



Standard Specification for Reinforced Concrete Elliptical Culvert, Storm Drain, and Sewer Pipe (Metric)¹

This standard is issued under the fixed designation C507M; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

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

1. Scope

1.1 This specification covers reinforced elliptically shaped concrete pipe to be used for the conveyance of sewage, industrial wastes, storm water, and for the construction of culverts.

1.2 Pipe designed for placement with the major axis horizontal shall be designated as “Horizontal Elliptical Pipe.” Pipe designed for placement with the major axis vertical shall be designated as “Vertical Elliptical Pipe.”

1.3 This specification is the SI companion to Specification C507; therefore, no inch-pound equivalents are presented in this specification. Reinforced concrete pipe that conforms to the requirements of C507 are acceptable under this Specification C507M unless prohibited by the owner.

NOTE 1—This specification is a manufacturing and purchase specification only, and does not include requirements for bedding, backfill, or the relationship between field load condition and the strength classification of pipe. However, experience has shown that the successful performance of this product depends upon the proper selection of the class of pipe, type of bedding and backfill, and care that the installation conforms to construction specifications. The owner of the reinforced concrete pipe specified herein is cautioned that he must correlate the field requirements with the class of pipe specified and provide inspection at the construction site.

2. Referenced Documents

2.1 ASTM Standards:²

A36/A36M Specification for Carbon Structural Steel

A615/A615M Specification for Deformed and Plain Carbon-Steel Bars for Concrete Reinforcement

A706/A706M Specification for Deformed and Plain Low-Alloy Steel Bars for Concrete Reinforcement

¹ This specification is under the jurisdiction of ASTM Committee C13 on Concrete Pipe and is the direct responsibility of Subcommittee C13.02 on Reinforced Sewer and Culvert 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.

A1064/A1064M Specification for Carbon-Steel Wire and Welded Wire Reinforcement, Plain and Deformed, for Concrete

C33/C33M Specification for Concrete Aggregates

C150/C150M Specification for Portland Cement

C260/C260M Specification for Air-Entraining Admixtures for Concrete

C309 Specification for Liquid Membrane-Forming Compounds for Curing Concrete

C443M Specification for Joints for Concrete Pipe and Manholes, Using Rubber Gaskets (Metric)

C494/C494M Specification for Chemical Admixtures for Concrete

C497M Test Methods for Concrete Pipe, Manhole Sections, or Tile (Metric)

C595/C595M 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

C989/C989M Specification for Slag Cement for Use in Concrete and Mortars

C990M Specification for Joints for Concrete Pipe, Manholes, and Precast Box Sections Using Preformed Flexible Joint Sealants (Metric)

C1017/C1017M Specification for Chemical Admixtures for Use in Producing Flowing Concrete

C1116/C1116M Specification for Fiber-Reinforced Concrete

C1602/C1602M Specification for Mixing Water Used in the Production of Hydraulic Cement Concrete

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 of five classes each for horizontal elliptical and vertical elliptical pipe with identification as follows:

Horizontal Elliptical Pipe
Class HE-A
Class HE-I
Class HE-II
Class HE-III
Class HE-IV

Vertical Elliptical Pipe
Class VE-II
Class VE-III
Class VE-IV
Class VE-V
Class VE-VI

4.2 The strength requirements for horizontal elliptical pipe are prescribed in [Table 1](#) and for vertical elliptical pipe are prescribed in [Table 2](#).

5. Basis of Acceptance

5.1 Unless otherwise designated by the owner at the time of, or before, placing an order, there are two separate and alternative bases of acceptance. Independent of the method of acceptance, the pipe shall be designed to meet both the 0.01-in. crack and ultimate strength requirements specified in [Table 1](#).

5.1.1 *Acceptance on Basis of Plant Load-Bearing Tests, Material Tests, and Inspection of Manufactured Pipe for Visual*

Defects and Imperfections—Acceptability of the pipe in all diameters and classes produced in accordance with [7.1](#) or [7.2](#) shall be determined by the results of the three-edge-bearing tests as defined in [11.3.1](#); by such material tests as are required in [6.2](#), [6.3](#), [6.5](#) and [6.6](#); by an absorption test of the concrete from the wall of the pipe as required in [11.9](#); and by visual inspection of the finished pipe to determine its conformance with the accepted design prescribed and its freedom from defects.

5.1.2 *Acceptance on the Basis of Material Test and Inspection of Manufactured Pipe for Defects and Imperfections*—Acceptability of the pipe in all diameters and classes produced in accordance with [7.1](#) or [7.2](#) shall be determined by the results of such material tests as are required in [6.2](#), [6.3](#), [6.5](#) and [6.6](#); by crushing tests on concrete cores or cured concrete cylinders; by an absorption test of the concrete from the wall of the pipe for each mix design that is used on an order; and by inspection of

TABLE 1 Design Requirements for Horizontal Elliptical (HE) Pipe^A

NOTE 1—The test load in kilonewtons per linear metre equals D-load × inside span in millimetres.

NOTE 2—Single cage reinforcement, providing tension steel at the top, bottom, and springline, shall be permitted instead of double cage reinforcement. The area of such reinforcement shall be 112 % of the tabulated inner cage area.

NOTE 3—An inner and outer cage plus quadrant mats shall be permitted instead of double cage reinforcement. The area of such reinforcement shall be in accordance with [Fig. 1](#).

