



ABCD Technical Seminar

Accelerated Bridge Construction with Precast Structures

Richard Tate and Kevin Grant



Contech Engineered Site Solutions



Bridge, Drainage, Erosion Control, Retaining Walls, Sanitary, Soil Stabilization, Stormwater, Wastewater Treatment

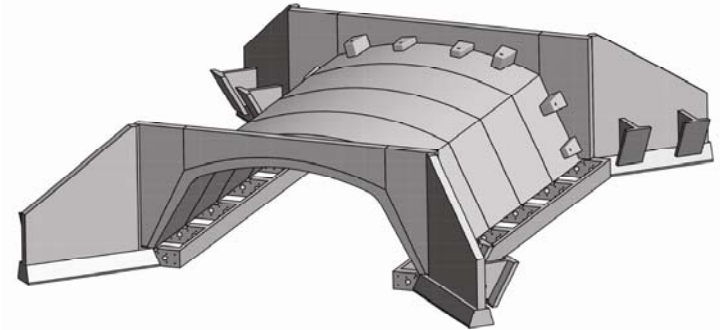
Contech. Your project partner.

- Bridge, Erosion Control, Pipe, Retaining Wall, Stormwater and Wastewater Treatment Solutions
- Over 60 Engineers and CAD Specialists
- 200 Sales Engineers and Project Consultants covering all 50 States
- Over 100 years experience in the Construction Industry



Contech. Your project partner.

- Summary & Overview Bridge Portfolio
- Innovative Bridge Developments
- Engineering Support & Design Tools
- Contech's Consultative Approach



Building Blocks to a successful Project

Planning & Solution Development

- Project Design Worksheet
- Structure Selection
- Siting & Layout
- DYOB
- Engineer Estimate
- Site Simulation
- Proposal Preparation
- Design Build Support

Design Support

- Specifications
- Contract Drawings
- Permitting
- Structural/Fabrication Drawings
- Approval Assistance
- Custom Shape Development
- Horizontal/Vertical Alignment
- Hydraulics & Scour Support
- Foundations

Installation Support

- Preconstruction Meeting
- On-Site Installation Assistance
- Logistics Coordination

FHWA Accelerated Bridge Program



U.S. Department of Transportation
Federal Highway Administration

Accelerated Bridge Program



U.S. Department of Transportation
Federal Highway Administration

Accelerated Bridge Construction (ABC):

- ABC is bridge construction that uses innovative planning, design, materials, and construction methods in a safe and cost-effective manner to reduce the onsite construction time that occurs when building new bridges or replacing and rehabilitating existing bridges

Prefabricated Bridge Elements and Systems

- PBES are structural components of a bridge that are built offsite, or near-site of a bridge and include features that reduce the onsite construction time and the mobility impact time that occurs when building new bridges or rehabilitating or replacing existing bridges relative to conventional construction methods.

Connection Details for Prefabricated Bridge Elements and Systems



March 30, 2009

Figure 2.4.3-1 depicts a proprietary arch system call the Con/Span[®] Bridge System. This system, including the arch elements, the spandrel walls, the wingwalls and the footings, can be completely made with precast concrete elements. The connections shown in Figure 2.4.3-1 are described in the following sections.

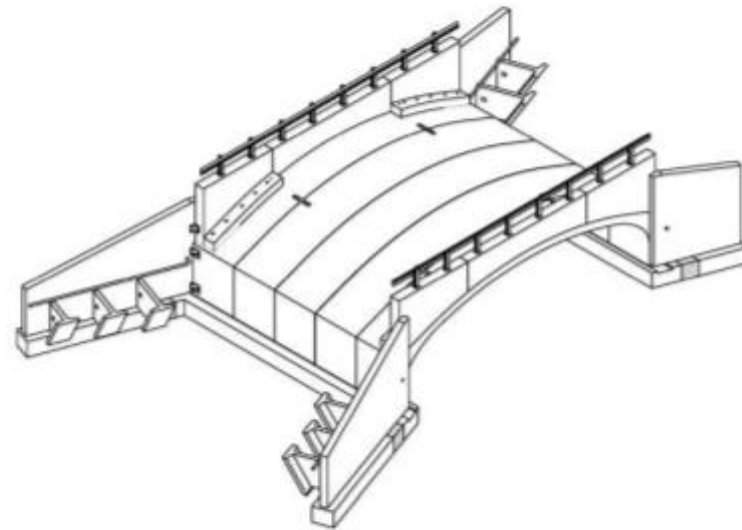


Figure 2.4.3-1 Con/Span[®] Bridge System

“Prefabricated elements of a bridge produced off-site can be assembled quickly, and can reduce design time and cost, minimize forming, minimize lane closure time and/or possibly eliminate the need for a temporary bridge.”

Bridge Overview Plate, Precast & Truss



Plate, Precast & Truss

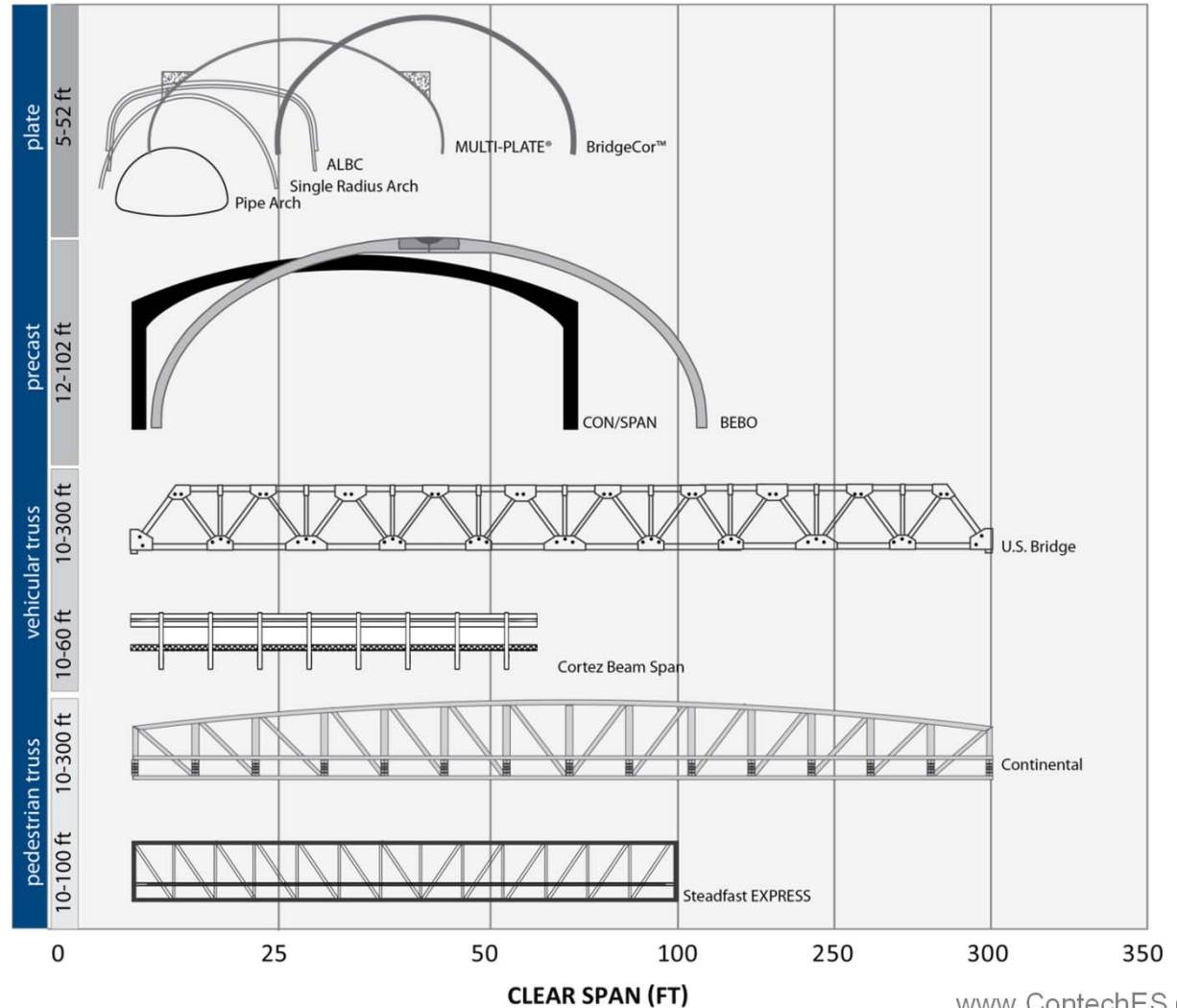
MULTI-PLATE®
Aluminum Structural Plate
Aluminum Box Culvert
SUPER-SPAN™
SUPER-PLATE®
BridgeCor™

