

# **ALTERNATIVE MATERIALS AND CONFIGURATIONS FOR PRESTRESSED-PRECAST CONCRETE PILE SPLICE CONNECTION**

**Quarterly Progress Report  
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Submitted to:  
ABC-UTC  
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## 1. Introduction and Background

Establishing bridge foundation when there is a top layer of weak soils normally requires application of deep foundations such as pile foundation. One of the options among various types of piles and installation methods is driving prestressed-precast concrete piles (PPCP) (Figure 1). Since it employs pile segments prefabricated in precast plants and delivered to the site for installation, it follows the principals of Accelerated Bridge Construction. Comparing to other types of piles, this option is in many cases more cost and time effective. Accordingly, PPCP generally reduces the construction time in line with the benefits promised by ABC methods. However traditional PPCPs which use conventional passive and none passive carbon steel reinforcements are prone to corrosion especially when they are in a marine environment. In such environments, accumulating salts in piles which are caused by alternating the level of water and water splash accelerate corrosion. Corrosion causes the piles to fail prematurely and incur costs. According to the Cost of Corrosion (Lampo et al., 1997), in highway bridges the dollar impact of corrosion on concrete and steel bridges is substantial and the indirect costs including the user and maintenance increase the overall costs tenfold. Accordingly, attempts have been made to increase corrosion resistance of PPCPs. Using Carbon Fiber Reinforced Polymers (CFRP) and High Strength Stainless Steel (HSSS) for strands and other types of reinforcements has shown a great improvement in corrosion resistance.



**Figure 1: Prestressed-Precast Concrete Piles**

(<https://dlsprestressed.com/services/driven-concrete-piles/>)

For various reasons, it becomes necessary or is desirable to splice PPCPs. The merits of casting shorter pile segments and splicing them on-site are: 1- easy handling, transporting, and driving,

2- possible reduction in concrete cracking during handling, transportation, and driving, 3- suitability of pile extension in unforeseen situations and soil conditions where longer piles become necessary, 4- reduction in transportation cost, 5- ability to be store in the precast yard and construction site (Venuti, 1980). It should be stated that these advantages can only be achieved if the use of splice is economical, can develop the structural capacity of pile section and the connection can be made quickly without the need for special skilled labors. With this in mind, splicing of pile segments has to be performed at the site to achieve longer lengths using various types of joints. There are various means of establishing bearing-type splices. Splicing with the use of corrosion-resistant material is the focus of this project. State Departments of Transportation including FDOT have Specifications and Standard Drawings showing details and designs for pile splices including those using corrosion-resistant materials.

Nevertheless, because of lack of understanding of the structural behavior and sometime complexity and cost associated with splicing, especially for the case of corrosion-resistant materials, their use has been very limited. On the other hand, much has been done in relation with ABC connections and details for bridge sub- and super-structure joints and connections, and a variety of new and effective joints have been developed and are in use. The aim of the proposed study is to build upon the experiences gathered in general for ABC connections and develop an effective yet simple splice connection for prestressed-precast concrete piles to provide the necessary pile lengths for reaching the required resistance and at the same time to promote corrosion resistance.

## **2. Objectives and Research Approach**

The objective of this project is to explore alternative pile splice connection configurations and materials, and to investigate the feasibility of these connections in comparison with the existing epoxy dowel splice for prestressed-precast concrete piles. The project begins with reviewing literature on types of driven piles, existing pile splice configurations and materials, as well as available ABC connections implemented for bridge sub- and superstructures. This will be followed by exploring alternative connection configurations and alternative materials. The performance of the promising designs will be compared to the existing designs using analytical modeling. Among other materials, a non-proprietary Ultra-High-Performance Concrete (UHPC) mix currently under investigation by ABC-UTC will be considered in detailing of the splice connection zone as well as its use as filler/bonding material for dowels. Additionally, the use of mechanical connection types utilizing corrosion resistant materials will be explored to address the time constraint associated with pile driving operation. The project will culminate in development of the most promising alternative splice connection details and materials for prestressed-precast concrete piles. This research project focuses on the use of analytical modeling and computational means for investigation on the structural behavior, and comparison between performances of existing details for pile splices and newly developed designs using alternative configuration and material. This will include finite element modeling of pile segments and splices, as well as section analysis using available analysis tools. Future activities will include performing experimental verification of the newly developed details.

### 3. Description of Research Project Tasks

The following is a description of tasks carried out to date.

#### Task 1 - Literature Review

##### 3.1. Types of Driven Piles

Driven piles are divided into piles made of wood, steel, concrete, and various types of composite materials. These types of pile are reviewed briefly here, however, this study focuses on prestressed precast concrete piles to be discussed in more details.

##### 3.1.1. Wooden Piles

Wooden piles have a long-rooted history. There are some reasons for using them. The ease and the speed of installation, being an eco-friendly or "green" construction, and being cost-effective are among the reasons that make wooden piles popular (Figure 2). However, wooden piles, especially in coastal areas, are prone to damage caused by marine borer activity. Therefore, fabricating more durable piles is needed in the marine environment and when piles are in the water, especially in the splash zone (Figure 3) (Iskander, 2003).



**Figure 2: Wooden piles**

<https://www.pinerivergroup.com/blog/wood-pilings>



**Figure 3: Tunneling in a timber pile caused by Teredo and Bankia (M. Iskander, 2003)**

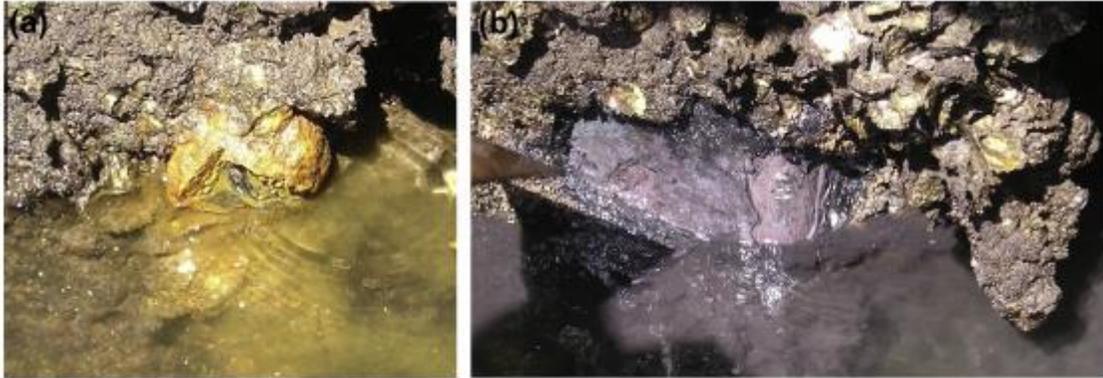
### **3.1.2. Steel Piles**

The use of steel piles has been limited due to the susceptibility to corrosion (Figure 4). Whenever employing a load-bearing steel pile foundation has been considered for a structure, the probability and the amount of corrosion have always caused concerns (OHSAKI, 1982). The rate of corrosion of steel piles immersed in fresh water is estimated to be 0.03 mm per year which increases to four times in the splash zone (Fleming et al., 2008). Localized corrosion of steel sheet piling has been investigated by E. Melchers et al. (2014) (Figure 5). In their research, samples of two types of sheet piling were exposed to natural seawater for 1, 2 and 3 years. The samples demonstrated localized corrosion in the central zone and close the flange-web junction. The corrosion in steel piles can affect the load-bearing capacity of piles dramatically. Therefore, there is a need for alternative materials for pile fabrication that are resistant to corrosion.



**Figure 4: Corrosion in steel pile**

<https://www.ducorr.com/ducorr-blog/2018/3/20/conventional-steel-corrosion-and-durability-design>



**Figure 5: Local corrosion of sheet piling (Melchers et al., 2014)**

### **3.1.3. Composite Piles**

Composite materials, due to their resistance to electrochemical corrosion and versatility of fabrication, provide alternative to customary material. The price for the composite is however high. Fiber Reinforced Plastic (FRP) composites are used in some cases in hybrid construction with concrete where the concrete provides the role of bulk mass, and the FRP has a role of load carrying partner and protector of the concrete from the exterior environment. This combination provides for a cost effective use of composites. Concrete-filled FRP tubes as a hybrid system, can be used for pile fabrication (Shahawy, 2003). They have been used in many marine environments (Figure 6).



**Figure 6: FRP tubes for composite piles**

[\(https://www.harbortech.us/products/composite-pilings/\)](https://www.harbortech.us/products/composite-pilings/)

The first recycled plastic pile was driven at the port of Los Angeles (Horeczko, 1995). It was a steel core composite pile. This experience showed that due to thermal stresses, the steel core composite piles experience core delamination. Therefore, producers presented a type of composite piles that included fiberglass and HDPE combined with fiberglass reinforcement and stabilizers. In 1998, Iskandar and Hassan reviewed the types of composite piles and compared them in term of material properties, durability, drivability, and the interaction between soil and piles. They found that piling materials made of FRP or fiberglass offer performance advantages for employing in harsh and marine environments. The advantages of using them are durability

and environmental benefit. However, disadvantages include high cost, less drivability and high compressibility ( Iskander & Hassan, 1998).

### **3.1.4. Prestressed precast concrete piles**

One of the options for establishing pile foundation is the use of prestressed-precast concrete piles (PPCP) (Figure 7). This option provides in many cases an economic alternative to other pile foundation types and accelerates the construction process, especially in marine environments. In PPCPs, prestressed strands provide the pile with the required tensile strength during the driving process. The strands, provide the extra strength to resist the moment bending which will be caused during lifting, transporting, and the bending moment as a result of lateral loads. PPCPs have been made in different shapes with different types of materials for strands.



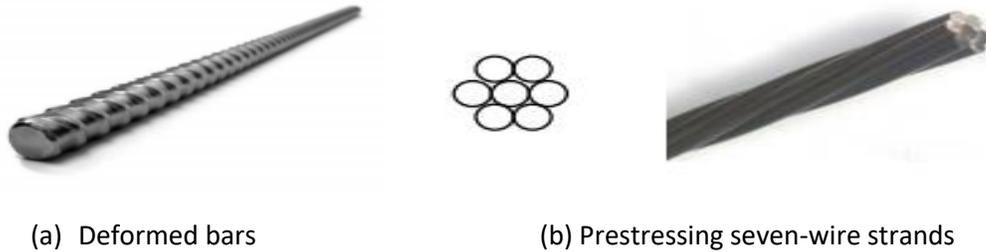
© <https://www.gimrock.com/FoundationWork.html>

**Figure 7: Prestressed-Precast Concrete Piles in marine environment**

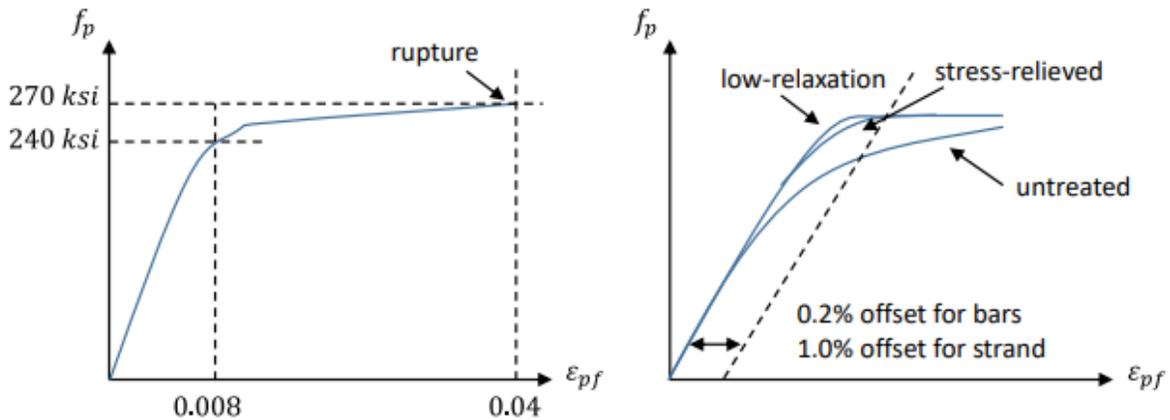
#### ***3.1.4.1. Prestressed Precast Concrete Piles Using Conventional Prestressed Strand***

Prestressed concrete piles can be reinforced with prestressing strands including threaded rebars (e.g., Dywidag rods), prestressing wire or seven-wire strands (Figure 8), and with other reinforcing bars and welded wire mesh. The most commonly used prestressing reinforcement is seven-wire strands. Two types of seven-wire strands have been used: 1- stress-relieved 2- low-relaxation. The difference in the behavior of these two types of strands is shown (Figure 9). In conventional PPCPs, the low relaxation seven-wire strands with the various nominal diameters including the common 0.5 and 0.6 inches have been used. However, traditional prestressed piles that use carbon steel strands and bars are prone to corrosion, especially when they are in marine environments. In such environments, alternating water levels and water splash promote deposit and migration of chlorides into the pile and provides a condition for accelerating the corrosion. Among other states departments of transportation, the Florida Department of Transportation (FDOT) has also implemented programs for the utilization of alternative prestressing strand materials that are corrosion resistant. The use of Carbon Fiber Reinforced Polymers (CRFP) and High Strength Stainless Steel (HSSS) for strands, longitudinal and transverse reinforcement in

the precast concrete piles have shown great improvements to resistance against corrosion (Belarbi et al., 2017; Mullins et al., 2014; Rambo-Roddenberry et al., 2016).