NOTE 4—An inner and outer cage plus a middle cage shall be permitted instead of double cage reinforcement. The area of such reinforcement shall be in accordance with [Fig. 2](#).

Designated Di- ameter, Equiva- lent Round Size, mm	Designated Rise, mm x Span, mm	Minimum Wall Thickness, mm	Reinforcement, cm ² /linear m									
			Class HE-A		Class HE-I		Class HE-II		Class HE-III		Class HE-IV	
			D-Loads									
			0.3 = 30 Ult = 45		0.3 = 40 Ult = 60		0.3 = 50 Ult = 75		0.3 = 65 Ult = 100		0.3 = 100 Ult = 150	
			In Cage	Out Cage	In Cage	Out Cage	In Cage	Out Cage	In Cage	Out Cage	In Cage	Out Cage
450	365 × 575	69	1.7	...	2.3	...	3.0	...	4.0	...	5.7	...
600	490 × 770	82	2.3	...	3.2	...	4.0	...	5.5	...	8.3	...
675	550 × 865	88	3.0	...	3.8	...	4.9	...	6.6	...	9.7	...
750	610 × 960	94	2.1	2.1	2.8	2.8	3.6	3.6	4.9	4.9	7.2	7.2
825	670 × 1055	94	2.5	2.5	3.6	3.6	4.4	4.4	5.9	5.9	8.7	8.7
900	730 × 1150	113	2.3	2.3	3.2	3.2	4.0	4.0	5.5	5.5	8.3	8.3
975	795 × 1250	119	2.8	2.8	3.6	3.6	4.4	4.4	6.1	6.1	9.3	9.3
1050	855 × 1345	125	3.2	3.2	4.2	4.2	5.1	5.1	7.0	7.0	10.6	10.6
1200	975 × 1535	138	3.6	3.6	4.9	4.9	5.9	5.9	8.3	8.3	...	...
1350	1095 × 1730	150	4.2	4.2	5.7	5.7	7.2	7.2	9.5	9.5	...	...
1500	1220 × 1920	163	5.1	5.1	6.8	6.8	8.5	8.5	11.2	11.2	...	...
1650	1340 × 2110	175	5.7	5.7	7.6	7.6	9.5	9.5	12.9	12.9	...	...
1800	1465 × 2305	188	6.6	6.6	8.7	8.7	11.0	11.0	14.8	14.8	...	...
1950	1585 × 2495	200	7.2	7.2	9.5	9.5	11.9	11.9	16.5	16.5	...	...
2100	1705 × 2690	213	8.0	8.0	10.6	10.6	13.3	13.3	18.6	18.6	...	...
2250	1830 × 2880	225	...	...	...	...	...	...	...	...	...	...
2400	1950 × 3070	238	...	...	...	...	...	...	...	...	...	...
2550	2075 × 3265	244	...	...	...	...	...	...	...	...	...	...
2700	2195 × 3455	250	...	...	...	...	...	...	...	...	...	...
2850	2315 × 3648	263	...	...	...	...	...	...	...	...	...	...
3000	2440 × 3840	275	...	...	...	...	...	...	...	...	...	...
3300	2680 × 4225	300	...	...	...	...	...	...	...	...	...	...
3600	2925 × 4610	325	...	...	...	...	...	...	...	...	...	...
Concrete strength ^B , MPa			27.6		27.6		27.6		†450 to 1650 mm, 27.6 †1800 to 2100 mm, 34.5		27.6	

^A Concrete strength for designs with reinforcement tabulated. For modified or special designs, see [7.3](#).

^B For sizes and loads beyond those shown in this table, pipe designs are available that make use of one or a combination of the following: shear steel, multiple cages, or thicker walls in accordance with the provisions of [7.3](#).

TABLE 2 Design Requirements for Vertical Elliptical Pipe^A

NOTE 1—Test load in kilonewtons per linear metre equals D-load × inside span in millimetres.

NOTE 2—An inner and outer cage plus quadrant mats shall be permitted instead of double cage reinforcement. The area of such reinforcement shall be in accordance with Fig. 3.

NOTE 3—Single cage reinforcement, providing tension steel at the top, bottom, and spring line shall be permitted instead of double cage reinforcement. The area of such reinforcement shall be 112 % of the tabulated inner cage area.

NOTE 4—An inner and outer cage plus a middle cage shall be permitted instead of double cage reinforcement. The area of such reinforcement shall be in accordance with Fig. 4.

