

SPECIFICATION
ALUMINUM BOX CULVERT

Scope: This specification covers the manufacture and installation of the aluminum box culvert structure detailed in the plans.

Material: The aluminum box culvert shall consist of plates, ribs, and appurtenant items as shown on the plans and shall conform to the requirements of ASTM B 864. Plate thickness, rib spacings, end treatment and type of invert and foundation shall be as indicated on the plans.

All manufacturing processes including corrugating, punching, curving and galvanizing shall be performed within the United States using raw materials made in the United States.

Bolts and nuts shall conform to the requirements of ASTM A307 or ASTM A449.

Assembly: The box culvert shall be assembled in accordance with the shop drawings provided by the manufacturer and per the manufacturer's recommendations. Bolts shall be tightened using an applied torque of between 100 and 150 ft.-lbs.

Installation: The box culvert shall be installed in accordance with the plans and specifications, the manufacturer's recommendations, and the AASHTO Standard Specification for Highway Bridges, Section 26 (Division II).

Bedding: The bedding should be constructed to a uniform line and grade using material outlined in the backfill section. The foundation must be capable of providing a bearing capacity of at least two (2) tons per square foot.

Backfill: The structure shall be backfilled using clean well graded granular material that meets the requirements of AASHTO M 145 for soil classifications A-1, A-3, A-2-4, or A-2-5. Backfill must be placed symmetrically on each side of the structure in 6 to 8 inch lifts. Each lift shall be compacted to a minimum of 90 percent density per AASHTO T 180.

Note: Construction loads that exceed highway load limits are not allowed on the structure without approval from the Engineer.

Live load traffic is not allowed on the structure until the structure has been backfilled and paved.



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