



Standard Specification for Reinforced Concrete Low-Head Pressure Pipe (Metric)¹

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This standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope

1.1 This specification covers reinforced concrete pipe intended to be used for the construction of pressure pipelines with low internal hydrostatic heads generally not exceeding 375 kPa.

1.2 This specification is the SI companion to Specification C361. It is compatible in technical content.

NOTE 1—Field tests on completed portions of the pipeline are not covered by this specification for the manufacture of the pipe but should be included in specifications for pipe laying.

2. Referenced Documents

2.1 ASTM Standards:²

- A27/A27M Specification for Steel Castings, Carbon, for General Application
- A36/A36M Specification for Carbon Structural Steel
- A82/A82M Specification for Steel Wire, Plain, for Concrete Reinforcement (Withdrawn 2013)³
- A185/A185M Specification for Steel Welded Wire Reinforcement, Plain, for Concrete (Withdrawn 2013)³
- A283/A283M Specification for Low and Intermediate Tensile Strength Carbon Steel Plates
- A496/A496M Specification for Steel Wire, Deformed, for Concrete Reinforcement (Withdrawn 2013)³
- A497/A497M Specification for Steel Welded Wire Reinforcement, Deformed, for Concrete (Withdrawn 2013)³
- A575 Specification for Steel Bars, Carbon, Merchant Quality, M-Grades

- A576 Specification for Steel Bars, Carbon, Hot-Wrought, Special Quality
- A615/A615M Specification for Deformed and Plain Carbon-Steel Bars for Concrete Reinforcement
- A675/A675M Specification for Steel Bars, Carbon, Hot-Wrought, Special Quality, Mechanical Properties
- A1008/A1008M Specification for Steel, Sheet, Cold-Rolled, Carbon, Structural, High-Strength Low-Alloy, High-Strength Low-Alloy with Improved Formability, Solution Hardened, and Bake Hardenable
- A1011/A1011M Specification for Steel, Sheet and Strip, Hot-Rolled, Carbon, Structural, High-Strength Low-Alloy, High-Strength Low-Alloy with Improved Formability, and Ultra-High Strength
- C31/C31M Practice for Making and Curing Concrete Test Specimens in the Field
- C33 Specification for Concrete Aggregates
- C39/C39M Test Method for Compressive Strength of Cylindrical Concrete Specimens
- C150 Specification for Portland Cement
- C260 Specification for Air-Entraining Admixtures for Concrete
- C309 Specification for Liquid Membrane-Forming Compounds for Curing Concrete
- C497M Test Methods for Concrete Pipe, Manhole Sections, or Tile (Metric)
- C595 Specification for Blended Hydraulic Cements
- C618 Specification for Coal Fly Ash and Raw or Calcined Natural Pozzolan for Use in Concrete
- C822 Terminology Relating to Concrete Pipe and Related Products
- C1602/C1602M Specification for Mixing Water Used in the Production of Hydraulic Cement Concrete
- C1619 Specification for Elastomeric Seals for Joining Concrete Structures
- D698 Test Methods for Laboratory Compaction Characteristics of Soil Using Standard Effort (12 400 ft-lbf/ft³ (600 kN-m/m³))
- D4253 Test Methods for Maximum Index Density and Unit Weight of Soils Using a Vibratory Table

¹ This specification is under the jurisdiction of ASTM Committee C13 on Concrete Pipe and is the direct responsibility of Subcommittee C13.04 on Low Head Pressure Pipe.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ The last approved version of this historical standard is referenced on www.astm.org.

D4254 Test Methods for Minimum Index Density and Unit Weight of Soils and Calculation of Relative Density

2.2 Other Standard:

ACI Code 318 Standard Building Code Requirements for Reinforced Concrete⁴
AISI-C1012⁵

3. Terminology

3.1 Definitions—For definitions of terms relating to concrete pipe, see Terminology **C822**.

4. Classification

4.1 Pipe manufactured according to this specification shall be for hydrostatic heads of 75, 150, 225, 300, and 375 kPa measured to the centerline of the pipe. Designs are provided in **Table 1** and **Table 2** for the above hydrostatic heads combined with external loadings of 1.5, 3.0, 4.5, and 6.0 m (designated A, B, C, and D in **Table 1** and **Table 2**) of earth cover over the top of the pipe under specific installation conditions. The specific installation conditions are covered in **Appendix X1**. Where the hydrostatic head, external loadings, and installation conditions vary from those given in **Table 1** and **Table 2** and **Appendix X1**, detailed design calculations shall be made. The design criteria for **Table 1** and **Table 2** are presented in **Appendix X2**.

5. Basis of Acceptance

5.1 Acceptability of the pipe in all diameters and classes shall be determined by the results of such material tests as are required in **6.2** through **6.9** by crushing tests on cured concrete cylinders, by hydrostatic pressure tests on units of the pipe, by joint leakage tests, and by inspection during or after manufacture to determine whether the pipe conforms to this specification as to design and freedom from defects.

5.2 Age for Acceptance—Pipe shall be considered ready for acceptance when they conform to the requirements, as indicated by the specified tests.

6. Materials

6.1 Reinforced Concrete—The reinforced concrete shall consist of portland cement, mineral aggregates, and water, in which steel has been embedded in such a manner that the steel and concrete act together. Fly ash or pozzolan is not prohibited when used as a partial cement replacement; see **9.1**.

6.2 Cementitious Materials:

6.2.1 Cement:

6.2.1.1 Portland Cement—Portland cement shall conform to the requirements of Specification **C150**.

6.2.1.2 Blended Hydraulic Cement—Blended cement shall conform to the requirements of Specification **C595** for Type IS portland blast furnace slag cement or Type IP portland pozzolan cement, except that the pozzolan constituent in the Type IP portland pozzolan cement shall not exceed 20 % by weight.

6.2.2 Fly Ash or Pozzolan—Fly ash or pozzolan shall conform to the requirements of Specification **C618**.

6.2.3 Allowable Cementitious Materials—The combination of cementitious materials used in the concrete shall be one of the following:

6.2.3.1 Portland cement only,

6.2.3.2 Portland blast furnace slag cement only,

6.2.3.3 Portland pozzolan cement only, or

6.2.3.4 A combination of portland cement and fly ash or pozzolan, wherein the proportion of fly ash or pozzolan is between 5 and 20 % by weight of total cementitious material (portland cement plus fly ash or pozzolan).

6.3 Aggregates—Aggregates shall conform to Specification **C33**, except that the requirements for grading are waived.

6.4 Admixtures—Admixtures, except for air-entraining agents, shall not be added to the concrete unless permitted by the owner. At the option of the manufacturer, or if specified by the owner, the concrete in precast concrete pipe placed by the cast-and-vibrated method shall contain an air-entraining agent conforming to Specification **C260**. The amount of air-entraining agent used shall be such as will affect the entrainment of not more than 3 % air by volume of concrete as discharged from the mixer.

6.5 Steel Reinforcement—Reinforcement shall consist of wire conforming to Specification **A82/A82M**, Specification **A496/A496M**, or of wire reinforcement conforming to Specification **A185/A185M** or Specification **A497/A497M**, or of bars of Grade 300 steel conforming to Specification **A615/A615M**.

6.6 Steel for Joint Rings:

6.6.1 Steel strips for bell rings less than 6 mm thick shall conform to Grade SS30 of Specification **A1011/A1011M** or Grade Designation 1012 of Specification **A575**. Steel that meets the requirements of AISI-C1012 for chemical components will be acceptable provided it conforms to Grade SS30 of Specification **A1011/A1011M** in other respects.

6.6.2 Steel plate for bell rings 6 mm or more in thickness and special shapes for spigot joint rings shall conform to Specification **A36/A36M**, or to Grade A of Specification **A283/A283M**, or to Grade Designation 1012 of Specification **A576**, or to Grade 50 of Specification **A675/A675M**. Steel that meets the requirements of AISI-C1012 for chemical components will be acceptable provided it conforms to Specification **A36/A36M** or to Specification **A283/A283M** in other respects.

6.7 Steel Castings for Fittings—Steel castings for fittings shall conform to Grade 70-36, Normalized, of Specification **A27/A27M**.

6.8 Steel Plates and Sheets for Specials and Fittings—Steel plates for specials and fittings shall conform to Specification **A36/A36M** or to Grade B or C of Specification **A283/A283M** or Grade SS30 or SS33 of Specification **A1011/A1011M** or Grade SS30 of Specification **A1008/A1008M**.

6.9 Rubber Gaskets:

6.9.1 Composition and Properties—All rubber gaskets shall comply with Specification **C1619** in terms of material and manufacture. The gaskets shall be of a solid circular cross

⁴ Available from American Concrete Institute (ACI), P.O. Box 9094, Farmington Hills, MI 48333-9094, <http://www.concrete.org>.

⁵ Available from the American Iron and Steel Institute (AISI), 1140 Connecticut Ave. NW, Suite 705, Washington D.C. 20036, <http://www.steel.org>.



TABLE 1 Design Requirements for Reinforced Concrete Low-Head Pressure Pipe [300 to 3650 mm Diameter], Concrete Design Strength 34.5 MPa (except as noted) Steel Reinforced Yield Strength 276 MPa

NOTE 1—See Appendix for specific installation conditions and design criteria conditions required in conjunction with the use of Table 1.

NOTE 2—Designations A, B, C, and D, for class of pipe, denote 1.5, 3.0, 4.5, and 6.0 m of earth cover over top of pipe. Figures 75, Figures 150, Figures 225, etc. for class of pipe, denote hydrostatic pressure heads in kilopascals measured to centerline of pipe.

NOTE 3—An “s” in place of a steel area indicates the pipe class is a special design requiring stirrup reinforcement. Stirrups may be eliminated by changing wall thickness, main reinforcement, concrete strength, or a combination thereof.

NOTE 4—The boldfaced value denotes 41.4 MPa concrete strength required.

Circumferential reinforcement, mm ² /linear m of pipe ^{A, B}																								
Internal Designated Dia, mm	300				375				450				525				600				675			
Type of Reinforce-ment	Circular		Circular		Circular		Elliptical		Circular		Elliptical		Circular		Elliptical		Circular				Elliptical			
Wall Thickness, mm	50	75	50	75	57	75	60	75	60	75	63	75	63	75	66	79	82	107	66	82				
Layers of Reinforce-ment	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Inner	Outer	Inner	Outer	Single	Single		
Class	A-75	140	120	200	170	250	320	280	320	290	390	350	390	350	460	410	290	200	230	160	460	370		
	B-75	210	170	310	240	390	320	500	420	610	540	610	540	610	740	650	440	280	340	210	740	440		
	C-75	280	220	420	310	540	430	690	570	870	730	870	730	870	1060	890	590	350	450	250	1060	590		
	D-75	360	270	540	390	700	540	730	690	910	730	950	1150	950	1430	1170	750	440	560	300	1430	750		
	A-150	220	220	280	270	350	320	430	390	610	510	480	690	690	600	550	390	300	330	250	780	780		
	B-150	270	230	380	320	480	420	600	530	610	740	660	740	690	880	780	540	370	430	300	880	780		
	C-150	340	280	500	390	630	520	800	680	800	990	860	990	860	1190	1030	690	450	540	340	1190	780		
	D-150	420	330	620	470	790	640	1020	840	1020	1280	1070	1280	1070	1570	1310	850	530	650	390	1570	850		
	A-225	340	340	430	430	520	520	600	600	...	690	690	690	...	770	770	490	400	430	350	...	...		
	B-225	340	340	460	430	580	520	710	640	...	860	780	...	...	1020	920	640	470	520	390	...	...		
	C-225	400	340	570	470	720	620	910	790	...	1110	980	...	...	1330	1170	790	550	630	440	...	...		
	D-225	480	390	700	550	880	730	1130	950	...	1400	1200	...	...	1710	1440	940	630	730	480	...	...		
	A-300	490	490	610	610	730	730	860	860	...	980	980	...	...	1100	1100	590	500	590	510	...	...		
	B-300	490	490	610	610	730	730	860	860	...	980	980	...	...	1160	1100	740	570	620	480	...	...		
	C-300	490	490	650	610	820	730	1020	900	...	1240	1110	...	...	1470	1310	880	650	720	530	...	...		
	D-300	540	490	770	620	980	820	1240	1050	...	1530	1320	...	...	1850	1580	1040	730	820	570	...	...		
A-375	650	650	820	820	980	980	1140	1140	...	1310	1310	...	...	1470	1470	790	680	780	690	...	...			
B-375	650	650	820	820	980	980	1140	1140	...	1310	1310	...	...	1470	1470	830	670	810	660	...	...			
C-375	650	650	820	820	980	980	1140	1140	...	1360	1310	...	...	1610	1470	980	750	830	640	...	...			
D-375	650	650	850	850	1070	980	1350	1160	...	1650	1450	...	...	1990	1720	1140	830	910	670	...	...			