Designated Di- ameter, Equiva- lent Round Size, mm	Designated Rise, mm x Span, mm	Minimum Wall Thickness, mm	Reinforcement, cm ² /linear m									
			Class VE-II		Class VE-III		Class VE-IV		Class VE-V		Class VE-VI	
			D-Loads									
			0.3 = 50 Ult = 75		0.3 = 65 Ult = 100		0.3 = 100 Ult = 150		0.3 = 140 Ult = 175		0.3 = 190 Ult = 235	
In Cage	Out Cage	In Cage	Out Cage	In Cage	Out Cage	In Cage	Out Cage	In Cage	Out Cage	In Cage	Out Cage	
900	1150 x 730	113	1.7	1.1	2.3	1.5	3.4	2.1	4.9	3.0	6.6	4.0
975	1250 x 795	119	1.9	1.1	2.5	1.5	3.8	2.3	5.5	3.4	7.4	4.4
1050	1345 x 855	125	2.1	1.3	2.8	1.7	4.2	2.5	6.1	3.6	8.0	4.9
1200	1535 x 975	138	2.3	1.5	3.2	1.9	4.7	2.8	7.0	4.2	9.3	5.5
1350	1730 x 1095	150	2.8	1.7	3.8	2.3	5.7	3.4	8.5	5.1	11.2	5.8
1500	1920 x 1220	163	3.4	2.1	4.4	2.8	6.6	4.0	9.9	5.9	...	...
1650	2110 x 1340	175	3.8	2.3	5.3	3.2	7.6	4.7	11.6	7.0	...	...
1800	2305 x 1465	188	4.4	2.8	5.9	3.6	8.7	5.3	...	...	...	...
1950	2495 x 1585	200	4.9	3.0	6.6	4.0	9.9	5.9	...	...	...	...
2100	2690 x 1705	213	5.5	3.4	7.4	4.4	11.2	6.8	...	...	...	...
2250	2880 x 1830	225	...	...	...	...	...	...	...	...	...	...
2400	3070 x 1950	238	...	...	...	...	...	...	...	...	...	...
2550	3265 x 2075	244	...	...	...	...	...	...	...	...	...	...
2700	3455 x 2195	250	...	...	...	...	...	...	...	...	...	...
2850	3648 x 2315	263	...	...	...	...	...	...	...	...	...	...
3000	3840 x 2440	275	...	...	...	...	...	...	...	...	...	...
3300	4225 x 2680	300	...	...	...	...	...	...	...	...	...	...
3600	4610 x 2925	325	...	...	...	...	...	...	...	...	...	...
Concrete strength ^B , MPa			27.6		27.6		27.6		34.5		41.4	

^A For sizes and loads beyond those shown in this table, pipe designs are available which make use of one or a combination of the following: shear steel, multiple cages, or thicker walls in accordance with the provisions of 7.3.

^B Concrete strength for designs with reinforcement tabulated. For modified or special designs, see 7.3.

the finished pipe, including amount and placement of reinforcement, to determine its conformance with the accepted design and its freedom from defects.

5.1.3 When agreed upon by the owner and the manufacturer, any portion or any combination of the tests itemized in 5.1.1 or 5.1.2 may form the basis of acceptance.

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 cementitious materials, mineral aggregates, admixtures, if used, and water, in which steel has been embedded in such a manner that the steel and concrete act together.

6.2 Cementitious Materials:

6.2.1 *Cement*—Cement shall conform to the requirements for portland cement of Specification C150/C150M, or shall be portland blast-furnace slag cement, portland-limestone cement, or portland-pozzolan cement conforming to the requirements

of Specification C595/C595M, except that the pozzolan constituent in the Type IP portland pozzolan cement shall be fly ash.

6.2.2 *Slag Cement*—Slag cement shall conform to the requirements of Grade 100 or 120 of Specification C989/C989M.

6.2.3 *Fly Ash*—Fly ash shall conform to the requirements of Class F or Class C of Specification C618.

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

6.2.4.1 Portland cement only,

6.2.4.2 Portland blast-furnace slag cement only,

6.2.4.3 Portland-pozzolan cement only,

6.2.4.4 Portland-limestone cement only,

6.2.4.5 A combination of portland cement or portland-limestone cement and slag cement,

6.2.4.6 A combination of portland cement or portland-limestone cement and fly ash,

6.2.4.7 A combination of portland cement or portland-limestone cement, slag cement, and fly ash, or

6.2.4.8 A combination of portland-pozzolan cement and fly ash.

6.3 *Aggregates*—Aggregates shall conform to the requirements of Specification C33/C33M except that the requirement for gradation shall not apply.

6.4 *Admixtures*—The following admixtures and blends are allowable:

6.4.1 Air-entraining admixture conforming to Specification C260/C260M;

6.4.2 Chemical admixture conforming to Specification C494/C494M;

6.4.3 Chemical admixture for use in producing flowing concrete conforming to Specification C1017/C1017M; and

6.4.4 Chemical admixture or blend approved by the owner.

6.5 *Steel Reinforcement*—Reinforcement shall consist of wire and welded wire conforming to Specification A1064/A1064M, or of bars conforming to Specification A36/A36M, Specification A615/A615M Grade 280 or 420, or Specification A706/A706M Grade 420. For helically wound cages only, weld shear tests are not required.

6.6 *Fibers*—Synthetic fibers and nonsynthetic fibers shall be allowed to be used, at the manufacturer's option, in concrete pipe as a nonstructural manufacturing material. Synthetic fibers (Type II and Type III) and nonsynthetic fiber (Type I) designed and manufactured specifically for use in concrete and conforming to the requirements of Specification C1116/C1116M shall be accepted.

6.7 *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 *Size and Shape*—The standard sizes of elliptical pipe shall be as listed in Table 1 and Table 2. The internal shape for each size pipe shall be defined by the internal dimensions shown in Fig. 5, subject to permissible variations.

