

**SECTION 31 23 23.33**  
**FLOWABLE FILL**

**PART 1 - GENERAL**

**1.1 INTRODUCTION:**

- A. Flowable fill refers to a cementitious slurry consisting of a mixture of fine aggregate or filler, water, and cementitious material(s), which is used as a fill or backfill in lieu of compacted earth. This mixture is capable of filling all voids in irregular excavations and hard to reach places (such as under undercuts of existing slabs), is self-leveling, and hardens in a matter of a few hours without the need for compaction in layers. Flowable fill is sometimes referred to as controlled density fill (CDF), controlled low strength material (CLSM), lean concrete slurry, and unshrinkable fill.
- B. Flowable fill materials will be used as only as a structural fill replacement on VA projects. The materials and mix design for the flowable fill should be designed to produce a comparable compressive strength to the surrounding soil after hardening, making excavation at a later time possible /to produce the compressive strength indicated for the placed location, as determined by the COR.

**1.2 DESCRIPTION:**

Furnish and place flowable fill in a fluid condition, that sets within the required time and, after curing, obtains the desired strength properties as evidenced by the laboratory testing of the specific mix design, at locations shown on the plans.

**1.3 RELATED WORK:**

- A. Materials testing and inspection during construction: Section 01 45 29, TESTING LABORATORY SERVICES.
- B. Earthwork, excavation and backfill and compaction requirements: Section 31 20 00, EARTH MOVING.

**1.4 DEFINITIONS:**

- A. Flowable fill - Ready-mix Controlled Low Strength Material used as an alternative to compacted soil, and is also known as controlled density fill, and several other names, some of which are trademark names of material suppliers. Flowable fill (Controlled Low Strength Material) differs from portland cement concrete as it contains a low cementitious content to reduce strength development for possible future removal. Unless specifically approved otherwise, by the COR, flowable fill shall be designed as a permanent material, not designed for future removal. Design strength for this permanent type flowable fill shall be a

compressive strength of 2.1 MPa (300 psi) minimum at 28 days. Chemical admixtures may also be used in flowable fill to modify performance properties of strength, flow, set and permeability.

- B. Excavatable Flowable fill - flowable fill designed with a compressive strength that will allow excavation as either machine tool excavatable at compressive strength of 1.5 MPa (200 psi) maximum at 1 year, or hand tool excavatable at compressive strength of 0.7 MPa (100 psi) maximum at 1 year.

**1.5 SUBMITTALS:**

- A. Submit in accordance with Section 01 33 23, SHOP DRAWINGS, PRODUCT DATA, AND SAMPLES.
- B. Flowable fill Mix Design: Provide flowable fill mix design containing cement and water. At the contractor's option, it may also contain fly ash, aggregate, or chemical admixtures in any proportions such that the final product meets the strength and flow consistency, and shrinkage requirements included in this specifications. The mix design should state the sources and proportions of each of the flowable fill constituents. The coefficient of permeability of flowable fill shall be that of uniform fine sand,  $4.0 \times 10^{-1}$  cm/sec (0.16 in/sec) or as indicated to provide a backfill material with permeability equal to or greater than that of the surrounding soil.
1. Test and Performance - Submit the following data:
- a. Flowable fill shall have a minimum strength of 2.1 MPa (300 psi) according to ASTM C 39 at 28 days after placement.
  - b. Flowable fill shall have minimal subsidence and bleed water shrinkage. Evaporation of bleed water shall not result in shrinkage of more than 10.4 mm per m (1/8 inch per ft.) of flowable fill depth (for mixes containing high fly ash content). Measurement of a Final Bleeding shall be as measured in Section 10 of ASTM C 940 "Standard Test Method for Expansion and Bleeding of Freshly Mixed Grouts for Preplaced-Aggregate Concrete in the Laboratory.
  - c. Flowable fill shall have a unit weight of 1500 - 1900 kg/m<sup>3</sup> (90 - 115 lbs/feet<sup>3</sup>) measured at the point of placement after a 60 minute ready-mix truck ride.
- C. Provide documentation that the admixture supplier has experience of at least one year, with the products being provided and any equipment required to obtain desired performance of the product.

- D. Manufacturer's Certificates: Provide COR with documentation issued by the State Agency responsible for approving materials for burial, indicating conformance with applicable rules and regulations.

**1.6 APPLICABLE PUBLICATIONS:**

- A. Publications listed below form a part of this specification to extent referenced. Publications are referenced in text by basic designation only.
- B. American Society for Testing and Materials (ASTM):
- D4832-10.....Standard Test Method for Preparation and Testing of Controlled Low Strength Material (CLSM) Test Cylinders.
  - C618-12.....Standard Specifications for Coal Fly Ash and Raw or Calcined Natural Pozzolan for use in Concrete. (Use Fly Ash conforming to the chemical and physical requirements for mineral admixture, Class F listed, including Table 2 (except for Footnote A). Waive the loss on ignition requirement.)
  - C403/C403M-08.....Standard Test Method for Time of Setting of Concrete Mixtures by Penetration Resistance.
  - C150/C150M-11.....Standard Specification for Portland Cement
  - C33/C33M-11a.....Standard Specification for Concrete Aggregates
  - C94/C94M-12.....Standard Specification for Ready-Mixed Concrete
  - C494/C494M-11.....Standard Specification for Chemical Admixtures for Concrete
  - C685/C685M-11.....Standard Specification for Concrete Made by Volumetric Batching and Continuous Mixing
  - C940-10a.....Standard Specification for Expansion and Bleeding of Freshly Mixed Grouts for Preplaced - Aggregate Concrete in the Laboratory
  - D5971.....Sampling Freshly Mixed Controlled Low Strength Material
  - D6103.....Flow Consistency of Controlled Low Strength Material
  - D6023.....Unit Weight, Yield, Cement Content and Air Content (Gravimetric) of Controlled Low Strength Material
- C. American Concrete Institute (ACI):
- SP-150-94.....Controlled Low-Strength Materials