TABLE 1 Continued

Circumferential reinforcement, mm ² /linear m of pipe ^{A, B}																																
Internal Designated Dia, mm	900						975 ^C						1050																			
Type of Reinforcement	Circular						Circular						Elliptical																			
	Elliptical						Elliptical						Circular																			
Wall Thickness, mm	79		82		100		125		79		100		88		107		132		88		107		94		113		138		94		113	
	Single	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Single	Single	Single	Single	Inner	Outer	Inner	Outer	Inner	Outer	Single	Single	Single	Inner	Outer	Inner	Outer	Inner	Outer	Single	Single		
Layers of Reinforcement	Single		Single		Single		Single		Single		Single		Single		Single		Single		Single		Single		Single		Single		Single		Single			
	Single		Single		Single		Single		Single		Single		Single		Single		Single		Single		Single		Single		Single		Single		Single			
Class																																
A-75	670	460	320	380	260	330	220	670	490	340	420	290	360	240	530	530	520	360	450	310	390	270	570									
B-75	1130	740	480	600	380	490	300	1130	600	510	650	410	540	330	790	650	850	540	710	450	590	370	850									
C-75	1650	1030	640	800	480	640	370	1650	800	680	870	530	710	420	1090	870	1160	720	940	570	780	460	1160									
D-75	2150	1330	800	1010	600	800	450	2150	1010	860	1100	650	880	500	1410	1100	1500	910	1190	710	970	550	1500									
A-150	850	590	450	510	390	440	340	1040	1040	630	480	550	420	480	370	1130	670	510	590	450	530	400	1210									
B-150	1320	870	610	720	500	610	420	1320	1040	930	650	780	540	660	460	1130	990	690	840	580	730	500	1210									
C-150	1840	1150	760	920	610	760	490	1840	1040	1220	810	1000	660	830	540	1220	1130	860	1080	710	910	590	1300									
D-150	2330	1450	930	1130	720	910	570	2330	1130	1540	990	1230	780	1000	620	1540	1230	1630	1050	840	1100	680	1630									
A-225	1040	720	580	630	510	570	460	...	...	770	620	680	550	620	500	...	810	650	730	590	670	540	...									
B-225	1500	1000	740	840	620	720	530	...	...	1070	780	910	670	790	580	...	1130	830	980	720	860	630	...									
C-225	2030	1280	890	1040	730	870	610	...	...	1360	950	1130	790	950	660	...	1440	1000	1210	850	1040	720	...									
D-225	2520	1580	1060	1250	840	1030	680	...	...	1670	1120	1350	910	1130	750	...	1760	1180	1460	980	1230	820	...									
A-300	1470	860	720	800	670	790	670	...	...	910	760	860	730	860	730	...	960	800	930	780	930	780	...									
B-300	1690	1130	870	960	740	840	650	...	...	1200	920	1040	800	910	710	...	1270	980	1120	860	990	770	...									
C-300	2210	1400	1020	1160	850	990	720	...	...	1490	1080	1250	920	1080	790	...	1580	1150	1350	980	1170	850	...									
D-300	2700	1700	1180	1370	960	1140	800	...	...	1800	1250	1480	1040	1250	870	...	1900	1320	1590	1110	1360	950	...									
A-375	1960	1050	910	1050	910	1050	910	...	...	1140	980	1140	980	1140	990	...	1230	1060	1230	1060	1230	1060	...									
B-375	1960	1260	1000	1090	870	1090	870	...	...	1340	1060	1180	940	1180	950	...	1420	1290	1470	1010	1270	1020	...									
C-375	2400	1530	1150	1280	970	1110	850	...	...	1620	1220	1380	1050	1210	920	...	1720	1290	1480	1120	1300	990	...									
D-375	2890	1820	1310	1480	1080	1250	910	...	...	1920	1390	1600	1160	1370	990	...	2030	1460	1720	1250	1490	1080	...									



TABLE 1 Continued

Circumferential reinforcement, mm ² /linear m of pipe ^{A, B}																
Internal Designated Dia, mm	1350						1425 ^C						1500			
	Circular						Circular						Circular			
Type of Reinforcement	Circular						Circular						Circular			
	Elliptical						Elliptical						Elliptical			
Wall Thickness, mm	157						163						125			
	113						144						150			
Layers of Reinforcement	113						119						169			
	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer
Class	710						740						780			
	890	1320	1740	2190	890	1320	1740	2190	890	1320	1740	2190	890	1320	1740	2190
A-75	480	610	780	950	1110	1280	1450	1620	1790	1960	2130	2300	2470	2640	2810	2980
	730	940	1140	1340	1540	1740	1940	2140	2340	2540	2740	2940	3140	3340	3540	3740
B-75	580	720	860	1000	1140	1280	1420	1560	1700	1840	1980	2120	2260	2400	2540	2680
	830	1040	1240	1440	1640	1840	2040	2240	2440	2640	2840	3040	3240	3440	3640	3840
C-75	680	820	960	1100	1240	1380	1520	1660	1800	1940	2080	2220	2360	2500	2640	2780
	930	1140	1340	1540	1740	1940	2140	2340	2540	2740	2940	3140	3340	3540	3740	3940
D-75	780	920	1060	1200	1340	1480	1620	1760	1900	2040	2180	2320	2460	2600	2740	2880
	1030	1240	1440	1640	1840	2040	2240	2440	2640	2840	3040	3240	3440	3640	3840	4040
A-150	880	1120	1360	1600	1840	2080	2320	2560	2800	3040	3280	3520	3760	4000	4240	4480
	1130	1340	1540	1740	1940	2140	2340	2540	2740	2940	3140	3340	3540	3740	3940	4140
B-150	980	1220	1460	1700	1940	2180	2420	2660	2900	3140	3380	3620	3860	4100	4340	4580
	1230	1440	1640	1840	2040	2240	2440	2640	2840	3040	3240	3440	3640	3840	4040	4240
C-150	1080	1320	1560	1800	2040	2280	2520	2760	3000	3240	3480	3720	3960	4200	4440	4680
	1330	1540	1740	1940	2140	2340	2540	2740	2940	3140	3340	3540	3740	3940	4140	4340
D-150	1180	1420	1660	1900	2140	2380	2620	2860	3100	3340	3580	3820	4060	4300	4540	4780
	1430	1640	1840	2040	2240	2440	2640	2840	3040	3240	3440	3640	3840	4040	4240	4440
A-225	1270	1510	1750	1990	2230	2470	2710	2950	3190	3430	3670	3910	4150	4390	4630	4870
	1520	1730	1930	2130	2330	2530	2730	2930	3130	3330	3530	3730	3930	4130	4330	4530
B-225	1370	1610	1850	2090	2330	2570	2810	3050	3290	3530	3770	4010	4250	4490	4730	4970
	1620	1830	2030	2230	2430	2630	2830	3030	3230	3430	3630	3830	4030	4230	4430	4630
C-225	1470	1710	1950	2190	2430	2670	2910	3150	3390	3630	3870	4110	4350	4590	4830	5070
	1720	1930	2130	2330	2530	2730	2930	3130	3330	3530	3730	3930	4130	4330	4530	4730
D-225	1570	1810	2050	2290	2530	2770	3010	3250	3490	3730	3970	4210	4450	4690	4930	5170
	1820	2030	2230	2430	2630	2830	3030	3230	3430	3630	3830	4030	4230	4430	4630	4830
A-300	1670	1910	2150	2390	2630	2870	3110	3350	3590	3830	4070	4310	4550	4790	5030	5270
	1920	2130	2330	2530	2730	2930	3130	3330	3530	3730	3930	4130	4330	4530	4730	4930
B-300	1770	2010	2250	2490	2730	2970	3210	3450	3690	3930	4170	4410	4650	4890	5130	5370
	2020	2230	2430	2630	2830	3030	3230	3430	3630	3830	4030	4230	4430	4630	4830	5030
C-300	1870	2110	2350	2590	2830	3070	3310	3550	3790	4030	4270	4510	4750	4990	5230	5470
	2120	2330	2530	2730	2930	3130	3330	3530	3730	3930	4130	4330	4530	4730	4930	5130
D-300	1970	2210	2450	2690	2930	3170	3410	3650	3890	4130	4370	4610	4850	5090	5330	5570
	2220	2430	2630	2830	3030	3230	3430	3630	3830	4030	4230	4430	4630	4830	5030	5230
A-375	1970	2210	2450	2690	2930	3170	3410	3650	3890	4130	4370	4610	4850	5090	5330	5570
	2220	2430	2630	2830	3030	3230	3430	3630	3830	4030	4230	4430	4630	4830	5030	5230
B-375	2070	2310	2550	2790	3030	3270	3510	3750	3990	4230	4470	4710	4950	5190	5430	5670
	2320	2530	2730	2930	3130	3330	3530	3730	3930	4130	4330	4530	4730	4930	5130	5330
C-375	2170	2410	2650	2890	3130	3370	3610	3850	4090	4330	4570	4810	5050	5290	5530	5770
	2420	2630	2830	3030	3230	3430	3630	3830	4030	4230	4430	4630	4830	5030	5230	5430
D-375	2270	2510	2750	2990	3230	3470	3710	3950	4190	4430	4670	4910	5150	5390	5630	5870
	2520	2730	2930	3130	3330	3530	3730	3930	4130	4330	4530	4730	4930	5130	5330	5530