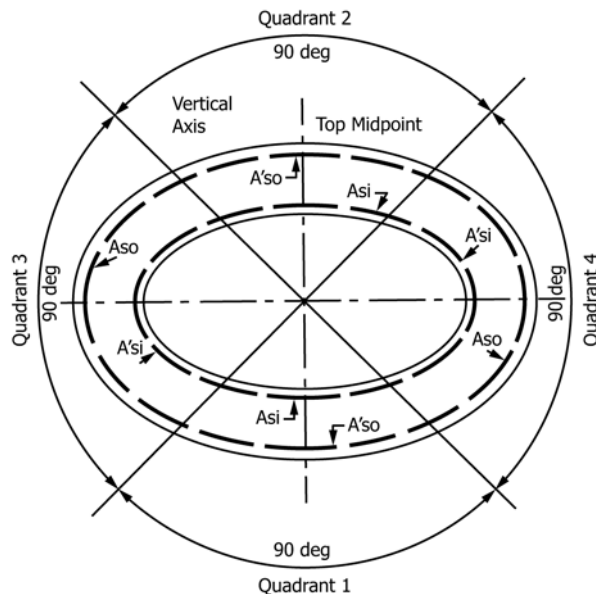
7.2 *Design Tables*—The wall thickness, compressive strength of concrete, and the area of circumferential reinforcement shall be as prescribed in Table 1 and Table 2, subject to the provisions of 7.3, 11.4, and Section 12.

7.2.1 Footnotes to the tables herein are intended to be amplifications of the tabulated requirements and are to be considered applicable and binding as if they were contained in the body of the specification.

7.3 Modified and Special Designs:

7.3.1 If permitted by the owner, the manufacturer may request approval by the owner of modified designs which differ from the designs in this section; or special designs for sizes and loads beyond those shown in Table 1 and Table 2; or special designs for pipe sizes that do not have steel reinforcement areas shown in Table 1 and Table 2.

7.3.2 Such modified and special designs shall be based on rational or empirical evaluations of the ultimate strength and cracking behavior of pipe and shall fully describe to the owner any deviations from the requirements of this section. The descriptions of modified or special designs shall include the wall thickness, the concrete strength, and the area, type, placement, number of layers, and strength of the steel reinforcement.



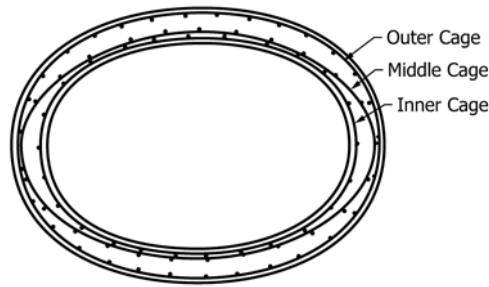
NOTE 1—The total reinforcement area ($A'si$) of the inner cage plus the quadrant mat in Quadrants 1 and 2 shall not be less than that specified for the inner cage in Table 1.

NOTE 2—The total reinforcement area ($A'so$) of the outer cage plus the quadrant mat in Quadrants 3 and 4 shall not be less than that specified for the outer cage in Table 1.

NOTE 3—The reinforcement area ($A'si$) of the inner cage in Quadrants 3 and 4 shall be not less than 25 % of that specified for the inner cage in Table 1.

NOTE 4—The reinforcement area ($A'so$) of the outer cage in Quadrants 1 and 2 shall be not less than 25 % of that specified for the outer cage in Table 1.

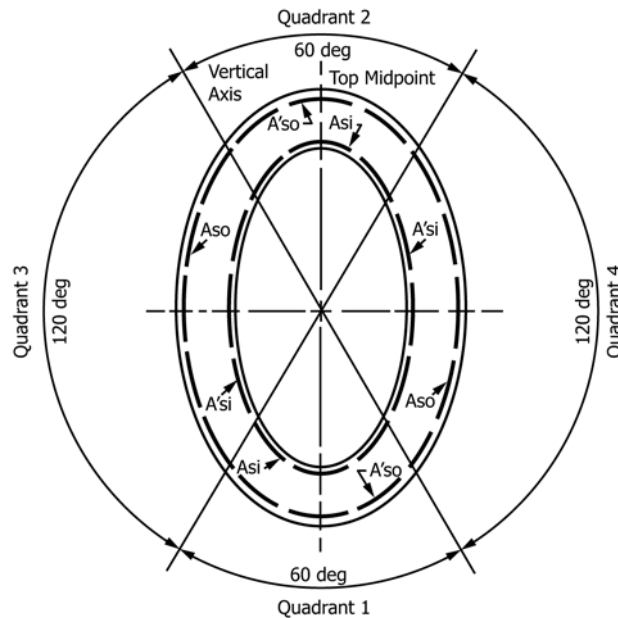
FIG. 1 Quadrant Reinforcement, Horizontal Elliptical Pipe



NOTE 1—The total reinforcement area of the inner cage plus the middle cage shall not be less than that specified for the inner cage in Table 1.

NOTE 2—The total reinforcement area of the outer cage plus the middle cage shall not be less than that specified for the outer cage in Table 1.

FIG. 2 Horizontal Elliptical Pipe



NOTE 1—The total reinforcement area ($A'si$) of the inner cage plus the quadrant mat in Quadrants 1 and 2 shall not be less than that specified for the inner cage in Table 2.

