

SECTION 03 64 23
EPOXY RESIN INJECTION GROUTING

PART 1 GENERAL

1.01 REFERENCES

A. The following is a list of standards which may be referenced in this section:

1. ASTM International (ASTM):
 - a. C882, Standard Specification for Test Method for Bond Strength of Epoxy Resin System Used with Concrete by Slant Shear.
 - b. D570, Standard Test Method for Water Absorption of Plastics.
 - c. D638, Standard Test Method for Tensile Properties of Plastics.
 - d. D648, Standard Test Method for Deflection Temperature of Plastics under Flexural Load in the Edgewise Position.
 - e. D695, Standard Test Method for Compressive Properties of Rigid Plastics.
 - f. D790, Standard Test Methods for Flexural Properties of Unreinforced and Reinforced Plastics and Electrical Insulating Materials.

1.02 DEFINITIONS

- A. Crack: Complete or incomplete separation of concrete into two or more parts produced by breaking or fracturing.
- B. Defective Area: As defined in Section 03 30 00, Cast-in-Place Concrete.
- C. Hydraulic Structure: Liquid containment structure and/or structure designed to mitigate liquid infiltration.
- D. Injection: Method of bonding together, addressing or eliminating leakage through cracks or joints by installing resin under pressure to fill the void in crack or joint.
- E. Joint: A planned and formed discontinuity in concrete structure at junction of adjacent and sequential concrete placements and may contain embedded waterstops.
- F. Leak or Leakage: Crack or joint exhibiting presence of moisture, sign of efflorescence, intermittently wet to touch, or continuous flow of liquid.
- G. Narrow Cracks: Width equal to or less than 0.015 inch.
- H. Wide Cracks: Wider than 0.015 inch.

1.03 SUBMITTALS

A. Action Submittals:

1. Physical and chemical properties for epoxy resin.
2. Technical data for metering, mixing, and injection equipment.
3. Depth of penetration, length, material used, and procedures where epoxy is approved for use.
4. Marked up drawings of proposed epoxy injection repair crack locations, widths, and lengths and direction on structure.
5. Sample bottle.
6. Pot Life Test.
7. Slant Shear Test (Bond Strength).

B. Informational Submittals:

1. Manufacturer's recommended surface preparation procedures and application instructions for epoxy resins.
2. Manufacturer's Certificate of Compliance in accordance with Section 01 67 00, Product Requirements. Certified test results for each batch of epoxy resin.
3. Statements of Qualification for Epoxy Resin:
 - a. Manufacturer's Site representative.
 - b. Injection applicator.
 - c. Injection pump operating technician.
4. Sample of epoxy resin two component ratio and injection pressure test records for concrete crack repair work.
5. Installation instructions for repairing core holes with repair mortar.
6. Health and Safety Plans for confined space entry. Test results of epoxy resin bond tests.
7. Epoxy resin two component ratio and injection pressure test records for concrete crack repair work.

1.04 QUALITY ASSURANCE

A. Qualifications for Injection Staffs:

1. Manufacturer's Site Representative:
 - a. Capable of instructing successful methods of epoxy injection process for concrete structure.
 - b. Understands and is capable of explaining technical aspects of correct material selection and use.
 - c. Experienced in operation, maintenance, and troubleshooting of application equipment.

2. Injection Crew and Job Foreman:
 - a. Provide written and verifiable evidence showing compliance with the following requirements:
 - 1) Licensed or certified by epoxy resin material manufacturer.
 - 2) Minimum 3 years' experience in successful epoxy injection for at least 10,000 linear feet of successful crack injection, including 2,000 linear feet of wet crack injection to stop water leakage.
- B. Injected Epoxy Resin:
 1. Fill cracks and joints with minimum resin depth penetration no less than 90 percent of:
 - a. Full thickness of concrete section for cracks or joints.
 - b. Depth between waterstop and inside outside face of structure for joints with an embedded waterstop.
- C. Injected cracks and joints which leak shall be considered deficient work irrespective of depth of penetration. Reinjection of deficient work or, with approval of Contracting Officer, provide other repairs to eliminate leakage.
- D. Bond Strength Test for Epoxy Resin:
 1. Concrete failure before resin failure.
 2. 1,500 psi minimum bond strength per ASTM C882 test requirements with no failure of either concrete or epoxy resin.

