

SECTION 33 63 00
STEAM ENERGY DISTRIBUTION

PART 1 - GENERAL

1.1 DESCRIPTION

Underground steam distribution and condensate return piping system. Type of system shall be: pre-engineered direct-buried drainable-dryable-testable (DDT).

1.2 DEFINITIONS

- A. System: A complete underground steam and condensate distribution system including all components such as carrier piping, pipe supports, insulation, protective enclosures, anchors, corrosion protection and accessories.
- B. Pre-Engineered Direct-Buried System: System that is designed and factory-fabricated by a company specializing in these systems. The system includes pre-fabricated protective enclosures and does not require a concrete trench or tunnel. The pre-engineered system shall include all piping and components to a point at least 150 mm (6 inches) inside the building and manhole walls.
- C. Drainable-Dryable-Testable (DDT) Pre-Engineered Direct-Buried System: A factory-fabricated system including an airtight and watertight outer protective casing, an insulated carrier pipe and an air space between the insulated carrier pipe and the casing. Drains and vents are provided in the ends of the system (in manholes or buildings). The drains allow draining of ground water or condensate that may leak into the air space if there is a failure in the casing or the carrier pipe. The vents allow water vapor to escape and provide an indication of leakage.
- D. Carrier Pipe: Pipe carrying the steam or condensate.
- E. Casing: Outer protective pipe on pre-engineered systems. Carrier pipe and insulation are within the casing. The casing may also be referenced as the "conduit".

1.3 RELATED WORK

- A. Concrete work: Section 03 30 00, CAST-IN-PLACE CONCRETE.
- B. Painting exposed steel and other surfaces: Section 09 91 00, PAINTING.

1.4 QUALITY ASSURANCE

- A. Approval by Contracting Officer is required of products or services of proposed manufacturers, suppliers and installers.
- B. For pre-engineered direct-buried systems, expansion joints and ball joints, submit certification that:
 - 1. Manufacturers regularly and currently manufacture the product.

2. There is a permanent service organization trained by the manufacturer that will provide the required field supervision of the installation of the system or equipment. Submit name and address of the service organization.
- C. The manufacturer of pre-engineered direct-buried distribution system shall design the system to comply with the requirements of these specifications and is responsible for the complete product to be supplied, fabrication, witnessing installation and testing of the system. The complete design of the system shall be prepared, signed and sealed by a Professional Engineer employed by the system manufacturer.
- D. Products Experience Record:
1. Pre-Engineered Direct-Buried Systems: Shall be manufactured by a company which specializes in these systems and which has been in this business for five or more years.
 2. All Other Products: The designs shall be of current production and have been in satisfactory operation on at least three installations for approximately five years.
- E. Provide a complete installation with all necessary specialties, materials and equipment fully and properly connected and coordinated. Installation shall be fully operational upon completion of work defined and as phased.
- F. Apply and install systems, materials, equipment and specialties in accordance with manufacturer's instructions. Printed instructions shall be available at the site prior to and during construction.
- G. Materials, design, installation and workmanship shall conform to applicable local codes, and to national codes and standards as referenced in this specification.
- H. Manufactured Products:
1. When two or more items serve the same function, they shall be products of one manufacturer.
 2. Manufacturers of assemblies of products, which include components made by others, shall assume complete responsibility for final assembled unit.
 - a. All components of an assembled unit need not be products of the same manufacturer.
 - b. Constituent parts that are alike shall be products of a single manufacturer.
 - c. Components shall be compatible with each other and with the total assembly for intended service.
 3. All systems and equipment shall be free from defects that would adversely affect the performance, maintainability, or appearance of individual components or overall assembly.

4. Each product shall be designed for the service conditions specified for that product. If no conditions are specified, the product shall be suitable for the actual service conditions.
- I. Manufacturer's Identification: Components of equipment shall bear manufacturer's name or trademark and model number on a name plate securely affixed in a conspicuous place, or cast integral with, stamped or otherwise permanently marked upon the components of the equipment. Refer to Part 2 for requirements for pre-engineered direct-buried systems.
- J. Radiographic Testing of Welds: Weld examination methods and procedures and the interpretation of examining films shall conform to ASME B31.1. The testing firm shall utilize the proper film exposure, techniques, and penetrometer to produce density and geometric sharpness required for first quality film, and all radiographs shall be reviewed and interpreted and reading reports signed by not less than an American Society for Non-Destructive Testing (ASNT) Certified Level III Radiographer.
- K. Cathodic Protection: Required on drainable-dryable-testable (DDT) pre-engineered direct buried systems.

1.5 SUBMITTALS

- A. Submit in accordance with Section 01 33 23, SHOP DRAWINGS, PRODUCT DATA, AND SAMPLES.
- B. Submit all items listed simultaneously (except for items that can only be submitted during construction and upon completion of construction).
 1. Pre-Engineered Direct-Buried Systems:
 - a. Certification that system manufacturer regularly and currently manufactures direct-buried systems, and that the designs of the system and equipment to be provided for this project conform to specification requirements. This certification shall be an original signed by a principal officer of the manufacturer.
 - b. Complete descriptions and drawings of design of system and materials of construction including component parts, assembly, carrier pipes, casing, anchors, pipe guides, pipe supports, expansion loops, manhole and building wall penetrations, end seals, leak plates, field installation instructions.
 - c. Manufacturer's data sheets on casing coatings. Provide test report that concludes that coating can withstand a minimum 96 hour test at 186 °C (366 °F) without disbonding from the steel jacket.
 - d. A detailed design layout of the system showing the size, type, and location of each component, the design of anchors and manhole and building wall penetrations, the design of the transition points to

- aboveground or other type systems. Also, the type and details of the cathodic protection system including dielectric gaskets.
- e. Manufacturer's quality assurance plan for fabrication, delivery, storage, installation and testing of system.
 - f. Certificate of Qualification from system manufacturer that the manufacturer's field representative regularly performs the specified duties of monitoring the installation of the system and is technically qualified and experienced in the installation of the system and is authorized by the supplier to make and sign the daily reports specified herein.
 - g. Manufacturer's data sheets and thickness of carrier pipe insulation.
 - h. Calculations approved and stamped by Professional Engineer demonstrating that allowable stress of piping will not be exceeded due to thermal expansion and that anchor forces and moments are not excessive. Calculations shall be performed by a finite-element, three dimensional analysis computer program. Final report shall show node stresses, forces, moments and displacements.
 - i. Design life calculations for cathodic protection system. These shall be approved and stamped by NACE-qualified corrosion engineer.
 - j. All drawings and calculations shall have Professional Engineer's stamp.
 - k. A proposed schedule of activities indicating when various items of work and tests are to be carried out and when quality control inspectors of the supplier will be present at the job site.
 - l. The daily written report from the manufacturer's representative at the job site during all stages of material delivery and construction.
 - m. Proposed changes in design due to unforeseen conflicts or interferences along the route of the system.
 - n. Upon completion of the work:
 - 1) Certificate of Compliance signed by principal officers of the manufacturer and the contractor certifying that the system has been installed in accordance with contract requirements.
 - 2) Operation and maintenance manual.
 - 3) As-built layout of system including all final elevations (hard copies and AutoCAD on CD).
2. Expansion Joints and Ball Joints:
- a. Joint locations, sizes, types, movements.
 - b. Anchor locations, design, forces and moments.