TABLE 1 Continued

Circumferential reinforcement, mm ² /linear m of pipe ^{A, B}																								
1575 ^C						1650						1725 ^C												
Internal Designated Dia, mm	Circular						Elliptical		Circular						Elliptical		Circular						Elliptical	
	Type of Reinforcement		Circular				Elliptical		Circular						Elliptical		Circular						Elliptical	
Wall Thickness, mm	132		157		175		132	157	138		163		182		138	163	144		169		188		144	169
Layers of Reinforcement	Inner	Outer	Inner	Outer	Inner	Outer	Single	Single	Inner	Outer	Inner	Outer	Inner	Outer	Single	Single	Inner	Outer	Inner	Outer	Inner	Outer	Single	Single
Class	840	570	740	500	690	460	860	860	880	600	780	530	730	490	900	900	920	620	820	550	770	520	940	940
A-75	1310	840	1110	700	1010	630	1310	1110	1360	870	1160	740	1060	670	1360	1160	1410	910	1220	770	1120	700	1410	1220
B-75	1840	1140	1520	930	1370	820	1840	1520	1910	1190	1610	980	1450	870	1910	1610	1990	1240	1690	1030	1530	920	1990	1690
C-75	2350	1430	1920	1150	1700	1000	2350	1920	2450	1490	2020	1210	1800	1060	2450	2020	2540	1550	2120	1270	1900	1120	2540	2120
D-75	1040	780	940	700	880	660	1820	1820	1090	810	990	730	930	690	1900	1900	1140	850	1040	770	980	730	1990	1990
A-150	1510	1040	1300	900	1200	830	1820	1820	1560	1080	1370	940	1260	870	1900	1900	1620	1120	1430	990	1330	910	1990	1990
B-150	2030	1340	1710	1120	1560	1020	2030	2030	2110	1390	1800	1180	1650	1070	2110	1900	2200	1450	1890	1240	1730	1130	2200	1990
C-150	2530	1620	2100	1340	1890	1190	2530	2100	2630	1690	2210	1400	1990	1260	2630	2210	2740	1750	2310	1470	2100	1330	2740	2310
D-150	1250	990	1140	900	1080	860	...	...	1300	1030	1190	940	1140	900	...	...	1360	1070	1250	990	1200	940	...	...
A-225	1710	1250	1500	1100	1390	1020	...	...	1770	1290	1570	1150	1460	1070	...	...	1840	1340	1640	1200	1540	1120	...	...
B-225	2220	1540	1900	1320	1750	1210	...	...	2310	1600	2000	1380	1840	1270	...	...	2400	1660	2100	1450	1940	1340	...	...
C-225	2720	1820	2280	1530	2070	1380	...	...	2820	1890	2400	1600	2190	1460	...	...	2930	1960	2510	1680	2300	1530	...	...
D-225	1460	1200	1410	1160	1400	1160	...	...	1520	1250	1470	1210	1470	1210	...	...	1580	1300	1540	1270	1540	1270	...	...
A-300	1910	1450	1700	1300	1590	1220	...	...	1980	1510	1770	1360	1670	1280	...	...	2050	1560	1850	1420	1750	1340	...	...
B-300	2410	1740	2100	1520	1940	1400	...	...	2510	1810	2200	1590	2040	1470	...	...	2610	1880	2300	1660	2140	1550	...	...
C-300	2900	2010	2470	1720	2260	1570	...	...	3010	2090	2590	1800	2380	1650	...	...	3130	2170	2710	1890	2500	1740	...	...
D-300	1860	1570	1860	1580	1850	1580	...	...	1950	1640	1950	1650	1940	1650	...	...	2040	1720	2040	1720	2030	1720	...	...
A-375	2110	1660	1920	1510	1910	1520	...	...	2190	1720	2010	1590	2000	1590	...	...	2270	1780	2100	1660	2100	1660	...	...
B-375	2610	1940	2290	1710	2130	1600	...	...	2710	2010	2400	1790	2240	1680	...	...	2820	2090	2510	1870	2350	1760	...	...
C-375	3090	2210	2660	1910	2450	1760	...	...	3210	2290	2790	2000	2570	1850	...	...	3330	2380	2920	2090	2700	1940	...	...
D-375																								



TABLE 1 Continued

Circumferential reinforcement, mm ² /linear m of pipe ^{A, B}																				
Internal Designated Dia, mm	1800						1950						2100							
Type of Reinforcement	Circular						Elliptical						Circular							
	150		175		194		150	175	163		188		207		175		200		219	
Wall Thickness, mm	Inner	Outer	Inner	Outer	Inner	Outer	Single	Single	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer
Layers of Reinforcement	Inner	Outer	Inner	Outer	Inner	Outer	Single	Single	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer
Class	1020	690	910	610	850	570	1020	980	1110	750	1000	670	940	630	1210	810	1100	730	1040	690
A-75	1550	1000	1340	850	1230	770	1550	1340	1660	1060	1460	920	1340	840	1780	1140	1580	1000	1460	920
B-75	2210	1370	1860	1140	1690	1020	2210	1860	2370	1470	2020	1240	1840	1110	2500	1550	2170	1330	1990	1200
C-75	2830	1720	2340	1400	2100	1240	2830	2340	3020	1840	2550	1530	2300	1360	3150	1920	2760	1660	2520	1490
D-75																				
A-150	1260	930	1140	850	1080	800	1260	1080	1370	1010	1250	920	1190	870	1480	1080	1360	1000	1300	950
B-150	1790	1230	1570	1080	1450	1000	1790	1450	1910	1320	1700	1170	1580	1090	2040	1400	1830	1260	1720	1180
C-150	2430	1600	2080	1360	1900	1240	2430	2080	2600	1710	2260	1480	2070	1350	2750	1810	2420	1580	2230	1460
D-150	3040	1940	2550	1620	2310	1460	3040	2550	3250	2070	2770	1760	2530	1600	3400	2180	3000	1910	2760	1740
A-225	1500	1180	1370	1080	1310	1030	...	...	1620	1270	1500	1170	1430	1120	1750	1360	1630	1270	1560	1210
B-225	2020	1470	1790	1310	1680	1220	...	...	2160	1570	1940	1410	1820	1330	2300	1670	2090	1520	1980	1440
C-225	2660	1830	2310	1590	2120	1460	...	...	2840	1960	2490	1720	2310	1590	3000	2070	2670	1840	2480	1710
D-225	3250	2160	2770	1840	2520	1680	...	...	3470	2310	3000	2000	2760	1830	3650	2440	3240	2160	3000	1990
A-300	1740	1420	1610	1320	1610	1320	...	...	1880	1530	1750	1430	1750	1430	2020	1630	1890	1530	1890	1530
B-300	2260	1710	2020	1540	1900	1450	...	...	2410	1820	2190	1660	2070	1570	2560	1940	2350	1790	2230	1700
C-300	2880	2070	2530	1820	2350	1690	...	...	3080	2200	2730	1960	2540	1830	3250	2330	2920	2100	2740	1970
D-300	3470	2390	2980	2070	2740	1900	...	...	3700	2550	3230	2240	2990	2070	3890	2690	3490	2410	3240	2240
A-375	2130	1790	2130	1790	2130	1790	...	...	2310	1930	2310	1940	2310	1940	2500	2080	2490	2080	2490	2080
B-375	2490	1950	2260	1780	2190	1730	...	...	2660	2080	2430	1910	2370	1870	2830	2210	2610	2050	2560	2010
C-375	3110	2300	2750	2050	2570	1910	...	...	3320	2450	2970	2210	2780	2070	3510	2590	3170	2360	2990	2230
D-375	3690	2620	3200	2290	2960	2120	...	...	3930	2790	3470	2480	3220	2310	4150	2960	3730	2660	3490	2490



TABLE 1 Continued

Circumferential reinforcement, mm ² /linear m of pipe ^{A, B}																	
Internal Designated Dia, mm	2250				2400				2550				2700				3650
Type of Reinforcement	Circular				Circular				Circular				Circular				Circular
Wall Thickness, mm	188		200		200		213		213		225		225		238		305
Layers of Reinforcement	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Outer
Class																	
A-75	1310	880	1250	830	1410	940	1360	900	1520	1010	1470	970	1640	1080	1580	1040	1570
B-75	1900	1210	1790	1140	2020	1290	1920	1220	2160	1370	2050	1300	2290	1460	2190	1390	2030
C-75	2640	1630	2460	1520	2780	1720	2610	1610	2930	1820	2770	1710	3090	1910	2930	1810	2560
D-75	3360	2050	3190	1930	3580	2180	3410	2060	3790	2310	3570	2160	3980	2420	3750	2280	S
A-150	1590	1160	1530	1120	1710	1240	1650	1200	1830	1330	1780	1290	1960	1420	1910	1370	1990
B-150	2170	1490	2060	1420	2310	1590	2210	1510	2460	1680	2360	1610	2610	1780	2510	1710	2440
C-150	2900	1910	2720	1790	3060	2010	2890	1900	3220	2120	3060	2010	3390	2230	3230	2120	2960
D-150	3620	2320	3440	2190	3850	2460	3670	2340	4080	2610	3860	2460	4270	2740	4050	2590	S
A-225	1880	1450	1810	1400	2010	1550	1950	1500	2150	1650	2090	1600	2290	1750	2230	1710	2420
B-225	2450	1780	2340	1700	2600	1880	2500	1810	2760	2000	2660	1920	2930	2110	2830	2040	2860
C-225	3160	2180	2990	2060	3340	2300	3170	2190	3520	2420	3350	2310	3700	2550	3540	2440	3370
D-225	3880	2590	3690	2450	4120	2750	3940	2620	4370	2910	4140	2760	4570	3050	4350	2900	S
A-300	2160	1740	2100	1690	2310	1850	2250	1800	2470	1970	2400	1920	2630	2090	2560	2040	2850
B-300	2730	2060	2620	1980	2900	2180	2790	2110	3070	2310	2970	2230	3250	2440	3150	2370	3280
C-300	3430	2460	3260	2340	3620	2590	3450	2480	3810	2730	3650	2620	4010	2870	3850	2760	3780
D-300	4140	2860	3950	2720	4400	3030	4210	2900	4660	3210	4430	3060	4880	3360	4660	3210	S
A-375	2680	2220	2680	2220	2860	2360	2860	2370	3050	2510	3050	2510	3230	2650	3230	2650	3490
B-375	3010	2350	2900	2260	3190	2490	3080	2410	3380	2630	3280	2550	3580	2770	3470	2700	3700
C-375	3700	2740	3530	2620	3900	2890	3740	2770	4110	3040	3950	2920	4330	3190	4170	3080	4200
D-375	4410	3140	4210	2990	4670	3320	4810	3180	4950	3510	4730	3360	5190	3680	4970	3530	S

^A Steel areas may be interpolated between those shown for variations in wall thickness. See 7.2 for provisions for special designs.

^B The prescribed amounts of reinforcement do not provide any allowance for pressure surges (water hammer) in pipelines.

^C Available in some areas.



TABLE 2 Design Requirements for Reinforced Concrete Low-Head Pressure Pipe [300 to 3650 mm Diameter], Concrete Design Strength 34.5 MPa (except as noted) Steel Reinforcement Yield Strength 414 Mpa

NOTE 1—See Appendix for specific installation conditions and design criteria conditions required in conjunction with the use of Table 2.

NOTE 2—Designations A, B, C, and D, for class of pipe, denote 1.5, 3.0, 4.5, and 6.0 m of earth cover over top of pipe. Figures 75, Figures 150, Figures 225, etc. for class of pipe, denote hydrostatic pressure heads in kilopascals measured to centerline of pipe.

NOTE 3—An “s” in place of a steel area indicates the pipe class is a special design requiring stirrup reinforcement. Stirrups may be eliminated by changing wall thickness, main reinforcement, concrete strength, or a combination thereof.

NOTE 4—The boldfaced value denotes 41.4 MPa concrete strength required.

