

## SECTION 03450 - ARCHITECTURAL PRECAST CONCRETE

## PART 1 - GENERAL

## 1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 1 Specifications, apply to this Section.

## 1.2 SUMMARY

- 1. Precast architectural concrete linear lintel units, window sills, and horizontal accent bands and square medallions.
- B. Related Sections include the following:
  - 1. Division 4 Section "Unit Masonry Assemblies" for full-size brick facing, mortar, and anchorages.
  - 2. Division 7 Section "Sheet Metal Flashing and Trim" for flashing receivers and reglets.
  - 3. Division 7 Section "Joint Sealants" for elastomeric joint sealants and sealant backings.

## 1.3 DEFINITION

- A. Design Reference Sample: Sample of approved architectural precast concrete color, finish and texture, preapproved by Architect.

## 1.4 PERFORMANCE REQUIREMENTS

- A. Structural Performance: Provide architectural precast concrete units and connections capable of withstanding the following design loads within limits and under conditions indicated:
  - 1. Loads: Requested to support brick above.

## 1.5 SUBMITTALS

- A. Product Data: For each type of product indicated.
- B. Design Mixtures: For each precast concrete mixture. Include compressive strength and water-absorption tests.
- C. Shop Drawings: Detail fabrication and installation of architectural precast concrete units. Indicate locations, plans, elevations, dimensions, shapes, and cross sections of each unit. Indicate joints, reveals, extent and location of each surface finish, and types of reinforcement, including special reinforcement. Indicate details at building corners.

1. Indicate welded connections by AWS standard symbols. Detail loose and cast-in hardware, inserts, connections, and joints, including accessories.
  2. Indicate locations and details of anchorage devices to be embedded in other construction.
  3. Comprehensive engineering analysis [**signed and sealed**] [**certified**] by the qualified professional engineer responsible for its preparation. Show governing panel types, connections, and types of reinforcement, including special reinforcement. Indicate location, type, magnitude, and direction of loads imposed on the building structural frame from architectural precast concrete.
- D. Samples: For each type of finish indicated on exposed surfaces of architectural precast concrete units, in sets of 3, illustrating full range of finish, color, and texture variations expected; approximately 12 by 12 by 2 inches.
- E. Welding certificates.
- F. Material test reports: For aggregates.
- G. Material Certificates: Signed by manufacturers:
- H. Field quality-control test reports.

#### 1.6 QUALITY ASSURANCE

- A. Installer Qualifications: An experienced installer who has completed precast architectural concrete work in similar material, and extent to that indicated for this Project and whose work has resulted in construction with a record of successful inservice performance.
- B. Fabricator Qualifications: A firm that assumes responsibility for engineering architectural precast concrete units to comply with performance requirements. This responsibility includes preparation of Shop Drawings and comprehensive engineering analysis by a qualified professional engineer.
1. Participates in PCI's plant certification program and is designated a PCI-certified plant for Group A, Category A1 - Architectural Cladding and Load Bearing Units.
- C. Design Standards: Comply with ACI 318 and design recommendations of PCI MNL 120, "PCI Design Handbook - Precast and Prestressed Concrete," applicable to types of architectural precast concrete units indicated.
- D. Quality-Control Standard: For manufacturing procedures and testing requirements, quality-control recommendations, and dimensional tolerances for types of units required, comply with PCI MNL 117, "Manual for Quality Control for Plants and Production of Architectural Precast Concrete Products."
- E. Welding: Qualify procedures and personnel according to AWS D1.1/D.1.1M, "Structural Welding Code - Steel"; and AWS D1.4, "Structural Welding Code - Reinforcing Steel."
- F. Sample Panels: After sample approval and before fabricating architectural precast concrete units, produce a minimum of 1 sample panel approximately 18 sq. ft. in area for review by

Architect. Incorporate full-scale details of architectural features, finishes, textures, and transitions in sample panels.

## PART 2 - PRODUCTS

### 2.1 REINFORCING MATERIALS

- A. Reinforcing Bars: ASTM A 615/A 615M, Grade 60, deformed.
- B. Low-Alloy-Steel Reinforcing Bars: ASTM A 706/A 706M, deformed.
- C. Plain-Steel Welded Wire Reinforcement: ASTM A 185, fabricated from galvanized steel wire into flat sheets.
- D. Deformed-Steel Welded Wire Reinforcement: ASTM A 497/A 497M, flat sheet.
- E. Supports: Suspend reinforcement from back of mold or use bolsters, chairs, spacers, and other devices for spacing, supporting, and fastening reinforcing bars and welded wire reinforcement in place according to PCI MNL 117.
- F. Prestressing Strand: ASTM A 416/A 416M, Grade 270, uncoated, 7-wire, low-relaxation strand.
  - 1. Coat unbonded post-tensioning strand with corrosion inhibitor passing ASTM D 1743 and sheath with polypropylene tendon sheathing. Include anchorage devices and coupler assemblies.