NOTE 2—The total reinforcement area ($A'so$) of the outer cage plus the quadrant mat in Quadrants 3 and 4 shall not be less than that specified for the outer cage in Table 2.

NOTE 3—The reinforcement area ($A'si$) of the inner cage in Quadrants 3 and 4 shall be not less than 25 % of that specified for the inner cage in Table 2.

NOTE 4—The reinforcement area ($A'so$) of the outer cage in Quadrants 1 and 2 shall be not less than 25 % of that specified for the outer cage in Table 2.

FIG. 3 Quadrant Reinforcement, Vertical Elliptical Pipe

7.3.3 The manufacturer shall submit to the owner proof of the adequacy of the proposed modified and special design. Such proof may comprise the submission of certified three-edge-bearing tests already made, which are acceptable to the owner or, if such three-edge-bearing tests are not available or acceptable, the manufacturer may be required to perform proof tests on sizes and classes selected by the owner to demonstrate to the correctness and adequacy of the proposed design.

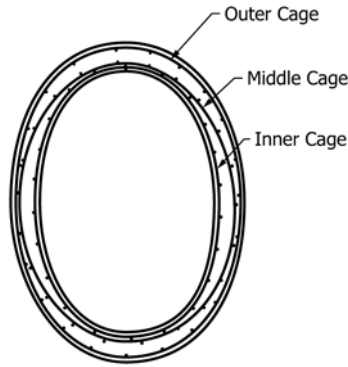
7.3.4 Such pipe shall meet all of the test and performance requirements specified by the owner in accordance with Section 5.

7.4 Area—In this specification, when the word area is not described by adjectives, such as cross-section or single wire, it shall be understood to be the cross-sectional area of reinforcement per unit lengths of pipe.

8. Reinforcement

8.1 *Circumferential Reinforcement*—A line of circumferential reinforcement for any given total area may be composed of two layers for pipe with wall thicknesses of less than 180 mm or three layers for pipe with wall thicknesses of 180 mm or greater. The layers shall not be separated by more than the thickness of one longitudinal plus 6 mm. The multiple layers shall be fastened together to form a single cage. All other specification requirements such as laps, welds, and tolerances of placement in the wall of the pipe, etc., shall apply to this method of fabricating a line of reinforcement.

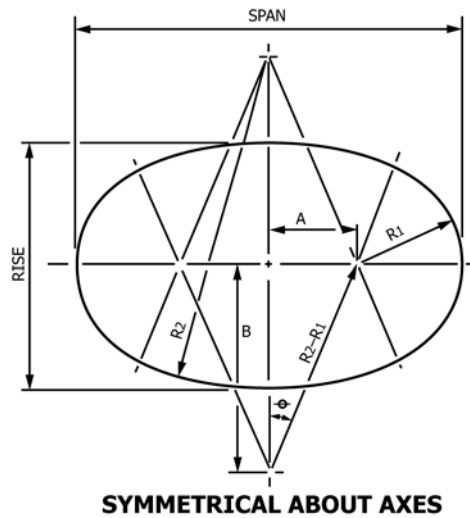
8.1.1 Where one line of reinforcement is used, it shall be placed so that the cover of the concrete over the circumferential reinforcement at the vertical and horizontal diameters of the pipe is 25 mm from the inside and outside surfaces of the pipe,



NOTE 1—The total reinforcement area of the inner cage plus the middle cage shall not be less than that specified for the inner cage in Table 2.

NOTE 2—The total reinforcement area of the outer cage plus the middle cage shall not be less than that specified for the outer cage in Table 2.

FIG. 4 Vertical Elliptical Pipe



SYMMETRICAL ABOUT AXES

Approximate Equivalent Round Size, mm	Full Flow Water Area, m ²	Rise, mm	Span, mm	A, mm	B, mm	R ₁ , mm	R ₂ , mm	θ degrees†
450	0.170	360	580	135	325	155	505	22.6
600	0.305	490	770	176	420	210	665	22.6
675	0.383	550	865	198	475	235	750	22.6
750	0.474	610	960	220	530	260	835	22.6
825	0.588	680	1065	243	580	290	920	22.6
900	0.684	730	1155	263	635	315	1000	22.6
975	0.816	800	1255	283	685	345	1085	22.6
1050	0.948	865	1355	308	733	370	1165	22.6
1200	1.20	970	1520	345	825	415	1310	22.6
1350	1.55	1105	1725	388	933	475	1485	22.6
1500	1.90	1225	1920	435	1143	525	1655	22.6
1650	2.30	1345	2110	475	1143	580	1815	22.6
1800	2.73	1470	2300	520	1245	630	1980	22.6
1950	3.21	1595	2490	560	1348	685	2145	22.6
2100	3.73	1715	2680	605	1448	735	2305	22.6
2250	4.28	1840	2870	645	1550	790	2470	22.6
2400	4.87	1960	3065	688	1655	845	2635	22.6
2550	5.49	2085	3250	730	1753	895	2795	22.6
2700	6.17	2210	3440	770	1850	950	2955	22.6
2850	6.87	2330	3635	813	1950	1005	3115	22.6
3000	7.63	2455	3825	858	2053	1055	3280	22.7
3300	9.22	2700	4205	938	2255	1165	3605	22.6
3600	11.0	2950	4590	1025	2460	1270	3935	22.6

†Editorially corrected.