Circumferential reinforcement, mm ² /linear m of pipe ^{A, B}																								
Internal Designated Dia., mm	300				375				450				525				600				675			
Type of Reinforcement	Circular				Circular				Circular				Circular				Circular				Circular			
Wall Thickness, mm	50	75	50	75	57	75	57	75	60	75	63	75	63	75	66	79	82	107		66	82			
	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Inner	Outer	Single	Single			
Layers of Reinforcement	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Inner	Inner	Outer	Single	Single			
	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Inner	Inner	Outer	Single	Single			
Class	Circular				Circular				Circular				Circular				Circular				Circular			
	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single	Single			
A-75	100	100	130	130	170	150	250	250	290	290	260	230	330	330	300	280	190	130	160	110	370	370		
	140	110	200	160	260	220	260	250	330	290	410	360	410	360	490	430	290	180	230	140	490	370		
B-75	190	140	280	210	360	290	360	290	460	380	580	490	580	490	700	590	400	240	300	170	700	400		
	240	180	360	260	470	360	470	360	610	490	770	630	770	630	950	780	500	290	370	200	950	500		
A-150	220	220	270	270	320	320	520	520	610	610	430	430	690	690	490	490	280	210	280	210	780	780		
	220	220	270	270	320	320	520	520	610	610	490	440	690	690	520	520	360	250	290	200	780	780		
C-150	230	220	330	270	420	350	520	520	610	610	660	570	690	690	800	690	460	300	360	230	800	780		
	280	220	410	310	530	420	530	520	680	610	850	720	850	720	1050	870	570	360	430	260	1050	780		
A-225	340	340	430	430	520	520	...	...	...	...	690	690	...	...	770	770	430	350	430	350	...	...		
	340	340	430	430	520	520	...	...	...	...	690	690	...	...	770	770	440	330	440	330	...	...		
C-225	340	340	430	430	520	520	...	...	...	...	740	690	...	...	890	780	520	370	460	320	...	...		
	340	340	470	430	590	520	...	...	...	...	930	800	...	...	1140	960	630	420	490	320	...	...		
A-300	490	490	610	610	730	730	...	...	...	...	980	980	...	...	1100	1100	590	500	590	510	...	...		
	490	490	610	610	730	730	...	...	...	...	980	980	...	...	1100	1100	620	480	620	480	...	...		
C-300	490	490	610	610	730	730	...	...	...	...	980	980	...	...	1100	1100	630	470	630	470	...	...		
	490	490	610	610	730	730	...	...	...	...	1020	980	...	...	1230	1100	690	490	650	450	...	...		
A-375	650	650	820	820	980	980	...	...	...	...	1310	1310	...	...	1470	1470	790	680	780	690	...	...		
	650	650	820	820	980	980	...	...	...	...	1310	1310	...	...	1470	1470	810	660	810	660	...	...		
B-375	650	650	820	820	980	980	...	...	...	...	1310	1310	...	...	1470	1470	830	640	830	640	...	...		
	650	650	820	820	980	980	...	...	...	...	1310	1310	...	...	1470	1470	850	620	850	620	...	...		
D-375	650	650	820	820	980	980	...	...	...	...	1140	1140	...	...	1470	1470	850	620	850	620	...	...		



TABLE 2 Continued

Circumferential reinforcement, mm ² /linear m of pipe ^{A, B}																
Internal Designated Dia, mm	900								975 ^C							
	Circular				Elliptical				Circular				Elliptical			
Type of Reinforcement																
Wall Thickness, mm	82		100		125		79	100	88		107		132		88	107
	Inner	Outer	Inner	Outer	Inner	Outer	Single	Single	Inner	Outer	Inner	Outer	Inner	Outer	Single	Single
Layers of Reinforcement	Single	Inner	Outer	Inner	Outer	Inner	Single	Single	Inner	Outer	Inner	Outer	Inner	Outer	Single	Single
	79	82	100	125	Outer	Inner	Outer	Single	88	107	132	Outer	107	138	94	113
Class																
A-75	440	310	250	180	220	370	280	490	330	230	280	190	240	350	240	300
B-75	760	500	320	400	330	400	280	490	530	340	430	270	360	560	360	470
C-75	1100	680	420	530	430	500	350	530	730	450	580	350	470	770	480	630
D-75	1430	890	680	400	530	300	1430	680	940	570	740	440	590	1000	600	800
A-150	650	390	370	280	370	280	1040	1040	420	320	400	300	400	440	340	430
B-150	880	580	480	330	400	280	1040	1040	620	430	520	360	440	660	460	560
C-150	1230	770	610	400	500	330	1230	1040	820	540	670	440	550	870	570	720
D-150	1550	970	750	480	610	380	1550	1040	1030	660	820	520	670	1090	700	880
A-225	1030	570	460	370	570	460	...	...	620	500	620	500	620	670	540	670
B-225	1030	670	490	330	590	440	...	...	710	520	640	480	640	750	550	690
C-225	1350	850	590	480	610	420	...	...	900	630	750	520	660	960	670	810
D-225	1680	1050	700	560	680	450	...	...	1110	750	900	600	750	1180	790	970
A-300	1470	800	670	480	790	670	...	...	860	720	860	730	860	930	780	930
B-300	1470	830	640	400	830	640	...	...	900	690	900	690	900	970	740	970
C-300	1470	940	680	500	850	620	...	...	990	720	920	670	920	1050	760	990
D-300	1800	1130	790	640	860	600	...	...	1200	830	980	690	940	1270	880	1060
A-375	1960	1050	910	670	1050	910	...	...	1140	980	1140	980	1140	1230	1060	1230
B-375	1960	1090	870	500	1090	870	...	...	1180	940	1180	940	1180	1270	1010	1270
C-375	1960	1120	840	610	1110	850	...	...	1210	910	1210	920	1210	1310	980	1300
D-375	1960	1210	870	680	1140	820	...	...	1280	920	1230	890	1230	1360	980	1330



TABLE 2 Continued

Circumferential reinforcement, mm ² /linear m of pipe ^{A, B}																														
Internal Designated Dia, mm	1125 ^C								1200								1275 ^C													
Type of Reinforcement	Circular				Elliptical				Circular				Elliptical				Circular				Elliptical									
	97		119		144		97		119		104		125		144		104		125		107		132		150		107		132	
Wall Thickness, mm	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer
Layers of Reinforcement	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer
Class	A-75	380	260	320	220	280	190	610	610	280	410	280	350	240	320	220	650	450	310	450	380	260	350	230	700	700	700	700	700	700
B-75	620	400	400	510	320	430	270	620	610	430	670	430	580	350	490	310	650	730	470	590	370	530	330	730	700	700	700	700	700	
C-75	850	530	530	680	410	570	330	850	680	570	920	570	740	450	650	390	740	1000	620	790	480	700	420	1000	790	700	700	700	700	
D-75	1100	670	670	860	510	700	410	1100	860	720	1190	720	940	560	810	470	1190	1300	790	1000	600	870	510	1300	1000	1000	1000	1000	1000	
A-150	480	370	370	460	350	460	350	1300	1300	390	520	390	490	370	490	370	1380	560	420	520	400	520	400	400	1470	1470	1470	1470	1470	1470
B-150	720	500	500	600	420	530	360	1300	1300	540	780	540	660	450	590	410	1380	840	580	700	480	630	430	470	1470	1470	1470	1470	1470	1470
C-150	950	630	630	770	510	660	430	1300	1300	680	1020	680	840	550	750	490	1380	1110	740	900	590	800	520	1470	1470	1470	1470	1470	1470	1470
D-150	1190	770	770	950	600	790	500	1300	1300	830	1290	830	1030	660	900	570	1380	1400	900	1100	700	970	610	1470	1470	1470	1470	1470	1470	1470
A-225	720	570	570	710	580	710	580	...	...	610	770	610	760	610	760	610	...	810	650	810	650	810	650	...	...	...	...	...	...	...
B-225	820	600	600	740	550	740	550	...	...	890	890	650	790	580	790	580	...	960	700	840	620	840	620	...	...	...	...	...	...	...
C-225	1050	730	730	870	610	760	530	...	...	1130	1130	780	940	660	850	590	...	1220	850	1000	700	900	630	...	...	...	...	...	...	...
D-225	1290	860	860	1040	700	890	590	...	...	1390	1390	930	1130	760	1000	670	...	1500	1010	1210	810	1070	720	...	...	...	...	...	...	...
A-300	1000	830	830	1000	840	1000	840	...	...	890	1070	890	1070	890	1060	890	...	1140	940	1130	940	1130	950	...	...	...	...	...	...	...
B-300	1040	790	790	1040	800	1040	800	...	...	850	1110	850	1110	850	1110	850	...	1180	900	1180	900	1170	900	...	...	...	...	...	...	...
C-300	1140	830	830	1060	770	1060	770	...	...	890	1230	890	1130	820	1130	820	...	1330	960	1200	870	1200	870	...	...	...	...	...	...	...
D-300	1380	960	960	1130	790	1080	750	...	...	1030	1490	1030	1230	860	1150	800	...	1610	1120	1310	910	1220	850	...	...	...	...	...	...	...
A-375	1320	1130	1130	1320	1130	1310	1140	...	...	1200	1410	1210	1410	1210	1400	1210	...	1500	1280	1500	1280	1490	1280	...	...	...	...	...	...	...
B-375	1370	1080	1080	1360	1090	1360	1090	...	...	1150	1460	1160	1460	1160	1450	1160	...	1550	1220	1550	1230	1550	1230	...	...	...	...	...	...	...
C-375	1400	1050	1050	1400	1050	1390	1060	...	...	1120	1500	1120	1490	1120	1490	1120	...	1590	1190	1580	1190	1580	1190	...	...	...	...	...	...	...
D-375	1480	1060	1060	1420	1030	1420	1030	...	...	1140	1590	1140	1520	1100	1520	1100	...	1710	1230	1610	1160	1610	1170	...	...	...	...	...	...	...



TABLE 2 Continued

Circumferential reinforcement, mm ² /linear m of pipe ^{A, B}																								
Internal Designated Dia, mm	1350						1425 ^C						1500											
Type of Reinforcement	Circular						Elliptical			Circular						Elliptical								
Wall Thickness, mm	113		138		157		113	138	163		119	144	125		150		169	125	150					
	Inner	Outer	Inner	Outer	Inner	Outer	Single	Single	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer						
Layers of Reinforcement	113		138		157		Single	Single	Inner	Outer	Inner	Outer	Single	Single	Inner	Outer	Inner	Outer	Single					
Class	470	320	400	270	370	250	740	740	500	340	430	290	400	270	780	780	520	360	460	310	420	290	820	820
A-75	760	490	630	400	560	350	760	740	790	510	680	420	590	370	790	780	820	530	690	440	630	390	820	820
B-75	1050	650	840	520	750	450	1050	840	1100	680	900	550	800	480	1100	900	1150	720	950	580	850	510	1150	950
C-75	1360	830	1060	640	930	550	1360	1060	1410	860	1130	670	990	580	1410	1130	1480	900	1190	710	1060	620	1480	1190
D-75	590	440	560	420	560	420	1560	1560	620	470	590	440	590	440	1640	1640	650	490	620	460	620	460	1730	1730
A-150	880	610	740	510	670	460	1560	1560	910	630	780	540	710	490	1640	1640	950	660	820	560	750	520	1730	1730
B-150	1160	770	950	630	860	560	1560	1560	1220	800	1010	660	910	590	1640	1640	1270	840	1070	700	970	630	1730	1730
C-150	1460	940	1170	750	1040	650	1560	1560	1530	980	1240	790	1110	700	1640	1640	1590	1020	1310	830	1170	740	1730	1730
D-150	860	690	860	690	860	690	...	...	910	720	910	730	910	730	...	...	960	760	960	760	960	760	...	...
A-225	1000	730	890	660	890	660	...	...	1040	760	940	690	940	690	...	...	1080	790	990	730	990	730	...	...
B-225	1280	890	1060	740	970	670	...	...	1330	930	1130	780	1030	710	...	...	1390	970	1190	830	1090	750	...	...
C-225	1570	1050	1280	860	1150	760	...	...	1640	1100	1350	910	1220	810	...	...	1710	1140	1430	950	1290	860	...	...
D-225	1200	1000	1200	1000	1200	1000	...	...	1270	1050	1270	1050	1270	1050	...	...	1340	1100	1340	1110	1340	1110	...	...
A-300	1250	950	1250	950	1240	960	...	...	1320	1000	1310	1010	1310	1010	...	...	1390	1060	1380	1060	1380	1060	...	...
B-300	1390	1000	1270	930	1270	930	...	...	1450	1050	1350	980	1350	980	...	...	1510	1090	1420	1030	1420	1030	...	...
C-300	1680	1160	1390	970	1300	900	...	...	1750	1210	1470	1020	1370	950	...	...	1820	1270	1540	1080	1440	1000	...	...
D-300	1590	1350	1580	1360	1580	1360	...	...	1680	1420	1670	1430	1670	1430	...	...	1770	1500	1760	1500	1760	1500	...	...
A-375	1650	1290	1640	1300	1640	1300	...	...	1740	1370	1730	1370	1730	1370	...	...	1830	1440	1820	1440	1820	1440	...	...
B-375	1680	1260	1680	1260	1680	1260	...	...	1780	1330	1770	1330	1770	1330	...	...	1870	1390	1870	1400	1870	1400	...	...
C-375	1790	1280	1710	1230	1710	1230	...	...	1860	1330	1800	1300	1800	1300	...	...	1940	1390	1900	1370	1900	1370	...	...
D-375																								



