forms to be reused in the Work. Do not use split, frayed, delaminated, or otherwise damaged form-facing material. Apply new form-release agent.
- C. When forms are reused, clean surfaces, remove fins and laitance, and tighten to close joints. Align and secure joints to avoid offsets. Do not use patched forms for cast-in-place architectural concrete surfaces.

3.4 CONCRETE PLACEMENT

- A. Before placing concrete, verify that installation of formwork, form-release agent, reinforcement, and embedded items is complete and that required inspections have been performed.
- B. Do not add water to concrete during delivery, at Project site, or during placement unless approved by Architect.
- C. Before test sampling and placing concrete, water may be added at Project site, subject to limitations of ACI 301.
- D. Deposit concrete continuously between construction joints. Deposit concrete to avoid segregation.
 - 1. Deposit concrete in horizontal layers of depth to not exceed formwork design pressures and in a manner to avoid inclined construction joints.
 - 2. Consolidate placed concrete with mechanical vibrating equipment according to ACI 303.1.
 - 3. Do not use vibrators to transport concrete inside forms. Insert and withdraw vibrators vertically at uniformly spaced locations to rapidly penetrate placed layer and at least 6 inches into preceding layer. Do not insert vibrators into lower layers of concrete that have begun to lose plasticity. Do not permit vibrators to contact forms.
- E. Cold-Weather Placement: Comply with ACI 306.1 and as follows. Protect concrete work from physical damage or reduced strength that could be caused by frost, freezing actions, or low temperatures.
 - 1. When average high and low temperature is expected to fall below 40 deg F for three successive days, maintain delivered concrete mixture temperature within the temperature

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- range required by ACI 301.
2. Do not use frozen materials or materials containing ice or snow. Do not place concrete on frozen subgrade or on subgrade containing frozen materials.
 3. Do not use calcium chloride, salt, or other materials containing antifreeze agents.
 4. Do not use chemical accelerators unless otherwise specified and approved in design mixtures.

F. Hot-Weather Placement: Comply with ACI 301 and as follows:

1. Maintain concrete temperature below 90 deg F at time of placement. Chilled mixing water or chopped ice may be used to control temperature, provided water equivalent of ice is calculated to total amount of mixing water. Using liquid nitrogen to cool concrete is Contractor's option.
2. Fog-spray forms, steel reinforcement, and subgrade just before placing concrete. Keep subgrade uniformly moist without standing water, soft spots, or dry areas.

3.5 FINISHES, GENERAL

- A. Architectural Concrete Finish: Match Architect's design reference sample, identified and described as indicated, to satisfaction of Architect.
- B. Related Unformed Surfaces: At tops of walls, horizontal offsets, and similar unformed surfaces adjacent to formed surfaces, strike off smooth and finish with a texture matching adjacent formed surfaces.
 1. Continue final surface treatment of formed surfaces uniformly across adjacent unformed surfaces, unless otherwise indicated.
- C. Maintain uniformity of special finishes over construction joints, unless otherwise indicated.

3.6 AS-CAST FORMED FINISHES

- A. Smooth-Formed Finish: As-cast concrete texture imparted by form-facing material, arranged in an orderly and symmetrical manner with a minimum of seams. Remove fins and other projections exceeding specified limits on formed-surface irregularities. Repair defects.
- B. Rubbed Finish: Apply the following to smooth-form-finished as-cast concrete where indicated:
 1. Grout-Cleaned Finish: Wet concrete surfaces and apply grout of a consistency of thick paint to coat surfaces and fill small holes. Mix one part portland cement to one and one-half parts fine sand with a 1:1 mixture of bonding admixture and water. Add white portland cement in amounts determined by trial patches so color of dry grout will match surrounding concrete. Scrub grout into voids and remove excess grout. When grout whitens, rub surface with clean burlap and keep surface damp by fog spray for at least 36 hours.

3.7 CONCRETE PROTECTING AND CURING

- A. General: Protect freshly placed concrete from premature drying and excessive cold or hot temperatures. Comply with ACI 306.1 for cold-weather protection and with ACI 301 for hot-weather protection during curing.
- B. Begin curing cast-in-place architectural concrete immediately after removing forms from concrete. Cure according to ACI 308.1, by one or a combination of the following methods that will not mottle, discolor, or stain concrete:
 - 1. Curing Compound: Mist concrete surfaces with water. Apply curing compound uniformly in continuous operation by power spray or roller according to manufacturer's written instructions. Recoat areas subjected to heavy rainfall within three hours after initial application. Maintain continuity of coating and repair damage during curing period.

3.8 FIELD QUALITY CONTROL

- A. General: Comply with Division 3 Section "Cast-in-Place Concrete" for field quality-control requirements.

3.9 REPAIRS, PROTECTION, AND CLEANING

- A. Repair and cure damaged finished surfaces of cast-in-place architectural concrete when approved by Architect. Match repairs to color, texture, and uniformity of surrounding surfaces and to repairs on approved mockups.
 - 1. Remove and replace cast-in-place architectural concrete that cannot be repaired and cured to Architect's approval.
- B. Protect corners, edges, and surfaces of cast-in-place architectural concrete from damage; use guards and barricades.
- C. Protect cast-in-place architectural concrete from staining, laitance, and contamination during remainder of construction period.
- D. Clean cast-in-place architectural concrete surfaces after finish treatment to remove stains, markings, dust, and debris.
- E. Wash and rinse surfaces according to concrete finish applicator's written recommendations. Protect other Work from staining or damage due to cleaning operations.
 - 1. Do not use cleaning materials or processes that could change the appearance of cast-in-place architectural concrete finishes.

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