- c. Certification that expansion joints conform to service requirements and to design standards of Expansion Joint Manufacturers Association.
 - d. Certification that representative of expansion joint manufacturer has reviewed the applications in detail and has taken no exception.
 - e. Certified test data on number of cycles to failure on similar units at project service conditions - bellows type and expansion compensators.
- C. Independent Weld Testing Firm for Carrier Piping in Pre-Engineered Direct-Buried and Concrete Shallow Trench Systems:
- 1. Certificate of Qualification of testing firm.
 - 2. Certificate of Acceptability of actual welds.
- D. Credentials of NACE-qualified firm for testing the cathodic protection. Refer to Section 26 42 00, CATHODIC PROTECTION.
- E. Proposed test procedures and samples of test data sheets for each required test, 30 days prior to the test date. Provide calibration data on all test instruments. Tests shall not begin until procedures have been approved.
- F. Test reports resulting from testing of installed systems, in booklet form showing all field tests performed to prove compliance with specified performance criteria.

1.6 STORAGE AND HANDLING

- A. Equipment and material placed on the job shall remain in the custody of the Contractor until final acceptance whether or not the Government has reimbursed the Contractor for the equipment and material.
- B. The Contractor is solely responsible for the protection of the equipment and material against damage from any source. Protect piping systems against entry of water and mud and all foreign substances by installing watertight protection on open ends at all times. Protect direct-buried system coatings from ultraviolet light (sunlight). Existing equipment worked on by the Contractor or in the Contractor's working area shall be under the custody and responsibility of the Contractor.
- C. All insulated piping systems exposed to water must be replaced with new systems.
- D. Place all damaged items in first class new operating condition or replace damaged items as determined and directed by the Resident Engineer (RE)/Contracting Officers Representative (COR), at no additional cost to the Government.

1.7 JOB CONDITIONS

- A. Interruption of Existing Service: Arrange, phase and perform work and provide temporary facilities, materials, equipment, and connections to utilities, to assure adequate steam and condensate return service for

existing installations at all times. Only such absolutely necessary interruptions as may be required for making connections will be permitted, and only at such times when approval is obtained from COR. Interruptions to steam and condensate service shall be only with prior approval, and be the minimum possible duration.

1.8 APPLICABLE PUBLICATIONS

- A. The publications listed below form a part of this specification to the extent referenced. The publications are referenced in the text by basic designation only.
- B. Federal Specifications (Fed. Spec.):
 - A-A-60005 NOT 1..... Frames, Covers, Grating, Steps, Sump And Catch Basin, Manhole
 - L-P-535E..... Plastic Sheet (Sheeting): Plastic Strip: Poly (Vinyl Chloride) and Poly (Vinyl Chloride-Vinyl Acetate)
 - L-S-125B..... Screening, Insect, Nonmetallic
- C. Military Specifications (Mil. Spec.):
 - MIL-S-901D..... Shock Tests. H.I. (High Impact) Shipboard Machinery, Equipment and Systems
- D. ASTM International (ASTM):
 - A36/A36M-05..... Structural Steel
 - A47/A47M-99(2004)..... Ferritic Malleable Iron Castings
 - A53/A53M-06a..... Pipe, Steel, Black and Hot-Dipped, Zinc-Coated Welded and Seamless
 - A105/A105M-05..... Carbon Steel Forgings for Piping Applications
 - A106/A106M-06a..... Seamless Carbon Steel Pipe for High-Temperature Service
 - A126-04..... Gray Iron Castings for Valves, Flanges and Pipe Fittings
 - A134-96(2005)..... Pipe, Steel, Electric-Fusion (Arc)-Welded (Sizes NPS 16 and over)
 - A135/A135M-06..... Electric-Resistance Welded Steel Pipe
 - A139/A139M-04..... Electric-Fusion (Arc)-Welded Steel Pipe (NPS 4 and over)
 - A167-99(2004)..... Stainless and Heat-Resisting Chromium-Nickel Steel Plate, Sheet and Strip
 - A193/A193M-07..... Alloy-Steel and Stainless Steel Bolting Materials for High Temperature Service
 - A194/A194M-07a..... Carbon and Alloy Steel Nuts for Bolts for High-Pressure or High-Temperature Service, or Both
 - A197/A197M-00 (2006)... Cupola Malleable Iron

- A216/A216M-07 Steel Castings, Carbon, Suitable for Fusion Welding, for High-Temperature Service.
- A234/A234M-07 Pipe Fittings of Wrought Carbon Steel and Alloy Steel for Moderate and High Temperature Service
- A240/A240M-07e1 Chromium and Chromium-Nickel Stainless Steel Plate, Sheet and Strip for Pressure Vessels and for General Applications
- A395/A395M-99(2004) Ferritic Ductile Iron Pressure-Retaining Castings for Use at Elevated Temperatures
- A536-84(2004) Ductile Iron Castings
- B61-02 Steam or Valve Bronze Castings.
- B209-06 Aluminum and Aluminum-Alloy Sheet and Plate
- C411-05 Hot-Surface Performance of High-Temperature Thermal Insulation
- C449/C449M-00 Mineral Fiber Hydraulic-Setting Thermal Insulating and Finishing Cement
- C533-07 Calcium Silicate Block and Pipe Thermal Insulation
- C547-06 Mineral Fiber Pipe Insulation
- C552-03 Cellular Glass Thermal Insulation
- C591-07 Unfaced Preformed Rigid Cellular Polyisocyanurate Thermal Insulation
- C655-04e1 Reinforced Concrete D-Load Culvert, Storm Drain and Sewer Pipe
- C920-05 Elastomeric Joint Sealants
- C1126-04 Faced or Unfaced Rigid Cellular Phenolic Thermal Insulation
- C1136-06 Flexible, Low Permeance Vapor Retarders for Thermal Insulation
- D1784-06a Rigid Poly (Vinyl Chloride)(PVC) Compounds and Chlorinated Poly (Vinyl Chloride)(CPVC) Compounds
- D2310-06 Machine-Made "Fiberglass" (Glass-Fiber Reinforced Thermosetting-Resin) Pipe
- D2487-06 Soils for Engineering Purposes (Unified Classification System)
- D2996-01(2007)e1 Filament-Wound Fiberglass (Glass-Fiber-Reinforced-Thermosetting-Resin) Pipe
- E. American Society of Mechanical Engineers (ASME):
- B16.3-2006 Malleable Iron Threaded Fittings
- B16.5-2003 Pipe Flanges and Flanged Fittings NPS ½ - 24
- B16.9-2003 Factory-Made Wrought Buttwelding Fittings
- B16.11-2005 Forged Fittings, Socket-Welding and Threaded