### 2.2 CONCRETE MATERIALS

- A. Portland Cement: ASTM C 150, Type I or Type III, gray, unless otherwise indicated.
  - 1. For surfaces exposed to view in finished structure, mix gray with white cement, of same type, brand, and mill source.
- B. Supplementary Cementitious Materials:
  - 1. Fly Ash: ASTM C 618, Class C or F, with maximum loss on ignition of 3 percent.
  - 2. Metakaolin Admixture: ASTM C 618, Class N.
  - 3. Silica Fume Admixture: ASTM C 1240, with optional chemical and physical requirement.
  - 4. Ground Granulated Blast-Furnace Slag: ASTM C 989, Grade 100 or 120.
- C. Normal-Weight Aggregates: Except as modified by PCI MNL 117, ASTM C 33, with coarse aggregates complying with Class 5S. Stockpile fine and coarse aggregates for each type of exposed finish from a single source (pit or quarry) for Project.
  - 1. Face-Mixture-Fine Aggregates: Selected, natural or manufactured sand of same material as coarse aggregate, unless otherwise approved by Architect.

- D. Coloring Admixture: ASTM C 979, synthetic or natural mineral-oxide pigments or colored water-reducing admixtures, temperature stable, and nonfading.
- E. Air-Entraining Admixture: ASTM C 260, certified by manufacturer to be compatible with other required admixtures.
- F. Chemical Admixtures: Certified by manufacturer to be compatible with other admixtures and to not contain calcium chloride, or more than 0.15 percent chloride ions or other salts by weight of admixture.

### 2.3 STEEL CONNECTION MATERIALS

- A. Carbon-Steel Shapes and Plates: ASTM A 36/A 36M.
- B. Carbon-Steel Plate: ASTM A 283/A 283M.  
  
Malleable Iron Castings: ASTM A 47/A 47M.  
  
Carbon-Steel Castings: ASTM A 27/A 27M, Grade 60-30.  
  
High-Strength, Low-Alloy Structural Steel: ASTM A 572/A 572M.  
  
Carbon-Steel Structural Tubing: ASTM A 500, Grade B.  
  
Wrought Carbon-Steel Bars: ASTM A 675/A 675M, Grade 65.  
  
Deformed-Steel Wire or Bar Anchors: ASTM A 496 or ASTM A 706/A 706M.
- C. Zinc-Coated Finish: For exterior steel items, steel in exterior walls, and items indicated for galvanizing, apply zinc coating by hot-dip process according to ASTM A 123/A 123M or ASTM A 153/A 153M.
  - 1. Galvanizing Repair Paint: High-zinc-dust-content paint with dry film containing not less than 94 percent zinc dust by weight, and complying with DOD-P-21035A or SSPC-Paint 20.
- D. Welding Electrodes: Comply with AWS standards.

### 2.4 BEARING PADS

- A. Provide bearing pads for precast architectural concrete units as follows:
  - 1. Elastomeric Pads: AASHTO M 251, plain, vulcanized, 100 percent polychloroprene (neoprene) elastomer, molded to size or cut from a molded sheet, 50 to 70 Shore A durometer, minimum strength 2250 psi per ASTM D 412.

## 2.5 GROUT MATERIALS

- A. Nonmetallic, Nonshrink Grout: Premixed, nonmetallic, noncorrosive, nonstaining grout containing selected silica sands, portland cement, shrinkage-compensating agents, plasticizing and water-reducing agents, complying with ASTM C 1107, Grade A for drypack and Grades B and C for flowable grout and of consistency suitable for application within a 30-minute working time.

