

**SECTION 03331**  
**ARCHITECTURAL CAST-IN-PLACE CONCRETE**

**PART 1 - GENERAL**

**1.1 RELATED DOCUMENTS**

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions, apply to this Section.

**1.2 SUMMARY**

- A. This Section specifies cast-in-place exposed aggregate architectural concrete exposed to view, including formwork, reinforcement accessories, concrete materials, concrete mix design, placement procedures, and finishes.
- B. Related Sections:
  - 1. Division 3 Section "Cast-in-Place Concrete" for structural and general cast-in-place concrete construction, including formed and unformed finishes.
  - 2. Division 7 Section "Joint Sealants" for elastomeric joint sealants in contraction and other joints in cast-in-place architectural concrete.

**1.3 DEFINITION**

- A. Cast-in-Place Architectural Concrete: Concrete that is exposed to view on surfaces of the completed structure or building and that requires special concrete materials, formwork, placement, or finishes to obtain specified architectural appearance.
- B. Design Reference Sample: Sample designated by Architect in the Contract Documents that reflects acceptable surface quality and appearance of cast-in-place architectural concrete.
- C. Reveal: Projection of the coarse aggregate from the matrix after exposure.

**1.4 SUBMITTALS**

- A. Product Data: For each type of manufactured material and product indicated.
- B. Design Mixes: For each concrete mix. Include alternate mix designs when characteristics of materials, Project conditions, weather, test results, or other circumstances warrant adjustments.
- C. Shop Drawings: Show formwork construction including form-facing joints, rustications, construction and contraction joints, form joint-sealant details, form tie location and patterns, inserts and embedments, cutouts, cleanout panels, and other items that visually affect cast-in-place architectural concrete.
- D. Samples for Verification: Architectural concrete samples, cast vertically, approximately 18 by 18 by 2 inches, of finishes, colors, and textures to match the design reference sample. Include Sample sets showing the full range of variations expected in these characteristics.
- E. Material Certificates: Signed by manufacturers certifying that each of the following materials complies with requirements:
  - 1. Cementitious materials and aggregates.
  - 2. Admixtures.

## 1.5 QUALITY ASSURANCE

- A. **Installer Qualifications:** An experienced cast-in-place architectural concrete contractor who has specialized in installing cast-in-place architectural concrete similar in material, design, and extent to that indicated for this Project and whose work has resulted in construction with a record of successful in-service performance.
1. Installer shall retain a quality-control inspector, experienced in inspecting cast-in-place architectural concrete, who is an ACI-certified Concrete Construction Inspector or is certified by BOCA, ICBO, or SBCCI as a Reinforced Concrete Special Inspector.
- B. **Concrete Manufacturer Qualifications:** A firm experienced in manufacturing ready-mixed concrete products complying with ASTM C 94 requirements for production facilities and equipment.
1. Manufacturer must be certified according to the National Ready Mixed Concrete Association's "Certification of Ready Mixed Concrete Production Facilities."
- C. **Testing Agency Qualifications:** An independent testing agency, acceptable to authorities having jurisdiction, qualified according to ASTM C 1077 and ASTM E 329 to conduct the testing indicated, as documented according to ASTM E 548.
1. Personnel conducting field tests shall be qualified as ACI Concrete Field Testing Technician, Grade 1, according to ACI CP-1 or an equivalent certification program recognized by ASTM C 1077.
- D. **Source Limitations for Cast-in-Place Architectural Concrete:** Obtain each color, size, type, and variety of concrete material and concrete mix from one manufacturer with resources to provide cast-in-place architectural concrete of consistent quality in appearance and physical properties.
- E. **ACI Standards:** Comply with ACI 303.1, "Specification for Cast-in-Place Architectural Concrete"; ACI 301, "Specification for Structural Concrete"; and ACI 117, "Specifications for Tolerances for Concrete Construction and Materials," unless more stringent provisions are indicated.
- F. **Sample Panels:** Before casting architectural concrete, produce sample panels to demonstrate the approved range of selections made under sample Submittals. Produce a minimum of 3 sets of full-scale sample panels, cast vertically, approximately 10 feet wide by 7 feet high by 6 inches minimum, to demonstrate the expected range of finish, color, and texture variations.
1. Locate panels as indicated or, if not indicated, as directed by Construction Manager.
  2. Demonstrate methods of curing aggregate exposure, sealers, and coatings, as applicable.
  3. In presence of CM, damage part of an exposed-face surface for each finish, color, and texture, and demonstrate materials and techniques proposed for repair of tie holes and surface blemishes to match adjacent undamaged surfaces.
  4. Maintain sample panels during construction in an undisturbed condition as a standard for judging the completed Work.
- G. **Preinstallation Conference:** Conduct conference at Project site to comply with requirements in General and Supplemental Conditions' "Project Meetings."

