

**EPOXY RESIN INJECTION**

**(10-12-01)**

**1.0 GENERAL**

For repairing cracks, an approved applicator is required to perform the epoxy resin injection. Make certain the supervisor and the workmen have completed an instruction program in the methods of restoring concrete structures utilizing the epoxy injection process and have a record of satisfactory performance on similar projects.

The applicator furnishes all materials, tools, equipment, appliances, labor and supervision required when repairing cracks with the injection of an epoxy resin adhesive.

**2.0 SCOPE OF WORK**

[FOR EXAMPLE SEE LAST PAGE OF THIS SPECIAL PROVISION]

**3.0 COOPERATION**

Cooperate and coordinate with the Technical Representative of the epoxy resin manufacturer for satisfactory performance of the work.

Have the Technical Representative present when the job begins and until the Engineer is assured that his service is no longer needed.

The expense of having this representative on the job is the Contractor’s responsibility and no direct payment will be made for this expense.

**4.0 TESTING**

The North Carolina Department of Transportation Material and Tests Unit obtains test cores from the repaired concrete. If the failure plane is located at the repaired crack, a minimum compressive strength of 3000 psi (20.7 MPa) is required of these cores.

**5.0 MATERIAL PROPERTIES**

Provide a two-component structural epoxy adhesive for injection into cracks or other voids. Provide modified epoxy resin (Component “A”) that conforms to the following requirements:

	Test Method	Specification Requirements
Viscosity @ 40 ± 3°F (4 ± 1°C), cps	Brookfield RVT Spindle No. 4 @ 20 rpm	6000 - 8000
Viscosity @ 77 ± 3°F (25 ± 1°C), cps	Brookfield RVT Spindle No. 2 @ 20 rpm	400 - 700
Epoxide Equivalent Weight	ASTM D1652	152 - 168
Ash Content, %	ASTM D482	1 max.

Provide the amine curing agent (Component “B”) used with the epoxy resin that meets the following requirements:

	Test Method	Specification Requirements
Viscosity @ 40 ± 3°F (4 ± 1°C), cps	Brookfield RVT Spindle No. 2 @ 20 rpm	700 - 1400
Viscosity @ 77 ± 3°F (25 ± 1°C), cps	Brookfield RVT Spindle No. 2 @ 20 rpm	105 - 240
Amine Value, mg KOH/g	ASTM D664*	490 - 560
Ash Content, %	ASTM D482	1 max.
* Method modified to use perchloric acid in acetic acid.		

Certify that the Uncured Adhesive, when mixed in the mix ratio that the material supplier specifies, has the following properties:

- Pot Life (60 gram mass)
  - @ 77 ± 3°F (25 ± 1°C) 15 minutes minimum
  - @ 100 ± 3°F (38 ± 1°C) 5 minutes minimum

Certify that the Adhesive, when cured for 7 days at 77 ± 3°F (25 ± 1°C) unless otherwise specified, has the following properties:

	Test Method	Specification Requirements
Ultimate Tensile Strength	ASTM D638	7000 psi (48.3 MPa) min.
Tensile Elongation at Break	ASTM D638	4% max.
Flexural Strength	ASTM D790	10,000 psi (69.0 MPa) min.
Flexural Modulus	ASTM D790	3.5 x 10 <sup>5</sup> psi (2413.2 MPa)
Compressive Yield Strength	ASTM D695	11,000 psi (75.8 MPa) min.
Compressive Modulus	ASTM D695	2.0 - 3.5 x 10 <sup>5</sup> psi (1379.0 - 2413.2 MPa)
Heat Deflection Temperature Cured 28 days @ 77 ± 3°F (25 ± 1°C)	ASTM D648*	125°F (52°C) min. 135°F (57°C) min.
Slant Shear Strength, 5000 psi (34.5 MPa) compressive strength concrete  Cured 3 days @ 40°F (4°C) wet concrete Cured 7 days @ 40°F (4°C) wet concrete Cured 1 day @ 77°F	AASHTO T237	3500 psi (24.1 MPa) min.  4000 psi (27.6 MPa) min.  5000 psi (34.5 MPa) min.