CON/SPAN®
BEBO®

U.S. Bridge (Vehicular)

Continental® Bridges
(Pedestrian)

Steadfast EXPRESS
(Pedestrian)

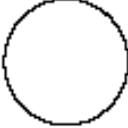



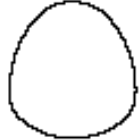









Contech Structural Plate



CONTECH[®]
STRUCTURAL PLATE

Structural Plate Shapes

Shapes		Sizes — Span x Rise		
Round		5' to 26'	Arch (single radius)	 5' x 1'9" to 25' x 12'6"
Vertical Ellipse		4'8" x 5'2" to 25' x 27'7"	Low-Profile Arch *	 20'1" x 7'6" to 45'0" x 18'8"
Underpass		12'2" x 11'0" to 20'4" x 17'9"	High-Profile Arch *	 20'1" x 9'1" to 35'4" x 20'0"
Pipe-Arch		6'1" x 4'7" to 20'7" x 13'2"	Pear-Arch	 23'-11" x 23'-4" to 30'-4" x 25'-10"
Horizontal Ellipse		7'4" x 5'6" to 14'11" x 11'2"	Pear	 23'-8" x 25'-5" to 29'-11" x 31'-3"
			Horizontal Ellipse	 19'4" x 12'9" to 37'2" x 22'2"
			Box Culvert	 8'9" x 2'6" to 35'-3" x 13'-7"

Precast – CON/SPAN and BEBO Concrete Arches



Precast Bridge Arches



CON/SPAN[®]



BEBO[®] E-Series



BEBO[®] C-Series

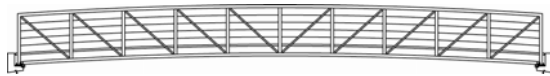


BEBO[®] T-Series

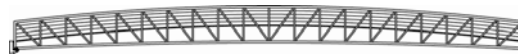
Truss Bridges – Pedestrian and Vehicular



Pedestrian Truss Bridge Styles



Connector[®]



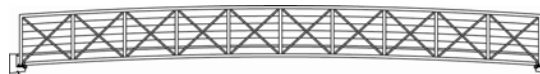
Capstone[®]



Keystone[®]



Gateway[®]

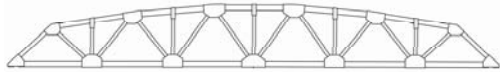


Link[®]



Cable Stayed

Vehicular Truss Bridge Designs



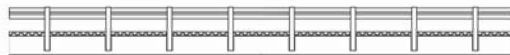
The Cambridge



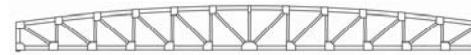
The Cambridge Flat



The Seneca



The Cortez



The Viking



Precast	Plate	Truss
50 years	80 years	60 years
8,000 installations	50,000 installations	20,000 installations
..... Comprehensive Engineering Support		
.....Installations In Every State.....		

Applications



Applications



A new generation of innovation...

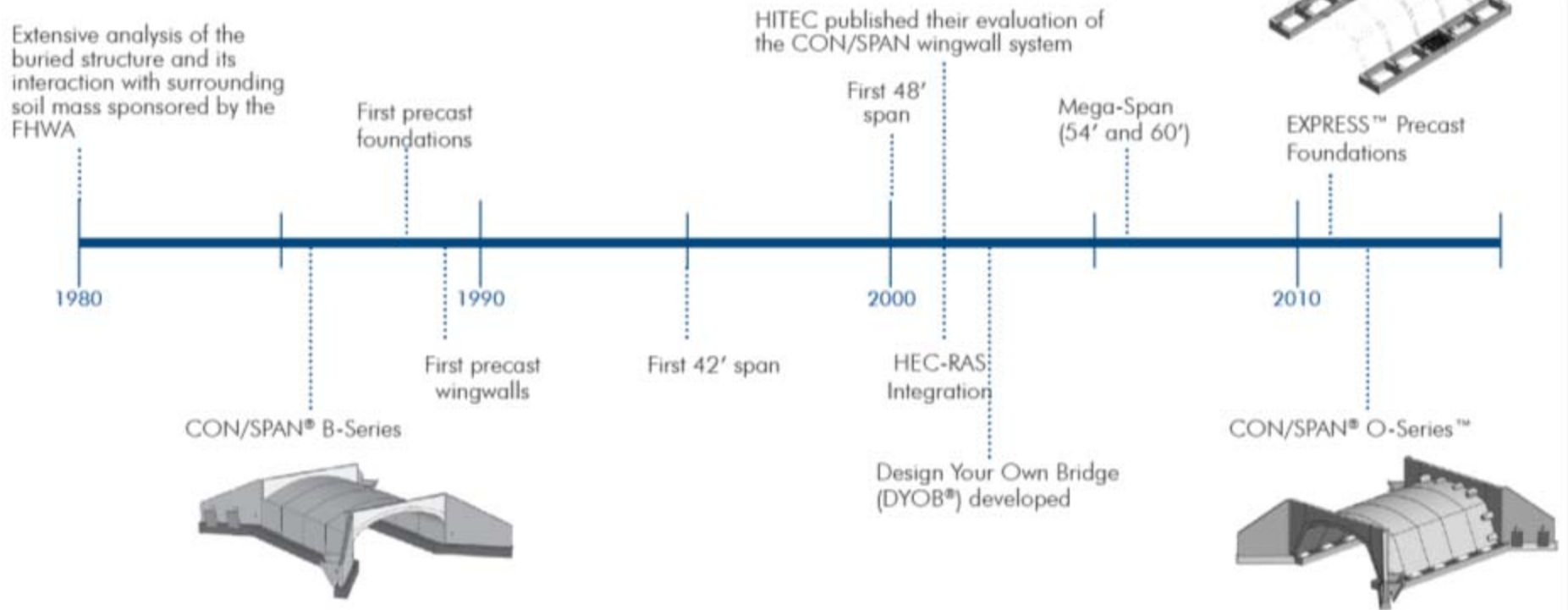
- # 1  **CON SPAN**[®]
-SERIES
- # 2 **BridgeCor**[™]
- # 3 **EXPRESS**[™] Foundations
- # 4  **U.S. BRIDGE**[®]
BRIDGING AMERICA SINCE 1936 Thru Truss

