



Designation: **A1078/A1078M—19 A1078/A1078M – 22**

Standard Specification for Epoxy-Coated Steel Dowels for Concrete Pavement¹

This standard is issued under the fixed designation A1078/A1078M; 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.

1. Scope*

1.1 This specification covers plain steel dowel bars with protective fusion-bonded epoxy coating for use in concrete pavements.

1.2 This specification is applicable for orders in either inch-pound units (as Specification A1078) or in SI units (as Specification A1078M).

1.3 The values stated in either inch-pound or SI units are to be regarded separately as standard. Within the text, the SI units are shown in brackets. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with this specification.

1.4 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

NOTE 1—The coating applicator is identified throughout this specification as the manufacturer.

1.5 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 ASTM Standards:²

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

A775/A775M Specification for Epoxy-Coated Steel Reinforcing Bars

A934/A934M Specification for Epoxy-Coated Prefabricated Steel Reinforcing Bars

A1055/A1055M Specification for Zinc and Epoxy Dual-Coated Steel Reinforcing Bars

D4417 Test Methods for Field Measurement of Surface Profile of Blast Cleaned Steel

2.2 Society for Protective Coatings Specifications:³

SSPC-PA 2 Measurement of Dry Coating Thickness with Magnetic Gauges

SSPC-SP 10 Near-White Blast Cleaning

SSPC-VIS 1 Pictorial Surface Preparation Standards for Painting Steel Surfaces

¹ This specification is under the jurisdiction of ASTM Committee A01 on Steel, Stainless Steel and Related Alloys and is the direct responsibility of Subcommittee A01.05 on Steel Reinforcement.

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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 Available from Society for Protective Coatings (SSPC), 40 24th St., 6th Floor, Pittsburgh, PA 15222-4656, http://www.sspc.org.

*A Summary of Changes section appears at the end of this standard

2.3 Concrete Reinforcing Steel Institute Documents:⁴

CRSI Voluntary Certification Program for Fusion Bonded Epoxy Coating Applicator Plants

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 *epoxy powder coating, n*—a fusion-bonded epoxy coating product containing pigments, thermosetting epoxy resins, cross-linking agents, and other additives, which is applied in the form of a powder onto a clean, heated metallic substrate and fuses to form a continuous barrier coating.

3.1.2 *final coat, n*—the last application of the Type 1 or Type 2 coating.

3.1.3 *holiday, n*—discontinuity in a coating that is not discernible to a person with normal or corrected vision.

3.1.4 *patching material, n*—liquid two-part epoxy coating used to repair damaged ~~or uncoated areas~~ coating and to coat uncoated areas on the surface of a coated bar.

3.1.5 *plain bar, n*—steel bar without protrusions.

3.1.6 *pretreatment, n*—a preparation of the blast-cleaned steel surface prior to coating application that is formulated to pre-treat the metal to promote coating adhesion, reduce metal/coating reactions, improve corrosion resistance, and increase blister resistance.

3.1.7 *Type 1 coating, n*—epoxy powder coating meeting Annex A1 of Specification **A775/A775M** or Annex A1 of Specification **A1055/A1055M**.

3.1.8 *Type 2 coating, n*—epoxy powder coating meeting Annex A1 of Specification **A934/A934M**.

4. Ordering Information

4.1 Orders for epoxy-coated steel dowels under this specification shall contain the following information:

4.1.1 Quantity of dowels,

4.1.2 Diameter of dowels (5.3),

4.1.3 Type of coating (5.5), and

4.1.4 ASTM designation A1078 [A1078M] and year of issue.

4.2 The purchaser shall have the option to specify additional requirements, including but not limited to the following:

4.2.1 Requirements for plain bars, if other than ASTM designation A615 [A615M] and year of issue (5.1),

4.2.2 Length of dowels, if other than 18 in. [460 mm] (5.4),

4.2.3 Grade of steel if other than Grade 60 [420] (5.1),

4.2.4 Test report for type of coating used, if desired (5.6),

4.2.5 Representative sample of epoxy coating powder (5.10),

4.2.6 Test report for review to confirm that the epoxy powder conforms to Annex A1 (5.5),

⁴ Available from Concrete Reinforcing Steel Institute (CRSI), 933 N. Plum Grove Rd., Schaumburg, IL 60173–4758, <http://www.crsi.org>.

