



Designation: C1504M – 15^{ε1}

Standard Specification for Manufacture of Precast Reinforced Concrete Three-Sided Structures for Culverts and Storm Drains (Metric)¹

This standard is issued under the fixed designation C1504M; 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.

^{ε1} NOTE—Editorial correction was made in April 2015.

1. Scope

1.1 This specification covers single-cell precast conventionally reinforced concrete three-sided structures intended to be used for the construction of culverts and for the conveyance of storm water.

1.2 This specification is the metric counterpart of Specification C1504; therefore, no imperial (metric) equivalents are presented in this specification.

NOTE 1—This specification is primarily a manufacturing and purchasing specification. The successful performance of this product depends upon the proper selection of the geometric section, bedding, backfill, and care that the installation conforms to the construction specifications. The purchaser of the precast reinforced concrete three-sided structure specified herein is cautioned that proper correlation of the loading conditions and the field requirements with the geometric section specified and provisions for inspection at the construction site are required.

1.3 The values stated in either SI units or inch-pound units are to be regarded separately as standard. 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 the standard.

2. Referenced Documents

2.1 *ASTM Standards*:²

[A1064/A1064M Specification for Carbon-Steel Wire and Welded Wire Reinforcement, Plain and Deformed, for Concrete](#)

[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](#)
[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/C260M Specification for Air-Entraining Admixtures for Concrete](#)
[C309 Specification for Liquid Membrane-Forming Compounds for Curing Concrete](#)
[C494/C494M Specification for Chemical Admixtures for 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](#)
[C989 Specification for Slag Cement for Use in Concrete and Mortars](#)
[C1116 Specification for Fiber-Reinforced Concrete and Shotcrete](#)
[C1602/C1602M Specification for Mixing Water Used in the Production of Hydraulic Cement Concrete](#)

2.2 *AASHTO Standard*:

[AASHTO LRFD Bridge Design Specifications](#)³

2.3 *ACI Standard*:

[ACI 318 Building Code Requirements for Structural Concrete and Commentary](#)⁴

3. Terminology

3.1 *Definitions*—For definitions of terms, see Terminology C822.

¹ This specification is under the jurisdiction of ASTM Committee C13 on Concrete Pipe and is the direct responsibility of Subcommittee C13.07 on Acceptance Specifications and Precast Concrete Box Sections.

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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 American Association of State Highway and Transportation Officials (AASHTO), 444 N. Capitol St., NW, Suite 249, Washington, DC 20001, <http://www.transportation.org>.

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

4. Types

4.1 Precast reinforced concrete three-sided structures manufactured in accordance with this specification shall be designated by span, rise, and design earth cover.

5. Basis of Acceptance

5.1 Acceptability of the three-sided sections produced in accordance with Section 7 shall be determined by the results of the concrete compressive strength tests described in Section 10, by the material requirements described in Section 6, and by inspection of the finished three-sided sections.

5.2 Three-sided sections shall be considered ready for acceptance when they conform to the requirements of this specification.

6. Materials

6.1 *Reinforced Concrete*—The reinforced concrete shall consist of cementitious materials, mineral aggregates 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 or shall be portland blast-furnace slag cement or portland-pozzolan cement conforming to the requirements of Specification C595, except that the pozzolan constituent in the Type IP portland pozzolan cement shall be fly ash.

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

6.2.3 *Ground Granulated Blast-Furnace Slag (GGBFS)*—GGBFS shall conform to the requirements of Grade 100 or 120 of Specification C989.

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

- (1) Portland cement only,
- (2) Portland blast-furnace slag cement only,
- (3) Portland pozzolan cement only,
- (4) A combination of portland cement and fly ash,
- (5) A combination of portland cement and ground granulated blast-furnace slag,
- (6) A combination of portland cement, ground granulated blast furnace slag, and fly ash.
- (7) A combination of portland pozzolan cement and fly ash.

6.3 *Aggregates*—Aggregates shall conform to Specification C33, except that the requirements for gradation shall not apply.

6.4 *Admixtures and Blends*—Admixtures and blends shall conform to Specification C494/C494M.

6.4.1 *Air Entraining Admixtures*—Air entraining will be required on all products produced with positive slump, wet-cast concrete, and shall conform to the requirements of Specification C260/C260M.

6.5 *Steel Reinforcement*—Reinforcement shall consist of welded wire reinforcement conforming to Specification A1064/A1064M for steel wire and welded wire reinforcement, plain and deformed, for concrete. For circumferential

reinforcement, deformed and plain steel bars for reinforced concrete are permitted conforming to Specification A706/A706M or A615/A615M, Grade 420, and longitudinal distribution reinforcement shall consist of welded wire reinforcement or deformed billet-steel bars conforming to Specification A706/A706M or A615/A615M, Grade 420.

NOTE 2—This specification does not address reinforcement with prestressing strand or any other form of pre-tensioning or post-tensioning.

6.6 *Synthetic Fibers*—Collated fibrillated virgin polypropylene fibers may be used, at the manufacturer's option, in three-sided structures as a nonstructural manufacturing material. Only type III synthetic fibers designed and manufactured specifically for use in concrete and conforming to the requirements of Specification C1116 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 *Design Criteria*—The three-sided section's dimensions and reinforcement details shall be as required by design, in accordance with Section 3, 5, and 12.14 of the American Association of State Highways and Transportation Officials (AASHTO) LRFD Bridge Design Specifications. The minimum concrete compressive strength shall be 35 MPa, and the minimum steel yield strength shall be 450 MPa for welded-wire reinforcement and 420 MPa for deformed billet-steel bars.

7.2 *Placement of Reinforcement*—The minimum cover of concrete over the circumferential reinforcing diameter shall be 25 mm for bar reinforcement and welded wire reinforcement for all structures up to 3.6 m in span and 38 mm for longer spans subject to provisions of Section 11 for both bar reinforcement and welded wire reinforcement. The clear distance of the end circumferential wires shall be not less than 13 mm nor more than 50 mm from the ends of each section. For three-sided sections covered by less than 0.6 m of fill, minimum cover for the reinforcement in the top of the top slab shall be 50 mm, subject to the provisions of Section 11. Reinforcement shall be assembled utilizing any combination of single or multiple layers of welded-wire reinforcement, not to exceed three layers or utilizing single or multiple layers of deformed billet steel bars, not to exceed two layers. The welded-wire reinforcement on 7.3 shall be composed of circumferential and longitudinal wires meeting the spacing requirements of 7.3 and shall contain sufficient longitudinal wires extending through the three-sided section to maintain the shape and position of reinforcement. Longitudinal distribution reinforcement may be welded-wire reinforcement or deformed billet-steel bars and shall meet the spacing requirements of 7.3. The ends of the longitudinal distribution reinforcement shall not be more than 50 mm from the ends of a three-sided section. The exposure of the ends of longitudinals, stirrups, and spacers used to position the reinforcement shall not be a cause for rejection.

7.3 *Laps, Welds, and Spacing*—Splices in the circumferential reinforcement shall be made by lapping. For welded wire reinforcement, the overlap measured between the outermost