**Figure 8: Type of reinforcement for prestressing**



**Figure 9: Difference in the behavior of the low-relaxation and stress relieved strands**

#### 3.1.4.2. *Prestressed Precast Concrete Piles Using Alternative Strand Materials*

There have been several investigations on the application and performance of PPCP using alternative prestressing strand material. CFRP and its variant Carbon Fiber Composite Cable (CFCC) is one of the materials that has shown great promise for replacing the normal prestressing strands. ACI-440-04 covers an extensive review of the background, material properties and design recommendation for the use of these materials and other FRPs. CFCC has shown high bond strength to concrete (about twice of that of steel), has light weight and high tensile strength, its relaxation is less than steel, and can be coiled in its twisted wire form. However, CFCC is more expensive than steel, has low impact resistance, and it is brittle in failure not as ductile as its steel counterpart (Rambo-Roddenberry et al., 2016). Grace (2007) used CFRP for post-tensioning tendons and reinforcing bars for the first time in the Bridge Street Bridge in Southfield, MI. His study monitored the performance for long period of time and demonstrated its suitability for use in prestressing/post-tensioning applications. Roddenberry et

al. (2014, 2016) tested PPCP using CFCC of various lengths to investigate the flexural strength, transfer length, development length, and drivability (Figure 10). They concluded that transfer and development length for CFCC is noticeably shorter than that of steel, and flexural strength higher than anticipated. Pile driving and installation were without any major damage to the pile despite the hard condition and high stress level. Some challenges in production were noted and modifications recommended including use of wood versus steel cap, care in installation and handling, lower stress rate, avoiding the use of regular vibrator, and strong quality control (QC).



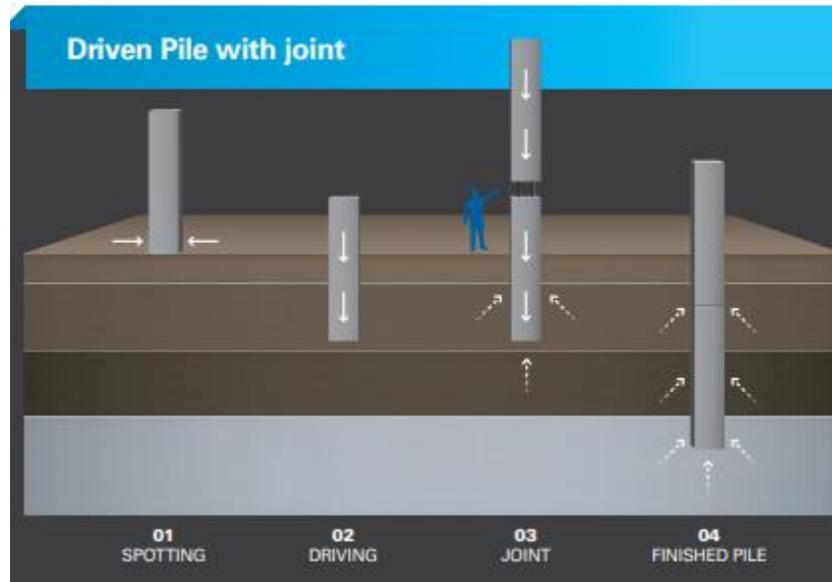
**Figure 10: Flexural testing of PPCP with CFCC (Roddenberry et al., 2014)**

PPCP using HSSS strands and spirals have also been studied as another alternative to carbon steel strand piles. Mullins et al. (2014) tested three types of stainless steel material that are available in strand form and compared their corrosion resistance and structural performance to conventional carbon steel prestressing strand. They showed that the use of HSSS strands had no adverse effect on transfer length, while it improves the corrosion resistance significantly (Figure 11). Paul et al. (2015) demonstrated through testing that transfer and development length for HSSS-2205 prestressing strands are considerably smaller than that predicted by AASHTO LRFD, the flexural and shear strengths of piles using SS were greater than predicted by both ACI-318 and AASHTO LRFD, and the stress loss was smaller than that predicted by AASHTO LRFD refined method. These properties were not affected after installation and extraction.



**Figure 11: PPCP with Stainless Steel Strand and Spiral (Mullins et al., 2014)**

Prestressed Precast Concrete Piles (PPCP) often require splicing for one or more of the following reasons such as (i) limits on length for shipping and transportation, (ii) limited pile-driving headroom that will force planned splicing, (iii) and when the required capacity is not achieved with the piles existing lengths resulting in unforeseen splicing, and others (Figure 12). The focus of this report is on the types of splices for precast prestressed concrete piles which can provide the piles with corrosion resistant materials and accommodates a time effective method.

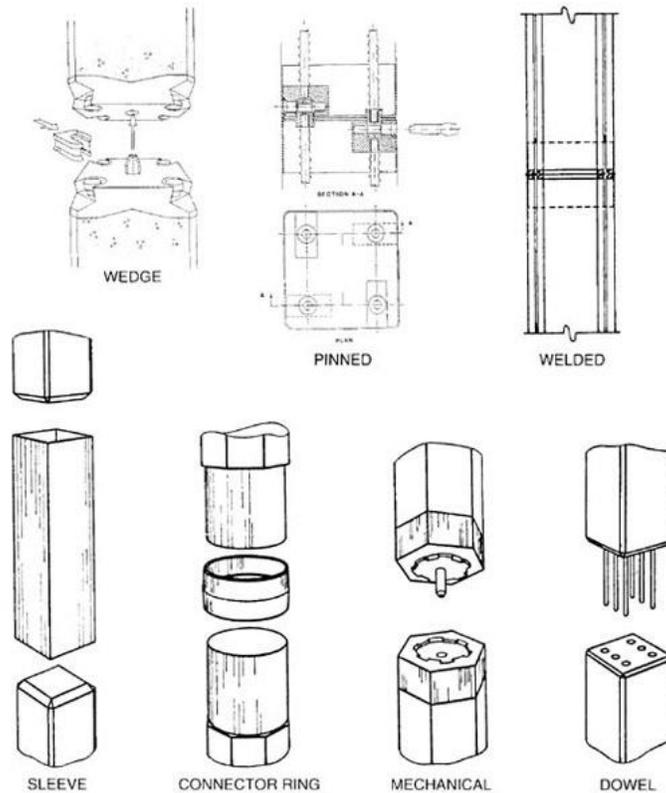


**Figure 12: Driven pile with joint/splice**

### **3.2. Pile Splices**

#### **3.2.1. Existing Splice Systems for Driven Piles**

There are various means for establishing bearing-type splices including wedge, pinned, welded end plates, post-tensioned, sleeve, connecting ring, mechanical and finally dowel splices as illustrated in Figure 13.



**Figure 13: Various types of existing pile splicing (Pile Buck Magazine, <http://www.pilebuck.com/education/pile-points/concrete-pile-splices/> 1/7)**

Gerwick (1968) reviewed the formation, utilization, and installation of the PPCPs, and discussed their failure and damages. In his work, epoxy dowel splices were mentioned as the most desired type in providing resistance for piles in flexural design. He also mentioned that mechanical splices are the most economical type of pile splices. In 1970, Liu presented a report which helped designers with splices. Driving and no driving conditions, the required concrete strength for piles, driving stress, head and tip design practice, and the requirements for an ideal splice were discussed. A combination of sleeve and wedge for establishing pile splices were discussed by Alley (1970). This splice was used in Seattle, WA, for splicing octagonal piles. The splice includes outer and inner steel sleeves which were connected to four steel wedges welded to form the piles. In 1971, a chapter in a textbook by Gerwick (1971) discussed typical detail of prestressing pile splices used in the U.S, Japan, Sweden, and Norway. In 1974, a comprehensive research was carried out on 20 types of splices by Bruce and Hebert (1974a). Details of various splices and their strengths were presented in this study. Also, the performance of each splice in tension, compression, and flexural was discussed. The results of this investigation is summarized in Table 1 (Bruce Jr & Hebert, 1974a).

**Table 1: Type of splices (Bruce Jr & Hebert, 1974a)**

Type of Splices for Piles					
Type	Splice type	Does this detail require preplanning?	Time needed (minutes)	Labor skill (procedure)	Country of Origin
Mechanical	Marier Splice	yes	minimal-30	average	Canada
Mechanical	Herkules Splice	yes	minimal-20	simple	Sweden
Mechanical	ABB Splice	yes	minimal-20	simple	Sweden, western Europe
Welded	NCS Splice	yes	high-60	average	Japan, Pacific, Northwest
Welded	Tokyu Splice	yes	high-60	average	Japan(Tokyo)
Welded	Raymond Cylinder	yes	high-90	average	USA
Welded	Bolognesi-Moretto Splice	yes	minimal-50	average	Argentina
Bolted	Japanese Bolted Splice	yes	minimal-30	average	Japan
Connecting Ring	Brunspile Connector Ring	yes	minimal-20	simple	USA
Sleeve	Anderson Splice	no	minimal-20	simple	USA
Welded Sleeve	Fuentes Splice	yes	minimal-30	average	USA(Puerto Rico)
Sleeve	Hamilton Form Company Splice	no	high-90	simple	USA
Dowel	Cement-Dowel Splice	yes	average-45	simple	USA
Post Tensioned	Macalloy Splice	yes	high-120	average	Great Britain.
Combination	Mouton Splice	yes	minimal-20	simple	USA
Combination (Sleeve and Wedge)	Raymond Wedge Splice	yes	minimal-40	simple	USA
Connecting Ring	Pile Coupler Splice	yes	minimal-20	simple	USA
Mechanical	Nilsson Splice	yes	minimal-20	average	Sweden
Wedge	Wennstrom Splice	yes	minimal-20	simple	Sweden
Mechanical	Pogonowski Splice	yes	minimal-20	average	USA

In Table 1, types of splice, the required time for installation, the skill of labor which needed during construction, and the country of origin are shown. This table also specifies whether preplanning is required to establish each type of splices. The installation time, as it is on any ABC method, is of extreme importance. By reducing the construction time, the impact of splicing on the overall bridge construction time will be reduced and the bridge usage by the public is greatly improved, especially when the replacement of an existing bridge is involved. In addition to requiring minimal time to establish the splice, the splice should be strong enough to resist all load effects including tension, compression, shear, and flexural. In Table 2, the performance of these splices has been summarized (Bruce Jr & Hebert, 1974a).

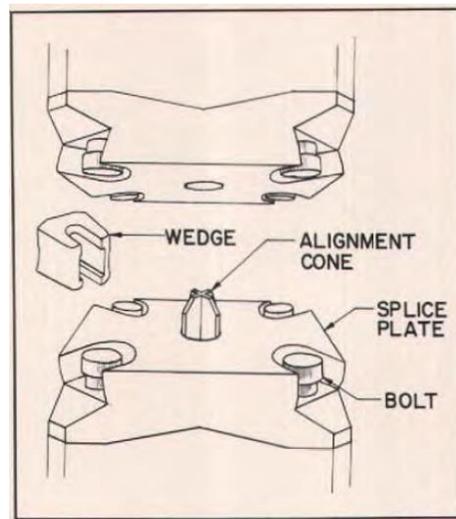
**Table 2: Performance of the splices in compression, tension, and flexure in comparison with un-spliced pile (Bruce Jr & Hebert, 1974a)**

<b>Type of Splices for Piles</b>					
<b>Type</b>	<b>Splice Type</b>	<b>Splice Performance in Compression</b>	<b>Splice Performance in Tension</b>	<b>Splice Performance in Flexure</b>	<b>Patent</b>
Mechanical	Marier Splice	100 percent of pile strength	100 percent of pile strength	100 percent of pile strength	yes
Mechanical	Herkules Splice	100 percent of pile strength	100 percent of pile strength	100 percent of pile strength	yes
Mechanical	ABB Splice	100 percent of pile strength	100 percent of pile strength	100 percent of pile strength	yes
Welded	NCS Splice	100 percent of pile strength	100 percent of pile strength	100 percent of pile strength	yes
Welded	Tokyu Splice	100 percent of pile strength	100 percent of pile strength	100 percent of pile strength	yes
Welded	Raymond Cylinder	100 percent of pile strength	100 percent of pile strength	100 percent of pile strength	yes
Welded	Bolognesi-Moretto Splice	100 percent of pile strength	50 percent of pile strength	100 percent of pile strength	yes
Bolted	Japanese Bolted Splice	100 percent of pile strength	90 percent of pile strength	90 percent of pile strength	yes
Connecting Ring	Brunspile Connector Ring	100 percent of pile strength	20 percent of pile strength	50 percent of pile strength	yes
Sleeve	Anderson Splice	100 percent of pile strength	no strength	100 percent of pile strength	no
Welded Sleeve	Fuentes Splice	100 percent of pile strength	100 percent of pile strength	100 percent of pile strength	yes
Sleeve	Hamilton Form Company Splice	100 percent of pile strength	75 percent of pile strength	100 percent of pile strength	no
Dowel	Cement-Dowel Splice	100 percent of pile strength	40 percent of pile strength	65 percent of pile strength	no
Post Tensioned	Macalloy Splice	100 percent of pile strength	100 percent of pile strength	100 percent of pile strength	yes
Combination	Mouton Splice	100 percent of pile strength	40 percent of pile strength	100 percent of pile strength	yes
Combination(sleeve and Wedge)	Raymond Wedge Splice	100 percent of pile strength	100 percent of pile strength	100 percent of pile strength	yes
Connecting Ring	Pile Coupler Splice	100 percent of pile strength	100 percent of pile strength	100 percent of pile strength	yes
Mechanical	Nilsson Splice	100 percent of pile strength	100 percent of pile strength	100 percent of pile strength	yes
Wedge	Wennstrom Splice	100 percent of pile strength	100 percent of pile strength	100 percent of pile strength	yes
Mechanical	Pogonowski Splice	100 percent of pile strength	100 percent of pile strength	100 percent of pile strength	yes

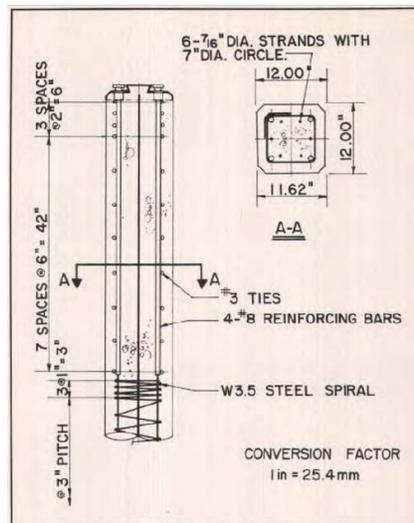
As it was shown, splice types Bolognesi-Moretto, Japanese Bolted, Brunspile Connector Ring, Anderson, Hamilton Form Company, Cement-Dowel, and Mouton Splice are weak in tension. Also, Japanese Bolted, Brunspile Connector Ring, and Cement-Dowel Splice could not pass the flexural design requirement. In the following sections, various types of splices and their advantages/disadvantages are discussed.