- B31.1-2004 Code for Pressure Piping, Power Piping, with Amendments
- B31.9-2004 Code for Pressure Piping, Building Services Piping, with Amendments
- B40.100-2005 Pressure Gauges and Gauge Attachments
- Boiler and Pressure Vessel Code, Section VIII: 2007 Edition, with Amendments
- F. American Welding Society (AWS):
 - AWS B2.1-00 Welding Procedure and Performance Qualification
- G. Manufacturers Standardization Society of the Valve and Fitting Industry (MSS):
 - SP45-03 By-Pass and Drain Connection Standard
 - SP58-02 Pipe Hangers and Supports-Materials, Design and Manufacture
 - SP69-03 Pipe Hangers and Supports-Selection and Application
 - SP80-03 Bronze Gate, Globe, Angle and Check Valves
- H. National Fire Protection Association (NFPA):
 - 255-06 Test of Surface Burning Characteristics of Building Materials
- I. American Society of Heating, Refrigerating and Air Conditioning Engineer (ASHRAE):
 - ASHRAE Handbook 2004 HVAC Systems and Equipment
- J. American Concrete Institute (ACI):
 - 318-05 Building Code Requirements for Reinforced Concrete
- K. NACE International (Corrosion Engineers) (NACE):
 - RP0169-02 Standard Recommended Practice, Control of External Corrosion on Underground or Submerged Metallic Piping Systems
- L. Expansion Joint Manufacturers Association (EJMA):
 - 8th Edition-2003 Standards of the Expansion Joint Manufacturers Association
- M. American Association of State Highway and Transportation Officials (AASHTO):
 - M300-03 Inorganic Zinc Rich Primer
- N. Society for Protective Coatings (SSPC):
 - SP-10/NACE No. 2-2004.. Near White Blast Cleaning
- O. Unified Facilities Guide Specifications (UFGS):
 - UFGS 33 63 13 Exterior Underground Steam Distribution System (April 2006 or later)

PART 2 - PRODUCTS

2.1 PRE-ENGINEERED, FACTORY-FABRICATED, DIRECT-BURIED, DRAINABLE-DRYABLE-TESTABLE (DDT) SYSTEMS

- A. Complete steam and condensate piping system with carrier pipes, carrier pipe insulation with jackets and banding, air space, 6.35 mm (0.25 inch) thick steel casing, fusion-bonded epoxy casing coatings, cathodic protection, accessories. Do not locate condensate pipes in casings (conduits) that contain steam pipes.
- B. Design Pressure and Temperature: All components of system shall be suitable for carrier pipe pressures and temperatures as follows:
 - 1. Steam System: 1000 kPa (150 psi); 185 °C (366 °F).
 - 2. Condensate System: 345 kPa (50 psi); 154 °C (310 °F).
- C. Description of System Design: Refer to Part 1, "DEFINITIONS".
- D. Steam Carrier Pipes: Refer to Paragraph, "STEAM PIPING".
 - 1. No piping joints allowed in factory-fabricated straight sections of pre-engineered direct-buried systems.
 - 2. Factory-fabricated direct-buried piping sections that are a portion of an expansion loop or bend shall have all welded joints 100% radiograph inspected.
- E. Condensate Carrier Pipes: Refer to Paragraph, "STEAM CONDENSATE PIPING".
 - 1. No piping joints allowed in factory-fabricated straight sections of pre-engineered direct-buried systems.
 - 2. Factory-fabricated direct-buried piping sections that are a portion of an expansion loop or bend shall have all welded joints 100% radiograph inspected.
- F. Carrier Pipe Insulation:
 - 1. Conform to minimum thickness and type of insulation listed in Tables 1 and 2 below as required for service temperature in carrier pipe as listed below.
 - 2. Section A: Steam temperature is 338°F, steam pressure is 100 psi. Pumped condensate temperature is 93 °C (200 °F). Drip return temperature is 100 °C (212 °F).
 - 3. Allowable Carrier Pipe Insulation Type and Minimum Insulation Thickness:

TABLE 1 Minimum Pipe Insulation Thickness mm (inches) For Steam 110 to 2800 kPa (16 to 408 psi) gage			
Nominal Pipe Diameter mm (inches)	MPT-PC MPT-PF	Delta	Thermo-12 Super Caltemp
25 (1)	50 (2)	65 (2 1/2)	100 (4)

TABLE 1 Minimum Pipe Insulation Thickness mm (inches) For Steam 110 to 2800 kPa (16 to 408 psi) gage			
Nominal Pipe Diameter mm (inches)	MPT-PC MPT-PF	Delta	Thermo-12 Super Caltemp
40 (1 1/2)	50 (2)	65 (2 1/2)	100 (4)
50 (2)	65 (2 ½)	85 (3 1/2)	110 (4 1/2)
65 (2 1/2)	65 (2 ½)	85 (3 1/2)	110 (4 1/2)
80 (3)	75 (3)	100 (4)	125 (5)
100 (4)	75 (3)	100 (4)	125 (5)
125 (5)	75 (3)	100 (4)	125 (5)
150 (6)	85 (3 ½)	110 (4 1/2)	135 (5 1/2)
200 (8)	85 (3 ½)	110 (4 1/2)	135 (5 1/2)
250 (10)	100 (4)	125 (5)	150 (6)
300 (12)	100 (4)	125 (5)	150 (6)
350 (14)	100 (4)	125 (5)	150 (6)
400 (16)	100 (4)	125 (5)	150 (6)
450 (18)	100 (4)	125 (5)	150 (6)

Notes: Insulation listed has passed the 96-hour boiling water test. Pipes smaller than 25 mm (1 inch) shall have same insulation thickness as 25 mm (1 inch) pipe.

TABLE 2 Minimum Pipe Insulation Thickness mm (inches) For Steam Less than 110 kPa (16 psi) gage, Condensate Return			
Nominal Pipe Diameter mm (inches)	MPT-PF MPT-PC	Delta	Thermo-12 Super Caltemp
25 (1)	40 (1 ½)	50 (2)	75 (3)
40 (1 1/2)	40 (1 ½)	50 (2)	75 (3)
50 (2)	40 (1 ½)	50 (2)	75 (3)
65 (2 1/2)	40 (1 ½)	50 (2)	75 (3)
80 (3)	50 (2)	65 (2 1/2)	85 (3 1/2)
100 (4)	50 (2)	65 (2 1/2)	85 (3 1/2)
125 (5)	50 (2)	65 (2 1/2)	85 (3 1/2)
150 (6)	65 (2 ½)	80 (3)	110 (4.5)
200 (8)	65 (2 ½)	80 (3)	110 (4.5)
250 (10)	80 (3)	100 (4)	125 (5)
300 (12)	80 (3)	100 (4)	125 (5)
350 (14)	80 (3)	100 (4)	125 (5)

TABLE 2 Minimum Pipe Insulation Thickness mm (inches) For Steam Less than 110 kPa (16 psi) gage, Condensate Return			
Nominal Pipe Diameter mm (inches)	MPT-PF MPT-PC	Delta	Thermo-12 Super Caltemp
400 (16)	80 (3)	100 (4)	125 (5)
450 (18)	80 (3)	100 (4)	125 (5)

Notes: Insulation listed has passed the 96-hour boiling water test which indicates that satisfactory performance in underground service can be expected.

