

Use coarse aggregate Grade 4, 5, or 6 for drilled shaft concrete in reinforced drilled shafts. Grade 2 or 3 may be used if the shaft is dry and reinforcing steel has a 5-in. minimum clear spacing.

Use a water-reducing, retarding admixture in accordance with DMS-4640, "Chemical Admixtures for Concrete," in all concrete when using casing that will be pulled or when placing shafts underwater or under slurry.

Use concrete with slump that meets the requirements of Table 2 as determined by Tex-415-A.

Table 2
Slump Requirements

Placement Type	Minimum Acceptable Placement Slump, in.	Recommended Design and Placement Slump, in.	Maximum Acceptable Placement Slump, in.
Dry	5-1/2	6-1/2	7-1/2
Underwater and under slurry	7	8	9

When casing is to be pulled or when concrete is to be placed underwater or under slurry, perform a slump loss test in accordance with Tex-430-A before beginning work. Provide concrete that will maintain a slump of at least 4 in. throughout the entire anticipated time of concrete placement. Time of concrete placement is described in Sections 416.3.F, "Concrete," and 416.3.G, "Additional Requirements for Slurry Displacement or Underwater Concrete Placement Methods." Note the temperature of the concrete mix at the beginning of the slump loss test. If concrete temperature at the time of placement into the drilled shaft is more than 10° higher than the slump loss test temperature, do not place the concrete. Use ice or other concrete cooling ingredients to lower concrete temperature, or run additional slump loss tests at the higher temperatures. Slump loss testing will be waived if anticipated time of concrete placement is less than 90 minutes.

Use drilling slurry that meets the requirements of Table 3, as determined by Tex-130-E.

Table 3
Slurry Requirements

Before Introduction into the Excavation		Sampled from the Bottom of the Excavation before Concreting		
Specific Gravity	Sand Content	Specific Gravity	Viscosity (seconds)	Sand Content
≤ 1.10	≤ 1%	≤ 1.15	≤ 45	≤ 6%

Use mineral slurry consisting of processed bentonite or attapulgite clays mixed with clean fresh water. Do not use PHPA (partially hydrolized polyacrylamide) polymeric slurry or any other fluid composed primarily of a polymer solution.

Before placing concrete, sample slurry from the bottom of the hole, and test it in accordance with Tex-130-E. Use a pump or air lift to remove slurry that does not meet the requirements of Table 3 while adding fresh clean slurry to the top of the hole to maintain the slurry level. Continue this operation until the slurry sampled from the bottom of the hole meets the requirements.

416.3. Construction. Place the shaft to within the following tolerances.

- Vertical plumbness – 1 in. per 10 ft. of depth.
- Center of shaft located under column – 1 in. of horizontal plan position.
- Center of shaft located under footing – 3 in. of horizontal plan position.

Complete the embankment at bridge ends before installing drilled shafts that pass through the fill. Refer to Item 423, “Retaining Walls,” for provisions for drilled shafts passing through the structural volume of retaining walls.

A. Excavation. The plans indicate the expected depths and elevations for encountering satisfactory bearing material. Excavate as required for the shafts and bell footings through all materials encountered to the dimensions and elevations shown on the plans or required by the site conditions. Removal of man-made obstructions not shown on the plans will be paid for in accordance with Article 9.4, “Payment for Extra Work.” If satisfactory founding material is not encountered at plan elevation, adjust the bottom of the shaft or alter the foundation, as determined by the Engineer, to satisfactorily comply with design requirements. Blasting is not allowed for excavations.

If caving conditions are encountered, stop drilling and adopt a construction method that stabilizes the shaft walls.

Do not excavate a shaft within 2 shaft diameters (clear) of an open shaft excavation, or one in which concrete has been placed in the preceding 24 hours.

Dispose of material excavated from shafts and bells and not incorporated into the finished project. Dispose of excavated material in accordance with the plans and with federal, state, and local laws.

Provide suitable access, lighting, and equipment for proper inspection of the completed excavation and for checking the dimensions and alignment of shafts and bell excavation.

- B. Core Holes.** If directed, take cores to determine the character of the supporting materials. Use a method that will result in recovery of an intact sample adequate for judging the character of the founding material. Such cores should be at least 5 ft. deeper than the proposed founding grade or a depth equal to the diameter of the shaft, whichever is greater. Take these cores when the excavation is approximately complete.
- C. Casing.** Use casing when necessary to prevent caving of the material or to exclude ground water. Provide casing with an outside diameter not less than the specified diameter of the shaft. Use casing strong enough to withstand handling stresses and pressures of concrete and of the surrounding earth or water, and that is watertight, smooth, clean, and free of accumulations of hardened concrete.

Drill the portion of the shaft below the casing as close as possible to the specified shaft diameter. The portion of shaft below the casing may be as much as 2 in. smaller than the specified shaft diameter.

Use construction methods that result in a minimal amount of disturbed soil being trapped outside the casing. This does not apply to temporary undersized casings used to protect workers inside shafts or to drilled shafts designed for point bearing only.

Do not leave any casing in place unless authorized or shown on the plans. Do not extract casing until after placing the concrete to an appropriate level. Maintain sufficient concrete in the casing at all times to counteract soil and water pressure. Before and during concrete placement, rotate or move the casing up or down a few inches if necessary to facilitate extraction of the casing.

- D. Requirements for Slurry Displacement Method.** Unless otherwise shown on the plans, the slurry displacement method may be used to construct drilled shafts. Use this method to support the sides of the

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excavation with processed mineral slurry that is then displaced by concrete to form a continuous concrete shaft.

Do not use casing other than surface casing. Do not use surface casing longer than 20 ft. without approval. Do not extract the surface casing until after placing the concrete.

For slurry mixed at the project site, pre-mix it in a reservoir of sufficient capacity to fill the excavation and for recovery of the slurry during concrete placement. Do not mix slurry in the shaft excavation or other hole. Allow adequate time for hydration of the slurry prior to introduction into the excavation.

During and after drilling maintain a head of slurry in the shaft excavation at or near ground level or higher as necessary to counteract ground water pressure.

Just before placing reinforcing steel, use an air lift or proper size cleanout bucket to remove any material that may have fallen from the sides of the excavation or accumulated on the bottom after the completion of drilling. Use a cleanout bucket if material is too large to be picked up with an air lift.

If concrete placement is not started within 4 hours of the completion of the shaft excavation, reprocess the hole with the auger as directed. Then clean the bottom with an air lift or cleanout bucket, and check the slurry at the bottom of the hole for compliance with the slurry requirements of Article 416.2, "Materials."

If the slurry forms a gel before concrete placement, agitate the congealed slurry to liquefaction just before concrete placement and whenever directed.

Recover and dispose of all slurry as approved by the Engineer, and in accordance with all federal, state, and local laws. Do not discharge slurry into or in close proximity to streams or other bodies of water.

- E. Reinforcing Steel.** Completely assemble the cage of reinforcing steel, and place it as a unit immediately before concrete placement. The cage consists of longitudinal bars and lateral reinforcement (spiral reinforcement, lateral ties, or horizontal bands). If overhead obstacles prevent placement of the cage as a single unit, connect individual segments with couplers or by lapping steel as approved.

If the shaft is lengthened beyond plan length, extend the reinforcing steel cage as follows, unless directed otherwise:

- For shafts supporting structures other than bridges, extend the cage to the bottom.