### 3.2.1.1. *Wedge Splices*

This type of splice which is also called mechanical wedges is used mainly for square piling but it is also used for octagonal, round, and hollow cross sections. In Scandinavia and Western Europe, it is used for precast reinforced concrete piles. Also, Venuti (1980) in his research successfully employed this type of splice for precast prestressed concrete piles. Both the lower and upper part of pile to be spliced have to be the same shape (Figure 14). It is made of two plates, cone, and four internally threaded bolts. The piles internal reinforcing bars are threaded into the bolts (Figure 15). The procedure of wedge splice is simple. The alignment cone is placed into the center of the lower pile. The upper pile section then is placed on the lower part till the splice plates are in their correct position. After that, the wedges are driven into each of the four corners of the splice by using a sledgehammer. The wedge become locked in the splice. This detail applies directly to reinforce concrete piles. However, with some modification, i.e., pre-installation of auxiliary bars inside the pile, it can also apply to prestressed piles.



**Figure 14: mechanical wedge splice (Venuti, 1980)**

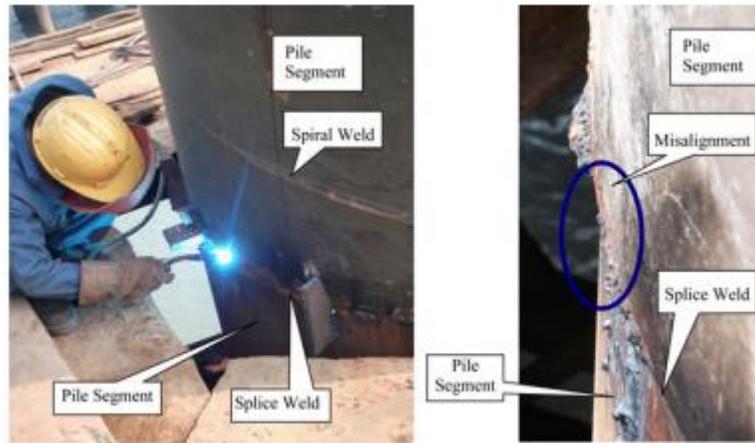


**Figure15: mechanical wedge splice details (Venuti, 1980)**

According to the investigation of Venuti (1980), this type of splice is designed to perform similar to un-spliced section in compression, tension, torsion, shear, and bending. After experimental testing on this type of splice, he concluded that wedge splice; 1- can develop the full capacity of the pile in tension, compression, and bending, 2- has the same strength for both the torsion and shear in all direction 3- requires minimum space for storage, 4- can be fabricated and handled simpler and faster since the splice parts are the same in each plie section, 5- can be installed easily and quickly and does not need skilled labor forces, 6- due to having zinc alloy alignment cone has a sacrificial role and improves corrosion resistant. The only disadvantage of using this splice is the need for careful and quality fabrication at a prestressing plant.

### **3.2.1.2. Welded Splices**

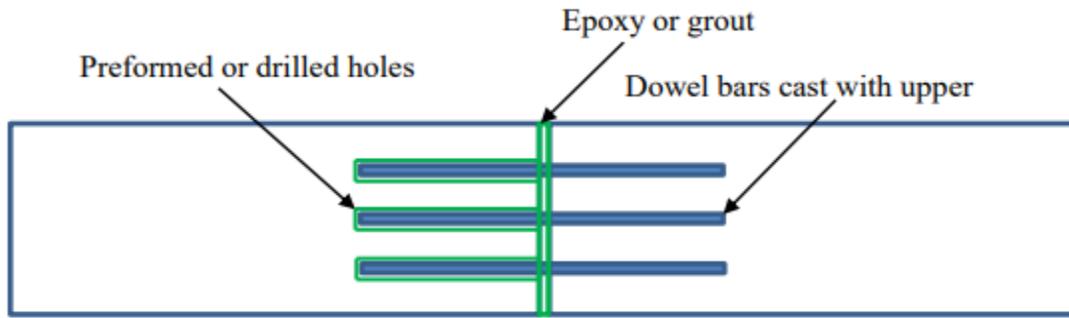
One of the problems with using welded splices is its corrosion potential, especially in corrosive soils and marine environment. Also, the lack of certified field labor and concerns with the quality of field welds have limited the use of welding systems (Michael P Culmo, 2009). Figure 16 shows welding of pile segments in welded splice (Li et al, 2014). Nippon Concrete Systems (NCS) type welded splice is a very common type of welded splice in the State of Washington. Tokyo splice can be used in prestressed concrete cylindrical piles. Also, temperature due to welding does not seem to affect concrete and the strength will not be reduced. Raymond splice can also be used in cylindrical piles. However, its use is limited due to longer time for installation. The last type of welded splice is Bolognesi-Moretto which is not common because the use of dowel in the plate causes warping (Bruce Jr & Hebert, 1974a).



**Figure 16: welded splice (Li et al., 2014)**

### **3.2.1.3. Dowel Splices**

The most common type of pile spliced used in the state of Florida is dowel splices. In this type of splice, holes are cast or field drilled into the top of the pile segment driven into the ground. Rebar dowels which are protruding of the end of the top pile segment are placed into the holes of the bottom pile and filler/bonding material is used to fill the spaces around the dowels in the holes and to bond them to the lower segment (Figures 17,18)(Wu, 2016). Dowel rebars can be made of conventional carbon steel or Stainless Steel (SS), Carbon Fiber Reinforced Polymer (CFRP) or Glass Fiber Reinforced Polymer (GFRP). Different types of resin and cement can be used as filler and bonding agent to connect the piles section. The setting time and the amount of strength that can be resisted by the filler and bonding materials should be considered in choosing (Bruce Jr & Hebert, 1974b; Canner, 2005). Installation of this type of splice causes the construction delay since it requires the top section of pile to be held till the filler or bonding materials cure. Epoxy is the most common type of bonding material that is used for PPCP splices. There have been efforts to decrease the curing time of epoxy (Navaratnarajah, 1981). Also, it is realized that some filler and bonding materials that are effective require more setting time. One of these materials which is under investigation by the FIU and UF researchers on ABC-UTC projects is non-proprietary UHPC. The bond strength of bars (No. 8 and No. 11) embedded with UHPC is 8 times of the bond strength between bars and conventional concrete (Tazarv & Saiidi, 2017). It is also realized that time to set and time to achieve desirable strength may be a challenge for the use of UHPC.



**Figure 17: Dowel splice (Wu, 2016)**

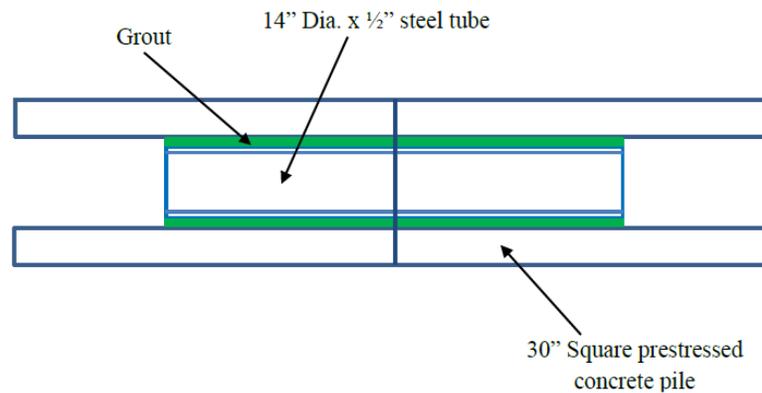


**A: Step 1: Inserting dowel rebars B: step 2: Filler or bonding material C: Step 3: Final installation**

**Figure 18: Dowel splice process at Econfina River Bridge in Taylor County, Florida**

#### **3.2.1.4. Sleeve Splice**

In this method, between two segments of voided piles, a steel tube is inserted (Cook & McVay, 2003). The steel tube is grouted to the pile for bond and transferring the load (Figure 19). Also, for improving the bond between the steel tube and the pile segments, spiral bars are welded to the steel tube. The required time for establishing the sleeve splice depends on the time needed for grout to reach the desired strength. The grout should reach the required strength before driving, otherwise, driving will fail (Wu, 2016).



**Figure 19: Sleeve splice (Wu, 2016)**

### 3.2.1.5. Mechanical Splices

Mechanical splice has been considered as the most economical type of splices. It needs minimal installation time, can provide good flexural and tensile capacity (500-1000psi tensile) and can develop full bending capacity. In general, there are several types of mechanical splices that can be used. One type of mechanical splice, often with octagonal PPCS, uses steel caps, one male and one female. At the end of the each pile matching holes or grooves are devised. The steel caps are mechanically connected with high strength steel pins inserted into the holes. (Figure 20) (Mullins & Sen, 2015).



**Figure 20: Mechanical splice (Mullins & Sen, 2015)**

In 1990, Gamble and Bruce investigated another type of splice called ABB splice. They experimentally investigated the behavior of ABB splice under different loading conditions and found that this splice which previously was used for shorter piles, can be used to extend piles to longer lengths. ABB splices are used often for square piles (Gamble & Bruce Jr, 1990) (Figure 21). In the late 1990s, GYA mechanical splice was developed (Figure 22) that is made of two steel caps, four grooved pins and four holes. This type of splice has performed well in load tests and is currently used in many projects (Korin, 2004).



**Figure 21: ABB splice**



**Figure 22: GYA mechanical splice (Korin, 2004)**

### **3.2.2. Grouted Post-Tensioning Duct Connections**

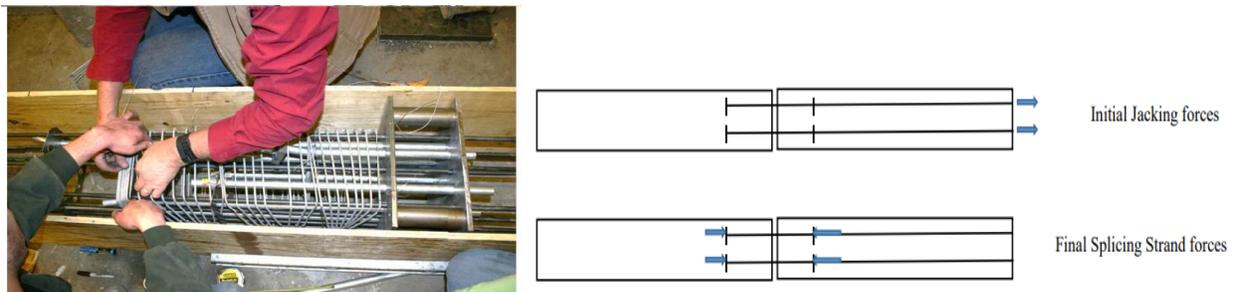
Recently, a new splice system was proposed by G. Mullins and R. Sen (2015) that used post-tensioning to establish the pile splice. In grouted post-tensioning duct connections, protruding reinforcements from one prefabricated element are embedded into the post-tensioning ducts cast at the end of the receiving prefabricated element. The duct is then filled with grout. The main difference between this splice with grouted coupler is that the reinforcing steel is not spliced but bonded to concrete. The mechanical coupler is a structural member. The role of grout is to transfer the force from the bar to the coupler. However, the grouted duct is a non-structural member that transfers the force from the reinforcement to the surrounding concrete. There have been much research that investigated the grouted post-tensioning duct connection. The research

has shown that using duct reduces the development length of bars in mass concrete. Also, it decreases the probability of cracking in the element at the ultimate load (Michael P Culmo et al., 2017).