**1.7 QUALITY ASSURANCE:**

- A. Manufacturer: Flowable fill shall be manufactured by a ready-mix concrete producer with a minimum of 1 year experience in the production of similar products.
- B. Materials: For each type of material required for the work of this Section, provide primary materials that are the products of one manufacturer. If not otherwise specified here, materials shall comply with recommendations of ACI 229, "Controlled Low Strength Materials."
- C. Pre-Approval Procedures: During the submittal process, the contractor shall prepare and submit flowable fill mix designs corresponding to required conditions. Approval for the strength of the flowable fill shall be obtained from the COR when the contractor desires, or is required, to use flowable fill at specific location(s) within the project. Prior to commencement of field operations the contractor shall establish procedures to maintain optimum working conditions and to coordinate this work with related and adjacent work.
- D. Sampling and Acceptance: Flowable fill shall be samples and testing in the field in conformance with either ASTM C 94 or C 685. Samples for tests shall be taken for every 115 cubic meters (150 cubic yards) of material, or fraction thereof, for each day's placement. Tests shall include temperature reading and four compressive strength cylinders. Compressive strength sampling and testing shall conform to ASTM D 4832 with one specimen tested at 7 days, two at 28 days, and one held for each batch of four specimens. Sampling and testing shall be performed by a qualified, independent commercial testing laboratory. Test results should be submitted within 48 hours of completion of testing.

**1.8 DELIVERY, STORAGE, AND HANDLING:**

Deliver and handle all products and equipment required, in strict compliance with manufacturer's recommendations. Protect from damage due to weather, excessive temperatures, and construction operations.

**1.9 PROJECT CONDITIONS:**

Perform installation of flowable fill only when approved by the COR, and when existing and forecasted weather conditions are within the limits established by the manufacturer of the materials and products used.

**PART 2 - PRODUCTS**

**2.1 MATERIALS:**

- A. Provide flowable fill containing, at a minimum, cementitious materials and water. Cementitious materials shall be portland cement, pozzolanic materials, or other self-cementing materials, or combinations thereof, at the contractor's option, and following approval by the COR. The

flowable fill mix design may also contain, fine aggregate or filler, and/or chemical admixtures in any proportions such that the final product meets the strength, flow consistency and shrinkage requirements included in this specification, as approved by the COR.

- B. Portland Cement: ASTM C150, Type 1 or Type 2. Meeting Wisconsin State DOT standards.
- C. Mixing Water: Meeting Wisconsin State DOT standards for use as mix-water for cast-in-place concrete.
- D. Air-Entraining Admixture: ASTM C260.
- E. Chemical Admixtures: ASTM C494.
- F. Aggregate: ASTM C33.

## **2.2 FLOWABLE FILL MIXTURE:**

- A. Mix design shall produce a consistency that will result in a flowable product at the time of placement which does not require manual means to move it into place.
- B. Flowable fill shall have a minimum strength of 2.1 MPa (300 psi) according to ASTM C39 at 28 days after placement.
- C. Flowable fill shall have minimal subsidence and bleed water shrinkage. Evaporation of bleed water shall not result in shrinkage of more than 10.4 mm per m (1/8 inch per foot) of flowable fill depth (for mixes containing high fly ash content). Measurement of a Final Bleeding shall be as measured in Section 10 of ASTM C 940 "Standard Test Method for Expansion and Bleeding of Freshly Mixed Grouts for Preplaced-Aggregate Concrete in the Laboratory.
- D. Flowable fill shall have a unit weight of 1500 - 1900 kg/m<sup>3</sup> (90 - 115 lbs/ft<sup>3</sup>) measured at the point of placement after a 60 minute ready-mix truck ride. In the absence of strength data the cementitious content shall be a maximum of 90 kg/m<sup>3</sup> (150 lbs/cy).
- E. Flowable fill shall have an in-place yield of at least 98% of design yield for permanent type a maximum of 110% of design yield for removable types at 1 year.
- F. Provide equipment as recommended by the Manufacturer and comply with manufacturer's recommendations for the addition of additives, whether at the production plant or prior to placement at the site.

## **PART 3 - EXECUTION**

### **3.1 EXAMINATION:**

Examine conditions of substrates and other conditions under which work is to be performed and notify COR, in writing, of circumstances detrimental to the proper completion of the work. Do not proceed until unsatisfactory conditions are corrected.

**3.2 APPLICATION OF FLOWABLE FILL:**

Secure tanks, pipes and other members to be encased in flowable fill. Insure that there are no exposed metallic pipes, conduits, or other items that will be in contact with the flowable fill after placement. If so, replace with non-metallic materials or apply manufacturers recommended coating to protect metallic objects before placing the flowable fill. Replacement or protection of metallic objects is subject to the approval of the COR.

**3.3 PROTECTION AND CURING:**

Protect exposed surfaces of flowable fill from premature drying, wash by rain or running water, wind, mechanical injury, and excessively hot or cold temperature. Curing method shall be subject to approval by COR.

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