Pipes smaller than 25 mm (1 inch) shall have the same insulation thickness as required for 25 mm (1 inch) pipe.

"Delta" is available from Rockwool, Leeds, AL.

"MPT" is available from Mineral Products of Texas, Houston, TX.

"Thermo-12" and "Super Caltemp" is available from Industrial Insulation Group, Brunswick, GA.

4. Insulation Banding and Jacket: Stainless steel bands and clips, at least 13 mm (0.5 inches) wide, ASTM A-167 (304 stainless steel), maximum spacing 460 mm (18 inches). A minimum of two bands is required for each 1300 mm (4 foot) section of insulation. Vinyl-coated fiberglass scrim jacket, Fed. Spec. L-S-125, Type II, Class 2, with 18 x 16 mesh (number of filaments per inch) and made of 0.335 mm (0.013 inches) diameter vinyl-coated fibrous glass yarn. Install bands over the jacket to secure the insulation to the carrier pipe.

- G. Casing: Smooth-wall steel, electric resistance welded, conforming to ASTM A134, ASTM A135, or ASTM A139. Plastic casings are not permitted. Use eccentric connectors as necessary between casing sections to provide continuous gravity drainage in bottom of casing between manholes and between manholes and buildings.

Casing Diameter mm (in.)	Minimum Thickness mm (in.)
150 - 1170 (6 - 46)	6.35 (0.250)

- H. Casing End Seal Plates with Vents and Drains: ASTM A36 steel, minimum thickness 9.5 mm (0.375 inches) for casings up thru 300 mm (12 inches) diameter and 13 mm (0.5 inches) for casings over 300 mm (12 inches) diameter. Provide 25 mm (one inch) drain at the bottom and vent at the top. Construct with threaded steel half couplings. Install threaded brass plugs in drains. Install vent riser pipes, ASTM A53, Schedule 40, galvanized, extending through top of manhole and terminate 300 mm (12 inches) above grade with 180-degree bend.

- I. Gland Seals: Not permitted because of the possibility of water entering the system thru the gland seal from a flooded manhole.
- J. Air Space: Provide continuous 25 mm (one inch) minimum air space between carrier pipe insulation and casing.
- K. Casing Coating: Dual layers of fusion-bonded epoxy, inner green-colored layer minimum thickness 0.5 mm (0.020 inches), outer black-colored layer minimum thickness 0.25 mm (0.010 inches). Rated by coating manufacturer for continuous service for at least 25 years at minimum temperature of 110 °C (230 °F) and having a coefficient of expansion similar to that of steel. Coating shall be applied in accordance to recommendations of coating manufacturer including surface preparation. Factory-inspect for holidays and make repairs as necessary.
- L. Coating of End Plates and Casing (Conduit) Sections Extending in Manholes: Zinc-rich coating that conforms to AASHTO M300, Type IA except that volatile organic compounds shall not exceed 0.34 kg per liter (2.8 pounds per gallon). The zinc rich coating shall be applied in accordance with the recommendations of the coating manufacturer including surface preparation. No additional top coat shall be applied.
- M. Carrier Pipe Guides and Supports: Maximum spacing 3000 mm (10 feet) on centers, no more than 1500 mm (5 feet) from pipe ends, minimum of three guides per elbow section. Designed to permit thermal expansion without damage, provide proper pipe guiding and support, and to allow horizontal movement in two directions as necessary at expansion loops and bends. Design of guides and supports must permit continuous drainage of water in bottom of casing. Pipe insulation shall extend thru the pipe guides and supports and be protected by steel sleeves. Design of guides and supports shall be such that no metal-to-metal contact exists between the casing and the carrier pipe. Insulation or non-metallic material used to ensure no metal to metal contact shall be designed to not be compressed by the weight of the carrier pipe when full of water.
- N. Anchor Plates: ASTM A36 steel, welded to carrier pipe and casing, 13 mm (0.5 inches) minimum thickness, passages for air flow and water drainage thru the annular air space in the system. Coated with same coating material as the casing. Locate 900 to 1500 mm (3 to 5 feet) from piping entrance to manhole or building wall. Walls of manholes and buildings cannot be utilized as anchor points.
- O. Field Connection of Casing Sections: Steel section conforming to casing specification, welded to casing sections, coated on all surfaces with system manufacturer's coating field repair compound, and covered with a

1.3 mm (0.05 inch) minimum thickness polyethylene shrink sleeve designed for a service temperature exceeding 80 °C (176 °F).

- P. Manhole and Building Wall Penetrations: Provide steel leak plates welded to wall sleeves or to casings. Where wall sleeve is utilized, allow sufficient annular space between the sleeve and the casing and install a watertight EPDM Link-Seal (Thunderline Corp) or equal, rated for 121 °C (250 °F) minimum. Manhole and building walls cannot be used as anchor points.
- Q. Cathodic Protection: Provide sacrificial anode type system with dielectric isolation devices and test stations for all systems. Design system for 25 years service, assume two percent bare metal. System shall comply with NACE RP0169 and shall conform to Section 26 42 00, CATHODIC PROTECTION.
- R. Manufacturer's Identification: Provide embossed brass or stainless steel tag hung by a brass or stainless steel chain at each end of each conduit or insulated piping in the manholes and buildings. The tag shall identify system manufacturer's name, date of installation, government contract, and manufacturer's project number.
- S. Branch Piping Connections: All branch piping connections must be located in manholes.
- T. Manufacturers: Perma-Pipe, Rovanco, Thermacor, or equal.

2.2 STEAM CARRIER PIPING

- A. Pipe: Steel; seamless, ASTM A53, Grade B or ASTM A106, Grade B; electric resistance welded ASTM A53, Grade B; Schedule 40. Standard weight permitted for pipe sizes 300 mm (12 inches) and above. Grade F, furnace butt-welded pipe, is not permitted.
- B. Joints:
 - 1. In trenches and direct-buried systems: Butt-weld except socket-weld for pipe sizes two-inches and below. Manufacturer's standard sliding gasketed joints permitted between sections of WSL pre-engineered direct-buried systems. No joints allowed in factory-fabricated straight sections of pre-engineered direct-buried systems. Factory-fabricated direct-buried piping sections that are a portion of an expansion loop or bend shall have all welded joints 100% radiograph inspected. All radiographs shall be reviewed and interpreted by an American Society for Non-Destructive Testing (ASNT) Certified Level III radiographer, employed by the testing firm, who shall sign the reading report. Dye penetrant testing may be utilized for pipe sizes 50 mm (2 inches) and below.
 - 2. In open areas: Butt-weld pipe sizes 65 mm (2-1/2 inches) and above; thread or socket-weld pipe sized 50 mm (two inches) and below.

C. Fittings:

1. Butt-Welded Joints: Steel, ASTM A234, Grade B, ASME B16.9, same schedule as adjoining pipe. All elbows shall be long radius unless otherwise indicated. Tees shall be full size or reducing as required, having interior surfaces smoothly contoured.
2. Threaded Joints: Malleable iron, ASTM A47 or A197, ASME B16.3, 2050 kPa (300 pound) class.
3. Socket-Welded Joints: Forged steel, ASME B16.11, 13,800 kPa (2000 psi) class.