## PART 2 - PRODUCTS

## 2.1 FORM-FACING MATERIALS

- A. General: Comply with Division 3 Section "Cast-in-Place Concrete" for formwork and other form-facing material requirements.
- B. Form-Facing Panels: Steel, glass-fiber-reinforced plastic, or other approved nonabsorptive panel materials that will provide continuous, true, and smooth architectural concrete surfaces. Furnish in largest practicable sizes to minimize number of joints.
- C. Forms for Cylindrical Columns, Pedestals, and Supports: Metal, glass-fiber-reinforced plastic, paper, or fiber tubes that will provide surfaces with gradual or abrupt irregularities not exceeding specified formwork surface class. Provide units with sufficient wall thickness to resist plastic concrete loads without detrimental deformation.
- D. Rustication Strips: Metal, rigid plastic, or dressed wood with sides beveled and back kerfed, nonstaining.
- E. Chamfer Strips: Metal, rigid plastic, elastomeric rubber, or dressed wood, 3/4 by 3/4 inch, minimum; nonstaining.
- F. Form Joint Tape: Compressible foam tape, pressure sensitive, AAMA 810.1, minimum 1/4 inch thick.
- G. Form Joint Sealant: Elastomeric sealant complying with ASTM C 920, Type M or S, Grade NS, that adheres to form joint substrates.
- H. Sealer: Penetrating, clear, polyurethane wood form sealer formulated to reduce absorption of bleed water and prevent migration from wood of set-retarding chemicals.
- I. Form-Release Agent: Commercially formulated form-release agent that will not bond with, stain, or adversely affect architectural concrete surfaces and will not impair subsequent treatments of those surfaces.
  - 1. Formulate form-release agent with rust inhibitor for steel form-facing materials.
- J. Form Ties: Factory-fabricated, internally disconnecting ties designed to resist lateral pressure of fresh concrete on forms and to prevent spalling of concrete on removal.
  - 1. Furnish ties that, when removed, will leave holes not larger than 3/4 inch in diameter on concrete surface.
  - 2. Furnish internally disconnecting ties that will leave no corrodible metal closer than 1-1/2 inches, plus reveal projection of exposed aggregate, from the plane of architectural concrete surface.
  - 3. Refer to Drawings for typical layout of form tie locations.

## 2.2 REINFORCEMENT ACCESSORIES

- A. General: Comply with Division 3 Section "Cast-in-Place Concrete" for steel reinforcement and other requirements for reinforcement accessories.
- B. Bar Supports: Bolsters, chairs, spacers, and other devices for spacing, supporting, and fastening reinforcing bars and welded wire fabric in place. Where legs of wire bar supports contact forms, use CRSI Class 1 plastic-protected bar supports.

## 2.3 CONCRETE MATERIALS

- A. Portland Cement: ASTM C 150, Type I, combination of white and gray cement. Cement shall be of same type, brand, and source for entire Project.
  - 1. White cement will be utilized in percentage as determined by CM.
  - 2. Fly Ash: ASTM C 618, Class C or F.
- B. Normal-Weight Coarse Aggregate: ASTM C 33, from the same source for entire Project, and as follows:
  - 1. Weathering Region and Class: Severe, 5S.
  - 2. Nominal Maximum Aggregate Size: 1 inch.
  - 3. Gradation: Uniformly graded.
  - 4. Aggregate to be selected by CM.
- C. Normal-Weight Fine Aggregate: ASTM C 33.
- D. Water: Potable, complying with ASTM C 94 except free of wash water from mixer washout operations.
- E. Chemical Admixtures: Certified by manufacturer to contain not more than 0.1 percent water-soluble chloride ions by mass of cementitious material and to be compatible with other admixtures and cementitious materials. Do not use admixtures containing calcium chloride.
  - 1. Air-Entraining Admixture: ASTM C 260.
  - 2. Water-Reducing Admixture: ASTM C 494, Type A.
  - 3. High-Range, Water-Reducing Admixture: ASTM C 494, Type F.
  - 4. Water-Reducing and Accelerating Admixture: ASTM C 494, Type E.
  - 5. Water-Reducing and Retarding Admixture: ASTM C 494, Type D.