Innovation #1:

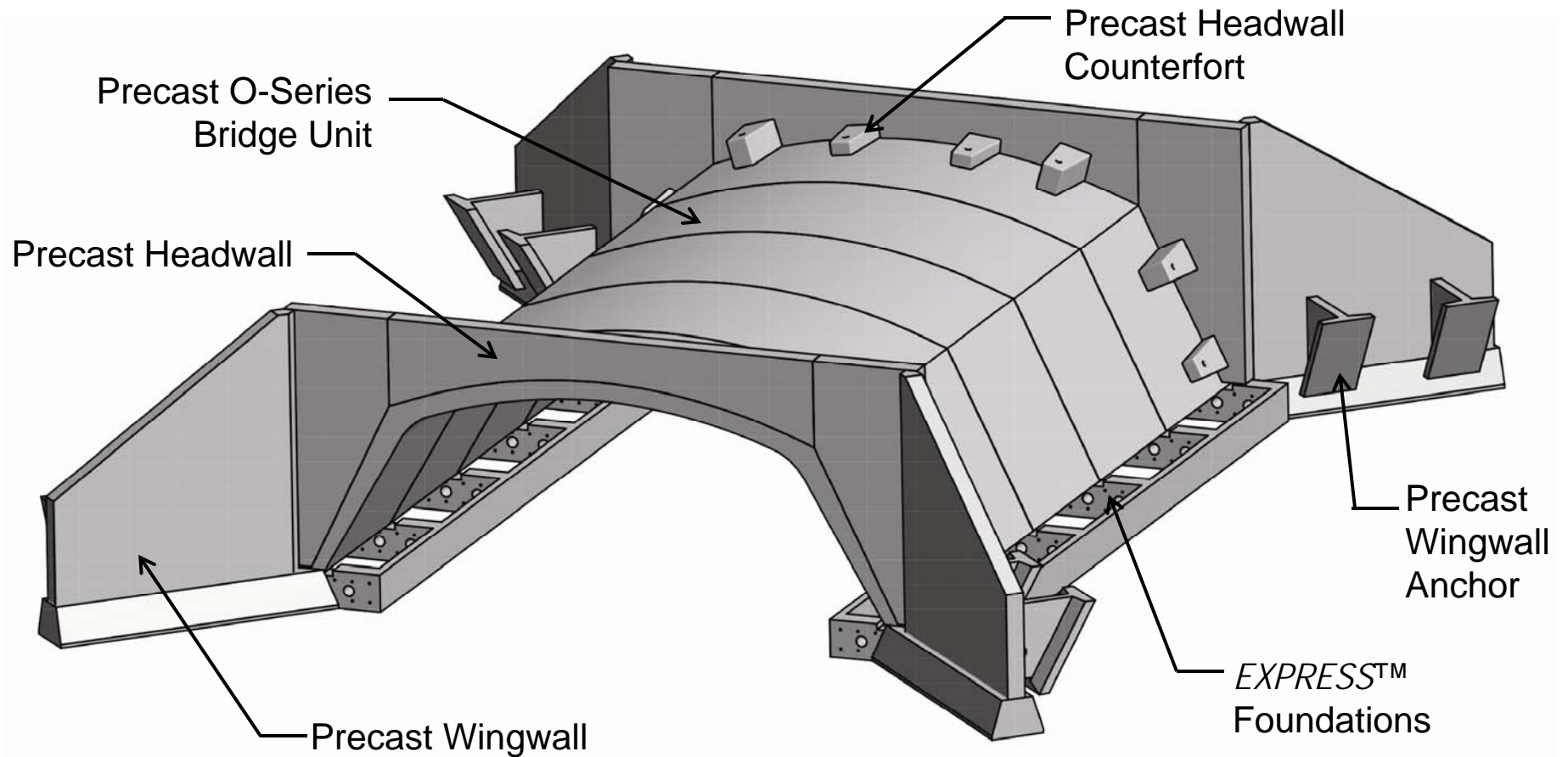




A Legacy of Innovative Technologies...



CON SPAN.
-SERIES

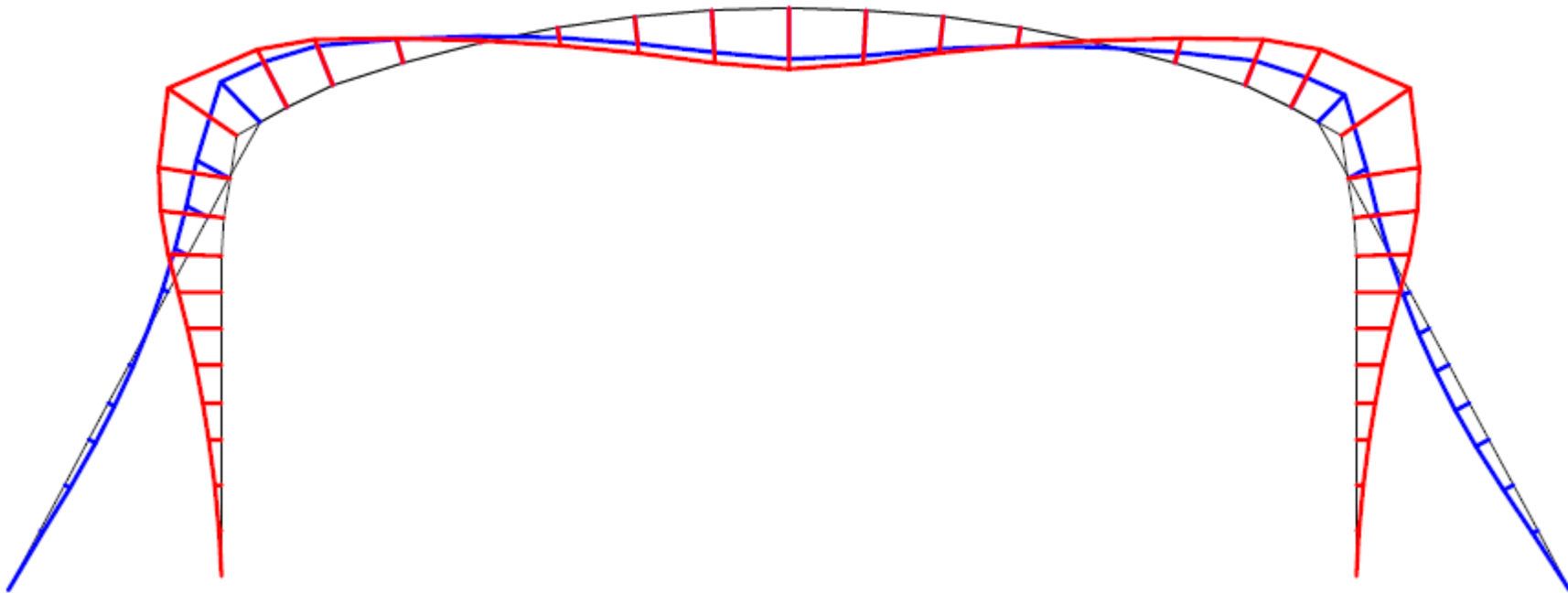




CON SPAN[®]
-SERIES[™]