G. Mullins and R. Sen (2015) after reviewing all the pile splices, proposed an alternative method to splice post-tensioned pile segments (Figure 29). In this splice system, the embedded anchorages are cast into the ends of splice pile segments where the stress due to post-tensioning was localized (Figure 30). This embedded anchorage provides the concrete near the end of pile segments with tensile capacity provided by the post-tensioning process. This type of splice like Macalloy (see Table 2) splice is established by post-tensioning of the strands.



**Figure 29: Alternative method to splice post tensioned pile segments (Mullins & Sen, 2015)**



**Figure 30: Embedded anchorages (Mullins & Sen, 2015)**

G. Mullins and R. Sen (2015) performed numerical modeling, laboratory testing, a full-scale bending test, and a pile-driving demonstration using their proposed spliced pile. To investigate the performance of the proposed splice system, scaled specimens that included four 20ft-long, 14-inch square piles were constructed, spliced, and tested in bending (Figure 31). They found that the cracking moment was unaffected by the splice indicating that the splice was successful in transferring the tensile capacity. Based on the lessons learned from scaled specimens test, full-scale testing was also conducted. Three, 40ft-long piles were spliced and tested in bending (Figure 32). The results again indicated that the proposed splice system could provide the piles

with the same cracking moment and 96% of the ultimate moment of the un-spliced pile. For the final part of their research, 100ft-long spliced pile specimens were constructed and driven at the field to assure the feasibility of the splice system (Figure 33). They concluded that the developed splice system could effectively restore the full capacity to withstand pile driving installation and structural loading. They also indicated that the spliced system can be practiced in the marine environment since the concrete cover provides full protection against corrosion for strands.



**Figure 31: Bending testing of scaled spliced pile specimen (Mullins & Sen, 2015)**



**Figure 32: Bending testing of full-scale spliced pile specimen (Mullins & Sen, 2015)**



**Figure 33: Pile driving using spliced pile specimen (Mullins & Sen, 2015)**

### 3.2.3. Other Pile Splices under Development

In 2019, FDOT initiated an investigating on the behavior and effectiveness of epoxy dowel splice, experimentally and analytically, for prestressed precast concrete piles using corrosion resistant material for dowels (SS, CFRP, and GFRP), and comparing their performance to conventional carbon steel dowel splices. This investigation is being performed by researchers at Florida International University (FIU). They are investigating the effectiveness of GFRP dowels to economically substitute other corrosion-resistant dowels (Mehrabi & Farhangdoust, 2019).

### 3.3. ABC Connections with Potential for Using in Piles

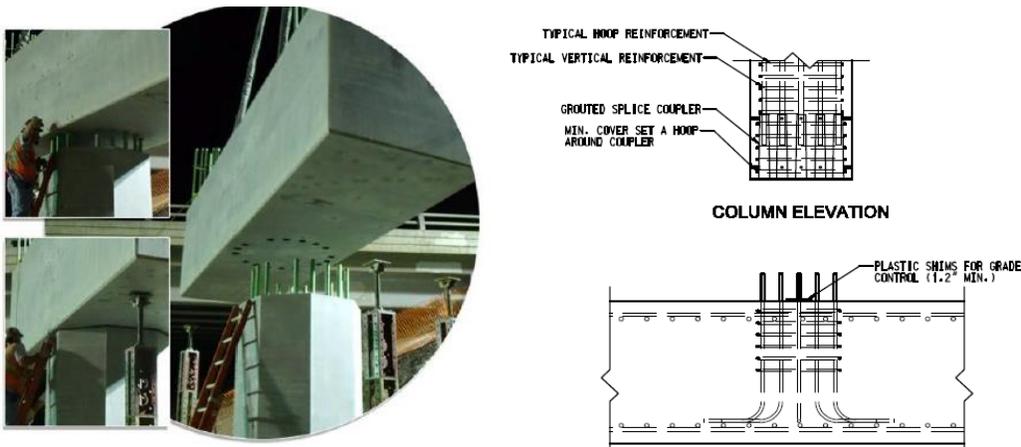
There have been a large amount of research in relation with joints and connections in Accelerated Bridge Construction (ABC), and many types of joints are implemented successfully and perform well. Some of these connections are used for connecting columns to pier caps, columns to footing, or column segments to each other. These concepts can be adopted or modified for pile splices. Table below summarizes some of the available concepts for connecting ABC columns.

**Table 3 Different connections of cap beam and column (Mehrabi, A.B., and Torrealba, 2019)**

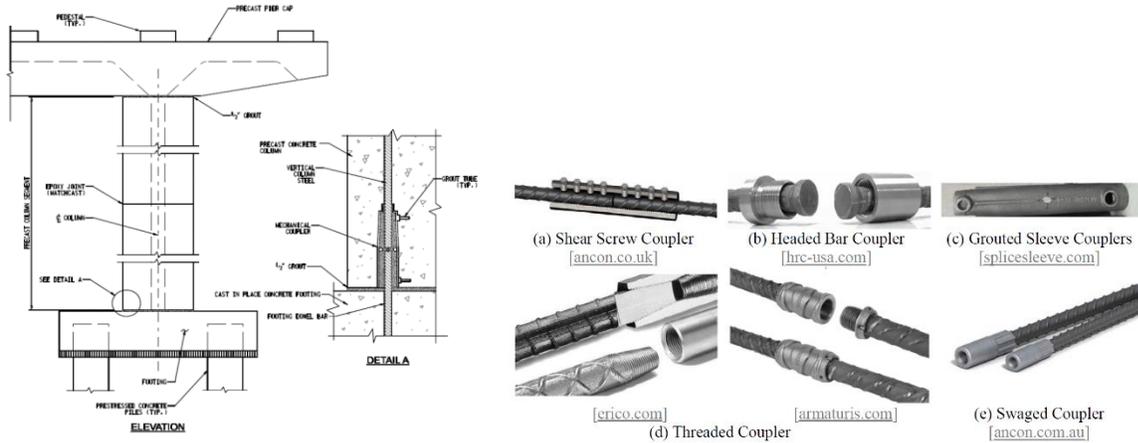
Type	Connection method	Usage
Formed in cap beam	Grouted sleeve	-Connect precast cap beam to cast-in-place or precast concrete column
	Grouted pocket	-Connect precast cap beam and precast or cast-in-place concrete column -Connect precast cap beam and steel pile or column
Formed along the Columns	UHPC column segment	-Connect precast cap beam and precast concrete column
	Grouted sleeve	-Connect precast cap beam and precast concrete column
	Mechanical couplers	-Connect precast column to cap beam
Other types	Welding	-Connect precast cap beam and steel pile or column
Cap beam segments	Closure pour	-Connect precast cap beam segments
	Mechanical couplers	-Connect precast cap beam segments to create moment connection

Following describes some of ABC connections with more relevance to pile splices. Figure 23 shows an example of grouted sleeve connection for column to cap formed inside the cap (left) and a grouted sleeve connection for column to footing connection (right). The concept of mechanical couplers perhaps is closer to the application to pile splices. Figure 24 shows connection of column to footing using mechanical coupler and a series of commercially available

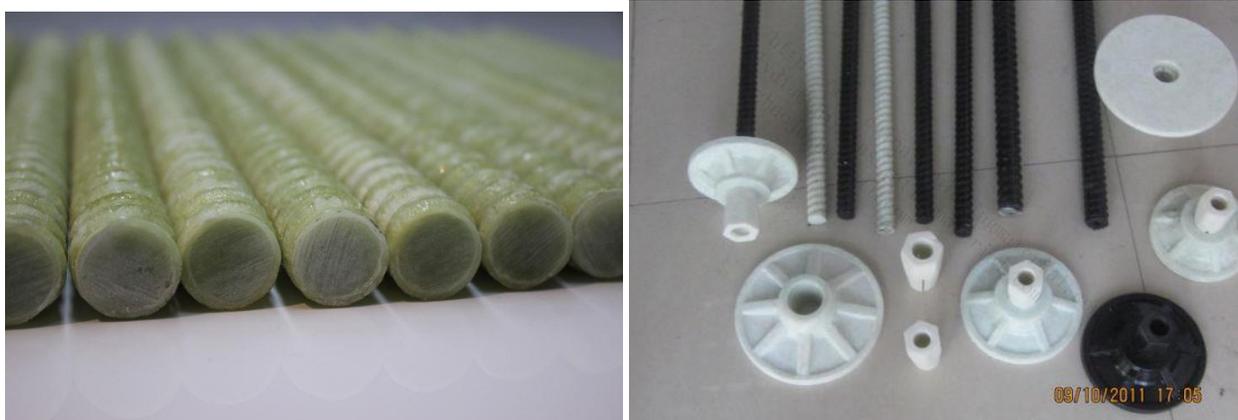
couplers. This type of coupler has been used also for connecting column segments and therefore, conceptually applicable to pile splices. One challenge in adopting these concepts would be their corrosion resistance that is a major issue for pile performance especially in the marine environment. Hence, emphasis should be on the use of alternative material to establish such connections. Use of corrosion resistant materials such as stainless steel (SS) and fiber reinforced plastics (FRP) has been investigated broadly and showed promising to be included in precast elements that are exposed to harsh and corrosive environment. Accordingly, these materials will be considered in this study for reinforcement as well as for establishing mechanical connections. SS material has been incorporated in almost all types of reinforcing and prestressing elements and therefore can establish forms, mechanisms and systems equivalent to conventional carbon steel. It has also been attempted widely to create shapes and mechanisms for FRP material so that they can be used as replacement to carbon steel. To this end, bars, strands and various profiles have been introduced. FRP threaded rods and fasteners are also becoming more available. Figure 25 shows some of these products that are available in the market. Production of FRP elements are quite versatile and can be adjusted to the project details if needed. These elements can be configured to accommodate connections similar to grouted sleeve and other mechanical connections for pile splice. This way, both strength and durability can be provided for piles and pile splices in corrosive environment. In the following mechanical couplers and grouted post-tensioning connections are discussed further.



**Figure 23: Grouted sleeve connection for column to cap (left- (Roddenberry & Servos, 2012)) and column to footing (right-(M P Culmo, 2009))**



**Figure 24: Mechanical coupler connection for column to footing (M P Culmo, 2009; Michael P Culmo et al., 2017)**



**Figure 25: FRP bars, bolts and fasteners**

### 3.3.1. Mechanical Couplers

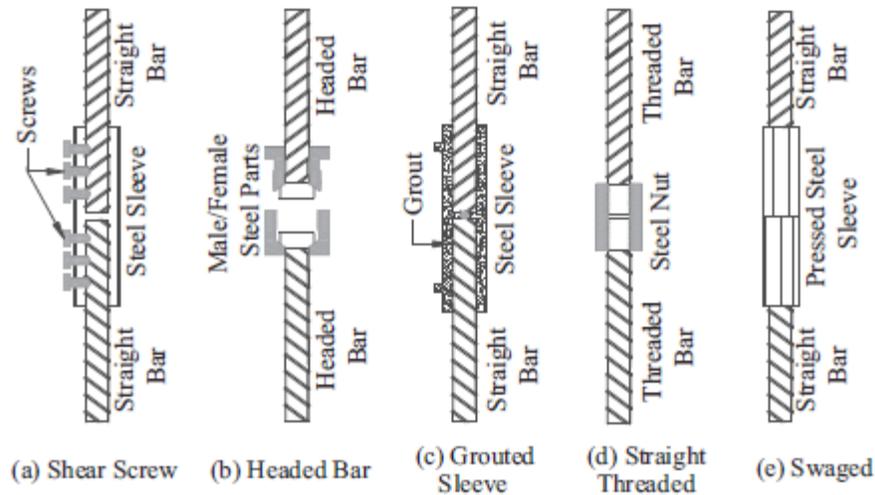
Prefabricated elements are often joined by splicing steel reinforcement. Joining prefabricated elements can therefore be performed using mechanical splicer. According to the AASHTO LRFD Bridge Design Specifications, mechanical bar splices, also called couplers should provide 125% of the specified yield strength of the bars which are connected to (Michael P Culmo et al., 2017). Several types of couplers are in the market (Figure 26). In general, they are divided into five categories (Figure 27). These are: (a) shear screw couplers, (b) headed bar couplers, (c) grouted sleeve couplers, (d) threaded couplers, and (e) swaged couplers. Shear screw splice is made of lock shear screw, shear rails, and coupling sleeve. Equal length of bars is placed into the sleeve, then the screws are tightened till the heads of screw shear off. In headed bar couplers, the plated end of bars are encased in sleeves that are threaded into each other. In grouted sleeve, two bars are connected to each other by placing them into a steel sleeve. Then the sleeve is filled with grout. In one version of grouted sleeve splice, the length required for coupler is reduced by threads inside the sleeve. In threaded couplers, the threaded bars are installed in a coupler with matching internal threads. Both straight and tapered threads can be used for the bar. In swaged coupler, straight bars are connected to pressed steel sleeve (Tazarv & Saiidi, 2016). The most

common type of mechanical couplers are grouted splice couplers. They transfer loads between bars based on the grout filled device. The load is transferred between the bars by the coupler. They have been used to connect prefabricated elements. One prefabricated element has the role of host. There are holes at the face of the host element to receive the protruding bars from the element to be connected. The connection between the host and the joining element is established when the bars are inserted into the sleeves and filled with the grout (Figure 28). Pouring the grout in the sleeve can be performed before the positioning of the bars, referred to pre-grout, or it can be done after placing the bars in the sleeve by use of grout pump (Michael P Culmo et al., 2017).