## 2.4 CURING MATERIALS

- A. Absorptive Cover: AASHTO M 182, Class 2, burlap cloth made from jute or kenaf, washed to prevent concrete staining, weighing approximately 9 oz./sq. yd. when dry.

## 2.5 REPAIR MATERIALS

- A. Bonding Agent: ASTM C 1059, Type II, non-redispersible, acrylic emulsion or styrene butadiene.

## 2.6 CONCRETE MIXES

- A. Prepare design mixes for each type and strength of cast-in-place architectural concrete determined by either laboratory trial mix or field test data bases. Proportion concrete according to ACI 211.1 and ACI 301.
- B. Use a qualified independent testing agency for preparing and reporting proposed concrete mix designs for the laboratory trial mix basis. Design mix shall match Architect's Architectural Concrete sample. Prepare mix for Architectural concrete after the final samples of have been reviewed and approved by the CM.
- C. Proportion concrete mix as follows:
  - 1. Compressive Strength (28 Days): 4,000 psi.
  - 2. Maximum Water-Cementitious Materials Ratio: 0.46.
  - 3. Maximum Slump: 4 inches.
  - 4. Maximum Slump for Concrete Containing High-Range, Water-Reducing Admixture: 8 inches after admixture is added to concrete with 2- to 4-inch slump.

- D. Cementitious Materials: For cast-in-place architectural concrete exposed to deicers, limit percentage, by weight, of cementitious materials other than portland cement according to ACI 301 requirements.
- E. Air Content: Add air-entraining admixture at manufacturer's prescribed rate to result in architectural concrete at point of placement having an air content of 6 percent within a tolerance of plus 1 percent or minus 1.5 percent.
- F. Coloring Admixture: Add coloring admixture to architectural concrete mix according to manufacturer's written instructions.

## 2.7 CONCRETE MIXING

- A. Ready-Mixed Concrete: Measure, batch, mix, and deliver cast-in-place architectural concrete according to ASTM C 94, and furnish batch ticket information.
  - 1. When air temperature is between 85 and 90 deg F, reduce mixing and delivery time from 90 to 75 minutes; when air temperature is above 90 deg F, reduce mixing and delivery time to 60 minutes.

## PART 3 - EXECUTION

### 3.1 FORMWORK

- A. General: Comply with Division 3 Section "Cast-in-Place Concrete" for formwork, embedded items, and shoring and reshoring.
- B. In addition to ACI 303.1 limits on form-facing panel deflection, limit concrete surface irregularities, designated by ACI 347R as abrupt or gradual, as follows:
  - 1. Class A, 1/8 inch.
- C. Fabricate forms for easy removal without hammering or prying against concrete surfaces. Provide crush or wrecking plates where stripping may damage cast-in-place surfaces. Provide top forms for inclined surfaces steeper than 1.5 horizontal to 1 vertical. Kerf wood rustications, keyways, reglets, recesses, and the like, for easy removal.
  - 1. Do not use rust-stained, steel, form-facing material.
- D. Provide temporary openings for cleanouts and inspection ports where interior area of formwork is inaccessible. Close openings with panels tightly fitted to forms and securely braced to prevent loss of concrete mortar. Locate temporary openings in forms at inconspicuous locations.
- E. Chamfer exterior corners and edges of cast-in-place architectural concrete.
- F. Coat contact surfaces of wood rustications and chamfer strips with sealer before placing reinforcement.
- G. Form openings, chases, offsets, sinkages, keyways, reglets, blocking, screeds, and bulkheads required in the Work. Determine sizes and locations from trades providing such items.
- H. Clean forms and adjacent surfaces to receive concrete. Remove chips, wood, sawdust, dirt, and other debris just before placing concrete.
- I. Seal form joints and penetrations at form ties with form joint tape or form joint sealant to prevent mortar leaks.

- J. Retighten forms and bracing before placing concrete, as required, to prevent mortar leaks and maintain proper alignment.
- K. Coat contact surfaces of forms with form-release agent, according to manufacturer's written instructions, before placing reinforcement.

### 3.2 REINFORCEMENT AND INSERTS

- A. General: Comply with Division 3 Section "Cast-in-Place Concrete" for fabricating and installing steel reinforcement.
- B. Set wire ties with ends directed into concrete, not toward exposed concrete surfaces.