TABLE 2 Continued

Circumferential reinforcement, mm ² /linear m of pipe ^{A, B}																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																											
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Wall Thickness, mm	132		157		175		132	157	138		163		182		138	163	144		169		188		144	169																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																			
	Inner	Outer	Inner	Outer	Inner	Outer	Single	Single	Inner	Outer	Inner	Outer	Inner	Outer	Single	Single	Inner	Outer	Inner	Outer	Inner	Outer	Single	Single																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																			
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Class	560		380		490		330		460		310		860		860		580		400		520		350		480		330		900		900		610		420		550		370		510		340		940		940																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																												
	A-75	870	B-75	1220	760	C-75	1570	D-75	690	1000	1350	1690	1010	1140	1480	1810	A-150	690	B-150	1000	C-150	1350	D-150	1690	A-225	1010	B-225	1140	C-225	1480	D-225	1810	A-300	1410	B-300	1460	C-300	1610	D-300	1930	A-375	1860	B-375	1920	C-375	1970	D-375	2060																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																											



TABLE 2 Continued

Circumferential reinforcement, mm ² /linear m of pipe ^{A, B}																
Internal Designated Dia, mm	1800								1950				2100			
	Circular								Circular				Circular			
Type of Reinforcement																
Wall Thickness, mm	150		175		194		163		188		207		175		200	
	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer
Layers of Reinforcement																
	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer
Class																
A-75	680	460	610	410	570	380	980	980	740	500	670	450	630	420	800	540
B-75	1040	660	890	570	820	510	1040	980	1110	710	970	610	900	560	1180	870
C-75	1470	910	1240	760	1120	680	1470	1240	1580	980	1350	820	1230	740	1670	1030
D-75	1890	1140	1560	930	1400	830	1890	1560	2020	1220	1700	1020	1540	910	2100	1280
A-150	840	620	760	560	750	550	2080	2080	910	670	830	610	810	600	980	720
B-150	1190	820	1040	720	970	660	2080	2080	1270	880	1130	780	1050	720	1360	940
C-150	1620	1070	1390	910	1270	830	2080	2080	1740	1140	1500	980	1380	900	1830	1200
D-150	2030	1290	1700	1080	1540	970	2080	2080	2160	1380	1850	1180	1690	1060	2270	1450
A-225	1160	910	1160	910	1160	910	...	...	1260	980	1260	980	1260	980	1360	1050
B-225	1350	980	1200	870	1190	870	...	...	1440	1050	1290	940	1290	940	1530	1110
C-225	1770	1220	1540	1060	1420	980	...	...	1890	1300	1660	1150	1540	1060	2000	1380
D-225	2170	1440	1840	1230	1680	1120	...	...	2600	1540	2000	1330	1840	1220	2430	1620
A-300	1620	1320	1610	1320	1610	1320	...	...	1750	1420	1750	1430	1750	1430	1890	1530
B-300	1670	1270	1660	1270	1660	1270	...	...	1810	1370	1800	1370	1800	1370	1950	1470
C-300	1920	1380	1710	1230	1710	1230	...	...	2050	1470	1850	1330	1850	1330	2170	1550
D-300	2550	1590	1990	1380	1830	1270	...	...	3100	1700	2160	1490	1990	1380	2620	1800
A-375	2130	1790	2130	1790	2130	1790	...	...	2310	1930	2310	1940	2310	1940	2500	2080
B-375	2200	1720	2190	1730	2190	1730	...	...	2380	1860	2380	1870	2370	1870	2570	2010
C-375	2260	1660	2250	1670	2250	1670	...	...	2470	1780	2440	1810	2430	1810	2670	1950
D-375	2960	1750	2280	1640	2280	1640	...	...	3600	1860	2480	1770	2480	1770	2890	1970
A-450	2620	1840	2430	1660	2430	1660	...	...	3100	1700	2160	1490	1990	1380	2620	1800
B-450	2670	1890	2480	1710	2480	1710	...	...	3100	1700	2160	1490	1990	1380	2620	1800
C-450	2720	1940	2530	1760	2530	1760	...	...	3100	1700	2160	1490	1990	1380	2620	1800
D-450	3420	2240	2720	1940	2720	1940	...	...	3600	1860	2480	1770	2480	1770	2890	1970



TABLE 2 Continued

Circumferential reinforcement, mm ² /linear m of pipe ^{A, B}																								
Internal Designated Dia, mm	2250				2400				2550				2700				3050		3350		3650			
Type of Reinforcement	Circular				Circular				Circular				Circular				Circular		Circular		Circular			
Wall Thickness, mm	188		200		200		213		213		225		225		225		238		254		279		305	
Layers of Reinforcement	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer	Inner	Outer
Class																								
A-75	870	580	830	560	940	630	900	600	1010	670	980	650	1090	720	1050	700	1250	820	1430	930	1610	1050		
B-75	1270	810	1190	760	1350	860	1280	810	1440	920	1370	870	1530	970	1460	930	1720	1090	1920	1220	2140	1350		
C-75	1760	1090	1640	1010	1850	1150	1740	1070	1950	1210	1850	1140	2060	1280	1950	1200	2280	1410	2510	1560	2760	1710		
D-75	2240	1370	2120	1280	2380	1450	2270	1370	2530	1540	2380	1440	2650	1620	2500	1520	S	S	S	S	S	S		
A-150	1060	770	1020	750	1140	830	1100	800	1220	890	1180	860	1310	940	1270	920	1490	1070	1680	1190	1890	1330		
B-150	1450	1000	1380	950	1540	1060	1470	1010	1640	1120	1570	1070	1740	1190	1670	1140	1950	1330	2170	1470	2410	1630		
C-150	1930	1270	1820	1190	2040	1340	1930	1260	2150	1410	2040	1340	2260	1490	2160	1410	2500	1640	2750	1800	3020	1980		
D-150	2410	1550	2330	1460	2560	1640	2800	1560	2720	1740	2570	1640	2850	1820	2700	1720	S	S	S	S	S	S		
A-225	1460	1130	1460	1130	1560	1200	1560	1200	1660	1270	1660	1270	1760	1340	1760	1340	1960	1480	2160	1620	2370	1760		
B-225	1630	1180	1560	1130	1740	1260	1660	1210	1840	1330	1770	1280	1950	1410	1880	1360	2180	1570	2430	1730	2680	1900		
C-225	2110	1450	1990	1370	2220	1530	2110	1460	2340	1610	2240	1540	2470	1700	2360	1630	2720	1870	3000	2060	3330	2250		
D-225	2590	1730	2890	1640	2750	1830	3470	1740	3020	1940	2760	1840	3260	2030	2900	1930	S	S	S	S	S	S		
A-300	2030	1630	2030	1640	2170	1740	2170	1740	2310	1840	2310	1850	2450	1950	2450	1950	2730	2150	3020	2360	3300	2560		
B-300	2090	1580	2090	1580	2230	1680	2230	1680	2370	1780	2370	1780	2510	1890	2510	1890	2800	2090	3080	2290	3400	2470		
C-300	2290	1640	2170	1560	2440	1730	2300	1650	2590	1820	2430	1740	2750	1910	2570	1840	3070	2110	3420	2310	3780	2520		
D-300	2820	1910	3460	1810	3100	2020	4140	1930	3600	2140	2980	2040	3880	2240	3170	2140	S	S	S	S	S	S		
A-375	2680	2220	2680	2220	2860	2360	2860	2370	3050	2510	3050	2510	3230	2650	3230	2650	3600	2930	3980	3210	4370	3470		
B-375	2750	2150	2750	2150	2940	2290	2940	2290	3130	2420	3120	2430	3330	2550	3310	2570	3740	2790	4160	3030	4570	3270		
C-375	2870	2030	2830	2070	3070	2160	3030	2190	3270	2280	3240	2320	3480	2400	3440	2440	3890	2650	4300	2890	4720	3120		
D-375	3100	2090	4020	1990	3600	2220	4810	2120	4170	2340	3410	2250	4510	2460	3680	2370	S	S	S	S	S	S		

^A Steel areas may be interpolated between those shown for variations in wall thickness. See 7.2 for provisions for special designs.

^B The prescribed amounts of reinforcement do not provide any allowance for pressure surges (water hammer) in pipelines.

^C Available in some areas.

section and shall be extruded or molded to the specified size within a diametrical tolerance of ± 0.4 mm or ± 1.5 % of the diameter, whichever is larger.

6.9.1.1 Standard Gasket Requirements—All rubber gaskets shall meet the dimensions, tolerances, and physical requirements of Specification **C1619**, Class A.

6.9.1.2 Oil Resistant Gasket Requirements—All rubber gaskets shall meet the dimensions, tolerances, and physical requirements of Specification **C1619**, Class B.

6.9.1.3 Durometer Hardness—The shore hardness shall be in the range of from 35 to 50 for concrete spigots and 35 to 65 for steel spigots where the range includes the allowable variation ± 5 from the manufacturer's specified hardness, provided the actual hardness is within the limits of 35 to 65.

6.10 Gasket Lubricants:

6.10.1 Where the joint design utilizing a rubber gasket dictates the use of a lubricant to facilitate assembly, the lubricant composition shall have no detrimental effect on the performance of the gasket and joint due to prolonged exposure.

6.10.2 Storage—The lubricant shall be stored in accordance with the lubricant manufacturer's recommended temperature range.

6.10.3 Certification—When requested by the owner, the manufacturer shall furnish written certification that the joint lubricant conforms to all requirements of this specification for the specific gaskets supplied.

6.10.4 Marking—The following information shall be clearly marked on each container of lubricant.

6.10.4.1 Name of lubricant manufacturer.

6.10.4.2 Usable temperature range for application and storage.

6.10.4.3 Shelf life.

6.10.4.4 Lot or batch number.

6.11 Mixing Water—Water used in the production of concrete shall be potable or non-potable water that meets the requirements of Specification **C1602/C1602M**.