NOTE 1—Rise, span, and radii are fixed; other dimensions and angles are calculated.

FIG. 5 Shape of Elliptical Pipe

except for wall thicknesses less than 62 mm, the protective cover of the concrete over the circumferential reinforcement in the wall of the pipe shall be 18 mm.

8.1.2 Where two lines of reinforcement of elliptical shape corresponding to the contour of the pipe are used, each line shall be so placed that the covering of concrete over the reinforcement is 25 mm.

8.1.3 The location of the reinforcement shall be subject to the permissible variations in dimensions given in 11.5. Requirements for placement and protective covering of the concrete from the inner or outer surface of the pipe do not apply to that portion of a cage which is flared so as to extend into the bell or reduced in diameter so as to extend into the spigot.

8.1.3.1 Where the wall reinforcement does not extend into the joint, the maximum longitudinal distance to the last circumferential from the inside shoulder of the bell or the shoulder of the spigot shall be 75 mm except that if this distance exceed one-half the wall thickness, the pipe wall shall contain at least a total reinforcement area of the minimum specified area per linear foot times the laying length of the pipe section. The minimum cover on the last circumferential near the spigot shoulder shall be 13 mm.

8.1.3.2 Where the reinforcement is in the bell or spigot the minimum end cover on the last circumferential shall be 13 mm in the bell or 6 mm in the spigot.

8.1.4 The spacing center to center of circumferential reinforcement in a cage shall not exceed 100 mm for pipe up to and including pipe having a 100-mm wall thickness nor exceed the wall thickness for larger pipe, and shall in no case exceed 150 mm.

8.1.5 The continuity of the circumferential reinforcing steel shall not be destroyed during the manufacture of the pipe, except that when agreed upon by the owner, lift eyes or holes may be provided in each pipe for the purpose of handling.

8.1.6 If 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 fabric are used without welding, the lap shall contain a longitudinal wire.

8.1.6.1 When splices are welded and are not lapped to the minimum requirements above, there shall be a minimum lap of 50 mm and a weld of sufficient length such that pull tests of representative specimens shall develop at least 50 % of the minimum specified tensile strength of the steel. For butt-welded splices in bars or wire, permitted only in helically wound cages, pull tests of representative specimens shall develop at least 75 % of the minimum specified tensile strength of the steel.

8.2 *Longitudinal Reinforcement*—Each line of circumferential reinforcement shall be assembled into a cage that shall contain sufficient longitudinal bars or members to maintain the reinforcement in shape and in position within the form to comply with permissible variations in 8.1. The exposure of the ends of longitudinals, stirrups, or spacers that have been used to position the cages during the placement of the concrete shall not be a cause for rejection.

8.3 *Joint Reinforcement*—In all pipe 900 mm or larger in diameter, either the bell or the spigot of the joint shall contain circumferential reinforcement.

8.3.1 For single-cage pipe, joint reinforcement shall be at least equal in area to that required for an equivalent length of pipe wall.

8.3.2 For double-cage and triple-cage pipe, joint reinforcement shall be at least equal in area to that required for an equivalent length of the outer circular cage if placed in the bell, or at least equal in area to that required for an equivalent length of the inner circular cage if placed in the spigot.

9. Joints

9.1 The joints shall be of such design and the ends of the concrete pipe sections so formed that the pipe can be laid together to make a continuous line of pipe compatible with the permissible variations given in Section 12.

9.2 Joints shall conform to the requirements of Specifications C443M, C990M, or other established joint types approved by the owner, including, but not limited to, mortar, sealant, or externally-wrapped joints.

10. Manufacture

10.1 *Mixture*—The aggregates shall be sized, graded, proportioned, and mixed with such proportions of cementitious materials, water, and admixtures, if any, to produce a thoroughly mixed concrete of such quality that the pipe will conform to the test and design requirements of this specification. All concrete shall have a water-cementitious materials ratio not exceeding 0.53 by weight. Cementitious materials shall be as specified in 6.2 and shall be added to the mix in a proportion not less than 280³ kg/m unless mix designs with a lower cementitious materials content demonstrate that the quality and performance of the pipe meet the requirements of this specification.

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

10.2 *Curing*—Pipe shall be subjected to any one of the methods of curing described in 10.2.1 to 10.2.4, or to any other method or combination of methods approved by the owner, that will give satisfactory results. The pipe shall be cured for a sufficient length of time so that the specified D-load is obtained when acceptance is based on 5.1.1 or so that the concrete will develop the specified compressive strength at 28 days or less when acceptance is based on 5.1.2.

10.2.1 *Steam Curing*—Pipe shall be placed in a curing chamber, free of outside drafts, and cured in a moist atmosphere maintained by the injection of live steam for such time and such temperature as needed to enable the pipe to meet the strength requirements. At no time shall the ambient temperature exceed 71°C. The curing chamber shall be so constructed as to allow full circulation around the inside and outside of the pipe.

10.2.2 *Water Curing*—Concrete pipe may be water-cured by covering with water-saturated material or by a system of perforated pipes, mechanical sprinklers, porous hose, or by any

other approved method that will keep the pipe moist during the specified curing period.

10.2.3 The manufacturer may at his option combine the methods described in 10.2.1 to 10.2.4, providing the required concrete compressive strength is attained.