### 3.3 REMOVING AND REUSING FORMS

- A. Formwork, for sides of beams, walls, columns, and similar parts of the Work, that does not support weight of concrete may be removed after cumulatively curing at not less than 50 deg F for 24 hours after placing concrete, provided concrete is hard enough to not be damaged by form-removal operations and provided curing and protection operations are maintained.
  - 1. Schedule form removal to maintain surface appearance that matches approved sample panels.
- B. Leave formwork, for beam soffits, joists, slabs, and other structural elements, that supports weight of concrete in place until concrete has achieved 28-day design compressive strength at least 70 percent of 28-day design compressive strength. Remove forms only if shores have been arranged to permit removal of forms without loosening or disturbing shores.
- C. Clean and repair surfaces of forms to be reused in the Work. Do not use split, frayed, delaminated, or otherwise damaged form-facing material. Apply new form-release agent.
- D. When forms are reused, clean surfaces, remove fins and laitance, and tighten to close joints. Align and secure joints to avoid offsets. Do not use patched forms for architectural concrete surfaces.

### 3.4 JOINTS

- A. Construction Joints: Install construction joints true to line with faces perpendicular to surface plane of cast-in-place architectural concrete so strength and appearance of concrete are not impaired, at locations indicated or as approved by Construction Manager.
  - 1. Place joints perpendicular to main reinforcement. Continue reinforcement across construction joints, unless otherwise indicated.
  - 2. Use bulkhead forms with keys of plywood, wood, or expanded galvanized steel sheet, unless otherwise indicated. Embed keys at least 1-1/2 inches into concrete. Align construction joint within rustications attached to form-facing material.
  - 3. Locate joints for beams, slabs, joists, and girders in the middle third of spans. Offset joints in girders a minimum distance of twice the beam width from a beam-girder intersection.
  - 4. Locate horizontal joints in walls and columns at underside of floors, slabs, beams, and girders and at the top of footings or floor slabs.
  - 5. Space vertical joints in walls as indicated. Locate joints beside piers integral with walls, near corners, and in concealed locations where possible.
  - 6. Use bonding agent at locations where fresh concrete is placed against hardened or partially hardened concrete surfaces.

- B. Contraction Joints: Form weakened-plane contraction joints true to line with faces perpendicular to surface plane of cast-in-place architectural concrete so strength and appearance of concrete are not impaired, at locations indicated or as approved by Construction Manager.

### 3.5 CONCRETE PLACEMENT

- A. Before placing concrete, verify that installation of formwork, reinforcement, and embedded items is complete and that required inspections have been performed.
- B. Do not add water to concrete during delivery, at Project site, or during placement, unless approved by Structural Engineer.
- C. Deposit concrete continuously between construction joints. Deposit concrete to avoid segregation.
- D. Deposit concrete in forms in horizontal layers no deeper than 24 inches and in a manner to avoid inclined construction joints. Place each layer while preceding layer is still plastic, to avoid cold joints.
  - 1. Consolidate placed concrete with mechanical vibrating equipment. Use equipment and procedures for consolidating concrete recommended by ACI 309R.
  - 2. Do not use vibrators to transport concrete inside forms. Insert and withdraw vibrators vertically at uniformly spaced locations no farther than the visible effectiveness of the vibrator. Place vibrators to rapidly penetrate placed layer and at least 6 inches into preceding layer. Do not insert vibrators into lower layers of concrete that have begun to lose plasticity. At each insertion, limit duration of vibration to time necessary to consolidate concrete and complete embedment of reinforcement and other embedded items without causing concrete mix constituents to segregate.
- E. Cold-Weather Placement: Comply with ACI 306.1 and as follows. Protect concrete work from physical damage or reduced strength that could be caused by frost, freezing actions, or low temperatures.
  - 1. When air temperature has fallen to or is expected to fall below 40 deg F, uniformly heat water and aggregates before mixing to obtain a concrete mixture temperature of not less than 50 deg F and not more than 80 deg F at point of placement.
  - 2. Do not use frozen materials or materials containing ice or snow. Do not place concrete on frozen subgrade or on subgrade containing frozen materials.
  - 3. Do not use calcium chloride, salt, or other materials containing antifreeze agents or chemical accelerators, unless otherwise indicated and approved in concrete mix designs.
- F. Hot-Weather Placement: Place concrete according to recommendations in ACI 305R and as follows, when hot-weather conditions exist:
  - 1. Cool ingredients before mixing to maintain concrete temperature below 90 deg F at time of placement. Chilled mixing water or chopped ice may be used to control temperature, provided water equivalent of ice is calculated to total amount of mixing water. Using liquid nitrogen to cool concrete is Contractor's option.
  - 2. Cover steel reinforcement with water-soaked burlap so steel temperature will not exceed ambient air temperature immediately before embedding in concrete.
  - 3. Fog-spray forms, steel reinforcement, and subgrade just before placing concrete. Keep subgrade moisture uniform without standing water, soft spots, or dry areas.

