

If additional mixing water is required to maintain the specified slump and is added with the permission of the Engineer, a minimum of 20 revolutions of the transit mixer drum at mixing speed shall be required before discharge of any concrete. At no time shall the total water introduced into any mix exceed the maximum W/CM ratio specified in Table 1.

Upon discharge of the concrete from the drum, a sufficient amount of water shall be charged into the drum to properly cleanse the drum. This water shall not be used as a part of the next succeeding batch but shall be discharged from the drum prior to the charging of the drum with the concrete ingredients. The drum shall be completely emptied before receiving materials for the succeeding batch. Re-tempering of concrete or mortar that has partially hardened, by remixing with or without additional materials, shall not be permitted.

6. **FIELD TESTS.** The Contractor shall provide assistance, equipment, materials, and curing for field sampling and testing as required by the Engineer. All costs shall be included in the Contract unit prices under Section 631. The Engineer shall perform all acceptance sampling and testing in accordance with the Agency's Quality Assurance Program. **All testing performed shall be in accordance with the requirements given in the current edition of the VTrans *Materials Sampling Manual for the HPC Structural Concrete section*.** For bridge deck pours, and other pours as required by the Engineer, the Contractor shall perform all on-site Quality Control (QC) sampling and testing. The person performing the QC sampling and testing shall have, as a minimum, current ACI Concrete Field Testing Technician Grade I Certification.

(a) **Trial Pour.** When concrete will be used for a deck or overlay, or when deemed necessary by the Engineer, the Contractor shall construct a slab to be used for the trial pour. The purpose of the trial pour is to ensure that the mix can be placed and finished in accordance with these specifications. The slab shall be a minimum of 10 feet × 10 feet × 9 inches thick.

If the concrete is intended to be placed by pump, the trial pour concrete shall be placed by pump. The pump will be setup in the configuration that best represents the most difficult pumping condition. The wet concrete properties will be checked at the point of placement. The Contractor will demonstrate that they can provide an acceptable finish to the concrete for the element to be completed. The Contractor will need to bull float a minimum of 50% of the surface area of the slab and hand finish the curb areas in the same manner as anticipated during the production pour.

The Contractor may elect to construct the slab so that the same screed equipment and same finishing method can be used as anticipated for the production pour. In this case the Contractor will not be required to bull float a minimum percentage of surface area unless that will be included in their process for finishing the concrete deck surface during the deck pour. The test slab will become the property of the Contractor and removed from the project after completion of the trial pour.

- Concrete production activities shall be closely monitored to ensure that no deviations are made from the approved mix design. If test results indicate a failure to obtain the characteristics as specified in Table 1, the Engineer may reject the material. The Contractor will be responsible for proposing solutions which could include changes to the mix design. The modified mix design shall not be used until successful test results are obtained during a trial pour that is representative of the anticipated pour conditions.
- (b) Sampling. Sampling for tests shall be taken in accordance with the requirements of *AASHTO R 60* or other procedures approved by the Agency. Sampling will be done at point of placement or as close to it as practical.
- (1) Changes. Any time that there is a change in admixture dosage outside of the allowable tolerances, whether modified at the batch plant or at the site, additional QC sampling and testing shall be performed on the modified load prior to incorporating the concrete into the work.
- (2) Beginning of Load Sampling. Beginning of Load Sampling is sampling for QC testing purposes that is taken before 15% of the load has been discharged. Beginning of Load Sampling shall be performed as required by the Engineer, or as needed to ensure that the Concrete meets the Contract requirements at the point of placement. The QC personnel shall monitor the placement operation and adjust the mix accordingly to ensure that the material being incorporated into the work meets Contract requirements.
- (c) Slump Tests. ~~Slump tests shall be made in accordance with *AASHTO T 119 M/T 119*.~~
- (d) Air Content Tests. Air content tests shall be made in accordance with the pressure method specified in *AASHTO T 152*, for acceptance or rejection.
- (e) Compressive Strength Tests.
- (1) General. The number of compressive strength tests performed should be in accordance with the guidance given in the current edition of the *VTrans Materials Sampling Manual*. The Engineer may order additional tests as deemed necessary.
- Compressive test cylinders shall be made in accordance with the requirements of *AASHTO T 23*, and tested for compressive strength in accordance with the requirements of *AASHTO T 22*.