D. Flanges and Bolts: Weld neck, ASME B16.5, forged steel, ASTM A105. Pressure class 1025 kPa (150 psi). Bolts shall be high strength ASTM A193, Class 2, Grade B8. Nuts shall be ASTM A194.

E. Unions: On pipe 50 mm (two inches) and smaller, threaded, malleable iron or steel, 2050 kPa (300 psi) class.

2.3 STEAM CONDENSATE CARRIER PIPING

A. Pipe: Seamless, ASTM A53, Grade B or ASTM A106, Grade B; electric resistance welded ASTM A53, Grade B; Schedule 80. Grade F, furnace butt-welded, pipe is not permitted.

B. Joints:

1. In Trenches and direct-buried systems: Butt-weld except socket-weld is required for pipe sizes 50 mm (two inches) and below. Manufacturer's standard sliding, gasketed joints permitted between factory-fabricated sections of direct buried WSL system. No joints allowed in factory-fabricated straight sections of pre-engineered direct-buried systems. Factory-fabricated direct-buried piping systems that are a portion of expansion loops or bends shall have all welded joints 100% radiograph inspected. All radiographs shall be reviewed and interpreted by an ASNT Certified Level III radiographer, employed by the testing firm, who shall sign the reading report. Dye penetrant testing may be utilized for pipe sizes 50 mm (2 inches) and below.
2. In Tunnels, Manholes and Open Areas: Butt-weld pipe sizes 65 mm (2-1/2 inches) and above; thread or socket-weld for pipe sizes 50 mm (two inches) and below.

C. Fittings:

1. Welded Joints: Steel, ASTM A234, Grade B, ASME B16.9, same schedule as adjoining pipe.
2. Threaded Joints: Malleable iron, ASTM A47 or A197, ASME B16.3, 2050 kPa (300 psi) class.
3. Socket-Welded Joints: Forged steel, ASME B16.11, 13,800 kPa (2000 psi) class.

- D. Unions (Except in Trenches): On piping 50 mm (two inches) and under, 2050 kPa (300 psi) malleable iron or steel.
- E. Flanges: Weld neck ASME B16.5, forged steel, ASTM A105, 1025 kPa (150 psi).

2.4 EXPANSION LOOPS AND BENDS

- A. Stresses shall be less than the maximum allowable stress in the Power Piping Code (ASME B31.1). Submit shop drawings and stress and anchor force calculations for all loops and bends. Show locations of all anchors, guides and supports. Base calculations on 1000 kPa (150 psi) and 185 °C (366 ° F) for steam line loops and bends and 345 kPa (50 psi) and 154 °C (310 °F) for condensate return line loops and bends. Base calculations on actual pressures and temperatures if they are higher than those listed above.

2.5 PIPE ANCHORS

Provide as required. Construct with all welded steel, ASTM A36.

2.6 INSULATION MATERIALS (IN MANHOLES AND OPEN AREAS)

- A. Calcium Silicate Insulation:
 - 1. Preformed Piping Insulation: ASTM C533, Type I.
 - 2. Blocks: ASTM C533, Type I.
 - 3. Fitting Insulation: ASTM C533, with polyvinyl chloride, Fed. Spec. L-P-535, Type II Grade GU, and Type III, premolded fitted covering 0.5 mm (0.020 inches) thick.
- B. Fiberglass Insulation:
 - 1. Preformed Piping Insulation: ASTM C547, 230 °C (450 °F).
 - 2. Fitting Insulation: ASTM C547, 230 °C (450 °F), with polyvinyl chloride, Fed. Spec. L-P-535, Type II Grade GU, and Type III, premolded fitted covering 0.5 mm (0.020 inches) thick.
- C. Rigid Closed Cell Phenolic Foam: Preformed Piping Insulation: ASTM C1126, Type III, Grade 1, 121 °C (250 °F).
- D. Cellular Glass Insulation: Preformed Piping Insulation: ASTM C552.
- E. Insulating and Finishing Cements: Best grade recommended by printed instructions of manufacturer for the type of insulation system and service conditions. Conform to ASTM C449.
- F. Insulation Bands: Minimum 12 mm (1/2 inch) wide by 0.4 mm (0.015 inch) thick ASTM A167 stainless steel.
- G. Aluminum Jackets: Minimum 0.4 mm (0.016 inch) thick aluminum, ASTM B209, 3003 alloy, H-14 temper, with locking longitudinal joints. Jackets for elbows, tees and other fittings shall be factory fabricated to match material and construction of the straight run jackets. Factory fabricated

stainless steel bands shall be furnished and installed on all circumferential joints. Bands shall be 20 mm (0.75 inch) wide on 450 mm (18 inch) centers. Bands shall be applied with manufacturers recommended sealant. Entire system shall be watertight.

- H. All-Service Jackets: White kraft bonded to 0.025 mm ((0.001 inch) thick aluminum foil, fiberglass reinforced, pressure sensitive adhesive closure. Beach puncture 50 units, suitable for painting without sizing. Comply with ASTM C1136. Jackets shall have minimum 40 mm (1-1/2 inch) lap on longitudinal joints and not less than 100 mm (4 inch) butt strips on end joints. Butt strip material shall be same as the jacket. Lap and butt strips may be self-sealing type with factory-applied pressure sensitive adhesive.
- I. Glass Cloth Jacket: Minimum 0.24 kg per square meter (7.8 ounces per square yard), 2000 kPa (300 psi) bursting strength, weathertight for outside service. Beach puncture 50 units.
- J. Pipe Covering Protection Saddles: MSS SP-58, Type 39 at all hanger points except where Type 3 pipe clamps are provided.
- K. Fire and Smoke Ratings: Assembled insulation systems shall meet flame spread (25) and smoke developed (50) ratings as developed under ASTM C411 and NFPA 255 standards and specifications.

2.7 PIPE AND VALVE FLANGE GASKETS

Non-asbestos, designed for the service conditions. On steam service utilize "Flexitallic" spiral-wound, "Lamons Grafoil Grade GHR", "Lamons Spira-wound", "Garlock ST-706", or equal.

2.8 BURIED UTILITY WARNING TAPE

Tape shall be 0.1 mm (0.004 inch) thick, 150 mm (6 inches) wide, yellow polyethylene with a ferrous metallic core, acid and alkali-resistant and shall have a minimum strength of 12,000 kPa (1750 psi) lengthwise and 10,300 kPa (1500 psi) crosswise with an elongation factor of 350 percent. Provide bold black letters on the tape identifying the type of system. Tape color and lettering shall be unaffected by moisture and other substances contained in the backfill material.

PART 3 - EXECUTION

3.1 GENERAL

- A. Connecting to Existing Work: Connect new work to existing work in a neat and workmanlike manner. Where an existing structure must be cut or existing utilities interfere, such obstruction shall be bypassed, removed, replaced or relocated, patched and repaired. Work disturbed or damaged shall be replaced to its prior condition, as required by Section 01 00 00,

GENERAL REQUIREMENTS. Piping connections shall be made only in manholes, tunnels or buildings.