- 4.2.7 Quantity of patching material (~~5.4~~5.11.4),
- 4.2.8 Requirements for patching (7.7),
- 4.2.9 Pretreatment of the abrasive blast-cleaned steel surface, if required (6.5),
- 4.2.10 Cutting of dowels with Type 2 coating, if permitted (7.6),
- 4.2.11 Thickness of coating on dowels, if other than 8 mils [200 µm] (8.1.1),
- 4.2.12 Place of testing, if other than manufacturer's plant (8.2.3),
- 4.2.13 Timing of holiday checks for Type 1 coatings, if other than before cutting (8.2.2),
- 4.2.14 Specific requirements for number of tests and frequency of tests (9.1),
- 4.2.15 Report on results of tests performed on the coated dowels being furnished (8.3.3),
- 4.2.16 Waive the requirement of patching of coated dowels prior to shipment (13.1),
- 4.2.17 Thickness of patching material, if other than as specified in ASTM designation A775 [A775M], A1055 [A1055M], or A934 [A934M] (13.3),
- 4.2.18 Requirements for inspection (12.1),
- 4.2.19 Manufacturer qualification and certification requirements,
- 4.2.20 Other special requirements, if any.

NOTE 2—It is recommended that the coating application procedures and processes be audited by an independent certification program for epoxy coating applicator plants such as that provided by the ~~CRSI Voluntary Certification Program~~, Concrete Reinforcing Steel Institute, or equivalent.

5. Materials

5.1 Dowels shall consist of plain bars. Unless otherwise specified, the bars shall be Grade 60 [420] and conform to Specification A615 [Specification A615M]. The bars shall be free of contaminants such as oil, grease, paint or chlorides.

5.2 Incoming steel bars found to be salt-contaminated shall be rejected.

5.3 Dowels shall be 1¼ in. [32 mm] or 1½ in. [38 mm] in diameter or as specified by the purchaser.

5.4 The coated dowels shall have an overall length of 18 in. [460 mm] or as specified by the purchaser.

5.5 The coating type shall be specified by the purchaser. Type 1 coatings shall be qualified in accordance with Annex A1 of Specification **A775/A775M** or Specification **A1055/A1055M**. Type 2 coatings shall be qualified in accordance with Annex A1 of Specification **A934/A934M**.

5.6 Upon request, the purchaser shall be provided with the test report for coatings used.

5.7 A written certification shall be furnished to the purchaser that properly identifies the designation of each lot of epoxy powder coating used in the order, material quantity represented, date of manufacture, name and address of the epoxy powder coating manufacturer, and a statement that the supplied powder coating is the same composition as that qualified in accordance with 5.5.

5.8 The powder coating shall be stored in a temperature-controlled environment following the documented recommendations of

the powder coating manufacturer until ready for use. At this point, if the storage temperature is below the plant ambient temperature, the powder coating shall be given sufficient time to reach a temperature that is within $\pm 5^{\circ}\text{F}$ [$\pm 2^{\circ}\text{C}$] $\pm 5^{\circ}\text{F}$ [$\pm 2^{\circ}\text{C}$] of the plant ambient temperature.

5.9 The powder coating shall be used within the powder coating manufacturer's written recommended shelf life.

5.10 If specified in the order, a representative 8 oz [0.2 kg] sample of the epoxy powder coating shall be supplied to the purchaser from each batch. The sample shall be packaged in an airtight container and identified by lot number.

~~5.11 If specified in the order, patching material, compatible with the coating, inert in concrete and recommended by the coating manufacturer shall be supplied to the purchaser.~~ Patching material for repairing damaged coating and for coating uncoated areas shall be inert in concrete, and feasible for repairs at the applicator plant or at the fabricating shop.

5.11.1 The powder coating manufacturer shall specify the approved patching material to be used with their powder.

5.11.2 Patching material shall be approved in accordance with Annex A2 of Specification [A775/A775M](#) prior to use.

5.11.3 The patching material manufacturer shall specify the method of metal surface preparation, and the procedures for application of the patching material.

5.11.4 If specified in the order, patching material shall be supplied to the purchaser.

6. Surface Preparation

6.1 Blast media found to be salt contaminated from exposure to deicing salt, salt spray or the manufacturing process, shall not be used.

6.2 The surface of the steel to be coated shall be cleaned by abrasive blast-cleaning to near-white metal in accordance with SSPC-SP 10. The final surface condition shall be defined according to SSPC-VIS 1.

