

while the concrete remains workable. No temporary casings will be removed if the concrete slump is less than four (4) inches. Should this condition occur, the shaft will be designated as defective, and corrections to the situation shall be as described above.

Special casing systems may be used in open water areas, when approved, which are designed to permit removal after the concrete has hardened. Special casings shall be designed so that no damage occurs to the drilled shaft concrete during their removal. Any defects either cosmetic or structural that are apparent after removal of the casing or are due to the removal of the casing shall be repaired to the satisfaction of the Engineer at no additional cost to the State.

In the event that permanent casing is not specified in the plans, and the Contractor elects to use a temporary casing and leave it in place, it shall be cut off at a maximum of 12 inches above the low water elevation as shown on the plans, or painted. Written approval from the Engineer is required in this event, and payment for the temporary casing left in place will be at the contract bid price for temporary casing.

803.03.2.3.7.5.3--Permanent Casings. Permanent casing shall be used when shown on the plans. The casing shall be continuous between top and bottom elevations prescribed on the plans or as directed by the Engineer. Exterior surfaces of permanent casing shall be painted in accordance with the plans unless otherwise noted. After installation is complete, the permanent casing shall be cut off at the prescribed elevation and the shaft completed.

In general, permanent casing shall not be placed in an overreamed shaft hole.

803.03.2.3.8--Slurry. Mineral slurries shall be employed when slurry is used in the drilling process, unless other drilling fluids are approved in writing by the Engineer. The slurry shall have both a mineral grain size that will remain in suspension and sufficient viscosity and gel characteristics to transport excavated material to a suitable screening system. The percentage and specific gravity of the material used to make the suspension shall be sufficient to maintain the stability of the excavation and to allow proper concrete placement. During construction, the level of the slurry shall be maintained at a height sufficient to prevent caving of the hole. In the event there is a sudden, significant loss of slurry within the drilled shaft excavation, the construction of the drilled shaft shall be stopped until a method to stop slurry loss or an alternate construction procedure has been approved by the Engineer.

Mineral slurry shall be premixed thoroughly with clean, fresh water, and an adequate time (as prescribed by the mineral manufacturer) shall be allotted for hydration, prior to introduction into the shaft excavation. Slurry tanks of adequate capacity will be required for slurry circulation, storage, and treatment. No excavated slurry pits will be allowed in lieu of slurry tanks, without the

written permission of the Engineer. Desanding equipment shall be provided by the Contractor as necessary to control slurry sand content to less than two percent (2%) by volume at any point in the borehole. Desanding will not be required for setting sign post or lighting mast foundations unless shown on the plans. The Contractor shall take all steps necessary to prevent the slurry from "setting up" in the shaft. Such methods may include, but are not limited to: agitation, circulation, and/or adjusting the properties of the slurry. Disposal of all slurry shall be performed offsite in suitable areas by the Contractor, and subject to all environmental regulations pertaining to slurry disposal.

Control tests using suitable apparatus shall be carried out on the mineral slurry mixture by a qualified individual or qualified professional testing laboratory approved by the Engineer. Tests to be conducted will be density, sand content, viscosity, and pH. The acceptable range of values for those physical properties is as shown in the following table:

MINERAL SLURRY
Sodium Montmorillonite (Commercial Bentonite)
Acceptable Range of Values

Property Units	At Time of Slurry Introduction	In Hole at Time of Concreting	Test Method
Density, pcf	64.3** - 69.1**	64.3** - 75.0**	Density Balance
Viscosity, seconds/quart	28 - 45	28 - 45	Marsh Cone
pH	8 - 11	8 - 11	pH paper pH meter

**Increase by 2 pcf in salt water

Notes: a. Tests should be performed when the slurry temperature is above 40 degrees Fahrenheit.

b. If desanding is required, sand content shall not exceed two percent (2%) by volume at any point in the borehole as determined by the American Petroleum Institute sand content test.

The limits in the above table may be adjusted when field conditions warrant, as successfully demonstrated on the trial shaft or as directed by the Engineer. All changes must be approved in writing by the Engineer before continued use.

Tests to determine density, viscosity, and pH value shall be performed during the shaft excavation to establish a consistent working pattern. A minimum of four (4) sets of tests shall be made during the first eight (8) hours of slurry use. When the results show consistent behavior, the testing frequency may be decreased to one set every four (4) hours of slurry use.

The Contractor shall insure that heavily contaminated slurry suspension, which could impair the free flow of concrete, has not accumulated in the bottom of the shaft. Prior to placing concrete in any shaft excavation, the Contractor shall take slurry samples using a sampling tool approved by the Engineer or similar to that shown in Figure 2. Slurry samples shall be extracted from the base of the shaft and at intervals not exceeding 10 feet up the shaft, until two consecutive samples produce acceptable values for density, viscosity, pH, and sand content.

When any slurry samples are found to be unacceptable, the Contractor shall take whatever action is necessary to bring the mineral slurry within specification requirements. Concrete shall not be poured until resampling and testing produce acceptable results.

Reports of all tests required above, signed by an authorized representative of the Contractor, shall be furnished to the Engineer on completion of each drilled shaft. Representatives of the Department may perform comparison tests as determined necessary during mineral slurry operations.

During construction, the level of mineral slurry in the shaft excavation shall be maintained at a level not less than four (4) feet above the highest expected piezometric pressure head along the depth of the shaft. If at any time the slurry construction method fails to produce the desired final results, the Contractor shall discontinue this method and propose an alternate method for approval by the Engineer.

Drilling tools should contain vents to stabilize hydrostatic pressure above and below the tool during extraction. The rate of tool extraction should not cause any noticeable turbulence in the hole.

In locations where saline or chemically contaminated groundwater exists, the slurry should be adjusted with appropriate chemical additives, or developed with a mineral material not affected by such conditions.

803.03.2.4--Excavation Inspection. The Contractor shall provide equipment for checking the dimensions and alignment of each drilled shaft excavation. The dimensions and alignment shall be determined by the Contractor in the presence of the Engineer or the Engineer's inspector. Final shaft depths shall be measured with a weighted tape or other approved methods after final cleaning. Unless otherwise stated on the plans, a minimum of 50 percent of the base of each shaft shall have less than 1/2 inch of sediment at the time of placement of the concrete.