- B. Coordination: Coordinate the location of all items of equipment and work of all trades. Maintain operability and maintainability of the equipment and systems. The contractor at his cost shall perform any relocation of equipment or systems to comply with the requirement of operability and maintainability.
- C. Grading: Unless otherwise shown on drawings, steam lines shall be graded downward not less than 50 mm in 12 meters (two inches in 40 feet) in direction of the flow. Provide eccentric reducing fittings on steam mains and branches, (except on vertical piping). Install said fittings to maintain continuity of grade in bottom of pipeline. Provide risers with drip pockets and steam traps on steam lines where space restrictions prevent continuous grading. All steam traps must be located in manholes or tunnels.

3.2 PIPING JOINTS AND FITTINGS

- A. Welded Joints:
 - 1. Branch connections shall be made with either welding tees or welding outlet fittings. Welding outlet fittings shall be forged, integrally reinforced to provide 100 percent pipe strength, beveled for full penetration welding and funneled at inlet for full fluid flow.
 - 2. Clean pipe and fittings before welding and installation in system.
- B. Threaded Joints:
 - 1. Pipe threads shall be cut to give proper engagement in threaded fittings. Threaded pipe shall have clean-cut threads; dull or damaged pipe dies shall not be used.
 - 2. Clean pipe and fittings before installation and ream pipe after cutting threads. Joints shall be made with oil and graphite pipe joint compound applied to male threads only.
- C. Fittings: All pipe intersections and all changes in direction shall be made with factory-built-reinforced fittings. Field-fabricated fittings and miters are not permitted.
- D. Flanged Joints: Gaskets and bolting shall be applied in accordance with the recommendations of the gasket manufacturer and bolting standards of ASME B31.1. Strains shall be evenly applied without overstress of bolts. Gaskets shall cover entire area of mating faces of flanges.

3.3 CLEANING OF PIPING

Clean pipe and fittings inside and outside before and after assembly. Remove all dirt, scale, and other foreign matter from inside the piping by use of a pipe swab or pipe "pig" before connecting pipe sections, valves, equipment or fittings.

3.4 WELDING

- A. The Contractor is entirely responsible for the quality of the welding and shall:
 - 1. Conduct tests of the welding procedures used by his organization, determine the suitability of the procedures used, determine that the welds made will meet the required tests, and also determine that the welding operators have the ability to make sound welds under standard conditions.
 - 2. Comply with ASME B31.1 and AWS B2.1.
 - 3. Perform all welding operations required for construction and installation of the heat-distribution system.
- B. Qualification of Welders: Rules of procedure for qualification of all welders and general requirements for fusion welding shall conform with the applicable portions of ASME B31.1 and AWS B2.1, and also as outlined below.
- C. Examining Welder: Examine each welder at job site, in the presence of the Resident Engineer (RE)/Contracting Officer's Representative (COR), to determine the ability of the welder to meet the qualifications required. Test welders for piping for all positions, including welds with the axis horizontal (not rolled) and with the axis vertical. Each welder shall be:
 - 1. Allowed to weld only in the position in which he has qualified.
 - 2. Required to identify his welds with his specific code marking signifying his name and number assigned.
- D. Examination Results: Provide the RE/COR with a list of names and corresponding code markings. Retest welders that fail to meet the prescribed welding qualifications. Disqualify welders, who fail the second test, for work on the project.
- E. Beveling: Field bevels and shop bevels shall be done by mechanical means or by flame cutting. Where beveling is done by flame cutting, surfaces shall be thoroughly cleaned of scale and oxidation just prior to welding. Conform to specified standards.
- F. Alignment: Utilize split welding rings or approved alternate method for field joints on all carrier pipes above 50 mm (two inches) to assure proper alignment, complete weld penetration, and prevention of weld spatter reaching the interior of the pipe. Make field joints 50 mm (two inches) and smaller with welding sockets.
- G. Erection: Piping shall not be split, bent, flattened, or otherwise damaged either before, during, or after installation. Where the pipe temperature falls to 0 °C (32 °F) or lower, the pipe shall be heated to approximately 38 °C (100 °F) for a distance of 300 mm (one foot) on each side of the

weld before welding, and the weld shall be finished before the pipe cools to 0 °C (32 °F).

- H. Defective Welds: Replace and reinspect defective welds. Repairing defective welds by adding weld material over the defect or by peening will not be permitted. Welders responsible for defective welds must be requalified.
- I. Electrodes: Electrodes shall be stored in a dry heated area, and be kept free of moisture and dampness during fabrication operations. Discard electrodes that have lost part of their coating.
- J. Radiographic Testing: An approved independent testing firm regularly engaged in radiographic testing shall perform radiographic examination of all field welds in the carrier piping of direct-buried systems and concrete trench systems, in manholes and in walk-through tunnels, in accordance with ASME B31.1. Furnish a set of films showing each weld inspected, a reading report evaluating the quality of each weld, and a location plan showing the physical location where each weld is to be found in the completed project, prior to installing conduit field joints, trench covers, backfilling and hydrostatic testing. All radiographs shall be reviewed and interpreted by an ASNT Certified Level III radiographer, employed by the testing firm, who shall sign the reading report. The RE/COR reserves the right to review all inspection records, and if any welds inspected are found unacceptable they shall be removed, rewelded, and radiographically reexamined at no cost to the Government.

3.5 DRAIN VALVES AND VENT VALVES

Provide 40 mm (1-1/2") minimum pipe size drain valves on condensate return carrier pipes at all low points in manholes. Provide 25 mm (1") minimum air vent valves in manholes at all high points in condensate return carrier piping.

3.6 PAINTING EXPOSED STEEL SURFACES IN MANHOLES

- A. Manholes: Provide surface cleaning and preparation and apply prime coat of rust resistant metal primer. Refer to Section 09 91 00, PAINTING.

3.7 DIRECT-BURIED SYSTEM INSTALLATION

- A. The system manufacturer shall oversee the delivery, storage, installation and testing of the system. All work shall be in strict accordance with the requirements specified herein and with the printed instructions of the manufacturer. Printed instructions must be available at the site prior to delivery of system components. Any changes required to the design and layout of the system due to site conditions must be approved in writing by the system designer and the RE/COR. All branch piping connections, valves and drip traps must be located within manholes.

