



Designation: C 935 – 80 (Reapproved 1995)

AMERICAN SOCIETY FOR TESTING AND MATERIALS
100 Barr Harbor Dr., West Conshohocken, PA 19428
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Standard Specification for General Requirements for Prestressed Concrete Poles Statically Cast¹

This standard is issued under the fixed designation C 935; 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 general requirements for prestressed concrete poles statically cast for use as structural supports for lights, distribution, transmission, and dead end poles.

1.2 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.

2. Referenced Documents

2.1 ASTM Standards:

- A 36/A36M Specification for Structural Steel²
- A 82 Specification for Steel Wire, Plain, for Concrete Reinforcement²
- A 370 Test Methods and Definitions for Mechanical Testing of Steel Products³
- A 416/A416M Specification for Steel Strand Uncoated Seven-Wire for Prestressed Concrete²
- A 421 Specification for Uncoated Stress-Relieved Steel Wire for Prestressed Concrete²
- A 586 Specification for Zinc-Coated Parallel and Helical Steel Wire Structural Strand⁴
- A 615/A615M Specification for Deformed and Plain Billet-Steel Bars for Concrete Reinforcement²
- A 722 Specification for Uncoated High-Strength Steel Bar for Prestressing Concrete²
- C 31 Practice for Making and Curing Concrete Test Specimens in the Field⁵
- C 33 Specification for Concrete Aggregates⁵
- C 39 Test Method for Compressive Strength of Cylindrical Concrete Specimens⁵
- C 42 Test Method for Obtaining and Testing Drilled Cores and Sawed Beams of Concrete⁵
- C 94 Specification for Ready-Mixed Concrete⁵
- C 150 Specification for Portland Cement⁶

¹ This specification is under the jurisdiction of ASTM Committee C-27 on Precast Concrete Products and is the direct responsibility of Subcommittee C27.20 on Architectural and Structural Products.

Current edition approved Nov. 6, 1980. Published January 1981.

² *Annual Book of ASTM Standards*, Vol 01.04.

³ *Annual Book of ASTM Standards*, Vol 01.03.

⁴ *Annual Book of ASTM Standards*, Vol 01.06.

⁵ *Annual Book of ASTM Standards*, Vol 04.02.

⁶ *Annual Book of ASTM Standards*, Vol 04.01.

- C 172 Practice for Sampling Freshly Mixed Concrete⁵
- C 173 Test Method for Air Content of Freshly Mixed Concrete by the Volumetric Method⁵
- C 231 Test Method for Air Content of Freshly Mixed Concrete by the Pressure Method⁵
- C 260 Specification for Air-Entraining Admixtures for Concrete⁵
- C 309 Specification for Liquid Membrane-Forming Compounds for Curing Concrete⁵
- C 330 Specification for Lightweight Aggregates for Structural Concrete⁵
- C 403 Test Method for Time of Setting of Concrete Mixtures by Penetration Resistance⁵
- C 494 Specification for Chemical Admixtures for Concrete⁵
- C 595/C595M Specification for Blended Hydraulic Cements⁶
- C 618 Specification for Fly Ash and Raw or Calcined Natural Pozzolan for Use as a Mineral Admixture in Portland Cement Concrete⁵

3. Basis of Acceptance

3.1 Acceptability of prestressed concrete poles produced in accordance with this specification shall be determined by the results of compressive strength tests of concrete cylinders and mill certificates for the reinforcing steel. A written statement, signed by the manufacturer, shall verify that the cement, aggregates, admixtures, and steel conform to the applicable specifications for the material and that the preparation of equipment, mixing, conveying, placing, consolidation, and curing conforms to the requirements of the applicable standard specifications. Concrete strength shall be determined by the compressive strength tests of cylinders. The manufacturer's statement shall also certify adherence to tolerance on dimensions. Acceptability of the concrete strength of completed prestressed concrete poles may also be determined by compression tests of concrete cores in accordance with Test Method C 42.

4. Materials

4.1 *Cement*—Portland cement shall conform to the requirements of Specification C 150 or shall be blended hydraulic cement conforming to the requirements of Types IS or IP Specification C 595.

4.2 *Aggregate*—The concrete shall be made with fine and coarse aggregates that conform to Specification C 33 or C 330.

The nominal maximum size of the coarse aggregate shall not exceed $\frac{1}{5}$ the minimum dimension of the member or $\frac{3}{4}$ of either the clear spacing between the reinforcing steel or the clear cover.

4.3 *Water*—Water used for curing, for washing aggregates, and for mixing concrete shall be free of oils, organic materials, and other substances in amounts that may be deleterious to concrete or steel, and it shall not contain concentrations of chloride ions in excess of 500 parts per million or sulfate ions in excess of 1000 parts per million.

4.4 *Admixtures*—Air-entraining admixtures shall conform to Specification C 260. Chemical admixtures shall conform to Specification C 494. Fly ash or other pozzolanic admixtures shall conform to the requirements of Specification C 618. Admixtures shall not contain chloride ions in quantities that will cause the total chloride content of the concrete to exceed 0.06 %.