### 3.6 FINISHES, GENERAL

- A. Architectural Concrete Finish: Match CM's design reference sample, identified and described as indicated.
- B. Related Unformed Surfaces: At tops of walls, horizontal offsets, and similar unformed surfaces adjacent to formed surfaces, strike off smooth and finish with a texture matching adjacent formed surfaces.
  - 1. Continue final surface treatment of formed surfaces uniformly across adjacent unformed surfaces, unless otherwise indicated.
- C. Maintain uniformity of special finishes over construction joints, unless otherwise indicated.

### 3.7 AS-CAST FORMED FINISHES

- A. Smooth-Formed Finish: As-cast concrete texture imparted by form-facing material, arranged in an orderly and symmetrical manner with a minimum of seams. Repair and patch tie holes and defective areas. Remove fins and other projections exceeding 1/8 inch in height.

### 3.8 EXPOSED-AGGREGATE FINISHES

- A. Abrasive-Blast Finish: Perform abrasive blasting after the compressive strength of concrete exceeds 2,000 psi. Coordinate with formwork removal to ensure that surfaces to be abrasive blasted are treated at the same age for uniform results.
  - 1. Surface Continuity: Perform abrasive-blast finishing in as continuous an operation as possible, maintaining continuity of finish on each surface or area of Work. Maintain required patterns or variances in depths of blast to match design reference sample or mockup.
  - 2. Abrasive Blasting: Abrasive blast corners and edges of patterns carefully, using backup boards, to maintain uniform corner or edge line. Determine type of nozzle, nozzle pressure, and blasting techniques required to match design reference sample or mockup.
  - 3. Depth of Cut: Use an abrasive grit of proper type and gradation to expose aggregate and surrounding matrix surfaces to match design reference sample or mockup, as follows:
    - a. Medium: Generally expose coarse aggregate with slight reveal. Maximum reveal 1/4 inch.
    - b. Heavy: Expose and reveal coarse aggregate to a maximum projection of one-third its diameter. Reveal range 1/4 to 1/2 inch.

### 3.9 CONCRETE CURING

- A. Protect freshly placed concrete from premature drying and excessive cold or hot temperatures according to ACI 301.
- B. Begin curing immediately after removing forms from concrete. Cure by one or a combination of the following methods that will not mottle, discolor, or stain concrete:
  - 1. Moisture Curing: Keep exposed surfaces of cast-in-place architectural concrete continuously moist for not less than seven days with the following materials:
    - a. Water.
    - b. Continuous water-fog spray.
    - c. Absorptive cover, water saturated and kept continuously wet. Cover concrete surfaces and edges with 12-inch lap over adjacent absorptive covers.

### 3.10 FIELD QUALITY CONTROL

- A. General: Comply with Division 3 Section "Cast-in-Place Concrete" for field quality-control requirements.

### 3.11 REPAIRS, PROTECTION, AND CLEANING

- A. Repair and cure damaged finished surfaces of cast-in-place architectural concrete when approved by CM. Match repairs to color, texture, and uniformity of surrounding surfaces and to repairs on approved mockups.
  - 1. Remove and replace cast-in-place architectural concrete that cannot be repaired and cured to CM's approval.
- B. Protect corners, edges, and surfaces of cast-in-place architectural concrete from damage; use guards and barricades.
- C. Protect cast-in-place architectural concrete from staining, laitance, and contamination during remainder of construction period.
- D. Clean cast-in-place architectural concrete surfaces after finish treatment to remove stains, markings, dust, and debris.
- E. Wash and rinse surfaces according to concrete finish applicator's written recommendations. Protect other Work from staining or damage due to cleaning operations.
  - 1. Do not use cleaning materials or processes that could change the appearance of cast-in-place architectural concrete finishes.

**END OF SECTION 03331**