## 2.6 CONCRETE MIXTURES

- A. Prepare design mixtures for each type of precast concrete required.
  - 1. Limit use of fly ash and silica fume to 20 percent of portland cement by weight; limit metakaolin and silica fume to 10 percent of portland cement by weight.
- B. Design mixtures may be prepared by a qualified independent testing agency or by qualified precast plant personnel at architectural precast concrete fabricator's option.
- C. Limit water-soluble chloride ions to maximum percentage by weight of cement permitted by ACI 318 or PCI MNL 117 when tested according to ASTM C 1218/C 1218M.
- D. Normal-Weight Concrete Mixtures: Proportion mixtures by either laboratory trial batch or field test data methods according to ACI 211.1, with materials to be used on Project, to provide normal-weight concrete with the following properties:
  - 1. Compressive Strength (28 Days): 5000 psi minimum.
- E. Water Absorption: 6 percent by weight or 14 percent by volume, tested according to PCI MNL 117.
- F. Add air-entraining admixture at manufacturer's prescribed rate to result in concrete at point of placement having an air content complying with PCI MNL 117.
- G. When included in design mixtures, add other admixtures to concrete mixtures according to manufacturer's written instructions.

## 2.7 FABRICATION

- A. Cast-in Anchors, Inserts, Plates, Angles, and Other Anchorage Hardware: Fabricate anchorage hardware with sufficient anchorage and embedment to comply with design requirements. Accurately position for attachment of loose hardware, and secure in place during precasting operations. Locate anchorage hardware where it does not affect position of main reinforcement or concrete placement.
- B. Furnish loose hardware items including steel plates, clip angles, seat angles, anchors, dowels, cramps, hangers, and other hardware shapes for securing architectural precast concrete units to supporting and adjacent construction.
- C. Cast-in reglets, slots, holes, and other accessories in architectural precast concrete units as indicated on the Contract Drawings.

- D. Reinforcement: Comply with recommendations in PCI MNL 117 for fabricating, placing, and supporting reinforcement.
  - 1. Clean reinforcement of loose rust and mill scale, earth, and other materials that reduce or destroy the bond with concrete.
  - 2. Accurately position, support, and secure reinforcement against displacement during concrete-placement and consolidation operations. Completely conceal support devices to prevent exposure on finished surfaces.
  - 3. Place reinforcement to maintain at least 3/4-inch minimum coverage. Arrange, space and securely tie bars and bar supports to hold reinforcement in position while placing concrete. Direct wire tie ends away from finished, exposed concrete surfaces.
  - 4. Install welded wire fabric in the lengths as long as practicable. Lap adjoining pieces at least one full mesh and lace splices with wire. Offset laps of adjoining widths to prevent continuous laps in either direction.
- E. Reinforce architectural precast concrete units to resist handling, transportation, and erection stresses.
- F. Prestress tendons for architectural precast concrete units by either pretensioning or post-tensioning methods. Comply with PCI MNL 117.
- G. Comply with requirements in PCI MNL 117 and requirements in this Section for measuring, mixing, transporting, and placing concrete. After concrete batching, no additional water may be added.
- H. Place face mixture to a minimum thickness after consolidation of the greater of 1 inch or 1.5 times the maximum aggregate size, but not less than the minimum reinforcing cover specified.
- I. Place concrete in a continuous operation to prevent seams or planes of weakness from forming in precast concrete units.
  - 1. Place backup concrete mixture to ensure bond with face-mixture concrete.
- J. Thoroughly consolidate placed concrete by internal and external vibration without dislocating or damaging reinforcement and built-in items, and minimize pour lines, honeycombing, or entrapped air on surfaces. Use equipment and procedures complying with PCI MNL 117.
  - 1. Place self-consolidating concrete without vibration according to PCI TR-6, "Interim Guidelines for the Use of Self-Consolidating Concrete in Precast/Prestressed Concrete Institute Member Plants."
- K. Comply with PCI MNL 117 for hot- and cold-weather concrete placement.
- L. Identify pickup points of architectural precast concrete units and orientation in structure with permanent markings, complying with markings indicated on Shop Drawings. Imprint or permanently mark casting date on each architectural precast concrete unit on a surface that will not show in finished structure.
- M. Cure concrete, according to requirements in PCI MNL 117, by moisture retention without heat or by accelerated heat curing using low-pressure live steam or radiant heat and moisture. Cure units until compressive strength is high enough to ensure that stripping does not have an effect on performance or appearance of final product.

- N. Discard and replace architectural precast concrete units that do not comply with requirements, including structural, manufacturing tolerance, and appearance, unless repairs meet requirements in PCI MNL 117 and Architect's approval.

## 2.8 FABRICATION TOLERANCES

- A. Fabricate architectural precast concrete units straight and true to size and shape with exposed edges and corners precise and true so each finished panel complies with PCI MNL 117 product tolerances as well as position tolerances for cast-in items.
- B. Position Tolerances: For cast-in items measured from datum line location, as indicated on Shop Drawings.
  - 1. Weld Plates: Plus or minus 1 inch.
  - 2. Inserts: Plus or minus 1/2 inch.
  - 3. Location of Rustication Joints: Plus or minus 1/8 inch.