4.5 *Steel*—Prestressing steel shall conform to Specifications A 416, A 421, A 586, or A 722. Auxiliary nontensioned reinforcement shall conform to Specification A 82 or A 615/A 615M. Base plates, anchor bolts, and top mount couplings shall conform to ASTM specifications designated on contract drawings.

5. Requirements

5.1 Poles shall be designed to carry all forces associated with prestressing, handling, storage, installation, loading, and other service conditions. Consideration shall be given to the level of prestress forces both before and after losses.

5.2 *Concrete*—Concrete shall have a minimum design compressive strength of 5000 psi (37.5 MPa) at 28 days.

5.3 *Concrete Cover*—The minimum concrete cover over the reinforcement shall be 1 in. (25 mm). Ends of prestressed steel shall be recessed $\frac{1}{4}$ in. (6 mm) and shall be covered with a suitable waterproofing product.

5.4 *Air Entrainment*—Unless otherwise specified by the purchaser, all concrete shall have an air content of 5 % plus or minus 1 % as measured by Test Method C 173 or C 231.

5.5 *Lifting Devices*—Flush inserts may be cast into the pole at locations agreeable to the purchaser. Removable attachments may utilize the flush inserts to provide for lifting of the pole. Steel strand loops may be used instead of flush inserts for lifting. The loops shall be installed with a recess in the pole the depth of the required minimum concrete cover over the reinforcement, and a diameter no less than $1\frac{1}{4}$ in. (32 mm). Steel strand lifting loops shall be removed flush to the concrete in the recess. The recess shall be filled and sealed with epoxy-based grout and the pole surface shall be troweled to match the finish. All repair work involved with the loops shall be completed before delivery.

5.6 *Grounding*—In order to provide good electrical continuity, the spiral steel shall be securely tied to each reinforcing steel member it contacts within 1 ft (0.3 m) of the top and the butt of the pole. An embedded ground wire or provisions to attach a ground wire to the surface of the pole may be specified. The embedded ground wire shall be copper and not smaller than No. 6 AWG (4 mm). It shall be bonded with a suitable electrical connector to the reinforcing steel within 2 ft (0.6 m) of both the top and butt of the pole. Grounding pigtail

wire of soft-drawn stranded copper, not smaller than No. 6 AWG (4 mm), shall be bonded with a suitable compression or mechanical connector to the embedded ground wire, and shall extend from the pole surface 4 ± 1 in. (100 ± 30 mm). Unless otherwise specified, grounding pigtails shall be located 3 ft (0.9 m) from the top and 4 ft (1.2 m) from the butt. Provisions to attach a ground wire to the surface of the pole must be specified by the purchaser. The type of fastener or provisions for fastening to be supplied by the pole manufacturer, the location, the spacing, and any electrical connection to the reinforcing steel must be covered in the purchaser's specifications.

6. Manufacture

6.1 *Mixture*—The aggregates shall be sized, graded, proportioned, and thoroughly mixed with proportions of cement and water that will produce a concrete mixture of quality such that the poles will conform to the test and design requirements of this specification. Concrete conforming to Specification C 94 may be used.

6.2 *Placing*—Concrete should be placed in the forms as nearly as possible in its final position. Special care should be taken to fill all parts of the forms, and to place concrete under and around all reinforcing steel. Reinforcement shall be adequately secured so as to remain in the proper position during the placing of the concrete. Tie wires, if used to fasten the reinforcing steel, shall be bent down to provide the maximum protective cover of concrete over the wires.

6.3 *Curing*—Poles shall be cured by one of the following methods or combination thereof. They shall be cured so that the concrete will develop the required compressive strength. The temperature of the concrete shall not exceed 100°F (38°C) nor drop below 40°F (4°C) for a minimum of 1 h after placing regardless of the curing option selected.

6.3.1 *Accelerated Curing*—Poles may be cured with either steam or radiant heat in a moist environment.

6.3.2 *Water Curing*—Poles may be water-cured by covering with water-saturated material or by a system of perforated pipes.

6.3.3 *Membrane Curing*—A curing compound conforming to the requirements of Specification C 309 may be applied and should be left intact until strength requirements are met. The concrete at the time of application shall be within 10°F (6°C) of the ambient air temperature. All surfaces shall be kept moist prior to the application of the compounds and shall be damp when the compound is applied.

6.3.4 *Steam Curing*—Steam chamber shall be so constructed to retain the live steam, to minimize moisture and heat losses, to allow free air circulation of the steam around the pole. The steam jets shall be positioned so they do not discharge directly on the forms or test cylinders. The cycle of steam curing shall conform to the following:

6.3.4.1 After placing and vibration, the concrete shall be allowed to attain an initial set (approximately 500 psi (3.5 MPa), determined by Test Method C 403) before starting to raise the temperature of concrete with the steam. If the ambient temperature is below 50°F (10°C) enough heat shall be applied to maintain the concrete at its placing temperature.

6.3.4.2 The temperature rise in the curing enclosure shall be uniform with a rate of rise between 30°F (17°C) and 60°F