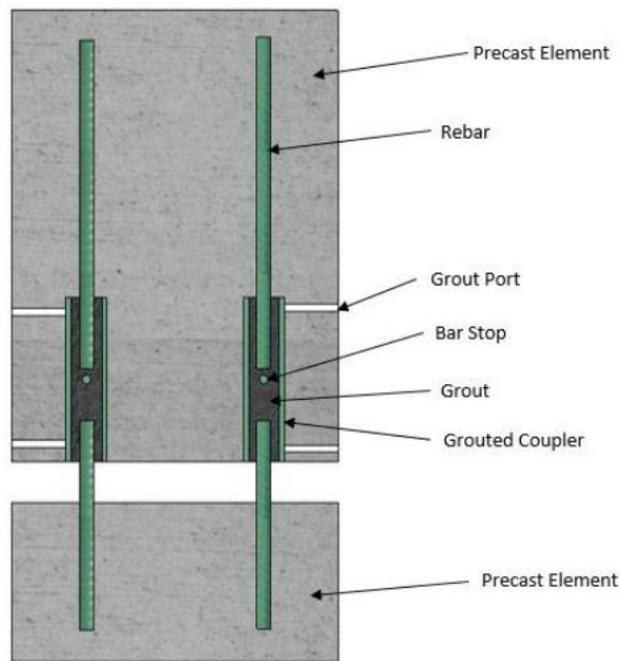


**Figure 26: Mechanical couplers in market (Nvent)**

(<https://www.nvent.com/us/en/products/concrete-reinforcing-steel-connections.html>)



**Figure 27: Types of mechanical couplers (Tazarv & Saiidi, 2016)**



**Figure 28: Grouted coupler in precast element (Redd, 2016)**

### 3.4. Filler or Bonding Material

Regardless of what configuration are used for connecting precast-prestressed pile segments, some kind of material is needed to perform as bonding, filler or coating agent. Different types of cement and resin are used as filler or bonding materials at the connection of the precast concrete structures. The properties that are of utmost importance for choosing proper grouts to be used in connections are durability, strength, and constructability. These properties are tabulated in Table 4 (Scholz et al., 2007).

**Table 4: General grout properties (Scholz et al., 2007)**

<b>Strength</b>	<b>Durability</b>	<b>Constructability</b>
Compressive	Shrinkage	Work Time
Tensile	Freeze/Thaw	Set Time
Bond	Sulfate Resistance	Flow
	Chloride Ingress	

Filler or bonding materials shall provide the required strength for members; otherwise, premature failure will be observed. Reaching required strength is defined as their ability to provide adequate resistance for both compressive and tensile stress in a structural element.

In ABC, since one of the goals is to accelerate constructions as much as possible, the rapid strength gain for the filler or bonding materials is of importance. Most grouts used for highway patching are rated for compressive strength of 2500 psi in two hours. Initial set time is the parameter used to compare the rapid strength of grouts, although work time should be taken into account to see the feasibility of pouring the grout. Work time is defined as a time interval between the start of mixing until workability begins to decrease. Decreased workability is deemed the inability to move a grout by vibration. If the work time is too short, the pouring of grout in the connections/joints will be a problem. There is a linear relationship between work time and initial set time, measured from the start of mixing until the product shows resistance to the penetration of a thin rod (Scholz et al., 2007). Quite a bit of research has been conducted to find bonding materials with proper constructability features. In the following sections, recent research on cement and polymer grout as well as epoxy resin will be reviewed and analyzed according to their constructability, durability, and strength.

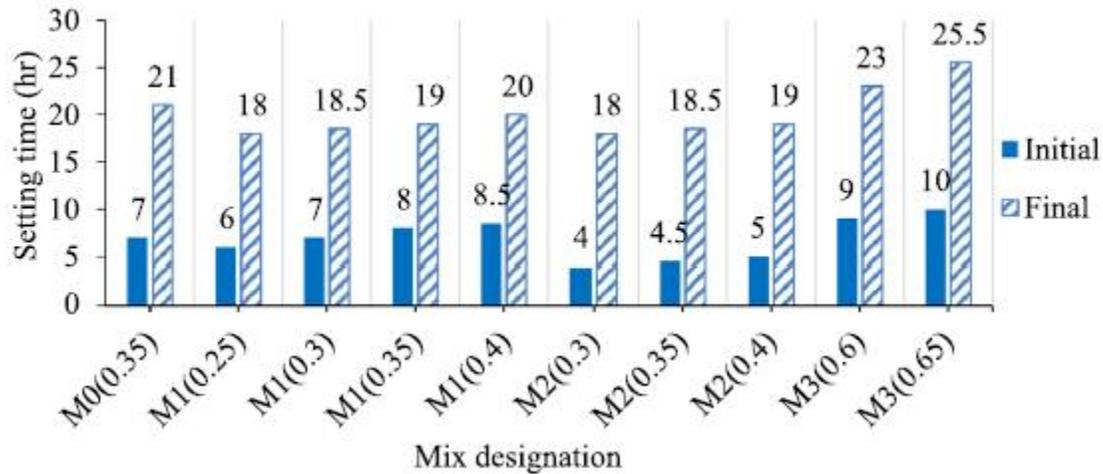
#### **3.4.1. Cement grout:**

Vasumithran et al. (2020) investigated the effects of incorporating fillers such as fine sand and fly ash in cement grouts to improve their constructability and evaluated the flowability as well as mechanical properties of the proposed mixes. They replaced 10 percent of cement mass with silica fume and up to 50 percent of cement mass with filler materials in certain mixes. Table 5 shows certain mixes of grout specimens. SF, FS, FA, and SP stand for silica fume, fine sand, fly ash, and superplasticizer, respectively.

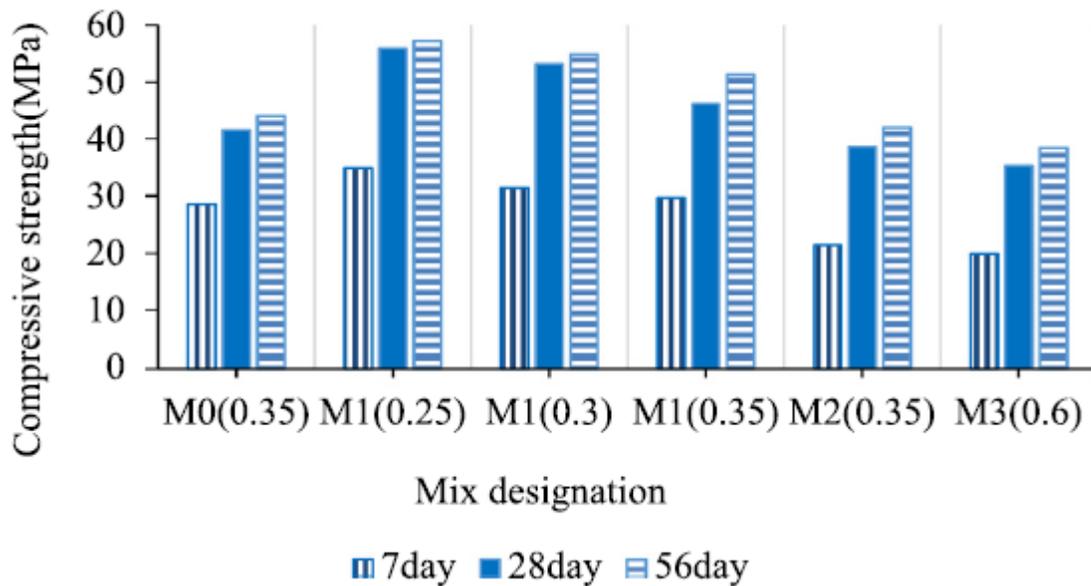
**Table 5: Mix proportion details (in kg/m<sup>3</sup>) (Vasumithran et al., 2020)**

Mix type (W/C)	Cement	SF	FS	FA	Water	SP
M0(0.35)	1458.6	-	-	-	510.5	5.8
M1(0.25)	1536.9	170.8	-	-	426.9	23.8
M1(0.3)	1416.1	157.3	-	-	472.0	13.7
M1(0.35)	1312.8	145.9	-	-	510.5	7.6
M1(0.4)	1223.5	136.0	-	-	543.8	2.4
M2(0.3)	865.7	96.2	961.9	-	288.6	19.2
M2(0.35)	825.9	91.8	917.8	-	321.2	14.7
M2(0.4)	789.7	87.8	877.5	-	351	8.8
M3(0.6)	673.9	74.9	-	748.7	449.2	13.5
M3(0.65)	649.6	72.2	-	721.7	469.1	11.5

Their findings indicate that increasing the water-cement ratio (w/c) causes; 1-low mechanical strengths, 2- long setting time, 3-grout instability, and 4-excessive bleeding. The results of the set time and compressive strength of the investigated various grout mixes are summarized in Figures 34 and 35.



**Figure 34: Setting time of the selected grout mixes (Vasumithran et al., 2020)**



**Figure 35: Compressive strength of various grout mixes (Vasumithran et al., 2020)**

They also concluded that grouts with fine fillers have a better performance in shrinkage and water absorption, and that fine fillers can be a proper replacement to cement since it increases the durability of grouts. They noted that replacing levels of cement with supplementary cementitious materials should be chosen wisely not to affect strength and durability properties. Otherwise, the high volume concentration of fillers in grouts can reduce the compressive strength dramatically (Vasumithran et al., 2020).

From the work by Vasumithran et al., it can be concluded that M2 grouts (see Table 5) have the least setting time, both initial and final, and as the w/c ratio increases, the setting time increases. The setting time for M2 with w/c equal to 0.3 is less than the mixes with w/c of 0.35 and 0.4 (Figure 34). Additionally, according to the Figure 35, M1 grouts have the highest compressive strength, and as the w/c increases the compressive strength decreases; the compressive strength for M1 with the w/c equal to 0.25 is more than that type of grout with the higher w/c of 0.3.

Jansson (2008) investigated the impact of two types of grout, Erico HY10L and Nisso SS Mortar, used for mechanical reinforcement splices (Figure 36). HY10L is a non-shrink metallic grout. Small steel fragments are used in the grout to improve the ductility of the hardened product. He found that the working time for HY10L is 25 to 30 minutes. After testing three specimens, their compressive strength was measured as reported in Table 6 (Jansson, 2008).



**Figure 36: Grout specimens (Jansson, 2008)**

**Table 6: Grout compressive strength in psi for Erico HY10L (Jansson, 2008)**

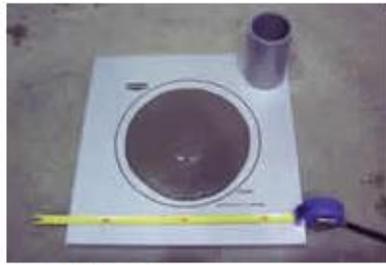
	24 hours	3-Day	7-Day	28-Day
Specimen 1	6,500	9,550	11,630	14,150
Specimen 2	6,550	9,580	11,750	15,000
Specimen 3	6,500	9,600	10,880	14,950
Average	6,520	9,580	11,420	14,700

Nissco SS Mortar is a non-shrink nonmetallic grout, and the working time was measured to be 40 minutes at 70 degrees Fahrenheit. The grout compressive strength for three specimens (2x2 in.) was reported and summarized in Table 7.

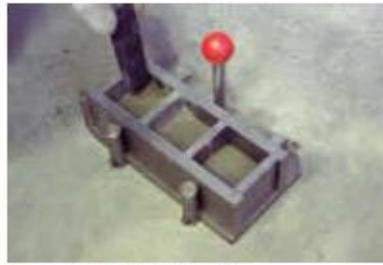
**Table 7: Grout compressive strength in psi for Nissco SS Mortar (Jansson, 2008)**

	24 hours	3-Day	7-Day	28-Day
Specimen 1	7,320	11,500	15,000+	15,000+
Specimen 2	7,520	11,380	15,000	15,000+
Specimen 3	7,220	11,330	15,000+	15,000+
Average	7,350	11,400	15,000+	15,000+

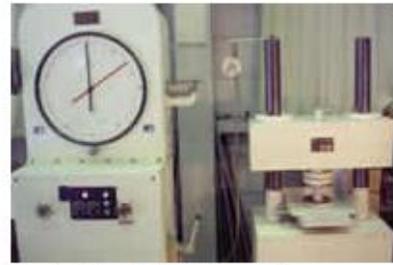
Splice sleeve Japan Inc. also introduced SS Mortar as a filler material for NMB splice sleeve. The advantages of applying this type of grout are; 1- high early strength, approximately 30 N/mm<sup>2</sup> in 24 hours, 2-high ultimate strength, approximately 100 N/mm<sup>2</sup> in 28 day, 3- flowability, and 4- not having significant shrinkage. Examples of the test results, based upon ASTM tests (Figure 37), for fresh SS Mortar and hardened SS Mortar are shown in Tables 8 and 9.