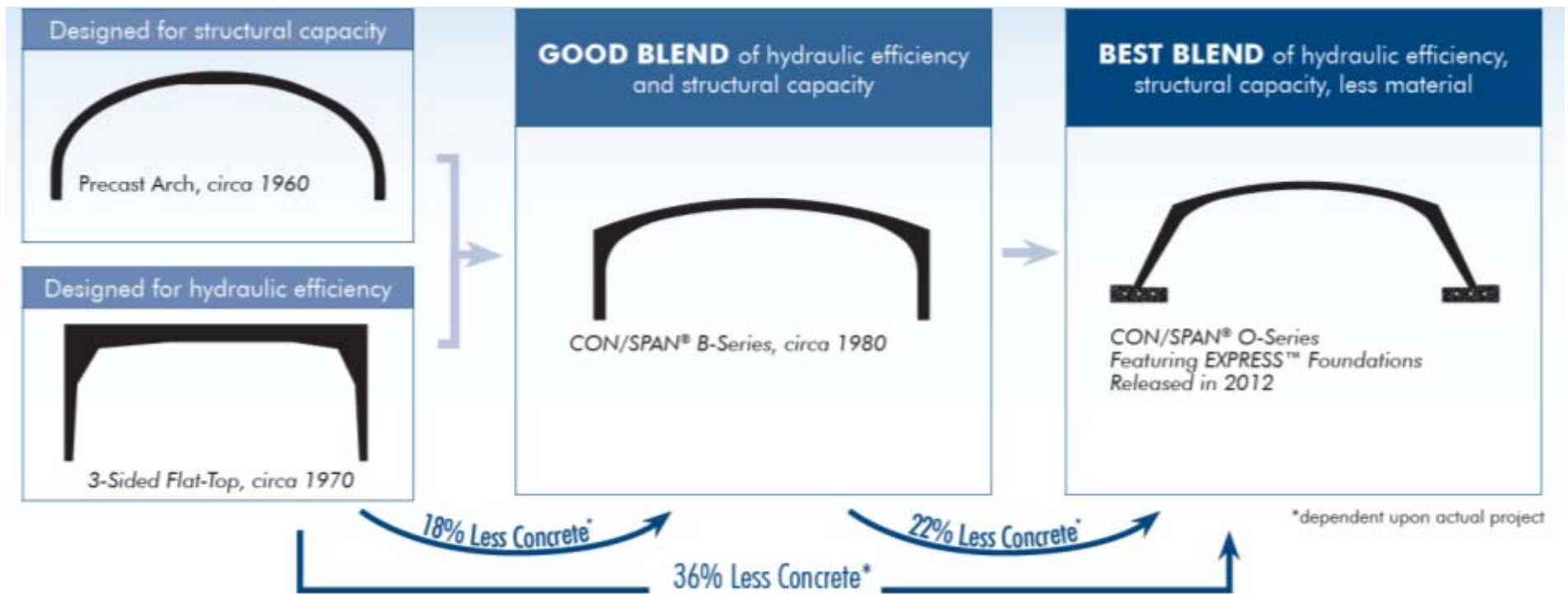


O-Series Moment Reduction



- Moment Diagram for HS25 Live Load, 2'-0" Cover
- O-Series results in:
 - Maximum positive and negative moment reduced
 - Required A1 and A3 steel areas *reduced*

Taken to the Next Level of Optimization



Any Application, Many Solutions – You Optimize

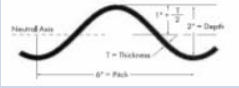
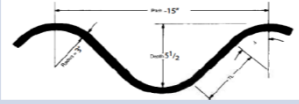
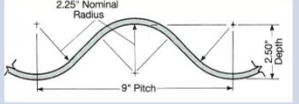
Wetlands & Clear Spanning	Hydraulic Optimization	Clearance Box/Grade Separation Optimization
		
 <p data-bbox="289 1105 527 1130">CON/SPAN® O-Series™</p>	 <p data-bbox="932 1101 1178 1125">CON/SPAN® O-Series™</p>	 <p data-bbox="1583 984 1829 1008">CON/SPAN® O-Series™</p> <p data-bbox="1415 1130 1633 1154">CON/SPAN® B-Series</p> <p data-bbox="1772 1130 1898 1154">BEBO® Arch</p>
<p data-bbox="128 1179 548 1247">Maximizing span for sensitive environmental conditions.</p>	<p data-bbox="751 1179 1318 1247">Maximizing waterway and span area for hydraulic efficiency.</p>	<p data-bbox="1373 1179 1961 1247">Minimizing excess materials, while closely matching clearance diagram.</p>



Duanesburg-Churches Road Bridge Replacement
Duanesburg, New York

Innovation #2:

BridgeCor[™]

	MULTI-PLATE	BridgeCor	Aluminum Structural Plate
Corrugation Profile			
Corrugation	6" x 2"	15" x 5 1/2"	9" X 2 1/2"
Corrugation Benefit	Standard structural plate profile Broadens size range over CMP	Deeper corrugation adds strength and stiffness Allows for longer spans and material efficiency	Corrugation used for ALSP and ALBC structures
Common Span Applications	> 5' - < 26'	> 20' - < 65'	> 6' - < 36'
Gage Benefit	Stiffer and Stronger than conventional CMP	Lighter gages in wider spans provides additional design options	Used in conjunction with ribs to provide strength Longest durability in the industry

BridgeCor™






Applications

- Wetland / Wildlife Crossings
- Mining or Heavy Loading Conditions
- Railroad
- Convert Conventional Bridges to Buried Structures

Specifications

- AASHTO Section 12.8.9
- AASHTO LRFD 12.9
- AASHTO M-167
- ASTM A-761

Available Shapes

Invert Structures		
	Round	19'-50' Diameter
	Ellipse	Custom Sizes
Arch Structures		
	Single Radius Arch	22'-54' Spans
	Multiple Radius Arch	22'-50' Spans <i>(Up to 65' custom)</i>
Box Culverts		
	Box Culvert	18'-35' Spans <i>(Up to 45' custom)</i>

Design Challenge »

- **Structure** – 2-radius arch
- **Stream width** – 40' clear span required
- **Application** – wildlife crossing
- **Length** – 260'

	SUPER-SPAN	BridgeCor
Corrugation	6"X2"	15"X5.5"
Structure	138A39	28A8
Span	42'-3"	42'-7"
Rise	15'-5"	15'-6"
End Area	510 sf	525 sf
Min. Cover	48"	30"
Gage	1	7
Weight/Ft.	940	680
Total Weight	244,400 lbs	176,800 lbs
Number of Trucks	6	4

A MINIMUM 35% COST SAVINGS

NOTE: A minimum of 35% cost savings for an erected structure. Total structure weight is less. Less trucks to the jobsite. In a low cover application, the SUPER-SPAN® will not meet specification design requirements.