1.05 DELIVERY, STORAGE, AND HANDLING

- A. Packing and Shipping:
 1. Package resin material in new sealed containers and label with following information:
 - a. Manufacturer's name.
 - b. Product name and lot number.
 - c. ANSI Hazard Classification.
 - d. ANSI recommended precautions for handling.
 - e. Mix ratio by volume for components.
- B. Storage and Protection: Store epoxy resin material containers in accordance with manufacturer's printed instructions and at ambient temperatures below 110 degrees F and above 45 degrees F.

PART 2 PRODUCTS

2.01 EPOXY INJECTION RESIN

- A. Physical Characteristics: None.
- B. Functional Characteristics: None.
- C. Performance Characteristics:
 - 1. Two-component A and B structural epoxy resin for injection into cracks or joints or other voids in concrete structures for bonding or grouting.
 - 2. Uncured Resin Properties:
 - a. When mixed in ratio specified on resin container label:

	Test Method	Wide Cracks or Joints	Narrow Cracks or Joints
Pot Life (60-gram mass) @ 77, plus or minus 4 deg F	As specified in Article Source Quality Control	13 to 25 minutes	15 to 30 minutes
Pot Life (60-gram mass) @ 100, plus or minus 4 deg F	As specified in Article Source Quality Control	3 to 10 minutes	10 to 20 minutes
Viscosity @ 40, plus or minus 3 deg F	Brookfield RVT Spindle No. 4 @ 20 rpm	4,400 cps	600 cps
Viscosity @ 75 to 77 deg F	Brookfield RVT Spindle No. 2 @ 20 rpm	375 to 350 cps	175 to 140 cps

- 3. Epoxy Resin Properties: When cured for 7 days at 77 degree F, plus or minus 3 degrees F and conditioned at test temperature 12 hours prior to test, unless otherwise specified.

	Test Method	Wide Cracks or Joints	Narrow Cracks or Joints
Ultimate Tensile Strength, psi	ASTM D368	8,000 min.	5,000 min.
Tensile Elongation @ Break, percent	ASTM D638	4.2 max.	3.0 max.
Flexural Strength, psi	ASTM D790	10,000 min.	10,000 min.
Flexural Modulus, psi	ASTM D790	5.5 x 10 ⁵ min.	4.5x10 ⁵ min.
Compressive Yield Strength, psi	ASTM D695*	15,000 min.	12,000 min.
Compressive Modulus, psi	ASTM D695*	4.0x10 ⁵ min.	4.0x10 ⁵ min.

	Test Method	Wide Cracks or Joints	Narrow Cracks or Joints
Heat Deflection Temperature	ASTM D648*	130 deg F min.	140 deg F min.
Cured 3 days @ 40 deg F – Wet Concrete		3,500 psi min.	3,500 psi min.
Cured 1 day @ 77 deg F – Dry Concrete		5,000 psi min.	5,000 psi min.
Cured 3 days @ 77 deg plus or minus 3 deg F		5,000 psi min.	5,000 psi min.
*Cure test specimens so that peak exothermic temperature of resin does not exceed 100 degrees F.			
Note: See referenced specifications for preparation method of test specimens.			

2.02 SURFACE SEAL

- A. Sufficient strength and adhesion for holding injection fittings firmly in place and to resist pressures preventing leakage during injection.
- B. Capable of removal after injection resin has cured.

2.03 WATER

- A. Clean and free from oil, acid, alkali, organic matter, or other deleterious substances, meeting federal drinking water standards.

2.04 SAMPLE BOTTLE

- A. Five-inch natural wide mouth HDPE bottle or 4-ounce clear PVC cylinder bottle; supplied with caps.

2.05 SOURCE QUALITY CONTROL

- A. Test Requirements: Perform tests for each batch of epoxy resin.
- B. Pot Life Test:
 1. Condition Component A and Component B to required temperature.
 2. Measure components in ratio of Component B as stated on manufacturer's label into an 8-fluid ounce paper cup.
 3. Mix components for 60 seconds using non-metallic stirring instrument. Scrape sides and bottom of cup periodically.
 4. Probe mixture once with non-metallic stirring instrument every 30 seconds, starting 2 minutes prior to minimum specified pot life.
 5. Pot Life Definition: Time at which a soft stringy mass forms in center of cup.

- C. Slant Shear Test: Prepare specimens and perform tests in accordance with ASTM C882.

PART 3 EXECUTION

3.01 GENERAL

- A. Unless permitted otherwise, structurally repair cracks or joints listed below:
 - 1. Cracks considered to be defective as defined in Section 03 30 00, Cast-in-Place Concrete.
- B. Do not proceed with injection work until submittals have been reviewed and approved by Contracting Officer.
- C. Perform cracks or joints injection work after removing defective surface materials and after performing surface preparation, but prior to applying surface repair material unless otherwise noted. See Section 03 01 32, Repair of Vertical and Overhead Concrete Surfaces, Section 03 01 33, Repair of Horizontal Concrete Surfaces, for concrete surface repair system.
- D. Width of cracks may vary along length and through thickness of concrete section.
- E. Remove all excess, unused epoxy resin materials on concrete surfaces exposed to view prior to end of Work.