- B. Excavation, Trenching, and Backfilling: Perform all excavation, trenching, and backfilling as required by the system manufacturer's design. Beach sand or any sand with large amounts of chlorides is not permitted. Place system on a 300 mm (12 inch) thick sand bed and backfill on all sides with 150 mm (6 inch) thick sand as measured from outside the casing. Foundation for system must be firm and stable. Foundation and backfill must be free from rocks or substances that could damage the system coating. Concrete anchor and thrust blocks must be installed in undisturbed earth. Backfilling must not commence until elevations have been surveyed and accepted and system has been satisfactorily pressure tested including hydrostatic testing of carrier pipes and air testing of casings.
- C. Representative of System Manufacturer: This shall be a person who regularly performs the duties listed below, is certified in writing by the system manufacturer to be technically qualified and experienced in the installation of the system, and shall be authorized by the manufacturer to make and sign the daily reports specified herein. The representative shall be present at the job site when the following types of work are being performed:
1. Inspection and unloading of material delivered to site.
 2. Inspection of trench prior to commencing installation of system.
 3. Inspection of concrete anchors and thrust blocks.
 4. Cold springing.
 5. Hydrostatic test of all service lines.
 6. Field joint closure work.
 7. Air test of conduit.
 8. Repair of any coatings.
 9. Holiday test of conduit coating.
 10. Installation of cathodic protection system.
 11. Initial backfill up to 250 mm (10 inches) above the top of the casing.
 12. The slope of the system. Elevation readings shall be witnessed and recorded.
 13. Testing of cathodic protection system.
 14. Operational tests.
- D. Reports to Contracting Officer:
1. Obtain a written report prepared daily and signed by the representative of the system manufacturer. Present the original report to the RE/COR on the same day it is prepared, and forward one copy to the manufacturer's main office.
 2. The report shall state whether or not the condition and quality of the materials used and the delivery, storage, installation and testing of the system are in accordance with the plans, specifications, and

manufacturer's printed instructions and is satisfactory in all respects. When any work connected with the installation is unsatisfactory, the report shall state what corrective action has been taken or shall contain the system manufacturer's recommendations for corrective action. The report shall identify any conditions that could result in an unsatisfactory installation, including such items as open conduit ends left in the trench overnight and improper manhole entries. The daily reports are to be reviewed, signed and sealed by the Professional Engineer responsible for the system design. Signed and sealed copies of the daily report shall be submitted with the payment requests. All work must stop if daily reports are not furnished and requests for payments shall be denied if the daily reports are not furnished as specified.

3. Upon completion of the work and before final acceptance, deliver to the RE/COR a notarized Certificate of Compliance signed by principal officers of both the manufacturing and the contracting firm, stating that the installation is satisfactory and in accordance with plans, specifications, and manufacturer's instructions.
 4. The manufacturer shall retain copies of all the daily reports and the Certificate of Compliance for 5 years after final acceptance of the system by the Government.
- E. Protect casing coating from damage during rigging, storage and installation. Protect casing and carrier pipe ends from water intrusion during rigging and installation. Protect casing coatings from ultraviolet light (sunlight).
- F. Defective Material: The Representative shall take prompt action to return to the factory all damaged or defective material and shall order prompt replacement of such material.
- G. Slope of Carrier Pipes: Maintain constant slope as shown or specified. Prior to backfilling over the top of the casing, but after removal of temporary supports, Contractor shall measure and record elevations of top of casing in the trench. Elevations shall be taken at every field joint, 1/3 points along each pipe section, and at tops of elbows. These measurements shall be checked against contract drawings and shall confirm that the conduit system has been installed to the elevations shown on the contract drawings. Slope shall be uniform within 0.1 percent. These measurements shall be recorded by the Contractor, included in the direct buried system manufacturer representative's daily report, and given to the RE/COR prior to covering the top of the casing with backfill.
- H. Cathodic Protection: Provide cathodic protection for all steel casing systems and all buried exposed metal. Provide dielectric pipe flanges and

unions and isolation devices at all points necessary. Provide test stations at grade on each section of the piping system. Isolation flanges and unions shall be rated for the carrier pipe service temperature and pressure.

- I. Cleaning of Piping: Remove all dirt, scale, and other foreign matter from inside the piping by use of a pipe swab or pipe "pig" before connecting pipe sections, valves, or fittings.
- J. Field Tests: Refer to Article, TESTS.
- K. Wet Insulation: Sections of system that have been fully or partially submerged in water must be replaced. Moisture content of insulation during installation shall not exceed five percent by weight.
- L. Vents and Drains on Ends of DDT Systems: At each casing termination (end plate) in buildings and manholes, plug the casing drain openings with brass plugs and extend one inch pipe size ASTM A53 galvanized vent pipes from the casing vents through the tops of the manholes or one foot above the conduit in buildings. Terminate the outside vents in 180-degree bends.
- M. Buried Utility Warning Tape: Install tape 300 mm (12 inches) below grade above the piping system.

3.8 THERMAL INSULATION

- A. For piping in pre-engineered direct-buried systems refer to Part 2 of this specification.
- B. Steam, condensate and drip return piping, other than in pre-engineered direct buried systems, shall be insulated as follows:
 - 1. Piping in manholes shall be insulated with calcium silicate or cellular glass pipe insulation, glass cloth or aluminum jacket.
 - 2. Minimum Insulation Thickness: Insulation thicknesses given in Table 5 and 6 are manufacturer's nominal thickness.

TABLE 5 Minimum Pipe Insulation Thickness mm (inches) For Steam 110 to 1724 kPa (16 to 250 psi) gage				
Nominal Pipe Diameter mm (inches)	MPT-PC MPT-PF	Delta	Thermo-12 Super Caltemp	Foamglas
25 (1)	50 (2)	63 (2 1/2)	100 (4)	110 (4 1/2)
40 (1 1/2)	50 (2)	63 (2 1/2)	100 (4)	110 (4 1/2)
50 (2)	63 (2 1/2)	85 (3 1/2)	110 (4 1/2)	125 (5)
65 (2 1/2)	63 (2 1/2)	85 (3 1/2)	110 (4 1/2)	125 (5)
80 (3)	75 (3)	100 (4)	125 (5)	150 (6)
100 (4)	75 (3)	100 (4)	125 (5)	150 (6)
125 (5)	75 (3)	100 (4)	125 (5)	150 (6)
150 (6)	85 (3 1/2)	110 (4 1/2)	135 (5 1/2)	150 (6)

TABLE 5 Minimum Pipe Insulation Thickness mm (inches) For Steam 110 to 1724 kPa (16 to 250 psi) gage				
Nominal Pipe Diameter mm (inches)	MPT-PC MPT-PF	Delta	Thermo-12 Super Caltemp	Foamglas
200 (8)	85 (3 1/2)	110 (4 1/2)	135 (5 1/2)	150 (6)
250 (10)	100 (4)	125 (5)	150 (6)	165 (6 1/2)
300 (12)	100 (4)	125 (5)	150 (6)	165 (6 1/2)
350 (14)	100 (4)	125 (5)	150 (6)	165 (6 1/2)
400 (16)	100 (4)	125 (5)	150 (6)	165 (6 1/2)
450 (18)	100 (4)	125 (5)	150 (6)	165 (6 1/2)

TABLE 6 Minimum Pipe Insulation Thickness mm, (inches) For Steam less than 110 kPa (16 psi) gage, Condensate Return				
Nominal Pipe Diameter mm (inches)	MPT-PC MPT-PF	Delta	Foamglas Thermo-12 Super Caltemp	Insul-phen
25 (1) and under	35 (1 1/2)	50 (2)	75 (3)	25 (1)
40 (1 1/2)	35 (1 1/2)	50 (2)	75 (3)	25 (1)
50 (2)	35 (1 1/2)	50 (2)	75 (3)	25 (1)
65 (2 1/2)	35 (1 1/2)	50 (2)	75 (3)	25 (1)
80 (3)	50 (2)	63 (2 1/2)	85 (3 1/2)	25 (1)
100 (4)	50 (2)	63 (2 1/2)	85 (3 1/2)	38 (1 1/2)
125 (5)	50 (2)	63 (2 1/2)	85 (3 1/2)	38 (1 1/2)
150 (6)	63 (2 1/2)	76 (3)	110 (4 1/2)	38 (1 1/2)
200 (8)	63 (2 1/2)	76 (3)	110 (4 1/2)	38 (1 1/2)

Insulation listed has passed a boiling test:

Delta is available from Rockwool Manufacturing Co., Leeds, AL.
Foamglass is available from Pittsburgh Corning Corp., Pittsburgh, PA.

