

METHODS OF SAMPLING AND TESTING
MT 402-04
METHOD OF SAMPLING AND TESTING CORRUGATED STEEL PIPE
(AASHTO M 36)

1 Scope:

- 1.1 The specification covers corrugated steel pipe intended for use for storm water drainage, under-drains, the construction of culverts, and similar uses. The steel sheet used in fabrication of the pipe has a protective metallic coating of zinc (galvanizing), aluminum, or aluminum-zinc alloy.

2 Referenced Documents:

2.1 AASHTO:

M 36 Corrugated Steel Pipe, Metallic-Coated, for Sewers and Drains

3 Sampling Procedure:

- 3.1 Sampling shall be performed or witnessed by MDT or an approved inspecting agency at the point of manufacture.
- 3.2 Random sampling shall consist of at least one set of three 3" x 3" samples per gauge, heat number, lot number and type of corrugation. Samples shall be obtained a minimum of 3" from any edge.
- 3.3 Previously tested material that is properly marked and accepted need not be re-sampled, but must be listed in the test report.
- 3.4 In the event that the samples fail to comply, two additional sets of three samples will be taken from the same gauge, heat number, lot number and type of corrugation. Both additional sets must comply with the requirements or the entire lot number will be rejected.

4 Fabrication:

- 4.1 Fabrication of the corrugated steel pipe shall conform to the requirements of AASHTO M 36, the Special Provisions, the Standard Specifications, and the plans for the specific project.

5 Certification:

- 5.1 The inspecting agency shall verify that all materials are in compliance with the "Buy America" provision in the Montana Standard Specifications for Road and Bridge Construction. Upon receipt of the materials, the Contractor will submit the appropriate test reports and chemical analysis representing each lot number on the Contractors Certificate of Compliance, Form 406. The reports shall include the following:
- 5.1.1 Lot number
- 5.1.2 Heat number.
- 5.1.3 Gauge.
- 5.1.4 Corrugation size.
- 5.1.5 Diameter and quantity of pipe.

5 Certification: (continued)

- 5.1.6 Type of seam.
- 5.1.7 Weight of coating in oz/ft² or g/m².
- 5.1.8 Name of supplier.
- 5.1.9 Montana Department of Transportation project for which the material is designated.
- 5.1.10 Two copies of the report are to be forwarded to the District Laboratory.

6 Approval for Shipment of Culverts:

- 6.1 Culverts and/or related material shall not be approved for shipment until they have been found to comply with our specifications.
- 6.2 Evidence of approval shall be by means of the inspecting agencies ID stamp or tag placed on a noticeable location on each section of the inspected material.
- 6.3 In the event of any questions pertaining to the approval for the shipment of culverts and/or related material, contact the Materials Bureau.

7 Field Inspection and Acceptance:

- 7.1 Field inspection shall be made by the Engineering Project Manager who shall be furnished by the seller with an itemized statement of the sizes and lengths of culvert pipe in each shipment. This inspection shall include an examination of the culvert pipe for deficiency in length and any evidence of damage during shipment along with the proper approval stamp or tag from the inspecting agency and be submitted on a Form 46.