3.02 EQUIPMENT

- A. Portable, positive displacement type pumps with in-line metering to meter and mix two epoxy resin components and inject mixture into cracks or joints.
- B. Pumps:
 - 1. Electric or air powered with interlocks providing positive ratio control of proportions for the two components at nozzle.
 - 2. Primary injection pumps for each material of different mix ratio, including a standby backup pump of similar ratio.
 - 3. Capable of immediate compensation for changes in resins.
 - 4. Do not use batch mix pumps.
- C. Discharge Pressure: Automatic pressure controls capable of discharging mixed epoxy resin at pressures in accordance with epoxy resin manufacturer's printed instruction and able to maintain pressure.
- D. Automatic Shutoff Control: Provide sensors on both Component A and Component B reservoirs for stopping machine automatically when only one component is being pumped to mixing head.

- E. Proportioning Ratio Tolerance: Maintain epoxy resin manufacturer's prescribed mix ratio within a tolerance of plus or minus 5 percent by volume at discharge pressure up to 160 psi.
- F. Ratio/Pressure Check Device:
 - 1. Two independent valve nozzles capable of controlling flow rate and pressure by opening or closing valve to restrict material flow.
 - 2. Pressure gauge capable of sensing pressure behind each valve.

3.03 PREPARATION

- A. Free cracks or joints from loose matter, dirt, laitance, oil, grease, efflorescence, salt, and other contaminants.
- B. Clean cracks or joints in accordance with epoxy resin manufacturer's instructions.
- C. Clean surfaces adjacent to cracks or joints from dirt, dust, grease, oil, efflorescence, and other foreign matter detrimental to bond of surface seal system and to expose the full extent of cracks and joints in accordance with manufacturer's printed instruction by low pressure water cleaning using a pressure of 1,000 psi to 3,000 psi.
- D. Do not use acids and corrosives for cleaning, other than those specified herein unless neutralized prior to injecting epoxy resin.
- E. During installation and curing of materials, if ambient temperature is expected to drop below manufacturer's recommended minimum temperature, provide enclosures and heat as required.
- F. Provide work platforms as required.
- G. Dry out cracks or joints if required by manufacturer's instructions.

3.04 APPLICATION

- A. All liquid is to be removed from hydraulic structure prior to commencing with epoxy injection, unless approved otherwise.
- B. Entry Ports:
 - 1. Establish openings for epoxy resin entry in surface seal along crack.
 - 2. Determine space between entry ports equal to thickness of concrete member to allow epoxy resin to penetrate to the full thickness of the member.
 - 3. Drill injection holes at an angle between 45 degrees and 60 degrees from surface of concrete and perpendicular to alignment of cracks or

joints, to intersect crack or joint at midpoint of concrete section, and intersect joints at midpoint between waterstop and interior concrete surface, except as noted otherwise.

4. Locate drill holes on alternate sides of crack or joint where possible, unless orientation of crack or joint is known or has been verified by non-destructive testing techniques or core drilling.
5. Drill Hole Spacing: Do not to exceed concrete thicknesses or 12 inches maximum, except as noted otherwise.
6. Adjust location and angle of drill holes to suit orientation of crack or joint and at commencement of drilling holes for injection and at beginning of each subsequent shift.
7. Take measures to prevent drilling holes for injection too shallow or too deep, or damaging existing waterstop in joints.
8. Remove dust and debris in drill holes and on surface of structure resulting from drilling operation, by flushing with water prior to installing the injection packers or ports.
9. Space entry ports closer together to allow adjustment of injection pressure to obtain minimum loss of epoxy to soil at locations where:
 - a. Cracks or joints extend entirely through concrete element.
 - b. Backfill of walls on one side.
 - c. Slab-on-grade.
 - d. Difficult to excavate behind wall to seal both surfaces of crack.
10. Install injection packers or ports in drill holes in accordance with manufacturer's printed instructions with zerk coupling or other one-way ball or check valve, to permit testing for watertightness and acid flushing of cracks and joints.

C. Application of Surface Seal along Cracks and Joints:

1. Apply surface seal in accordance with manufacturer's instructions to designated cracks and joints face prior to injection. Seal surface of cracks or joints to contain and prevent escape of injection epoxy.
2. Cure surface seal in accordance with manufacturer's printed instructions before commencing inject work.