7. Design

7.1 Design Tables—The diameter, wall thickness, compressive strength of the concrete, and the area of circumferential reinforcement shall be as prescribed for the classes of combined hydrostatic head and external loading given in **Table 1** subject to the provisions of **7.2**, **7.4**, **7.5**, **10.3**, **11.1**, **11.2**, and **11.5**.

7.2 Modified and Special Design—Manufacturers shall submit to the owner, for approval prior to manufacture, detailed designs for loading or installation conditions other than those shown in **Table 1**. Such pipe must meet all of the tests and performance requirements specified by the owner in accordance with Section 5.

7.3 Laying Lengths—The maximum laying lengths of pipe units that will be acceptable are as follows and are subject to the provisions of **11.4**:

Internal Diameter of Pipe, mm	Maximum Laying Length of Pipe, m
300 to 375	3.66
450	4.27
525 to 600	4.88
675 to 750	5.49
825 to 900	6.10
975 and larger	7.32

7.4 Placement of Reinforcement—The circumferential reinforcement shall be a single-cage circular, double-cage circular, or elliptical cage as shown in **Table 1** and **Table 2**. Elliptical reinforcement will be permitted for 75 and 150-kPa head classes only and only in pipe 450 to 1800 mm in diameter, inclusive. All pipe with a wall thickness of less than 82 mm shall be reinforced with either a circular cage or a single elliptical cage of steel as provided in **Table 1** and **Table 2**. All pipe with wall thickness of 82 mm and greater shall be reinforced with either two separate cages or a single elliptical cage of steel as provided in **Table 1** and **Table 2**, except that for pipe sizes 900 mm and less with wall thicknesses equal to or greater than 82 mm, a single circular cage is not prohibited if the steel area is equal to or greater than the least area shown for a single circular cage for the particular class of pipe. The areas of circumferential reinforcement shown in **Table 1** and **Table 2** are the design requirements for each of the wall thicknesses shown in the table. Where single-cage circular reinforcement is used, the center-line of the reinforcement shall be placed from 40 to 50 % of the wall thickness from the inner surface of the pipe, provided that the minimum concrete cover specified below shall be maintained. Where two separated circular cages of reinforcement are used, the inner and outer cages shall be placed so that the concrete cover, measured radially, over the circumferential reinforcement will be as follows:

Pipe Diameter, mm	Minimum Cover, mm	Maximum Cover, mm
1125 and less	19	25
1200 through 1500	19	29
1575 through 1725	19	32
1800 through 2700	25	38

7.4.1 These limits on minimum and maximum cover are applicable to elliptical steel at the horizontal and vertical axes of the pipe. The circumferential reinforcement at each end of the pipe unit shall consist of one complete coil or ring in which the end is lapped or welded as prescribed in **7.6**. The clear distance of the end coil or ring shall not be less than 13 mm or more than 25 mm from the end of the pipe unit, except this requirement does not apply to the inner layer of circumferential reinforcement in joints utilizing steel bell and spigot rings, provided that the clear distance restrictions will not apply for a distance of 20 bar diameters measured circumferentially from the end of the lap or weld.

7.4.2 The steel areas in **Table 1** and **Table 2** for inner and outer reinforcement are based on a single layer of reinforcement for that steel area. A line of reinforcement may be composed of more than one layer. However, this requires a special design in accordance with **7.2** and **Appendix X2**. If more than one layer of reinforcement is used, the layers shall not be separated by more than the thickness of one longitudinal plus 6 mm. The layers shall be fastened together to form a single rigid cage. Where inner and outer cages are used, the

minimum clear spacing between the two cage systems shall be 0.25 times the wall thickness. All other specification requirements such as laps, welds, concrete cover, and tolerances of placement in the wall of the pipe, etc., shall apply to this method for fabrication of a cage of reinforcement.

7.5 Longitudinal Reinforcement—Each layer of circumferential reinforcement shall be assembled into a cage supported by longitudinal bars that extend the full length of the pipe. The minimum concrete cover for longitudinal steel shall be 13 mm, except that the longitudinal bars or rods are not prohibited from extending to either or both ends of the pipe unit to form supports for holding the circumferential cage in proper position. Not less than four longitudinal bars at approximately equal spacing shall be provided for each cage, and additional bars used in the barrel of the pipe shall be provided as necessary so that the circumferential spacing between longitudinal bars shall not exceed 1050 mm in any cage. Where the pipe joint construction requires the use of a bell, the minimum number of longitudinal bars shall be provided in the bell and shall be continuous bars or spliced to the main longitudinal bars. The circumferential bars of each cage shall be spaced and supported by welding or tying each hoop to the longitudinal bars. Spacer bars, chairs, or other methods shall be provided to maintain the reinforcement cage or cages in proper position within the forms during the placement and consolidation of the concrete. The spacer bars or chairs are not prohibited from extending to the finished concrete surfaces of the pipe.

7.6 Laps, Welds, and Spacing—If the splices are not welded, the reinforcement shall be lapped not less than 20 diameters for deformed bars and deformed cold-worked wire, and 40 diameters for plain bars and cold-drawn wire. In addition, where lapped cages of welded wire reinforcement are used without welding, the lap shall contain a longitudinal wire. Lapped or butt welded splices shall develop a tensile strength of not less than the specified yield strength of the bars or wires spliced based on the nominal cross-sectional area of the bar or wire. Lapped welds shall have a minimum lap of 50 mm. The spacing center-to-center of adjacent rings of circumferential reinforcement in a cage shall not exceed 100 mm. The continuity of the circumferential reinforcing steel shall not be destroyed during the manufacture of the pipe.

8. Joints

8.1 Joints shall utilize steel joint rings, steel bells and concrete spigots, or be formed entirely of concrete. Joint assemblies shall be so formed and accurately manufactured that when the pipes are drawn together the pipe shall form a continuous watertight conduit with a smooth and uniform interior surface and shall provide for slight movements of any pipe unit in the pipeline due to expansion, contraction, settlement, or lateral displacement. The rubber gasket shall be the sole element of the joint depended upon to provide watertightness. The joint shall be so designed that the gaskets will not be required to support the weight of the pipe, but will keep the joint tight under all normal conditions of service. The ends of the pipe shall be in planes at right angles to the longitudinal centerline of the pipe, except where bevel-end pipe for deflections up to 5° is specified or indicated for bends.

8.2 Joints utilizing collars instead of bells cast as an integral part with the pipe barrel shall comply with the requirements for bell-and-spigot joints given in 8.4.1 through 8.4.8. The collar shall be flared at each end to facilitate entrance of the gasket when closing the joint. The straight section between the flares at either end shall be a true cylinder of such length that at the position of normal joint closure, the parallel surfaces upon which the gasket bears during closure will extend not less than 19 mm away from the edges of the gasket. Each end of the pipe shall have a groove formed on its outer surface of suitable dimensions to contain a circular rubber gasket.

8.3 Joints utilizing steel bell-and-spigot rings shall comply with the requirements for bell-and-spigot joints given in 8.4.1, 8.4.3, and 8.4.5. The bell ring shall have a minimum thickness of 5 mm and width sufficient to provide for adequate embedment in the pipe. It shall be flared at one end and is not prohibited from being tapered at the other end. The remainder of the bell ring shall be a true cylinder of such length that at the position of normal joint closure, the parallel surface upon which the gasket bears during the closure will extend not less than 25 mm away from the edge of the gasket. The spigot ring shall be formed from a specially shaped section of steel with a groove of suitable dimensions to contain a circular rubber gasket. The difference in circumference of the inside of the bell ring and the outside of the spigot ring shall not exceed 5 mm for gaskets of 17-mm diameter or less, and 6 mm for gaskets greater than 17-mm diameter.

8.4 In pipe utilizing bell-and-spigot joints, the joint shall be designed and manufactured so that the spigot and gasket will readily enter the bell of the pipe. In all-concrete joints the manufacturer shall provide sufficient reinforcement in the bell to resist the hydrostatic, hydrodynamic, and gasket pressures. The shape and dimensions of the joint shall be such as to provide the minimum requirements given in 8.4.1 through 8.4.8.

8.4.1 For design pressures greater than 75 kilopascals, the rubber gaskets shall be solid gaskets of circular cross section. For design pressures less than or equal to 75 kilopascals, the gaskets shall be solid gaskets of circular or non-circular cross section. All gaskets shall be confined in an annular space formed by shoulders on the bell and spigot or in a groove in the spigot of the pipe so that movement of the pipe or hydrostatic and hydrodynamic pressure cannot displace the gasket. When the joint is assembled, the gasket shall be compressed to form a watertight seal.

8.4.2 In joints that utilize spigot grooves, the volume of the annular space provided for the gasket, with the engaged joint at normal joint closure in concentric position, and neglecting ellipticity of the bell and spigot, shall be not less than the design volume of the gasket furnished. The cross-sectional area of the annular space shall be calculated for minimum bell diameter, maximum spigot diameter, minimum width of groove at surface of spigot, and minimum depth of groove. The volume of the annular space shall be calculated considering the centroid of the cross-sectional area to be at the midpoint between the inside bell surface and the surface of the groove on which the gasket is seated at the centerline of the groove.

8.4.3 In joints that utilize spigot grooves, if the average volume of the gasket furnished is less than 75 % of the volume of the annular space in which the gasket is to be contained with the engaged joint at normal joint closure in concentric position, the gasket shall not be stretched more than 20 % of its unstretched length when seated on the spigot or not more than 30 % if the design volume of the gasket is 75 % or more of the volume of the annular space. For determining the volume of the annular space, the cross-sectional area of the annular space shall be calculated for average bell diameter, average spigot diameter, average width of groove at surface of spigot, and average depth of groove. The volume of the annular space shall be calculated considering the centroid of the cross-sectional area to be at the midpoint between the inside bell surface and the surface of the groove on which the gasket is seated at the centerline of the groove. It is further specified that when the design volume of the gasket is less than 75 % of the volume of the annular space, as calculated above, the gasket shall be of such diameter that when the outer surface of the spigot and the inner surface of the bell come into contact at some point in their periphery, the deformation in the gasket shall not exceed 50 % at the point of contact nor be less than 15 % at any point. If the design volume of the gasket is 75 % or more of the volume of the annular space, the deformation of the gasket, as prescribed above, shall not exceed 50 % nor be less than 15 %. When determining the maximum percent deformation of the gasket, the maximum groove width, the minimum depth of groove, and the stretched gasket diameter shall be used and calculations made at the centerline of the groove. When determining the minimum percent deformation of the gasket, the minimum groove width, the maximum bell diameter, the minimum spigot diameter, the maximum depth of groove, and the stretched gasket diameter shall be used and calculations made at the centerline of the groove. For gasket deformation calculations, stretched gasket diameter shall be determined as being the design diameter of the gasket divided by the square root of $(1 + x)$ where x equals the design percent of gasket stretch divided by 100.

8.4.4 In joints that utilize shoulders on the bell and spigot to confine the gasket, the gasket shall not be stretched more than 20 % of its unstretched length when seated on the spigot. It is further specified that the gasket shall be of such diameter that when the outer surface of the spigot and the inner surface of the bell come into contact at some point in their periphery, the deformation in the gasket shall not exceed 50 % at the point of contact nor be less than 15 % at any point. When determining the maximum percent deformation of the gasket, the minimum depth of shoulders and the stretched gasket diameter shall be used. When determining the minimum percent deformation of the gasket, the maximum depth of shoulders, the maximum bell diameter, the minimum spigot diameter, and the stretched gasket diameter shall be used. For gasket deformation calculations, the stretched diameter shall be determined as described for joints that utilize spigot grooves.