## 2.9 FINISHES

- A. Panel faces shall be free of joint marks, grain, and other obvious defects. Corners, including false joints shall be uniform, straight, and sharp. Finish exposed-face surfaces of architectural precast concrete units to match approved sample panel and as follows:
  - 1. Smooth Surface Finish: Provide surfaces free of pockets, sand streaks, and honeycombs.
- B. Finish unexposed surfaces of architectural precast concrete units by float finish.

## 2.10 SOURCE QUALITY CONTROL

- A. Quality-Control Testing: Test and inspect precast concrete according to PCI MNL 117 requirements. If using self-consolidating concrete, also test and inspect according to PCI TR-6, "Interim Guidelines for the Use of Self-Consolidating Concrete in Precast/Prestressed Concrete Institute Member Plants."

## PART 3 - EXECUTION

### 3.1 EXAMINATION

- A. Examine substrates and conditions for compliance with requirements for installation tolerances, true and level bearing surfaces, and other conditions affecting performance. Proceed with installation only after unsatisfactory conditions have been corrected.
- B. Do not install precast concrete units until supporting concrete has attained minimum design compressive strength.

### 3.2 INSTALLATION

- A. Install clips, hangers, bearing pads, and other accessories required for connecting architectural precast concrete units to supporting members and backup materials.
- B. Erect architectural precast concrete level, plumb, and square within specified allowable tolerances. Provide temporary supports and bracing as required to maintain position, stability, and alignment as units are being permanently connected.
  - 1. Install bearing pads as precast concrete units are being erected.
  - 2. Maintain horizontal and vertical joint alignment and uniform joint width as erection progresses.
  - 3. Unless otherwise indicated, provide for uniform joint widths to match brick joints.
  - 4. Remove projecting hoisting devices and use sand-cement grout to fill voids within recessed hoisting devices flush with surface of concrete.
- C. Connect architectural precast concrete units in position by bolting, welding, grouting, or as otherwise indicated on Shop Drawings. Remove temporary shims, wedges, and spacers as soon as practical after connecting and grouting are completed.
- D. Welding: Comply with applicable AWS D1.1/D1.1M and AWS D1.4 for welding, welding electrodes, appearance, quality of welds, and methods used in correcting welding work.
  - 1. Protect precast architectural concrete units and bearing pads from damage by field welding or cutting operations and provide noncombustible shields as required.
  - 2. Repair damaged steel surfaces by cleaning and applying a coat of galvanizing repair paint to galvanized surfaces.
- E. At bolted connections, use lock washers, tack welding, or other approved means to prevent loosening of nuts after final adjustment.
- F. Grouting Connections: Grout connections where required or indicated. Retain grout in place until hard enough to support itself. Pack spaces with stiff grout material, tamping until voids are completely filled. Place grout to finish smooth, level, and plumb with adjacent concrete surfaces. Keep grouted joints damp for not less than 24 hours after initial set. Promptly remove grout material from exposed surfaces before it affects finishes or hardens.
- G. Erect architectural precast concrete units level, plumb, square, true, and in alignment without exceeding the noncumulative erection tolerances of PCI MNL 117, Appendix I.

### 3.3 REPAIRS

- A. Repair damaged architectural precast concrete units if permitted by Architect. The Architect reserves the right to reject repaired units that do not comply with requirements.
- B. Mix patching materials and repair units so cured patches blend with color, texture, and uniformity of adjacent exposed surfaces and show no apparent line of demarcation between original and repaired work, when viewed in typical daylight illumination from a distance of 20 feet.



- C. Prepare and repair damaged galvanized coatings with galvanizing repair paint according to ASTM A 780.
- D. Remove and replace damaged architectural precast concrete units when repairs do not comply with requirements.

### 3.4 CLEANING

- A. Clean surfaces of precast concrete units exposed to view.
- B. Clean mortar, plaster, fireproofing, weld slag, and other deleterious material from concrete surfaces and adjacent materials immediately.
- C. Clean exposed surfaces of precast concrete units after erection and completion of joint treatment to remove weld marks, other markings, dirt, and stains.
  - 1. Perform cleaning procedures, if necessary, according to precast concrete fabricator's recommendations. Clean soiled precast concrete surfaces with detergent and water, using stiff fiber brushes and sponges, and rinse with clean water. Protect other work from staining or damage due to cleaning operations.
  - 2. Do not use cleaning materials or processes that could change the appearance of exposed concrete finishes or damage adjacent materials.

END OF SECTION 03450