D. Epoxy Injection:

1. Ensure zerk coupling is not installed in ports or packers next to the one being injected.
2. Start injection into each crack or joint at lowest elevation entry port or packer along vertical or diagonal crack or joint, and at one end of horizontal crack or joint.
3. Where injection entry ports or packers are used, continue injection at first port or packer until resin begins to flow out of port or packer at next highest elevation. Plug first port or packer and start injection at second port or packer until resin flows from next port or packer.

4. Inject entire crack or joint with same sequence.
5. At no time inject more than 6 feet length of first vertical crack or joint before verifying resin in sample bottle has start to set and cure.
6. Prior to commencing injection work along a horizontal crack or joint in structure when processed using ports or packers with zerk couplings are used, remove zerk couplings from injection ports or packers except for two ports or packers located where injection work will commence. Commence injection work in first two ports or packers. Once clean resin is vented from third injection port or packer, cease injection at first port or packer, and install zerk coupling and commence injection at third port or packer. Repeat process for fourth and subsequent ports or packers until full length of crack or joint has been injected.

E. Finishing:

1. Allow epoxy resin to cure in accordance with manufacturer's instruction after cracks or joints have been completely injected to allow surface seal removal without draining or runback of uncured epoxy resin material from cracks or joints.
2. Remove surface seal and injection packers or ports from cured injection resin along crack.
3. Finish crack or joint faces flush with adjacent concrete.
4. Indentations or protrusions caused by placement of entry ports, packers, drill holes, or damage from removal of surface seal is not acceptable.
5. Grind off protrusions and patch indentations and holes from injection packers and entry ports with a suitable patch material to satisfaction of Contracting Officer.
6. Remove surplus surface seal material splatters and injection resin material runs and spills from concrete surfaces.

3.05 FIELD QUALITY CONTROL

A. Epoxy Resin Two Component Ratio Tests:

1. Disconnect mixing head and pump two resin components simultaneously through ratio check device.
2. Adjust discharge pressure to 160 psi for both resin components.
3. Simultaneously discharge both resin components into separate calibrated containers.
4. Compare amounts simultaneously discharged into calibrated containers during same time period to determine mix ratio.
5. Complete test at 160 psi discharge pressure and repeat procedure for 0 psi discharge pressure.
6. Run ratio test for each injection unit at beginning and end of each injection work day, and when injection work has stopped for more than 1 hour.

7. Document and maintain complete accurate records of ratios and pressure checks.

B. Injection Pressure Test:

1. Disconnect mixing head of injection equipment and connect two resin component delivery lines to pressure check device.
2. Pressure Check Device:
 - a. Two independent valved nozzles capable of controlling flow rate and pressure by opening or closing of valve.
 - b. Pressure gauge capable of sensing pressure buildup behind each valve.
3. Close valves on pressure check device and operate equipment until gauge pressure on each line reads 160 psi.
4. Stop pumps and observe pressure; do not allow pressure gauge to drop below 150 psi within 3 minutes.
5. Run pressure test for each injection equipment unit:
 - a. Beginning and end of each injection work day.
 - b. When injection work stop for more than 45 minutes.
6. Check tolerance to verify equipment capable of meeting specified ratio tolerance.

C. Bottled Sample Tests:

1. During injection operation, provide at least one sample of mixed epoxy resin for each injection pump per shift per injection work day in a sample bottle.
2. Provide sufficient sample to demonstrate sample material epoxy resin will set and cure correctly.
3. Label each bottled sample with Contractor's name, date, and time sample was taken, and location in structure where sample was taken. Record details of bottle sample tests.
4. Place filled sample bottle upright in a container and allow sample to cure.
5. After sample has been allowed to cure, cut bottled sample open and visually inspect contents to verify that epoxy resin material has completely reacted and cured.
6. Evaluation and Assessment of Test:
 - a. Should bottled sample(s) indicate a problem; such as epoxy resin not cured or foreign liquid in sample bottle, take verifying core sample immediately from cracks or joints, where material was used.
 - b. Should above-referenced bottle sample(s) and core sample(s) indicate a problem with epoxy resin, arrange to have a Technical Representative of the epoxy resin manufacturer come to Site to review bottled sample(s) and core drilled sample(s) with

Contracting Officer and provide technical advice on corrective measures.

- c. Carry out further investigation work or corrective measures recommended by Technical Representative of epoxy resin manufacturer.

END OF SECTION