8.4.5 Each gasket shall be manufactured to provide the volume of rubber required by the pipe manufacturer's joint design with a tolerance of $\pm 3\%$ for gaskets up to and including 13 mm in diameter and $\pm 1\%$ for gaskets of 25-mm

diameter and larger. The allowable percentage tolerance shall vary linearly between $\pm 3\%$ and $\pm 1\%$ for gasket diameters between 13 and 25 mm.

8.4.6 The tolerances permitted in the construction of the joint shall be those stated in the pipe manufacturer's design as approved.

8.4.7 The taper on all surfaces of the bells and spigots, on which the rubber gasket bears during closure of the joint and at any degree of partial closure, except within the gasket groove, shall form an angle of not more than 2° with the longitudinal axis of the pipe. The joint shall be so designed and manufactured that at the position of normal joint closure, the parallel surfaces upon which the gasket bears during closure will extend not less than 19 mm away from the edges of the gasket.

8.4.8 The surfaces of the bell and spigot in contact with the gasket, and adjacent surfaces that may come in contact with the gasket within a joint movement range, shall be free from airholes, chipped or spalled concrete, laitance, or other defects. The inside surface of the bell adjacent to the bell face shall be flared to facilitate joining the pipe sections without damaging or displacing the gasket.

8.5 *Alternative Joint Designs*—It is not prohibited for the manufacturer to submit to the owner, detailed designs for joints and gaskets other than those described in Section 8. Design submissions shall include joint geometry, tolerances, gasket characteristics, proposed plant tests, gasket splice bend tests, and such other information as required by the owner to evaluate the joint design for field performance. Joints and gaskets of alternate joint designs shall meet all test requirements of this specification and shall maintain at least 15 % deformation of the rubber gasket when out-of-roundness and off-center position of the joint is considered. Alternative joint designs shall be acceptable provided the designs are approved by the owner prior to manufacture and provided the test pipe comply with the specified tests.

9. Materials and Manufacture

9.1 *Concrete Mixture*—The aggregates shall be graded, proportioned, and thoroughly mixed with the proportions of cementitious material and water that will produce a workable, uniform, homogeneous concrete mixture of such quality that the pipe will conform to the test and design requirements of this specification. Batching shall be accomplished by weighing. If the concrete materials are weighed accumulatively, the cementitious material shall be weighed before the other ingredients. Cementitious materials shall be as specified in 6.2 and shall be added to the mix in a proportion not less than 330 kg/m³.

9.1.1 *Placement of Concrete*—The transporting and placement of concrete shall be by methods that will prevent separation of the concrete materials and the displacement of the reinforcement steel from its proper position in the form.

9.2 *Curing of Pipe*—The method and extent of curing shall be established by testing not less than five cylinders cured in the same manner as the pipe until they have attained an average strength of 25 MPa. After a satisfactory curing method and period have been established, they shall not be changed without approval of the owner. If required by the owner, each

day's run of pipe shall be cured until a companionate test cylinder cured in the same manner as the pipe has attained a strength of 25 MPa. Pipe shall be protected from temperatures below 5°C from the time the concrete is placed until the curing period is completed. Curing shall be by any method or combination of methods described below or by any other method approved by the owner.

9.2.1 *Steam Curing*—After the pipe has been cast, it shall be placed in an enclosure of such nature as to protect the pipe from outside drafts and to allow full circulation of saturated vapor around the inside and outside of the pipe. The rise in the ambient temperature shall not exceed 22°C in any 1 h; nor shall the ambient temperature exceed 37°C during the 2 h immediately following concrete placement. At no time shall the ambient temperature exceed 66°C. Following the periods of steam curing, the pipe shall be protected from rapid drops in temperature which are capable of injuring the pipe.

9.2.2 *Water Curing*—Concrete in pipe shall be water-cured by any method that will keep the pipe moist during the curing period.

9.2.3 *Membrane Curing*—The sealing compound used for membrane curing shall conform to the requirements of Specification C309. The pipe surfaces shall be kept moist prior to application of the compound, and at the time of application the surfaces shall be moist and the temperature of the concrete shall be within 6°C of the atmospheric temperature. If the membrane is damaged, it shall be repaired immediately with additional compound.

10. Physical Requirements

10.1 *Test Specimens*—The specified number of pipe required for the tests shall be furnished without charge by the manufacturer and shall be selected at random by the owner, and shall be pipe that would not otherwise be rejected under this specification. The selection shall be made at the point or points designated by the owner when placing the order. Pipe units that satisfactorily pass the required tests shall be acceptable for use.

10.2 *Number and Type of Test Required for Various Delivery Schedules:*

10.2.1 *Preliminary Tests for Extended Delivery Schedules*—An owner of pipe, whose needs require shipments at intervals over extended periods of time, shall be entitled to such tests, preliminary to delivery of pipe, as are required in Section 5, of not more than three sections of pipe covering each size in which he is interested. The strength of concrete shall be determined from test cylinders made from the concrete used in making the pipe as provided in 10.3.

10.2.2 *Additional Tests for Extended Delivery Schedules*—After the preliminary tests described in 10.2.1 an owner shall be entitled to additional tests in such numbers and at such times as he may deem necessary, provided that the total number of pipe shall not exceed 1 % of each size and class of pipe manufactured in each test period, except that at least one hydrostatic and joint leakage test shall be made for each size and class.

10.2.3 *Length of Test Period*—For the purpose of testing the pipe units, the length of the test period will be set at the number of days the plant of the pipe manufacturer is normally operated

in a calendar week. The test period will include any shutdown of the plant that does not exceed a 24-h period due to failure of the plant or equipment. The length of the test period shall be reduced, at the discretion of the owner, if there is a significant change in the materials used in the pipe, in the mix proportions, or in the production procedures or by numerous shutdowns of the plant due to failures of the plant or equipment. The length of the test period shall be increased at the discretion of the owner when results of tests for successive periods indicate that the manufacturer's operations are productive of uniformly acceptable pipe.

10.3 *Concrete Strength:*

10.3.1 *Compressive Strength*—Compression tests for satisfying the design concrete strength shall be made on cured concrete cylinders. The concrete shall have a minimum compressive strength as specified in 10.3.3. Compression tests of such cylinders shall be made in accordance with Test Method C39/C39M.

10.3.2 *Number of Compression Tests*—At least five standard test cylinders shall be prepared from each day's production of concrete. Test cylinders shall be prepared in conformance with Practice C31/C31M, except it is not prohibited that cylinders be prepared by methods comparable to those used to consolidate and cure concrete in the actual pipe manufactured, or for concrete of a consistency too stiff for compaction by rodding or internal vibration, the alternative method described in the cylinder strength test method of Test Methods C497M may be used.

10.3.3 *Compression Test Requirements*—The average 28-day compressive strength of all cylinders tested shall be equal to or greater than the design strength of the concrete. Not more than 10 % of the cylinders tested shall fall below the design strength. In no case shall any cylinder tested fall below 80 % of the specified design strength. These compressive strength requirements refer to standard 150 by 300-mm concrete test cylinders. Where the strength of 150 by 300-mm concrete test cylinders exceeds the capacity of the normal field testing machine (900 kN), 75 by 150-mm test cylinders will be permitted with correction for size of cylinder.

10.4 *Hydrostatic Tests:*

10.4.1 *Hydrostatic Testing of Pipe*—Hydrostatic tests on pipe shall be made in accordance with the provisions of Test Methods C497M. Before the test pressure is applied, the pipe shall be allowed, at the option of the manufacturer, to stand under reduced pressure, but not for more than 48 h. Acceptance hydrostatic tests shall be made to 120 % of the specified internal working pressure for which the pipe is designed. The pipe shall withstand the percentage of working pressure prescribed above for at least 20 min without cracking and with no leakage appearing on the exterior surface. Moisture appearing on the surface of the pipe in the form of patches or beads adhering to the surface will not be considered as leakage. Slow-forming beads of water that result in minor dripping which can be proven to seal and dry up upon retesting under the prescribed test pressure will be considered acceptable.

10.4.2 *Hydrostatic Testing of Rubber Gasket Joints*—Hydrostatic pressure tests on joints shall be made on joints assembled of two sections of pipe, properly connected in

accordance with the joint design. Suitable bulkheads shall be provided with the pipe adjacent to and on either side of the joint, or the manufacturer shall bulkhead the outer ends of joined pipe sections and conduct hydrostatic tests on both the pipe and pipe joint concurrently. No mortar or concrete coatings, fillings, or packings shall be placed prior to watertightness tests. After the pipe sections are fitted together with the rubber gasket or gaskets in place, the watertightness of the joints shall be tested under hydrostatic heads of 120 % of the pressure for which the pipe is designed, and there shall be no water leakage through the rubber gasket joint. On completion of the above straight alignment tests, the assembly shall be loaded to cause maximum joint annular space to occur. The load shall be applied such that a minimum differential load across the non-bulkheaded joint of 26.3 KN per mm of diameter is obtained or concrete to concrete contact occurs. The assembly shall then be retested as set forth in 10.4.1 and 10.4.2.

10.4.3 Retests of Pipe or Pipe Joints Not Meeting the Hydrostatic Test Requirements—In the event that a pipe or pipe joint fails the required tests, the manufacturer shall have the right to test two other sections of the pipe selected by the owner from the same period's run from which the original was selected. If these two pipe successfully pass the test, the remainder of the pipe in that period's run will be accepted. If either of these pipe fails, the remainder in that period's run will not be accepted until each pipe has satisfactorily passed this test.

10.5 Test Equipment—Every manufacturer furnishing pipe under the specifications shall furnish all facilities and personnel necessary to carry out the tests described in this specification.

11. Permissible Variations

11.1 Internal Diameter—Permissible variations in internal diameter shall be as prescribed in Table 3. In order to obtain continuity of the interior surfaces of the pipeline, the maximum offset at the joints shall not exceed 0.75 % of the internal diameter of the pipe.

11.2 Wall Thickness—The wall thickness shall not be less than that intended in the design by more than 5 % at any point.

11.3 Length of Two Opposite Sides—Variations in laying lengths (see L in Figs. 1 and Figs. 2 of Test Methods C497M) of two opposite sides of pipe shall not be more than 10 mm/m of diameter, with a maximum of 16 mm in any length of pipe, except where beveled-end pipe for laying on curves is specified by the owner.

11.4 Length of Pipe—The underrun or overrun in length of a section of pipe shall not be more than 10 mm/m with a maximum of 13 mm in any length of pipe.

11.5 Area of Reinforcement—The area of steel reinforcement shall be not less than 97 % of the design steel area of each cage ring. Steel areas greater than those required in the design shall not be cause for rejection.

11.6 The average diameter of any bell or spigot shall be within the minimum and maximum limits used in Section 8 (except 8.3 for design of the joint). The average diameter of a bell will be determined by taking the average of four equally spaced diametric measurements. The average spigot diameter will be determined by dividing the measured circumference by 3.1416.