Flow Guide Table



Cubic Mold (5x5x5 cm)



Compressive Strength Test

**Figure 37: Compressive strength and flowability tests**

(<http://splicesleeve.com/ssj/ssmortar.html>)

**Table 8: Test result for fresh SS Mortar**

(<http://splicesleeve.com/ssj/ssmortar.html>)

Amount of water (per bag)	Consistency (Dia. by Flow table)	Mixed temp.	Curing temp.	Bleeding ratio	Setting time (Hour-Min.)	
					Initial	Final
2.2 liters	180 mm	20°C	5°C	0%	9-31	13-35
			20°C	0%	4-18	5-55
			30°C	0%	2-23	3-20

**Table 9: Test result for hardened SS Mortar**

(<http://splicesleeve.com/ssj/ssmortar.html>)

Consistency (Flow table)	Curing temp	Compressive Strength (N/mm <sup>2</sup> )					
		12 hrs	18 hrs	1 day	3 day	7 day	28 day
180 mm	5°C	-	4.0	10.1	42.2	56.5	86.3
	20°C	5.6	20.2	30.5	55.2	71.1	100
	30°C	18.5	36.0	49.0	68.5	79.1	101

As it is shown, the setting time of SS mortar at 30 degrees centigrade is approximately 2 hours and, as the temperature decreases, the setting time increases. In 5 degrees centigrade, it reaches approximately 9 hours. Also, the compressive strength of SS mortar in 30 degrees centigrade is approximately 101 Pascal in 28 day, and as the temperature decreases, the compressive strength decreases. The temperature is an important factor affecting the properties of grouts and should be considered in the construction.

In 2007, Potter experimentally investigated the sensitivity of grouting material to installation process. In his research, 6 NMB sleeve splices with a #9 Grade 60 bar were constructed and

filled with SS mortar (Figure 38). Half of the tested specimens were representative of poor grouting material, in that the grout material was not rodded. Others were representative of proper grouting materials since they were rodded with a 1/8" diameter wire, 10 times for a depth at least 3/4 of the splice sleeve. The tensile test was applied to the specimens to find the effect of rodding on the SS mortar performance. The results indicated that rodding of SS mortar in the splice system might not affect the tensile strength of the splice system as long as sufficient amount of SS mortar is used and the placement of rebar is adequate.



**Figure 38: NMB sleeve splices setup for testing the sensitivity of grout (Potter, 2007)**

Varga et al. (2014) investigated 7 pre-bagged grouts used in the construction industry (Table 10).

**Table 10: Grout used in the investigation (De la Varga & Graybeal, 2015)**

Grout category	Solids specific gravity <sup>a</sup>	Nomenclature <sup>b</sup>
Nonmetallic cement-based	2.93	C1 - 0.16
Nonmetallic cement-based	2.93	C2 - 0.18
Nonmetallic cement-based	2.68	C3 - 0.17
Metallic cement-based	3.16	C4 - 0.167
Fly ash-based	2.84	F1 - 0.08
Epoxy-based	2.62	E1 - fluid <sup>c</sup>
Magnesium phosphate-based	2.59	M1 - 0.08
Ultrahigh-performance concrete	2.78	U1 - 0.18

<sup>a</sup>Specific gravity of the solids fraction measured using a gas (He) pycnometer.

<sup>b</sup>Grout nomenclature followed by the *w/s* used for each of the grouts.

<sup>c</sup>The supplier of E1 recommends two formulations: dry and fluid. In this study, the fluid formulation was used.

The results of their investigation on flowability and setting time are summarized in Table 11. Also, the results of the compressive strength of the grout cubes are summarized in Table 12.

**Table 11: Flow Measurements Using ASTM C1437 Methods(Standard, 2013), Time of Set (ASTM 2008b), and Fresh Air Content (A. ASTM, 2014)**

Grout	Number of drops	Flow at 5 min (%) <sup>a</sup>	Flow at 15 min (%) <sup>a</sup>	Final time of set (ASTM C403) (h)	Air content (ASTM C231) (%)
C1- 0.16	5	112	106	7.7	3.4
C2- 0.18	5	117	84	6.8	5.1
C3- 0.17	5	111	100	10.3	12
C4- 0.167	5	110	91	6.8	3.6
F1- 0.08	5	101	109	0.7	4.6
E1- fluid	N/A <sup>b</sup>	N/A <sup>b</sup>	N/A <sup>b</sup>	3.5	8.5
M1-0.08 <sup>a,c</sup>	5	115	75	0.4	6.9
U1- 0.18	5	N/A <sup>d</sup>	>125	6.9	3.2
a	Flow slightly changes depending on mixer used. These values were measured using a medium-sized Univex mixer				
b	Material sticks in mold. Test cannot be performed.				
c	Flow was measured at 2 and 5 min because of final setting time limitations				
d	Flow was measured only at 15 min because of mixing time requirements.				

**Table 12: Compressive strength results for grout cubes (De la Varga & Graybeal, 2015)**

Grout	Average compressive strength (MPa)					
	4 h	8 h	1 day	3 days	7 days	28 days
C1- 0.16	___a	___a	30.5(0.83) <sup>b</sup>	48.9 (2.21)	52.14 (1.17)	67.6 (2.00)
C2- 0.18	___a	___a	25.6 (0.41)	41.1 (0.90)	45.1 (0.97)	50.2 (2.35)
C3- 0.17	___a	___a	16.6 (0.48)	26.2 (0.76)	35.5 (0.21)	43.7 (0.41)
C4- 0.167	___a	___a	34.6 (0.76)	49.3 (1.52)	60.9 (0.07)	67.6 (1.52)
F1- 0.08	31.1 (0.21)	34.6 (1.38)	34.9 (1.04)	44.0 (0.90)	55.5 (1.04)	56.1 (0.35)
E1- fluid	___a	8.42 (0.14)	56.1 (1.45)	73.6 (0.35)	77.3 (0.41)	93.5 (3.24)
M1- 0.08	32.0 (2.07)	31.3 (0.41)	43.0 (2.14)	44.9 (1.93)	44.2 (1.24)	54.0 (2.35)
U1- 0.18	___a	___a	93.15 (0.28)	129.7 (3.45)	132.1 (1.59)	170.4 (0.90)
Note:	1 Mpa = 145 psi.					
a	Material had not set yet, or it was still to be tested.					
b	Numbers in parentheses indicate one standard deviation in Mpa as determined for three replicate specimens tested at each age.					

In their investigations, they also studied the shrinkage behavior of the grouts and found that although some grouts are referred to as non-shrink materials, the shrinkage was observed in most of them, especially in dry ambient conditions. The internal curing was introduced as an effective method in decreasing the shrinkage.

From their work, it can be concluded that UHPC and epoxy-based grouts have the highest compressive strength compared to others. Also, in terms of setting time, fly ash-based and magnesium phosphate-based grouts have the lowest setting time.

Scholz et al. (2007) conducted a thorough research on 8 types of grouts to develop a performance specification for grouts that fill the haunch between the top of a beam and the bottom of a deck panel (Figure 39). Standard or modified ASTM tests were used to determine the material properties of the 8 types of grout. The mix information of the candidate grouts is included in Table 13 (Scholz et al., 2007).



**Figure 39: The tests for grouts that fill the haunch between the top of a beam and the bottom of a deck panel**

**Table 13: Candidate Grouts and Mixing Information (Scholz et al., 2007)**

ID No. and Product Name		Mixing Quantities per 50-lb, Bag					Cost per bag, \$
		Initial Water, pints	Additional Water, pints	Aggregate Extension, % by weight	Aggregate Extension, lb	Yield Volume, cu. ft.	
Neat Grout	1. ThoRoc® 10-60 Rapid Mortar	5.50	1.00	0	0	0.43	12.75
	2. SikaQuick® 2500	5.00	0.50	0	0	0.43	13.75
	3. Five Star® Highway Patch	5.00	1.00	0	0	0.40	20.50
	4. Set® 45 Hot Weather	3.25	0.50	0	0	0.39	24.00
Extended Grout	5. ThoRoc® 10-60 Rapid Mortar	5.50	1.00	50	25	0.57	12.75
	6. SikaQuick® 2500	5.00	0.50	50	25	0.60	13.75
	7. Five Star® Highway Patch	5.00	1.00	80	40	0.66	20.50
	8. Set® 45 Hot Weather	3.25	0.50	60	30	0.58	24.00

As shown in Table 13, from the eight types of grouts investigated, four of them were neat grouts, and others were extended grouts. In the extended grouts, a third-eighth inch pea gravel extension was used. The ASTM tests were conducted to find the compressive as well as tensile strength ((C. ASTM, 2002),(C. ASTM, 1996)), bond strength with concrete (C. ASTM, 1999) (Figure 40), flowability (C. ASTM, 2001) (Figure 41), work time as well as set time (ASTM C 230), and shrinkage behavior (Materials, 1999). Also, the effect of extension on grouts was investigated.



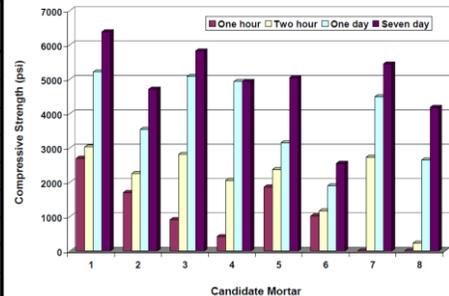
**Figure 40: Bond strength test between grout and concrete (Scholz et al., 2007)**



**Figure 41: Flowability test**

Tests results of compressive strength for the 8 grouts in one and two hours as well as one and 7 day are presented in Figure 42.

	Grout	Compressive Strength, psi			
		1 hr.	2 hr.	1 day	7 day
1	ThoRoc® 10-60	2700	3030	5210	6380
2	SikaQuick® 2500	1700	2250	3540	4710
3	Five Star® Patch	910	2810	5080	5820
4	Set® 45 HW	420	2050	4930	4930
5	ThoRoc® extended	1860	2370	3150	5040
6	SikaQuick® extended	1020	1170	1900	2550
7	Five Star® extended	-	2730	4490	5440
8	Set® 45 HW extended	-	230	2650	4180



**Figure 42: Compressive Strengths per ASTM C 109**

Scholz et al. (2007) concluded that most grouts reached 2 Ksi in the first two hours. ThorRoc10-60 (1) had the highest compressive strength among all both in the first hour and after 7 days.

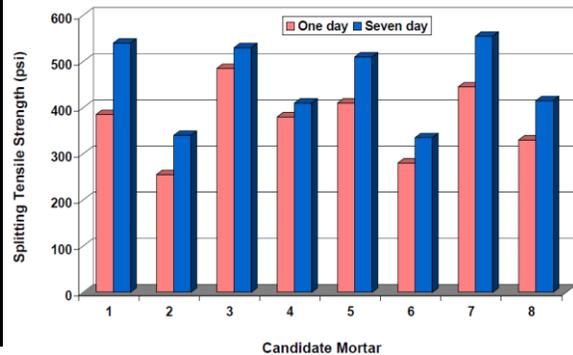
Also, the pea gravel extension reduced the compressive strength of the neat grouts. Based on ASTM C 109, a product shall meet the following requirements for compressive strength (Scholz et al., 2007):

- 1 hour: No strength
- 2 hour: Determined by engineer-of-record based on construction procedure.
- 1 day: Minimum 4000 psi
- 7 day: Minimum 5000 psi

Accordingly, ThorRoc10-60, the neat grout; Five Star Patch, both neat and with extension grouts; Set 45 HW, the neat grout meet the requirements.

Tests results for tensile strength for the grouts in one and 7 days are presented in Figure 43.

	Grout	Tensile Strength, psi	
		1 day	7 day
<b>1</b>	ThoRoc® 10-60	385	<b>540</b>
<b>2</b>	SikaQuick® 2500	255	340
<b>3</b>	Five Star® Patch	<b>485</b>	530
<b>4</b>	Set® 45 HW	380	410
<b>5</b>	ThoRoc® extended	410	510
<b>6</b>	SikaQuick® extended	280	335
<b>7</b>	Five Star® extended	<b>445</b>	<b>555</b>
<b>8</b>	Set® 45 HW extended	330	415



**Figure 43: Splitting Tensile Strengths per ASTM C 496**

Scholz et al. (2007) found that each candidate grout reached a 200 psi split tensile strength on the first day (Figure 43). In 7 days, all of them except Sika Quick 2500, both neat and extended, reached at least 400 psi split tensile strength. Based on ASTM C 496, a product shall meet the following criteria for the splitting tensile strength (Scholz et al., 2007):

- 1 day: Minimum 200 psi
- 7 day: Minimum 400 psi

If a 7 day splitting tensile strength is not available for a product, the following criteria shall be applied:

- 28 day: Minimum 600 psi

If no splitting tensile strength data is accessible for a product, the following requirement shall be applied:

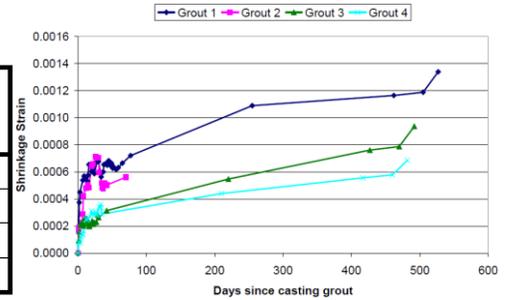
- 1 day compressive strength divided by 15 must be greater than 300 psi
- 7 day compressive strength divided by 15 must be greater than 400 psi

- 28 day compressive strength divided by 15 must be greater than 500 psi

Based on the above requirements, ThorRoc10-60, both neat and with extension grouts; Five Star Patch, both neat and with extension grouts; Set 45 HW, both neat and with extension grouts, satisfy the requirements. It also can be concluded that adding pea gravel extension has not made a tangible change in the tensile strength of products.