6.3 Average blast profile maximum roughness depth readings of ~~1.5~~ 1.5 mils to 4.0 mils [~~40~~ 40 μm to 100 μm] as determined by the use of a profilometer type surface measurement instrument that measures the peak count as well as the maximum profile depth, according to Test Methods [D4417](#), Method B, or as determined by replica tape measurements using Test Methods [D4417](#), Method C, shall be considered suitable as an anchor pattern.

6.4 Multidirectional, high-pressure, dry air knives shall be used after blast cleaning to remove dust, grit, and other foreign matter from the steel surface. The air knives shall not deposit oil on the steel.

6.5 Pretreatment of the blast-cleaned steel shall be applied when specified by the purchaser. The pretreatment shall be applied after abrasive cleaning and before coating, in accordance with the written application instructions specified by the pretreatment manufacturer. If compatible with the epoxy powder coating, additional steel pretreatments prior to coating with the epoxy may be specified by the purchaser.

7. Coating Application

7.1 The epoxy powder coating shall be applied to the cleaned steel surface as soon as possible after steel surface treatments have been completed and before visible oxidation of the steel surface is discernible to a person with normal or corrected vision. In no case shall application of the coating be delayed more than 3 hours after cleaning.

7.2 The epoxy powder coating shall be applied in accordance with the written recommendations of the manufacturer of the powder coating for initial steel surface temperature range and post-application cure requirements.

7.3 During continuous operations, the temperature of the steel surface immediately prior to coating shall be measured using infrared guns or temperature-indicating crayons, or both, at least once every 30 minutes.

NOTE 3—The use of temperature-indicating crayons prior to coating and infrared guns after coating are recommended.

7.4 The coating shall be applied by electrostatic spray or other suitable method, in one or more coating applications.

7.5 It is permissible to saw-cut or shear dowels with Type 1 coating. The ends of the dowels shall be free of burrs and projections. Coated dowels shall not be flame cut.

7.6 Dowels with Type 2 coating shall not be cut after the final coating application unless permitted by the purchaser.

7.7 Unless otherwise specified, cut ends of coated dowels shall be coated with a minimum thickness of 5 mils [125 µm] of patching material meeting Specification **A775/A775M**, Annex A2, or Specification **A1055/A1055M** for Type 1 coatings; or Specification **A934/A934M** for Type 2 coatings.

7.8 Multiple applications of repair material shall be permitted.

8. Requirements For Coated Dowels

8.1 Coating Thickness:

8.1.1 The coating thickness after curing for Type 1 and Type 2 coatings shall be greater than 8 mils [200 µm] or as requested by the purchaser in the purchase order or contract.

8.1.2 A single recorded coating thickness measurement is the average of three individual gauge readings. A minimum of five recorded measurements shall be taken approximately evenly spaced along opposite sides of the test specimen (A minimum of 10 recorded measurements per test specimen). No individual gauge reading shall be taken closer than 0.5 in. [13 mm] of the dowel ends.

8.1.3 For acceptance purposes, the average of all coating thickness measurements shall not be less than the specified minimum thickness. No single coating thickness measurement shall be less than 80 % of the specified minimum thickness.

8.1.4 Measurements shall be made in accordance with SSPC-PA 2 following the instructions for calibration and use recommended by the thickness gauge manufacturer. Pull-off or fixed-probe gauges shall be used. Pencil-type pull-off gauges that require the operator to observe the reading at the instant the magnet is pulled from the surface shall not be used.

8.2 Coating Continuity:

8.2.1 There shall not be more than an average of one holiday per foot [three holidays per metre] on the coated dowel.

8.2.2 Holiday checks to determine conformance with **8.2.1** shall be made at the manufacturer's plant with a 67.5-V, 80 000-ohm, wet-sponge-type direct current holiday detector. For dowels that are cut after the coating application, coating continuity may be conducted prior to cutting, unless otherwise specified by the purchaser.

NOTE 4—Holiday detection is generally intended for in-process use, but can be used for outside testing for quality control purposes.

8.2.3 *Place of Testing*—Testing of coated dowels shall be done at the manufacturer's plant prior to shipment or as specified by the purchaser.

8.3 Coating Adhesion:

8.3.1 For Type 1 coatings, perform the cathodic disbondment test in accordance with Specification **A775/A775M** or Specification **A1055/A1055M**, Annex Section A1.3.2.

8.3.2 For Type 2 coatings, perform the cathodic disbondment test in accordance with Specification **A934/A934M**, Section 9.4.

NOTE 5—It is recommended that the manufacturer retain test specimens for 30 days of production and use a 30-day rolling average of coating disbondment test data as a basis for its statistical process control program for the steel dowel coating operation.