A Simple Cost Comparison

BridgeCor™

VS



- **BridgeCor - 35% cost savings for an installed structure**
 - Lower overall assembly cost
 - Eliminates SUPER SPAN thrust beams
 - Reduces the amount of monitoring required
-
- **BridgeCor - Weight is less than SUPER SPAN**
 - 2 less trucks to the jobsite
- **BridgeCor - Less soil cover than SUPER SPAN**
 - At 3.0 feet of cover a SUPER SPAN structure design will not work

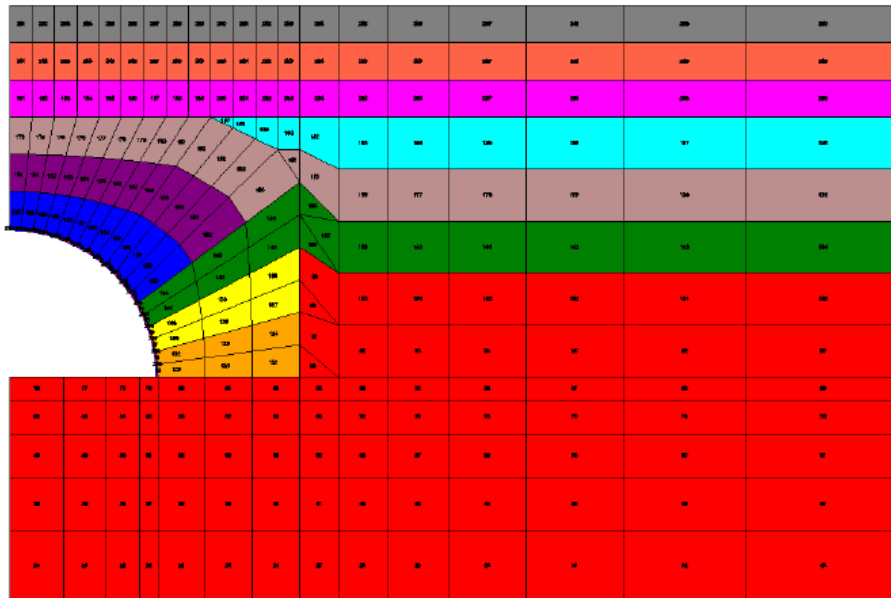
Building Blocks to a Successful Project

Solution
Development

Design Support

Installation

- Finite element analysis to optimize structure gage per AASHTO



- Certified BridgeCor assemblers are available





Pierre Creek Culvert Replacement
Boys, Washington

Innovation #3:

EXPRESS[™] Foundations



Cast-in-place



Precast foundation
(minimal continuity)



Precast Foundation with
closure pour



EXPRESS™ Foundations

EXPRESS[™] Foundations

A precast foundation system that blends the speed of precast with the economy of cast-in-place

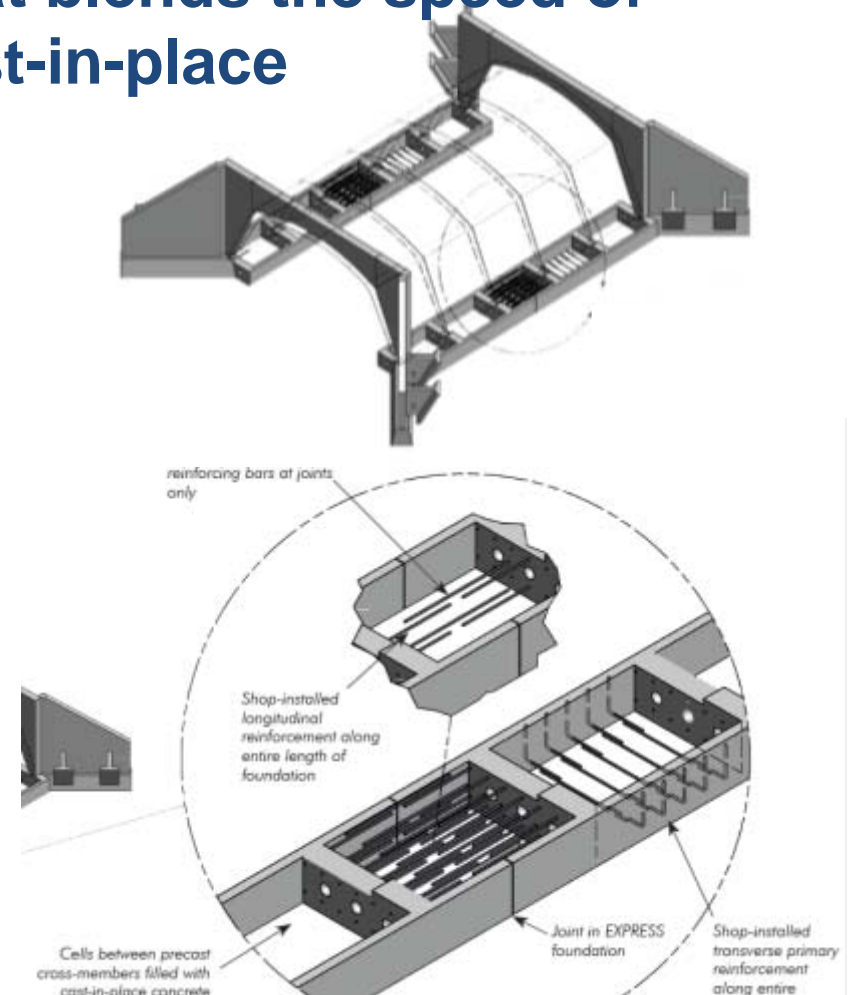


EXPRESS[™] Foundations

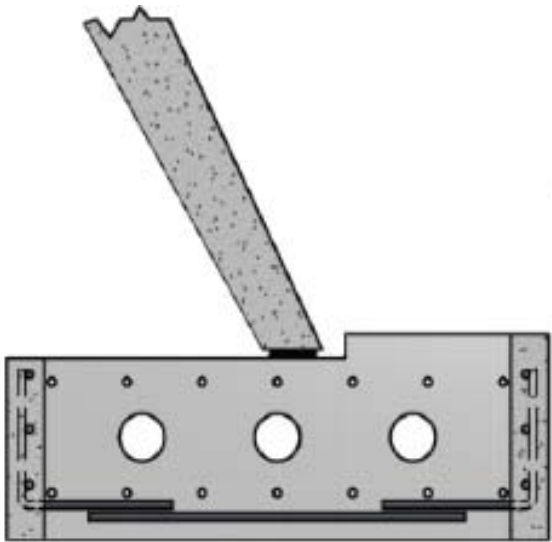
A precast foundation system that blends the speed of precast with the economy of cast-in-place

Benefits to You:

- Provides ease and speed of installation
- Alleviates hazardous working conditions
- Trapezoidal foundation reduces wingwall concrete quantities
- Minimal reinforcement to be placed on site
- Pick weights and sizes customized to your equipment

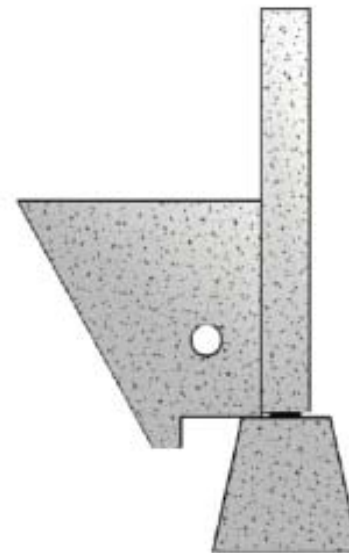


EXPRESS[™] Foundations



Example: 6'x2' foundation

- *27% Precast*
- *73% Poured in place concrete*



*Cross section of
wingwall foundation
(20% material savings versus
rectangular foundation)*

EXPRESS[™] Foundations

Construction Process:

- Excavate and prepare foundation subgrade
- Unload and set precast channels
- Place minimal reinforcing at joints to provide foundation continuity
- Set precast bridge units, headwalls and wingwalls
- Pour cast-in-place concrete
- Seal joints, grout wingwalls and backfill.