(25°C) dry concrete		
* Cure test specimens so that the peak exothermic temperature of the adhesive does not exceed 77°F (25°C).		

Use an epoxy bonding agent, as specified for epoxy mortar, as the surface seal (used to confine the epoxy resin during injection).

## 6.0 EQUIPMENT FOR INJECTION

Use portable positive displacement type pumps with interlock to provide positive ratio control of exact proportions of the two components at the nozzle to meter and mix the two injection adhesive components and inject the mixed adhesive into the crack. Use electric or air powered pumps that provide in-line metering and mixing.

Use injection equipment with automatic pressure control capable of discharging the mixed adhesive at any pre-set pressure up to  $200 \pm 5$  psi ( $1380 \pm 35$  kPa) and equipped with a manual pressure control override.

Use equipment capable of maintaining the volume ratio for the injection adhesive as prescribed by the manufacturer. A tolerance of  $\pm 5\%$  by volume at any discharge pressure up to 200 psi (1380 kPa) is permitted.

Provide injection equipment with sensors on both the Component A and B reservoirs that automatically stop the machine when only one component is being pumped to the mixing head.

## 7.0 PREPARATION

Follow these steps prior to injecting the epoxy resin:

- Remove all dirt, dust, grease, oil, efflorescence and other foreign matter detrimental to the bond of the epoxy injection surface seal system from the surfaces adjacent to the cracks or other areas of application. Acids and corrosives are not permitted.
- Provide entry ports along the crack at intervals not less than the thickness of the concrete at that location.
- Apply surface seal material to the face of the crack between the entry ports. For through cracks, apply surface seal to both faces.
- Allow enough time for the surface seal material to gain adequate strength before proceeding with the injection.

## 8.0 EPOXY INJECTION

Begin epoxy adhesive injection in vertical cracks at the lower entry port and continue until the epoxy adhesive appears at the next higher entry port adjacent to the entry port being pumped.

Begin epoxy adhesive injection in horizontal cracks at one end of the crack and continue as long as the injection equipment meter indicates adhesive is being dispensed or until adhesive shows at the next entry port.

When epoxy adhesive appears at the next adjacent port, stop the current injection and transfer the epoxy injection to the next adjacent port where epoxy adhesive appeared.

Perform epoxy adhesive injection continuously until cracks are completely filled.

If port to port travel of epoxy adhesive is not indicated, immediately stop the work and notify the Engineer.

## **9.0 FINISHING**

When cracks are completely filled, allow the epoxy adhesive to cure for sufficient time to allow the removal of the surface seal without any draining or runback of epoxy material from the cracks.

Remove the surface seal material and injection adhesive runs or spills from concrete surfaces.

Finish the face of the crack flush to the adjacent concrete, removing any indentations or protrusions caused by the placement of entry ports.

## **10.0 BASIS OF PAYMENT**

Payment for epoxy resin injection will be at the contract unit price per linear foot (meter) for "Epoxy Resin Injection". Such payment will be full compensation for all materials, tools, equipment, labor, and for all incidentals necessary to complete the work.

## EXAMPLE

### **2.0 SCOPE OF WORK**

Using Epoxy Resin Injection, repair all cracks 5mils (125  $\mu\text{m}$ ) wide or greater in the interior bent columns and caps, in the ends of the girders, in the cantilevered portion of the ends of the girders, and in the cantilevered portion of the superstructure deck on the downstream side.

Repair the column cracks to the top of the footings. Make the underwater repairs when water surface elevation is low and the water is still. For underwater repairs, use manufacturer recommended materials.

Repair any crack, void, honeycomb or spall area unsuitable for repair by injection with epoxy mortar.

NOTE: This part of the Special Provision must be written for each project.