10.2.4 A sealing membrane conforming to the requirements of Specification C309 may be applied and should be left intact until the required strength requirements are met. The concrete at the time of application shall be within 6°C of the atmosphere temperature. All surfaces shall be kept moist prior to the application of the compounds and shall be damp when the compound is applied.

11. Physical Requirements

11.1 *Test Specimens*—The specified number of pipe required for the tests shall be furnished without charge by the manufacturer, 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.

11.2 *Number and Type of Tests Required for Various Delivery Schedules:*

11.2.1 *Small Orders*—Small orders are those that consist of less than 100 pieces of each size and class of pipe. The owner of such an order shall be entitled to copies of test reports as are routinely performed on the particular lot, as required by the type and basis of acceptance specified by the owner in Section 5. A lot shall include up to five consecutive days of production, or 100 pieces, whichever is greater, provided the process and mix design is not altered in any way between production days.

11.2.2 *Large Orders*—For orders of 100 or more pieces of a size and class, the owner shall be entitled to tests per Section 5 on not more than one pipe per lot except where 11.2.3 and 11.2.4 are applicable.

11.2.3 *Tests for Extended Delivery Schedules for Large Orders*—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 required by the type of basis of acceptance specified by the owner in Section 5, of not more than three sections of pipe covering each size in which the owner is interested.

11.2.4 *Additional Tests for Extended Delivery Schedules*—An owner shall be entitled to additional tests at such times as the owner may deem necessary, provided the total number of pipe tested shall not exceed one pipe or 1 %, whichever is greater, of each size and class of pipe in the original order.

11.2.5 A purchaser who places orders of 50 or fewer pipe sections for a particular size and class shall be entitled to one test for each size and class.

11.3 *External Load Crushing Strength:*

11.3.1 The load required to produce a 0.3-mm crack or the ultimate load as determined by the three-edge-bearing method described in Test Methods C497M shall not be less than that prescribed in Table 1 and Table 2 for each respective class of pipe. Pipe that have been tested only to the formation of a 0.3-mm crack and that meet the 0.3-mm crack load requirements shall be accepted for use.

NOTE 2—As used in this specification, the 0.3-mm crack is a test criterion for pipe under load in a three-edge bearing test and is not intended as an indication of overstressed or failed pipe under installed conditions.

11.3.2 *Retests of Pipe not Meeting the External Load Crushing Strength Requirements*—Pipe shall be considered as meeting the strength requirements when all test specimens conform to the strength requirements. Should any of the test specimens fail to meet the strength requirements, the manufacturer shall be allowed a retest on two additional specimens for each specimen that failed, and the pipe shall be acceptable only when all of the retest specimens meet the strength requirements.

CONCRETE TESTING

11.4 *Type of Specimen*—Compression tests determining concrete compressive strength may be made on either standard rodded concrete cylinders or concrete cylinders compacted and cured in like manner as the pipe, or on cores drilled from the pipe.

11.5 *Compression Testing of Cylinders:*

11.5.1 *Cylinder Production*—Cylinders shall be prepared in accordance with Section 11 of Test Methods C497M.

11.5.2 *Number of Cylinders*—Prepare no fewer than five test cylinders from a group (one day's production) of pipe sections.

11.5.3 *Acceptability on the Basis of Cylinder Test Results:*

11.5.3.1 When the compressive strengths of all cylinders tested for a group are equal to or greater than the required concrete strength, the compressive strength of concrete in the group of pipe sections shall be accepted.

11.5.3.2 When the average compressive strength of all cylinders tested is equal to or greater than the required concrete strength, and not more than 10 % of the cylinder tested have a compressive strength less than the required concrete strength, and no cylinder tested has a compressive strength less than 80 % of the required concrete strength, then the group shall be accepted.

11.5.3.3 When the compressive strength of the cylinders tested does not conform to the acceptance criteria stated in 11.5.3.1 or 11.5.3.2, the acceptability of the group shall be determined in accordance with the provisions of 11.6.

11.6 *Compression Testing of Cores:*

11.6.1 *Obtaining Cores*—Cores shall be obtained and prepared in accordance with Section 6 of Test Methods C497M.

11.6.2 *Number of Cores*—One core shall be taken from a pipe section selected at random from each day's production run of a single concrete strength.

11.7 *Acceptability on the Basis of Core Test Results:*

11.7.1 When the compressive strength of a core tested for a group of pipe sections is equal to or greater than the required concrete strength, the compressive strength of the concrete for the group is acceptable.

11.7.2 If the compressive strength of the core tested is less than the required concrete strength, the pipe sections from which that core was taken may be recored. If the compressive strength of the recore is equal to or greater than the required

concrete compressive strength, the compressive strength of the concrete for the group is acceptable.

11.7.3 If the compressive strength of the recore is less than the required concrete strength, the pipe section from which the core was taken shall be rejected. Two pipe sections from the remainder of the group shall be selected at random and one core shall be taken from each pipe section. If the compressive strength of both cores is equal to or greater than the required concrete compressive strength, the concrete compressive strength of the remainder of the group shall be acceptable. If the compressive strength of either of the two cores tested is less than the required concrete compressive strength, then the remainder of the group shall be either rejected or, at the option of the manufacturer, each pipe section of the remainder shall be cored and accepted individually, and any of the pipe sections that have a core with less than the required concrete compressive strength shall be rejected.