Frenchtown Brook Bridge Replacement
East Greenwich, Rhode Island



Frenchtown Brook Bridge Replacement
East Greenwich, Rhode Island

Innovation #4:



Thru Truss

U.S. Bridge Thru Truss – 300' Span



- All Bolted connections for ease of installation, inspection and maintenance
- Galvanized finish w/ 35-year warranty for extended life spans
- On site erection support expertise & assistance by manufacturing representative for ease of installation & quality assurance
- Pre Engineered and Pre Fabricated for lower design and installation costs
- Industry leader with 15,000 installations since 1936
- Clear spans up to 300' for environmentally sensitive sites

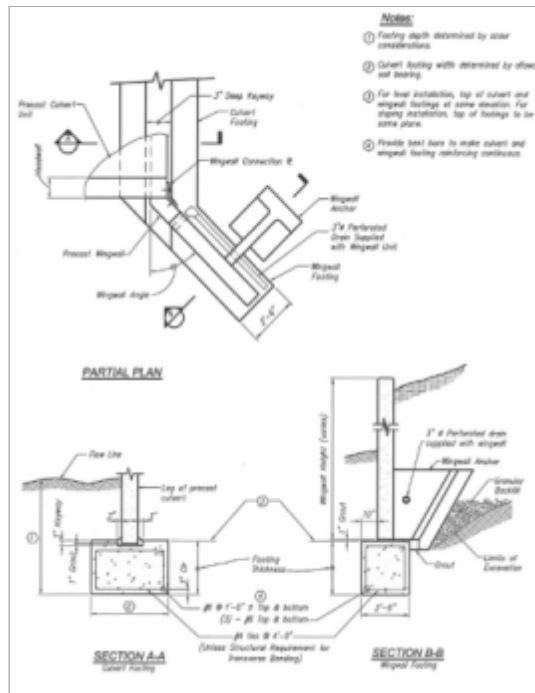
Building Blocks to a Successful Project

Solution
Development

Design Support

Installation

- Horizontal and vertical reactions
- Foundation sizing
- Foundation design calculations
- Foundation drawings



C-18

SAMPLE BRIDGE FOOTING CALCULATIONS			
JOB #		DATE: 24-JJ-02	
NAME: Foundation Design Example		DESIGNER:	
Note: Engineer of Record shall be responsible for accuracy of calculations in this spreadsheet.			
LOADS:			
Load, at structure center	3.0 k/ft, max	vertical load, per leg, R_v	12.1 k/ft
bridge span	20 ft	live load percentage	10%
bridge toe	5.0 ft	horizontal load, per leg, R_h	0.6 k/ft
live load	HS 20-44		
FOOTING WIDTH:		UNREINFORCED BENDING CHECK:	
base width (1 for yes, 0 for no)	0	Per AASHTO § 8.10.2.1.1	
Footing depth (incl. keyway), D	3.25 ft	$T_u = 60.0 \text{ k/ft}$	
Footing offset, e	0.0 ft	$T_u = 4.9 \text{ k/ft}$	
Total load per footing	12.1 k/ft	$T_u = 1.83 \text{ k/ft}$	(w/tp footing only)
Existing overburden depth	0.0 ft	$R_u = 4.51 \text{ k/ft}$	
Net allowable bearing	3.0 k/ft	$\gamma = 12.0 \text{ ft}$	
Gross allowable bearing	3.0 k/ft	$I = 13024 \text{ ft}^4$	
Total footing width	4.0 ft	$\phi_{bending} = 100 \text{ psi}$	
Actual footing width, B	4.5 ft	$\phi_{bending} = 47 \text{ psi}$	
Actual bearing load	2.68 k/ft		
	OK		
Per AASHTO § 4.4.11.6.1			
Bending need not be considered unless projection of footing from face of supported member exceeds footing thickness.			
REINFORCEMENT (BENDING, FACTORED LOADS):		REINFORCEMENT (BENDING, SERVICE LOADS):	
$\phi_{bending} = 2.3 \text{ k/ft}$		Per AASHTO § 8.10.4	
$\phi_{bending} = 0.4 \text{ k/ft}$		$\phi_{bending} = 0.13 \text{ ft}^2/\text{ft}$	
$\phi_{bending} = 2.9 \text{ k/ft}$		$R_u = 4.51 \text{ k/ft}$	
$\phi_{bending} = 0.9 \text{ k/ft}$		$\gamma = 8.04$	
$\phi_{bending} = 3.0 \text{ k/ft}$		$\gamma_{allow} = 0.0335$	
$R_u = 0.5 \text{ k/ft}$		$\gamma = 0.088$	
$\gamma = 20.8 \text{ ft}$		$\beta = 20.14$	
$R_u = 17 \text{ psi}$		$T_{allow} = 20.51 \text{ k/ft}$	
$\gamma = 17.65$		$\phi_s = 2.25 \text{ in}$	
$\phi_{bending} = 0.0033$		$A_s = 81.2 \text{ in}^2/\text{ft}$	
$\phi_{bending} = 0.0037 = 1.2\%$		$Z = 176$	
$\phi_{bending} = 0.0214$		$T_{allow} = 28.88 \text{ k/ft}$	
$\phi_{bending} = 0.0034$			
$\phi_{bending} = 0.05 \text{ ft}^2/\text{ft}$			
The bars = #4 @ 18 in		$\phi_s = 0.4 \text{ k/ft}$	
Long. bars = #6 @ 12 in		$\phi_s = 25.8 \text{ k/ft}$	
	OK		
		CHECK SHEAR:	
		$\phi_v = 0.4 \text{ k/ft}$	
		$\phi_v = 25.8 \text{ k/ft}$	
		SHEAR IS OK	

A new generation of innovation...