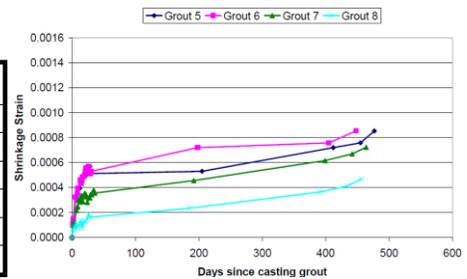
Tests results of shrinkage for the grouts are shown in Figures 44 and 45. These results were obtained by measuring, periodically, their shrinkage behavior over 500 days (Scholz et al., 2007).

	Grout	28 Day Shrinkage		
		in.	%	με
1	ThoRoc® 10-60	0.0076	0.076	760
2	SikaQuick® 2500*	0.0080*	0.080*	800*
3	Five Star® Patch	<b>0.0029</b>	<b>0.029</b>	<b>290</b>
4	Set® 45 HW	0.0034	0.034	340



**Figure 44: Neat grout shrinkage**

	Grout	28 Day Shrinkage		
		in.	%	με
5	ThoRoc® extended	0.0064	0.064	640
6	SikaQuick® extended	0.0089	0.089	890
7	Five Star® extended	0.0036	0.036	360
8	Set® 45 HW extended	<b>0.0018</b>	<b>0.018</b>	<b>180</b>



**Figure 45: Extended grout shrinkage**

In the shrinkage experiments, the size of the rod used in neat grouts (1 in. square cross-section bars) was different from the rod used for the extended grouts (3 in. square cross-section bars). To be able to compare these two sets of results, the ACI 209R provides correction factor (ACI-209R, 1998). The results with the correction factor are shown in Table 14.

**Table 14: 28 Day Shrinkage with Volume-Surface Ratio Correction Factor (Scholz et al., 2007)**

	Grout	$\Delta L$ , in.	$\gamma_{vs}$	Corrected Shrinkage, $\Delta L / \gamma_{vs}$		
				in.	%	$\mu\epsilon$
1	ThorRoc <sup>®</sup> 10-60	0.0076	1.165	0.0065	0.0653	653
5	ThorRoc <sup>®</sup> extended	0.0064	1.097	0.0058	0.0584	584
2	SikaQuick <sup>®</sup> 2500	0.0080	1.165	0.0069	0.0687	687
6	SikaQuick <sup>®</sup> extended	0.0089	1.097	0.0081	0.0812	812
3	Five Star <sup>®</sup> Patch	0.0029	1.165	0.0025	0.0249	249
7	Five Star <sup>®</sup> extended	0.0036	1.097	0.0033	0.0328	328
4	Set <sup>®</sup> 45 HW	0.0034	1.165	0.0029	0.0292	292
8	Set <sup>®</sup> 45 HW extended	0.0018	1.097	0.0016	0.0164	164

The shrinkage results showed that SikaQuick<sup>®</sup>2500 (2) and Five Star<sup>®</sup> Patch (3) had less amount of shrinkage than their corresponding extended grouts (6 & 7). Adding pea gravel extension increased the amount of shrinkage for ThorRoc10-60 and Set 45 HW. The effect of extension on grouts need further investigations. Based on either ASTM C 157 or ASTM C 596, a grout to be acceptable in shrinkage behavior shall meet the following criteria:

- 28 day: Maximum allowable shrinkage is 0.04% (400 micro strain)

Considering the above requirement, SikaQuick<sup>®</sup>2500 and ThorRoc10-60, both neat and with extension violate the requirements, although they are in use today.

The results of their work on the work time, initial set time in minutes are presented in Table 15 (Scholz et al., 2007).

**Table 15: Candidate Grout Workability Observations (Scholz et al., 2007)**

	Grout	Work Time, min.	Initial Set Time, min.	Consistency	Haunch Flow Observation
1	ThoRoc <sup>®</sup> 10-60	8	16	Thick	poor
2	SikaQuick <sup>®</sup> 2500	15	24	Medium	good
3	Five Star <sup>®</sup> Patch	18	30	Medium	good
4	Set <sup>®</sup> 45 HW	<b>28</b>	<b>44</b>	Runny	<b>very good</b>
5	ThoRoc <sup>®</sup> extended	10	19	Thick	fair
6	SikaQuick <sup>®</sup> extended	21	29	Medium	<b>good</b>
7	Five Star <sup>®</sup> extended	15	26	Thick	fair
8	Set <sup>®</sup> 45 HW extended	<b>24</b>	<b>35</b>	Medium	<b>good</b>

They found that ThoRoc<sup>®</sup> 10-60 has the shortest work time and set time among all candidate grouts. Although the short set time of ThoRoc<sup>®</sup> 10-60 seems to be beneficial for accelerating the construction, its short work time impacts negatively the flowability. ThoRoc<sup>®</sup> 10-60 is not preferable to be used in the connections/ joints with large space. However, using ThoRoc<sup>®</sup> 10-60 as filler and bonding agent in mechanical couplers can be a good option provided its

shrinkage does not make any tensile crack. It also can be concluded that adding pea gravel extension to the neat grout candidates increases their work and set time.

### 3.4.2. Polymeric grouts:

Mantawy et al. (2019) investigated the impact of using polymer, polymethyl methacrylate (PMMA) in place of Portland cement on the grout as filler materials (Table 16). Three tests were conducted to find the development as well as lap splice length and shear strength of the polymeric grout. The results of Polymer concrete, also called PC, were compared with ultra-high performance concrete with the mix shown in Table 17.

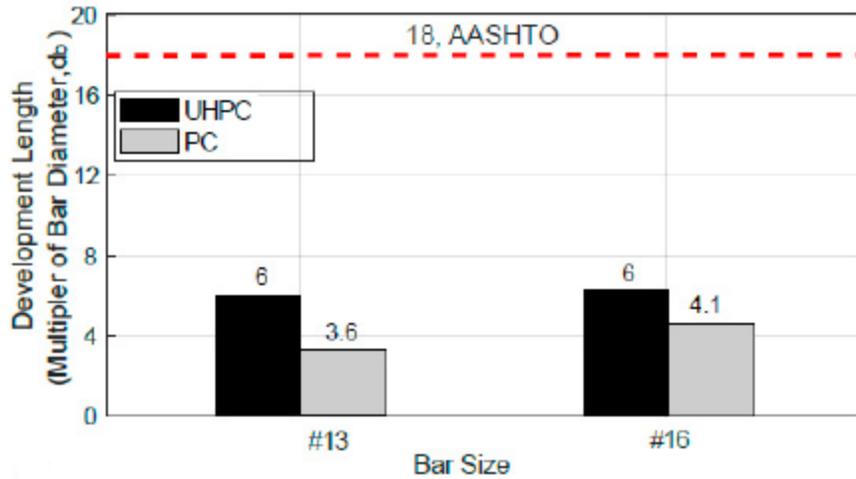
**Table 16: Mixture Proportions of PMMA-PC (kg/m<sup>3</sup>) (Mantawy et al., 2019)**

	PMMA-PC	Properties
Mixture	MMA Polymer Aggregate	159.5 2224.6

**Table 17: Mixture Proportions of Ultra-High Performance Concrete (UHPC) (kg/m<sup>3</sup>) (Mantawy et al., 2019)**

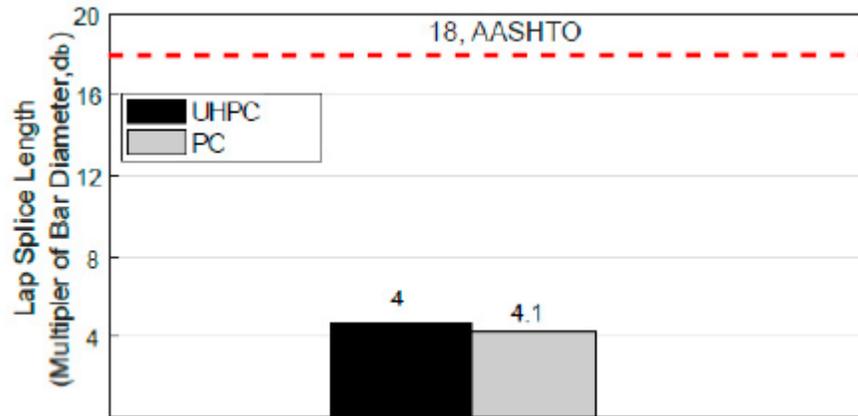
Cement	1029
Water	227.5
Aggregate (Clean Medium Sand)	910
Silica Fume	306.6
Superplasticizer (Glenium 3030 NS)	26.7

They found the minimum development length for PC in the range between 3.6 and 4.1 times of the reinforcing bar diameter that is considerably lower than the minimum development length for UHPC (Figure 46).



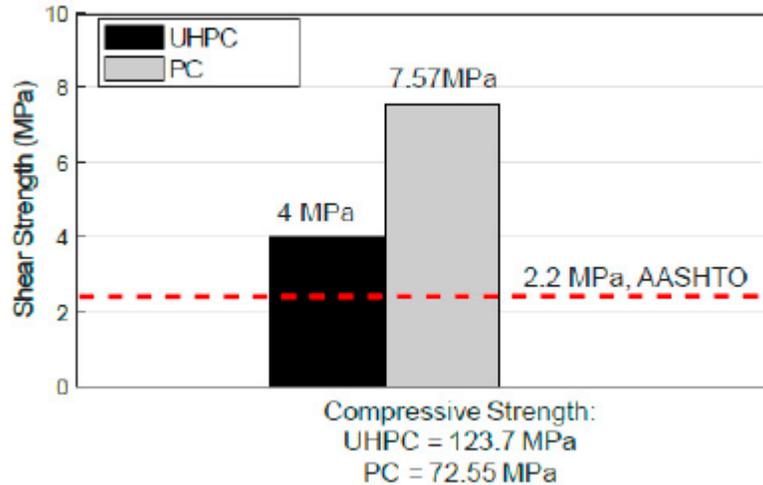
**Figure 46: The comparison of minimum development length between PC and UHPC (Mantawy et al., 2019)**

The minimum lap splice length needed for steel bars in PC for achieving yield stress found to be 4.1 times of the reinforcing bar diameter, whereas for the UHPC it is 4.5 times the reinforcing bar diameter (Figure 47) (Mantawy et al., 2019).



**Figure 47: The comparison of minimum splice length between PC and UHPC (Mantawy et al., 2019)**

Shear strength for PC was found much higher than both UHPC and normal concrete (Figure 48).



**Figure 48: The comparison of shear strength between PC and UHPC (Mantawy et al., 2019)**

The use of polymeric materials in grouts can effectively increase the compressive strength and reduce the required lap splice and development length.

### 3.4.3. Epoxy resin:

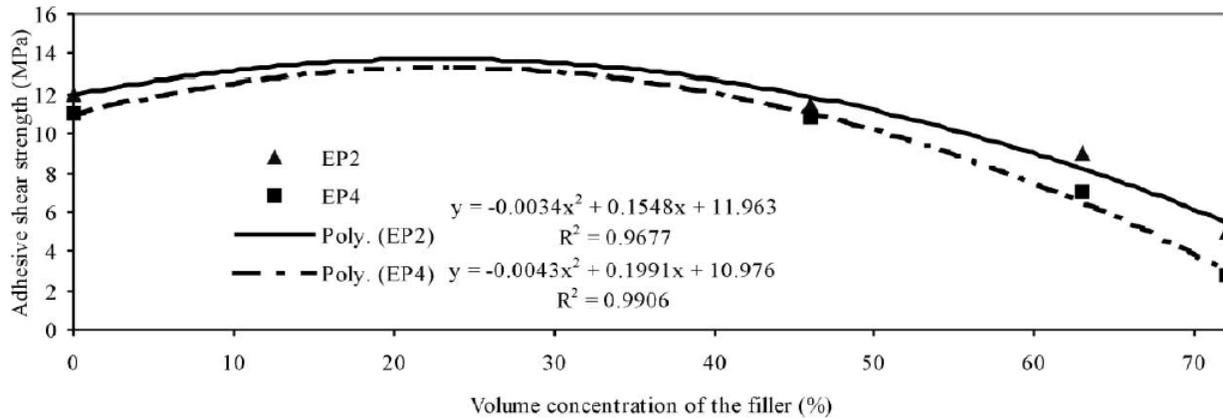
The internal stresses in cement-based bonding material are caused by the natural tendency of cement to shrink during solidification and differences in physical properties of fresh cement paste as well as hardened concrete. The internal stresses lead to circumferential tensile cracks in the surrounding concrete and thus reduce the bond strength. One solution to prevent or decrease circumferential tensile cracks is to select an adhesive that is compatible with materials to be joined as much as possible. Since the formulation within one class of adhesives varies widely impacting its physical properties, finding the best adhesive for a specific application is not easy. In selecting the adhesive materials, the properties of materials to be bonded, and the economy of bonding operations should be considered. For example, polymer adhesives cannot be applied to all types of materials. A disadvantage of applying polymer adhesives is that they have a much higher tendency to creep than concrete. One type of adhesive material that has shown a high adhesion strength to both steel and concrete is epoxy (Çolak, 2001). Epoxy compounds are formulated normally in two parts, A and B. Part A is the portion including the epoxy resin; part B is a hardener material. They can be used for grouting or pressure injection of cracks to restore the tensile strength of concrete or other materials. ASTM provides a specification for epoxy bonding system (ASTM C 881-83). It divides the epoxy material into classes, types, and grades. Type I is used for bonding hardened concrete to each other or other materials to hardened concrete. Type II is used for bonding fresh concrete to hardened concrete. The term Grade is used to define viscosity. Grade 1 is a low viscosity that can be used for filling fine cracks. Grade 2 is a medium viscosity, and grade 3 has non-sagging consistency. The class is used to define the set time that can be affected by the ambient temperature. Class A is used in applications below 40 degrees Fahrenheit, class B for applications between 40 and 60 degrees Fahrenheit, and class C for applications above 60 degrees Fahrenheit. Since their properties, including strength as well as deformation and fire resistance are not well established, care is advised in their use. Also,

most of the epoxies degrade due to creep in high temperatures in the range of 140 to 150 degrees Fahrenheit. Much research has been conducted to investigate epoxy adhesives (Sturm & Shaikh, 1988).