11.8 *Plugging Core Holes*—Core holes shall be plugged and sealed by the manufacturer in a manner such that the pipe section will meet all of the requirements of this specification. Pipe sections so plugged and sealed shall be considered satisfactory for use.

11.9 *Absorption*—An annual absorption test shall be performed for each mix design for each production process. The absorption of a sample from the wall of the pipe, as determined in accordance with Test Methods C497M, shall not exceed 9 % of the dry mass for Method A or 8.5 % for Method B. Each Method A sample shall have a minimum mass of 1.0 kg, shall be free of visible cracks, and shall represent the full wall thickness of the pipe. When the initial absorption sample from a pipe fails to conform to this specification, the absorption test shall be made on another sample from the same pipe and the results of the retest shall be substituted for the original test results.

11.10 *Retests of Pipe*—When not more than 20 % of the concrete specimens fail to pass the requirements of this specification, the manufacturer may cull the project stock and may eliminate whatever quantity of pipe desired and shall mark those pipe so that they will not be shipped. The required tests shall be made on the balance of the order and the pipe shall be accepted if they conform to the requirements of this specification.

11.11 *Test Equipment*—Every manufacturer furnishing pipe under this specification shall furnish all facilities and personnel necessary to carry out the tests described in Test Methods C497M.

12. Permissible Variations

12.1 *Internal Dimensions*—The internal dimensions of the elliptical pipe shall not vary more than ± 2 % from the internal dimensions shown in Fig. 5. The variation shall normally be determined by measuring the major and minor axes of the pipe. Where measurements at other points are necessary, the lengths so measured shall not depart from those shown in Fig. 5 by more than ± 2 %.

12.2 *Wall Thickness*—The wall thickness shall not vary more than shown in the design or specified wall by more than

± 5 % or 5 mm, whichever is greater. A specified wall thickness that is more than required in the design is not cause for rejection. Pipe having localized variations in wall thickness exceeding those specified above shall be accepted if the three-edge-bearing strength and minimum steel cover requirements are met.

12.3 *Length of Two Opposite Sides*—Variations in the laying length of two opposite sides of the pipe shall not be more than 6 mm for all sizes through 600-mm internal equivalent diameter, and not more than 10 mm/m of internal equivalent diameter for all sizes larger with a maximum of 16 mm in any length of pipe through 2100-mm internal equivalent diameter, and a maximum of 19 mm for 2250-mm internal equivalent diameter or larger, except where beveled-end pipe for laying on curves is specified by the owner.

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

12.5 Position or Area of Reinforcement:

12.5.1 *Position*—The maximum variation in the position of a line of circumferential reinforcement shall be ± 10 % of the wall or ± 13 mm, whichever is the greater. Pipes having variations in the position of a line of circumferential reinforcement exceeding those specified above shall be accepted if the three-edge-bearing strength requirements obtained on a representative specimen are met. In no case, however, shall the cover over the circumferential reinforcement be less than 6 mm as measured to the end of the spigot or 13 mm as measured to any other surface. The preceding minimum cover limitation does not apply to the mating surfaces of the non-rubber gasket joints or gasket grooves in rubber gasket joints. If convoluted reinforcement is used, the convoluted circumferential end wire may be at the end surface of the joint, providing that alternative convolutions have at least 25 mm cover from the end surface of the joint.

12.5.2 *Area of Reinforcement*—Reinforcement will be considered as meeting the design requirements if the area, computed on the basis of nominal area of the wire or bars used, equals or exceeds the requirements of 7.2 or 7.3. Actual area of the reinforcing used may vary from the nominal area according to permissible variations of the standard specifications for the reinforcing.

13. Repairs

13.1 Pipe may be repaired, if necessary, because of imperfections in manufacture or damage during handling and will be acceptable if, in the opinion of the owner, the repaired pipe conforms to the requirements of this specification.

14. Inspection

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

15. Rejection

15.1 Pipe shall be subject to rejection on account of failure to conform to any of the specification requirements. Individual sections of pipe may be rejected because of the following:

15.1.1 Fractures or cracks passing through the wall, except for a single end crack that does not exceed the depth of the joint,

15.1.2 Defects that indicate mixing and molding, not in compliance with 10.1, or surface defects indicating honey-combed or open texture, that would adversely affect the function of the pipe,

15.1.3 The ends of the pipe are not normal to the walls and center line of the pipe within the limits of variations given in 12.3 and 12.4,

15.1.4 Damaged or cracked ends, where such damage would prevent making a satisfactory joint, and

15.1.5 Any continuous crack having a surface width of 0.3 mm or more and extending for a length of 300 mm or more, regardless of position in the wall of the pipe, for pipe not installed or under load. See Note 2.

16. Product Marking

16.1 The following information shall be legibly marked on each section of pipe:

16.1.1 Pipe class and specification designation,

16.1.2 Date of manufacture,

16.1.3 Name or trademark of the manufacturer, and

16.1.4 Identification of plant.

16.2 Pipe with quadrant reinforcement shall be marked with the letter “Q.”

16.3 Markings shall be indented on the pipe section or painted thereon with waterproof paint.

17. Keywords

17.1 culvert; D-load; elliptical pipe; reinforced concrete; sewer pipe; storm drain

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