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Industry Trends

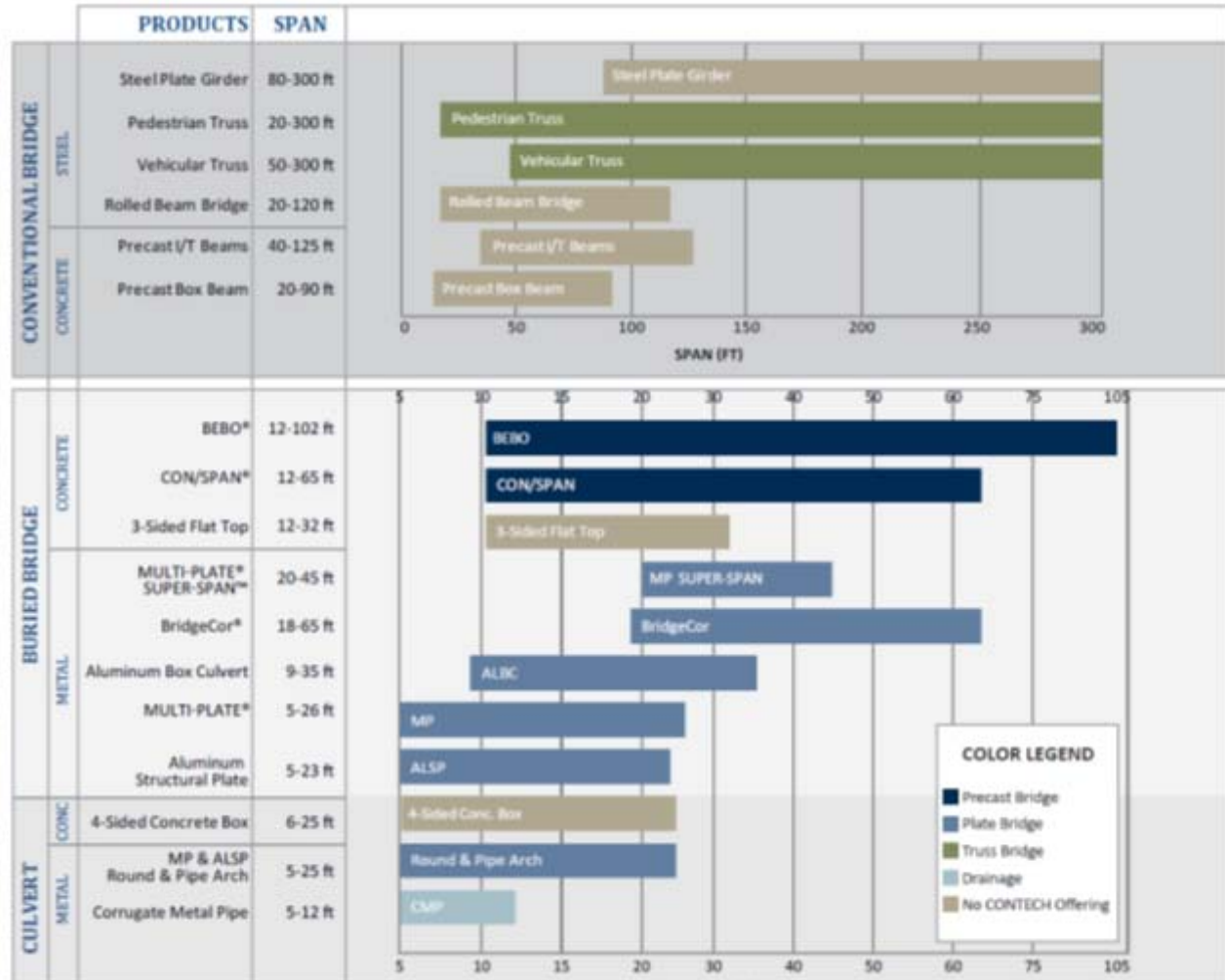
A. Buried Bridges

- Buried Bridge vs. Conventional Bridge
- Buried Bridge vs. Culvert

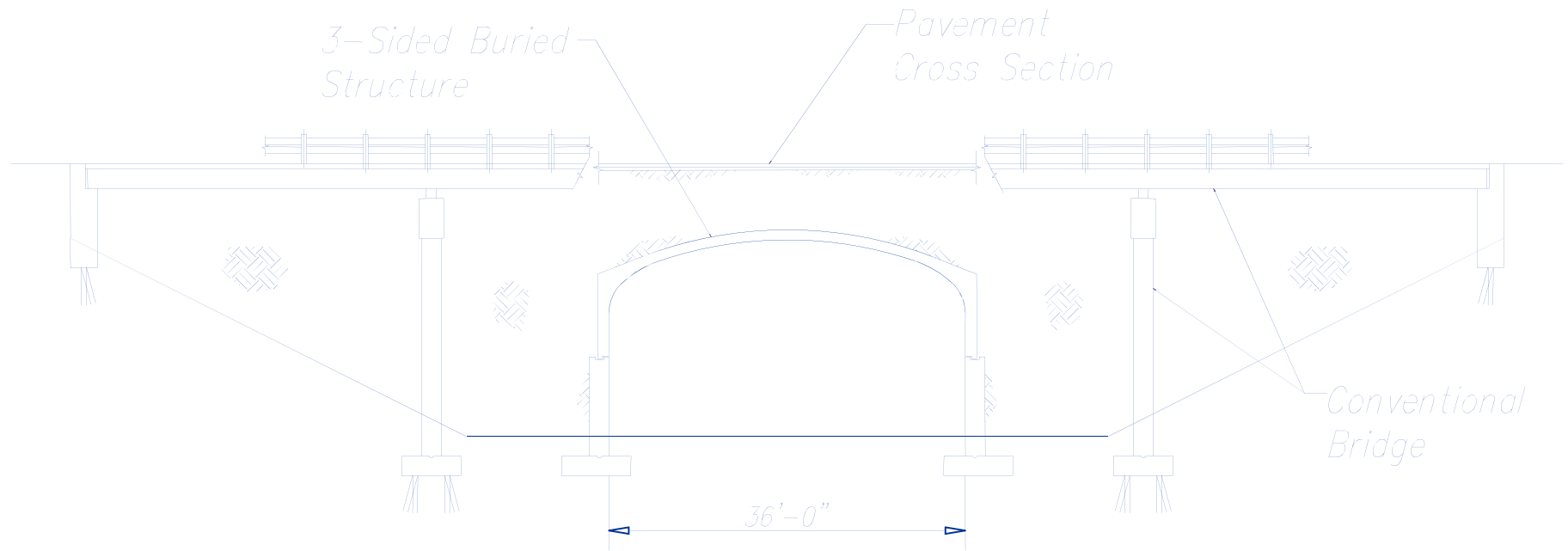
B. Environmental, Clear-spanning & Permitting

C. Accelerated Bridge Program

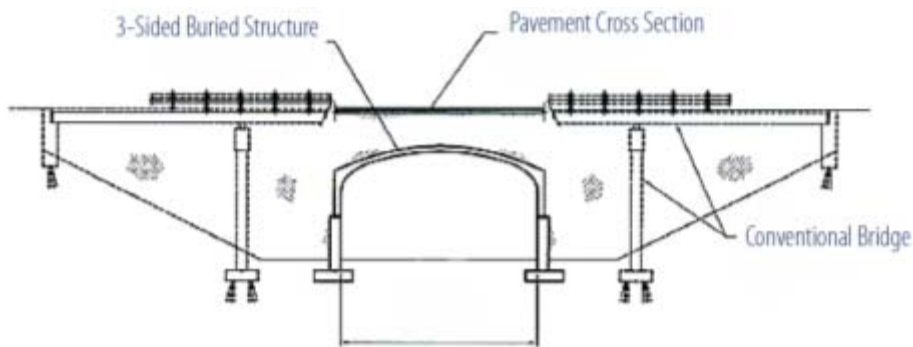
Bridge Type Selection Chart



Buried Bridge vs. Conventional Bridge



Buried Bridge vs. Conventional Bridge



CONVENTIONAL BRIDGES CONVERT TO BURIED BRIDGES:

- Shorter construction time/phasing means lower initial cost
- Minimal/no long term maintenance lowers overall life cycle cost
- Shorter construction time minimizes traffic disruption
- Bury utilities in backfill over structure
- Increased safety with limited/no freeze concerns & deck maintenance

Buried Bridge vs. Conventional Bridge



Before



After



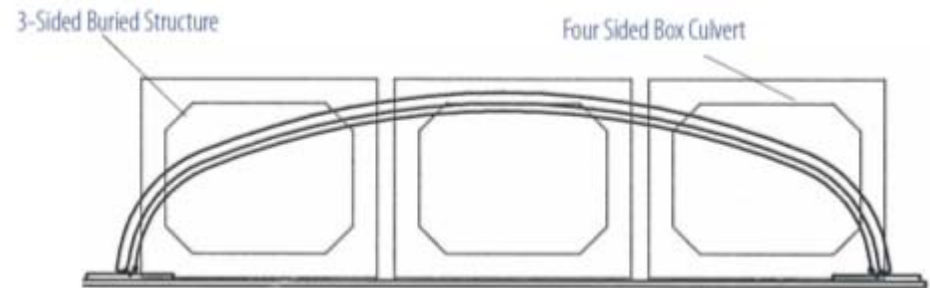
During

Bridge Type Comparison Chart

	CONVENTIONAL	BURIED
Traffic Disruption*	2 YEARS	5 MONTHS
Construction Time*	2 YEARS	1 YEAR
Initial Cost*	\$8 M	\$5.5 M
Typical Maintenance*	Deck Overlay every 15-18 years. Total Deck Replacement every 30-35 years.	Periodic Asphalt replacement.