MPT is available from Mineral Products of Texas, Houston, TX.
Thermo-12 and Super Caltemp are available from Johns-Manville, Denver, CO.

Insul-phen is available from Resolco International Div.
www.resolco.com

5. Parts Not Insulated:
Threaded valves

Steam traps
Check valves
Unions
Threaded strainers
Strainer basket removal cover and bolting
Dielectric flanges and unions
Expansion joints
Flexible connectors
Ball joints except piping between joints

6. Installation:

- a. Complete all pressure tests before installing insulation.
- b. All insulation material shall be new, clean, dry and stored in a clean dry environment; jacketing materials shall be clean and unmarred; store adhesives in original containers. Materials shall not have exceeded the predicted shelf life as set by manufacturer.
- c. Identify all materials incorporated in the job on manufacturer's container by name, type and description.
- d. Apply materials on clean, dry surfaces from which all dirt, loose scale, construction debris has been removed by wire brushing.
- e. The installation shall be neat, thermally and structurally tight without sag, neatly finished at all hanger or other penetrations and shall provide a smooth finished surface primed as required to receive specified painting.
- f. Do not use scrap insulation. Repair any work damaged by welding, burning, compressing due to concentrated construction loads.
- g. Apply pipe covering protection saddles (MSS SP-58, Type 39) at all hanger points. Fill space between saddle and piping with high density insulation, thoroughly packed. Terminate jacket clear of saddle bearing area.
- h. Insulation and jacket shall terminate hard and tight at all anchor points.
- i. Insulation termination at piping facilities not to be insulated shall stop short, and be finished with 45 degree chamfered section of insulating and finishing cement, and covered with jacket.
- j. Flanged fittings and valves shall be insulated with sections of pipe insulation cut, fitted and arranged neatly, and firmly wired in place. Insulating cement shall fill all cracks, voids and outer surface for covering with glass cloth. Insulation of valve bonnet shall terminate on valve side of bonnet flange to permit valve repair.

- k. On calcium silicate, cellular glass and rigid cellular phenolic insulated piping systems, fittings shall be insulated with field or factory-shaped sections of insulation, finished with specified insulating and finishing cements and covered with jacket or PVC premolded cover. On sizes 50 mm (two inches) and smaller it is permissible to apply insulating and finishing cements, and cover with jacket or PVC premolded cover.
- l. Fiberglass insulated piping systems fittings over 50 mm (two inch) size shall be insulated with specified molded pipe fitting insulation or compressed blanket, finished with specified insulating and finishing cements and covered with specified PVC fitting jacket. On sizes 50 mm (two inches) and under apply insulating and finishing cements and cover with PVC fitting jacket.
- m. Apply glass cloth jacket using an approved adhesive. Glass cloth shall be smooth, tight and neatly finished at all edges; prime cloth to receive paint specified in Section 09 91 00, PAINTING.

3.9 BURIED UTILITY WARNING TAPE

Bury directly above direct-buried system approximately 300 mm (12 inches) below grade.

3.10 IDENTIFICATION SIGNS

- A. Valve Identification: Provide laminated plastic signs, with engraved lettering not less than 5 mm (3/16 inch) high, on all isolating valves on steam and condensate return system, identifying building or area served. Attach to the valves with corrosion-resistant chains.
- B. Pipe Identification: Label service of all pipes in manholes and walk-thru tunnels. Refer to Section 09 91 00, PAINTING.

3.11 TESTS

- A. Demonstrate leak-tightness of all piping systems by performing hydrostatic and operational tests. All labor, material and test instruments must be furnished by the Contractor. All instruments must be approved by the RE/COR.
- B. Pressure test direct-buried systems in conformance with requirements stated in this specification and in printed instructions for the system supplied. Tests must include carrier piping and casing.
- C. Holiday testing of direct-buried system steel casings: Test entire surface of casings for faults in coating after installation in trench prior to backfilling. Use test method and voltage recommended by coating manufacturer. Repair any holidays found and retest. System shall not be backfilled until all holidays are eliminated.
- D. Radiographic testing of carrier pipe welds: Refer to Article, WELDING, in Part 3 of this specification.

- E. Before conducting steam system operating test, remove steam trap elements or use bypass connections around traps; then flush lines with high pressure water until discharge shows no foreign matter to the satisfaction of RE/COR.
- F. Hydrostatic and Operational Tests of Carrier Piping: Steam and condensate carrier piping shall be tested hydrostatically before insulation is applied at field joints and shall be proved tight at a pressure 1-1/2 times distribution supply pressure for a period not less than 2 hours with no pressure decay.
1. Test piping located in concrete trenches prior to installing trench covers. Test direct-buried systems prior to backfilling.
 2. Remove or isolate any elements of the system such as expansion joints, which are not designed for the test pressure.
 3. Prior to acceptance of installation, Contractor shall subject system to operating tests as may be required by RE/COR to demonstrate satisfactory functional and operating efficiency. These operating tests shall cover a period of not less than six hours for each portion of system tested. Conduct tests at times as the RE/COR may direct.
 4. Provide calibrated instruments, equipment, facilities and labor, at no additional cost to the Government. Test gage shall read in increments not exceeding 1 kPa (0.1 psi).
 5. Repeat tests when failures occur.
 6. After completion of satisfactory test, replace all elements that have been removed prior to testing.
- G. Pneumatic Testing of DDT System Casings:
1. Perform test on all sections of the system before field-coating the field joints and before back-filling.
 2. Test shall be with compressed air at 100 kPa (15 psi) for 24 hours with pressure source disconnected and with no decay in pressure. Corrections to the readings are permissible to compensate for significant ambient temperature changes during the test period.
 3. Pressure shall be measured with a gage with reading increments of 1 kPa (0.1 psi).
 4. Each casing field joint shall be tested for leaks by means of soap solution or equivalent.
- H. NACE-accredited corrosion specialist shall test cathodic protection systems and demonstrate proper operation and protection in accordance with the recommendations and criteria in NACE RP0169 and in Section 26 42 00, CATHODIC PROTECTION.
- I. Deficiencies discovered shall be corrected at the Contractor's expense, to satisfaction of RE/COR. Major deficiencies or failure to correct

deficiencies, to the satisfaction of the RE/COR, may be considered cause for rejecting the entire installation.

- - - END - - -