TABLE 3 Permissible Variations in Internal Diameter

Designated Size Diameter of Pipe, mm	Permissible Variation, Internal Diameter of Pipe	
	Minimum, mm	Maximum, mm
300	300	310
375	375	390
450	450	465
525	525	545
600	600	620
675	675	695
750	750	775
825	825	850
900	900	925
975	975	1000
1050	1050	1080
1125	1125	1155
1200	1200	1230
1275	1275	1305
1350	1350	1385
1425	1425	1460
1500	1500	1540
1575	1575	1615
1650	1650	1695
1725	1725	1770
1800	1800	1850
1950	1950	2000
2100	2100	2155
2250	2250	2310
2400	2400	2465
2550	2550	2620
2700	2700	2770

11.6.1 An additional tolerance referred to as “inspection” tolerance is allowed during inspection of completed pipe units. This tolerance quantitatively is two times the minimum design joint clearance. The minimum design joint clearance is one half of the difference between the maximum design spigot diameter and the minimum design bell diameter. This “inspection” tolerance shall be apportioned to the bell and to the spigot in a ratio elected by the manufacturer. This tolerance, when applied, defines the minimum acceptable bell diameter on any pipe unit, measured diametrically, to be the minimum design bell diameter minus that part of the “inspection” tolerance apportioned to the bell. Similarly, the maximum acceptable spigot diameter on any pipe unit, measured diametrically, is defined to be the maximum design spigot diameter plus that part of the “inspection” tolerance apportioned to the spigot.

12. Workmanship, Finish, and Appearance

12.1 Pipe shall be substantially free of fractures, excessive surface crazing, pits, air holes, laitance, excessive brush marks, and interior surface roughness.

13. Repairs

13.1 It is not prohibited for pipe to be repaired if made necessary because of imperfections in manufacture or damage during handling, and will be considered acceptable if, in the opinion of the owner, the defects do not subject the pipe unit to rejection as specified in Section 15, and the repairs are sound and properly finished and cured. Air holes in the gasket-bearing area shall be repaired. Such fillings shall be kept moist under wet burlap for at least 48 h. Hydrostatic testing of repaired pipe

shall be required if deemed necessary by the owner, and such testing shall be at no additional cost to the owner.

14. Inspection

14.1 The quality of all materials, the process of manufacture, and the finished pipe shall be subject to inspection and approval by the owner.

15. Rejection

15.1 It is not prohibited for pipe to be subject to rejection on account of failure to conform to any of the specification requirements or on account of any of the following:

15.1.1 Defects that indicate imperfect mixing and molding,

15.1.2 Surface defects indicating honeycombed or open texture, that would adversely affect the performance of the pipe, and

15.1.3 Damaged ends where such damage would prevent making a satisfactory joint.

16. Product Marking

16.1 The following shall be legibly marked on the interior surface of the pipe:

16.1.1 Specification designation, class, and size as indicated in Table 1 and Table 2.

16.1.2 Date of manufacture,

16.1.3 Name or trademark of the manufacturer, and

16.1.4 One end of each section of pipe with elliptical reinforcement shall be clearly marked, during the process of manufacturing or immediately thereafter, on the inside and the outside of opposite walls along the minor axes of the elliptical reinforcing. Markings shall be indented on the pipe section or painted thereon with waterproof paint.

APPENDIXES

(Nonmandatory Information)

X1. FIELD INSTALLATION PROCEDURE

X1.1 The class of pipe given in Table 1 and Table 2 for combined external load and hydrostatic head is based on a field installation procedure at least comparable to that described below. Where the designer does not expect to attain such an installation, a detailed design analysis of the pipe should be made taking into consideration the anticipated external loading, hydrostatic head, and installation procedure. Failure to comply with the requirements herein may result in a bedding angle of less than 90° as defined in Appendix X2 and may result in excessive pipe cracking.

X1.2 The trench shall be excavated of sufficient width to achieve the specified haunch backfill compaction, and to a depth of either 100 mm or 150 mm below the bottom of the pipe, to provide for granular cushion material as shown in Fig. X1.1. The trench shall be backfilled to the bottom of the pipe with uncompacted granular cushion material meeting the physical requirements of X1.2.2. After the pipe is placed in the trench to the correct grade and alignment, additional haunch

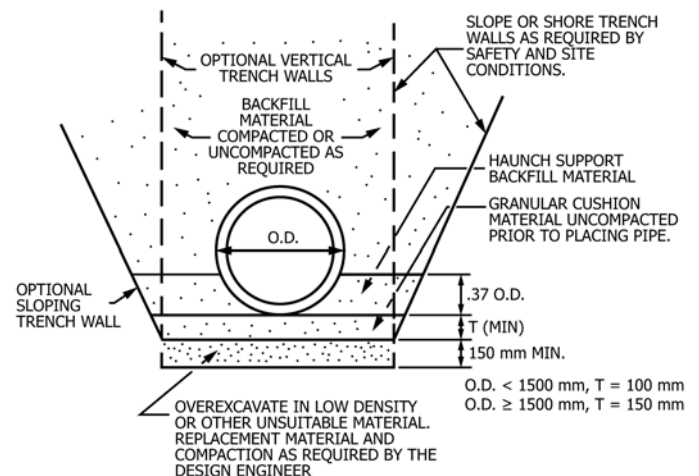


FIG. X1.1 Pipe Bedding

support backfill material shall be compacted in accordance

with **X1.2.1** or **X1.2.2**, depending on the type of soil used as pipe backfill material. An additional depth of 150 mm or more shall be removed if the native material in the trench is soft, low density, or unsuitable for a pipeline foundation. The additional 150 mm or more shall be compacted to the requirements of the design engineer.

X1.2.1 Cohesive Soil or Granular Soil Containing More Than 5 % Fines—If the haunch support backfill material is a cohesive soil or is a granular soil containing more than 5 % material passing the number 200 sieve, the material shall be placed in layers not exceeding 150 mm in thickness and compacted by appropriate surface methods such as tamping, rolling, vibration, or a combination thereof. The material shall be placed from the bottom of the pipe to a height of 0.37 times the outside diameter of the pipe, shall be placed and compacted in such a manner as to completely fill the space under the haunches of the pipe, and shall be compacted throughout to a minimum of 95 % of laboratory maximum density as determined in accordance with Test Method **D698**.

X1.2.2 Granular Soil Containing 5 % Fines or Less—If the haunch support backfill material is a cohesionless, free-draining soil (containing no more than 5 % material passing the number 200 sieve) it shall be placed a minimum depth of 0.37 times the outside diameter of the pipe and shall be compacted by saturation and internal vibration in such a manner as to completely fill the spaces under the haunches of the pipe and shall be compacted throughout to a minimum of 70 % relative density as determined in accordance with Test Methods **D4253** and **D4254**.

NOTE X1.1—In order to achieve specified density, it may be necessary to provide means for draining the water utilized during vibration whenever the trench sides and subgrade are incapable or readily absorbing the excess.

X1.2.3 The pipe backfill material in **X1.2.1** and **X1.2.2** shall have a maximum particle size not exceeding 19 mm and shall be graded to preclude migration of soil particles. The backfill material placed above the 0.37 outside diameter level shall be compacted or uncompacted to the requirements of the design engineer.

X2. DESIGN CRITERIA FOR TABLES 1 AND 2

X2.1 The designs for reinforced concrete low-head pressure pipe presented in **Table 1** and **Table 2** are based on specific loadings, bedding, and design requirements summarized in this appendix as information for the designer in considering the suitability of the designs. The reinforcement areas shown in **Table 1** and **Table 2** were obtained by converting the corresponding values in in.²/ft units from Tables 1 and 2 in Specification C361 to metric units.

X2.2 Loads—This pipe is designed for dead load of the pipe itself, the earth load, the water load, and the internal pressure due to hydrostatic head calculated from the inside top of the pipe to the design gradient. The hydrostatic head defined in **Table 1** is measured to the horizontal centerline of the pipe.

X2.2.1 The earth load is based on a one-metre length of the prism of earth directly over the outside diameter of the pipe. The *effective* density (mass per unit volume) of earth in kilograms per cubic metre is:

$$w_e = 1992 + 384(H_e / OD)$$

where:

H_e = earth cover over top of pipe, m,
 OD = outside diameter of pipe, m, and
 $\max w_e$ = 2688 kg/m³.

The force exerted on the pipe by the prism of earth over the pipe is:

$$W = w_e H_e (OD) g / 1000, \text{ kn/linear m} \quad (\text{X2.1})$$

where:

$$g = 9.81 \text{ m/s}^2$$

NOTE X2.1—The earth load from **X2.2.1** represents loose backfill over pipe in a trench of any width, as may be used for cross-country pipelines. For any other earth load design assumption selected by the engineer, the new earth load may be compared to the design earth load in kilonewtons per linear metre from **X2.2.1** for the range of cover loads, A through D,

within the same pressure head designation.

X2.2.2 The prescribed amounts of reinforcement do not provide any allowance for pressure surges (water hammer) in pipelines.

X2.3 Bedding—The bedding described in **Appendix X1** is assumed to result in bearing over a 90° central angle for earth, water, and live loads and 45° for pipe dead load. Pressure distributions and the analysis of stresses in the pipe wall are based on theory.⁶

X2.4 Design Requirements—Reinforced low-head concrete pressure pipe is designed for flexure, crack width control, diagonal tension (shear), and radial tension using methods found in AASHTO LRFD Bridge Design Specifications. The pipe is analyzed for three load conditions, and the reinforcing steel requirement is established based on the steel area needed to satisfy all three of these conditions.

Load Cond. I — Internal pressure only

Load Cond. II — Earth load, pipe weight, and water weight with no internal pressure

Load Cond. III — External and internal loads acting concurrently

Load factors used for design are:

Flexure, for internal pressure — 1.5

Flexure, for dead and earth loads — 1.6 except 1.0 for compressive thrust

Shear, for all loads — 1.3

Capacity reduction factors used for design are:

ϕ_f = strength reduction factor for flexure — 0.95

ϕ_v = strength reduction factor for shear and radial tension — 0.9

Table 1 and **Table 2** were developed using concrete strength of 35.4 MPa, and steel reinforcing yield strengths of 276 MPa

⁶ Olander, H. C., "Stress Analysis of Concrete Pipe," *Engineering Monograph No. 6*, U.S. Bureau of Reclamation, October 1950.

and 414 MPa, respectively. Bolded areas in the tables are based on concrete strength of 41.4 MPa when required by shear analysis.

Pipe fabricated with reinforcement areas shown in **Table 1** and **Table 2** must be specified with respective material requirements of minimum concrete and reinforcement strengths shown.

X2.4.1 For Load Cond. I, the minimum steel area is calculated for hydrostatic head only. The minimum area of circular reinforcement is:

$$A_s = \frac{PD_d}{2f_s}, \text{ mm}^2/\text{m}$$

where:

P = hydrostatic pressure head, kPa,

D_d = design diameter, the average of the minimum and maximum internal diameters shown in **Table 3**, mm, and

f_s = 117 – 0.08P, allowable tensile stress in the reinforcement, MPa.

For elliptical reinforcement, the minimum area of reinforcement is 1.6 times that required for circular reinforcement for hydrostatic head alone.

X2.4.2 Circumferential reinforcement to resist cracking of the concrete, diagonal tension (shear), and radial tension reinforcement (stirrups) shall be determined by methods in C361, **Appendix X2** in in.²/ft units and results converted to metric units. The design concrete cover is the average of the dimensions given in paragraph 7.4 of the specification for a particular range of pipe diameters. For single-layer reinforcement, the steel is assumed to be at the centerline of the cross-section.

X2.4.3 The minimum wall thickness of the pipe is:

$$t_{w\min} = \frac{D}{12}, \text{ mm}$$

where:

D = designated size given in **Table 3**.

The tensile stress in the concrete of the pipe wall is:

$$f_{ct} = \frac{PD}{2000 t_w}, \text{ MPa}$$

where:

t_w = design pipe wall thickness, assumed unreinforced, mm, and
 $f_{ct} \leq 0.37\sqrt{f'_c}$

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