

SPECIFICATION FOR CORRUGATED METAL PIPE

END SECTIONS - GALVANIZED STEEL

1.0 GENERAL

- 1.1 This specification covers the manufacture and installation of the galvanized steel end sections used for the pipe or pipe-arch detailed in the project plans.

2.0 DESIGN STANDARDS

- 2.1 The end section meets the design parameters of the American Iron and Steel Institute (AISI), National Corrugated Steel Pipe Association (NCSPA), or project requirements.

3.0 MATERIAL

- 3.1 The galvanized steel coils shall conform to the applicable requirements of AASHTO M 218 or ASTM A929.

4.0 END SECTION

- 4.1 The end section sizes shall be as shown on the project plans.
- 4.2 The end sections shall be manufactured to show careful finished workmanship.
 - 4.2.1 There shall be no loosely formed seams.
 - 4.2.2 There shall be no ragged shear edges.
 - 4.2.3 The markings on the sheets as received from the steel supplier shall be legible.
 - 4.2.4 The metallic coating on the end section shall not be bruised, broken or otherwise damaged. If there is damage to the coating it shall be repaired in accordance with ASTM A780.
- 4.3 All fabrication of the product shall occur within the United States.

5.0 HANDLING, ASSEMBLY, & INSTALLATION

- 5.1 Refer to the recommendations of the National Corrugated Steel Pipe Association's (NCSPA). If there are any inconsistencies or conflicts, the contractor must bring them to the attention of the project engineer.
- 5.2 The end sections shall attach to the pipe by means of a strap or rod and lug unless shown otherwise on the plans. The strap or rod and lug shall be securely tightened around the pipe.
- 5.3 The end sections shall have the standard toe plate. If shown on plans the end sections shall have the optional toe plate extension.
- 5.4 The toe plate shall be placed in narrow trench. The invert of the end section shall be supported evenly by the bedding.
- 5.5 The alignment of the end section shall match that of the pipe.
- 5.6 The installation shall be completed by proper compaction of the backfill around the end section.
- 5.7 It is always the contractor's responsibility to follow OSHA guidelines for safe practices.