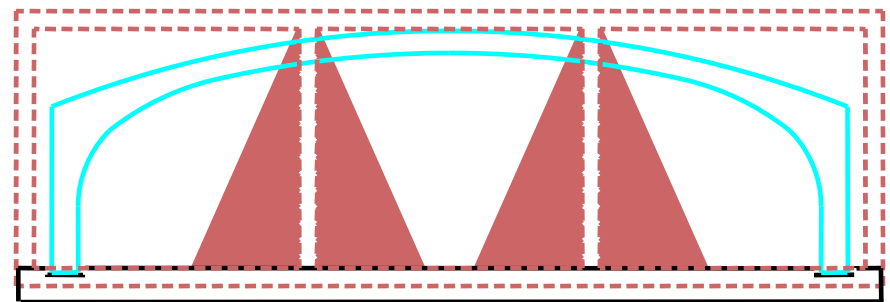
*Estimated

Buried Bridge vs. Culverts



CULVERTS CONVERT TO BURIED BRIDGES

- Complete system with headwalls, wingwalls and foundations
- Bottomless structure promotes natural aquatic habitat and fish/wildlife passage
- Maintenance-free structure lowers overall life cycle cost
- Project specific design to handle all loading requirements
- Long clear spans promote improved hydraulics while minimizing pier blockage



B. Environmental, Clear-spanning & Permitting







C. Accelerated Bridge Program



U.S. Department of Transportation
Federal Highway Administration

Accelerated Bridge Program



U.S. Department of Transportation
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March 30, 2009

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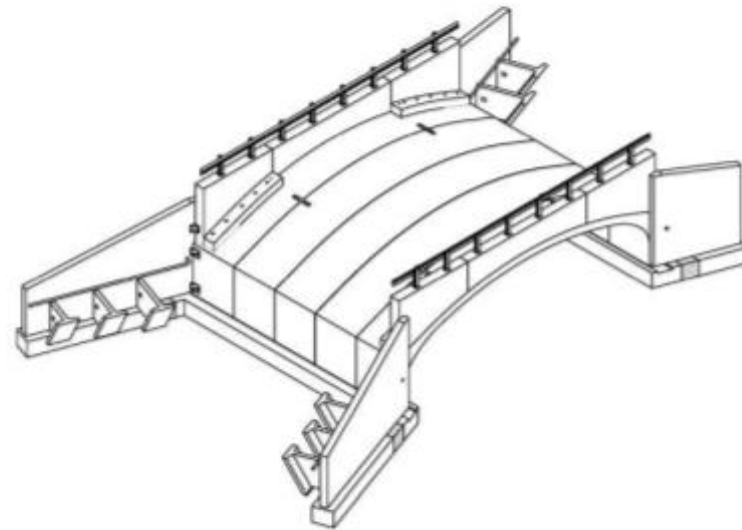


Figure 2.4.3-1 Con/Span[®] Bridge System

“Prefabricated elements of a bridge produced off-site can be assembled quickly, and can reduce design time and cost, minimize forming, minimize lane closure time and/or possibly eliminate the need for a temporary bridge.”

Local Project Examples

Buried Structures vs. Conventional Bridges

SR 0072-28

- 16' x 10' x 128 LF
- “Reline” existing triple span beam bridge
- Base slab utilized for ped. and vehicular use
- 120 LF of precast Wingwalls
- Constructed while existing structure handled traffic







2010/12/09



2010/12/13





SR 0081 Section 255
Luzerne County, Pennsylvania

McTish Kunkel

www.ContechES.com



SR 0081 Section 255
Luzerne County, Pennsylvania

McTish Kunkel

www.ContechES.com

Local Project Examples

Accelerated Bridge Construction

SEPTA R5 – Design Challenges:



- Obtain 24' x 12' Clearance Box
- Commuter Service Out for Less than Four Days
- Design for AREMA E-80 Railroad Loading

Solution Development

- ✓ Project Design Worksheet
- ✓ Structure Selection
- ✓ Siting & Layout
- ✓ Engineer Estimate
- ✓ Site Simulation

Design Support

- ✓ Specifications
- ✓ Contract Drawings
- ✓ Structural/Fabrication Drawings
- ✓ Custom Shape Development
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- ✓ Foundations

Installation

- ✓ Preconstruction Meeting
- ✓ On-Site Installation Assistance
- ✓ Logistics Coordination







SEPTA R5 Doylestown
Bucks County, Pennsylvania

SEPTA









Industry Trends

A. Buried Bridges

- Buried Bridge vs. Conventional Bridge
- Buried Bridge vs. Culvert

B. Environmental, Clear-spanning & Permitting

C. Accelerated Bridge Program

Contech. Your project partner.

- Summary & Overview Bridge Portfolio
- Innovative Bridge Developments
- Engineering Support & Design Tools
- Contech's Consultative Approach



Building Blocks to a successful Project

Planning & Solution Development

- Project Design Worksheet
- Structure Selection
- Siting & Layout
- DYOB
- Engineer Estimate
- Site Simulation
- Proposal Preparation
- Design Build Support

Design Support

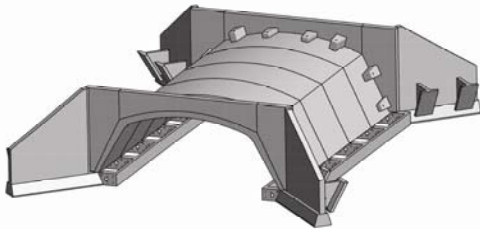
- Specifications
- Contract Drawings
- Permitting
- Structural/Fabrication Drawings
- Approval Assistance
- Custom Shape Development
- Horizontal/Vertical Alignment
- Hydraulics & Scour Support
- Foundations

Installation Support

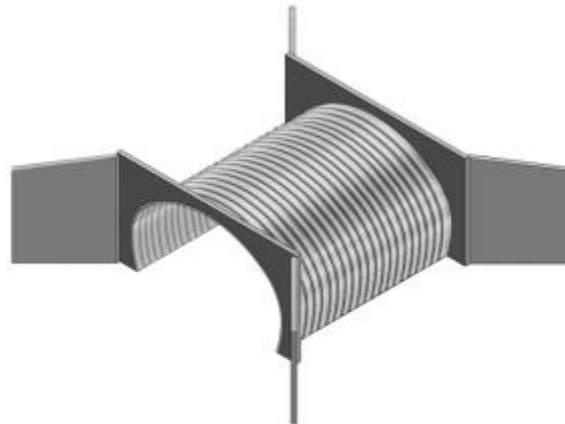
- Preconstruction Meeting
- On-Site Installation Assistance
- Logistics Coordination

Questions?

CON SPAN[®]
-SERIES[™]



BridgeCor[™]



EXPRESS[™] Foundations

