

# SPECIFICATION FOR CORRUGATED METAL PIPE

## Polymer Coated Galvanized Steel



### GENERAL

1. This specification covers the manufacture and installation of the Polymer Coated Galvanized Steel corrugated steel pipe or pipe-arch detailed in the associated project plans. TrueNorth Steel is the pre-approved manufacturer and supplier.

### DESIGN STANDARDS

1. The polymer coated corrugated steel pipe or pipe arch shall meet the design parameters of the American Association of State Highway and Transportation Officials (AASHTO) Standard Specification for Highway Bridges, AASHTO LRFD Bridge Design, and/or the American Iron and Steel Institute (AISI).

### MATERIAL

1. The polymer coated galvanized steel coils shall conform to the applicable requirements of AASHTO M 246 or ASTM A742. 4.0 PIPE. All aspects of the polymer coated galvanized steel coil shall be manufactured in the United States.

### PIPE

1. The corrugated steel pipe or pipe arch shall be manufactured with one of the following corrugations: 1 1/2" x 1/4"; 2 2/3" x 1/2"; 3 x 1; 5 x 1. The corrugated steel pipe or pipe arch shall be manufactured in accordance with the applicable requirements of AASHTO M 36 or ASTM A760. The pipe sizes, gauges and corrugations shall be as shown on the project plans.
2. All fabrication of the product shall occur within the United States.

### COUPLING BANDS

1. Coupling bands for the polymer coated corrugated steel pipe or pipe arch shall meet the requirements of ASTM A760 9.0 and shall be made of the same base metal and coatings as the spiral rib pipe or pipe arch with a minimum of 18 gauge thickness.
2. The pipe or pipe arch ends shall be rerolled with annular corrugations for proper indexing with the coupling bands. O-ring gaskets or 12" wide flat neoprene gaskets per ASTM A 760 9.4.5 and ASTM A1056.
3. Appropriate connection fasteners will be provided with coupling bands.

### HANDLING & ASSEMBLY

1. Refer to the recommendations of the National Corrugated Steel Pipe Association's (NCSPA) and or the guidelines provided by TrueNorth Steel.

### INSTALLATION

1. The installation shall be in accordance with AASHTO Standard Specifications for Highway Bridges, LRFD Section 26, Division II, NCSPA, or ASTM A798 and in conformance with the project plans and specifications. If there are any inconsistencies or conflicts, the contractor must bring them to the attention of the project engineer.  
Special attention shall be paid to minimum cover during the construction phase if live loads exceeding HS-25 or HL-93 are expected. Additional temporary cover over the pipe may be required in this case. Refer to NCSPA installation guidelines.
2. Contractor shall follow all applicable OSHA and state and local guidelines for safe practices.