Adnan (2001) investigated 4 types of epoxy adhesives (Table 18) and found that the presence of filler above 46 percent in adhesive formulation decreases the shear strength of epoxy adhesives dramatically (Figure 49).

**Table 18: Types of epoxy adhesive formulation (Çolak, 2001)**

Epoxy adhesive formulations				
Type of epoxy adhesive formulation	Resin	Reactive diluent	Curing agent	Filler
EP1	DGEBA	Diglycidyl ether	Tri methyl hexa methylene diamine	—
EP2	DGEBA	Diglycidyl ether	Tri methyl hexa methylene diamine	Quartz sand
EP3	DGEBA	Diglycidyl ether	Tri ethylene tetra amine	—
EP4	DGEBA	Diglycidyl ether	Tri ethylene tetra amine	Quartz sand



**Figure 49: The effect of volume concentration of the filler on the adhesive shear strength (Çolak, 2001)**

To establish proper bond in prestressed concrete piles using dowel connection, epoxy grout is commonly used. There are many types of epoxy grouts with different formulations in the market (Figure 50). The curing time of epoxy can be accelerated by heating methods such as enclosing the joints with a steam jacket (Navaratnarajah, 1981). Canner (2005) studied the CONCRETSIVE® 1420 (currently known as MasterEmaco ADH® 1420) as a general-purpose gel epoxy adhesive used in prestressed concrete piles spliced with steel pipes. In his investigation, CONCRETSIVE® 1420 was introduced as a proper product for the splice mating surface due to its ability to adhere to the surface and its high strength performance. The convenient way for applying epoxy is to mix them simultaneously in a larger container and pour it fast to prevent the setting of the epoxy before the completion of the process (Canner, 2005).



**Figure 50: Different epoxies in the market**

(<https://coastalone.com/epoxy.html>)

According to the Florida Department of Transportation, epoxy materials shall meet the requirements of Section 937. It also asserts the material should be on the FDOT’s Approved Product List (APL) unless an alternative product is approved by the Department.

**3.4.4. Sprayed polymer:**

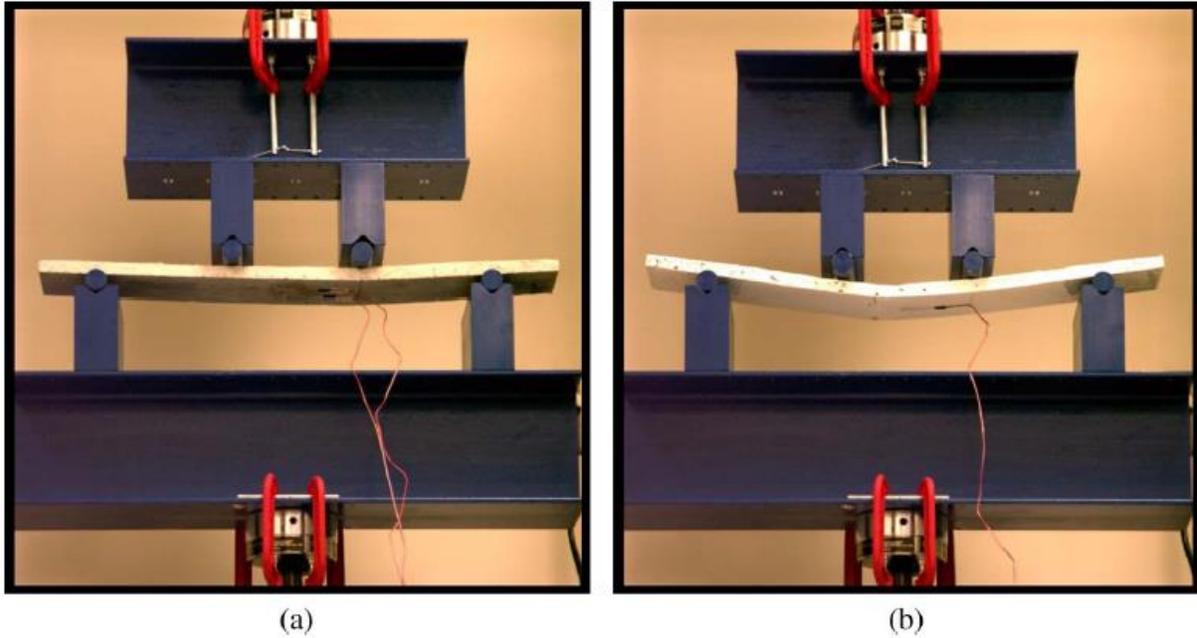
Choi et al. (2014) experimentally investigated the behavior and effectiveness of polymeric material, Polyurea, when sprayed as coating over cementitious concrete. Polyurea was sprayed on the surface of two types of specimens made of high-performance cementitious composites, PVB and PVA. The mix proportions for PVB and PVA fiber concretes is presented in Table 19.

**Table 19: Mix proportions for PVB and PVA fiber concretes ( Choi et al., 2014)**

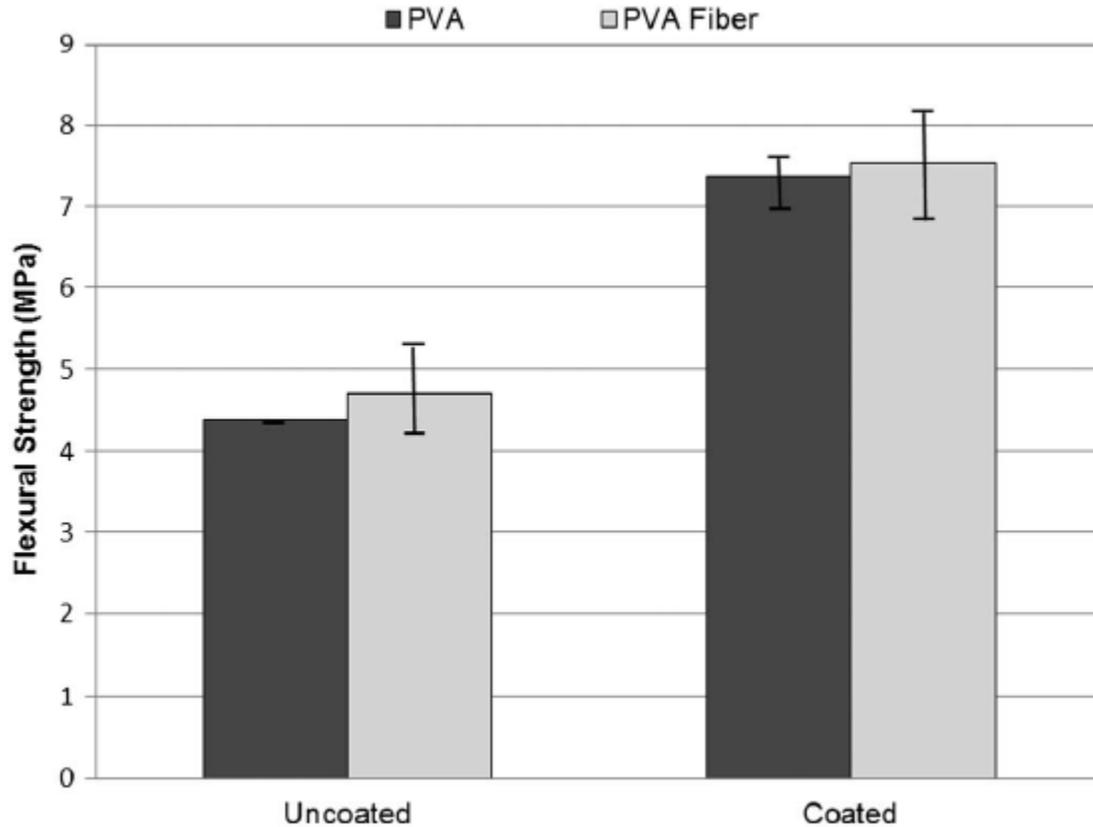
Constituents/concrete mix	PVB mix (without fiber)	PVA fiber mix
Cement	832.96	832.96
Metakaolin	79.30	79.30
B - 79 (Butvar - PVB)	182.39	182.39
B -75 (Butvar - PVB)	118.95	118.95
Water	364.78	364.78
Sika	26.68	26.68
PVA Fiber (RECS7)	0	7.93 (Vf = 0.6) <sup>a</sup>
W/C	0.438	0.438

<sup>a</sup>Fiber volume fraction (Vf) is constant for all PVA specimens.

In their work, two tests were conducted to investigate the effect of the sprayed Polyurea on the specimens. The first test investigated the flexural strength of coated and uncoated specimens (Figure 51). In this test, they found that coating by plain Polyuria increased the flexural strength of specimens by at least by 60 percent (Figure 52).



**Figure 51: Flexure tests were conducted on (a) uncoated; (b) coated plates ( Choi et al., 2014)**



**Figure 52: Flexural strengths for uncoated and coated specimens ( Choi et al., 2014)**

The second test, drop-weight tests, investigated the resistance of coated specimens to blast loads. The impact of sprayed Polyuria was investigated to see the proper location for spraying, top or bottom of specimens. They concluded that coating any surface is preferable to coating none. Also, coating the surface in the opposite direction of the striker is preferable to the coating the surface facing the striker, and coating both surfaces worked best (Table 20).

**Table 20: Post impact Panel Condition for a Constant Drop Height of 2.74 m ( Choi et al., 2014)**

Specimen number	Location of polyurea coating	Condition of upper/lower surfaces
PVB mix		
#1	Bottom	F / F
#2	Both	P / P
PVA fiber mix		
#1	Bottom	F / F
#2	Both	P / P

Note: F = failure due to cracking; P = pass where no cracks were observed.

### 3.4.5. Candidate Grouts:

Among all grouts investigated in this section, Table 21 shows the candidates that can be used in the promising splice based on the work and set time as well as compressive strength. Further investigations in the current study will determine the grout (or epoxy) mix(es) that are most promising for the purpose of establishing splice connection for precast-prestressed concrete piles.

**Table 21: Candidate Grouts for the promising splice**

Row	Type	Grout	Compressive strength - psi					Work time (hr)	Set time (hr)	Reference
			1 hour	2 hour	1 day	7 day	28 day			
1	Cement grout	Five Star® Highway Patch	910	2810	5080	5820		0.3	0.5	1
2	Cement grout	Erico HY10L			6520	11420	14700	0.4		2
3	Cement grout	M1(0.25)				5500			6	3
4	Cement grout	Nissco SS Mortar			7350	12000	15000+	0.5	2.5-9.5*	2
5	Cement grout	Fly ash-based		4509***	5061	8047	8134	can reach 2000 psi in less than 4 hour		4
6	Epoxy based grout	Epoxy based grout			6235	11208	13558	can reach 5000 psi in less than 8 hour		4
7	Cement grout	Set 45® Hot Weather Grout	420	2050	4930	4930		0.2	0.75	1
8	Cement grout	ThoRoc® 10-60	2700	3030	5210	6380		0.1	0.2	1
9	epoxy resin-based grout	Masterflow 647R			4900	10000+	10000+	0.17-0.7***		5
10	epoxy resin-based grout	10-60 RAPID MORTAR	2000	3000	6500		8000	0.13	0.27	5
*	set time depends on curing temperature									
**	temperature F(C)	90 (32) 10–20	***	2 to 4 hour						
	minutes	75 (24) 20–30								
		55 (13) 30–40								
	Reference 1	Scholz et al., 2007								
	Reference 2	Jansson, 2008								
	Reference 3	Vasumithran et al., 2020								
	Reference 4	De la Varga & Graybeal, 2015								
	Reference 5	<a href="http://www.bestmaterials.com">www.bestmaterials.com</a>								

### Task 2 –Development of New Splice Details and Configurations

The results of literature review will be analyzed to identify candidate concepts regarding details and configurations that would be applicable to pile splices. Modifications will be applied to better fit the details to the purpose of pile splicing, or new configuration will be explored to accommodate the splice requirements.

No work was performed for this task.

### Task 3 – Modeling and Analysis

The candidate details and configurations identified in the previous task will be analyzed using FE modeling and section analysis, and their structural performances will be compared to that of the existing splice details. This should result in selection of few configurations as most promising splice connections.

No work was performed for this task.

### Task 4 – Constructability Analysis



## 5. Reference

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