

Structures

Master Specification

ST-SC-C2 Post Tensioned Concrete

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ST-SC-C2 Post Tensioned Concrete

1 General

- 1.1 This Part specifies the requirements for the production of post-tensioned prestressed concrete.
- 1.2 Unless specified otherwise, the definitions in AS5100: Bridge Design Part 5: Concrete apply to this Part. Design Standards.
- 1.3 Unless specified otherwise, all design and / or documentation must comply with the most recent revisions (including published amendments) of the following design standards and / or specifications:
- a) AS 1012 Methods of Testing Concrete.
 - b) AS 1314 Prestressing Anchorages.
 - c) AS 1349 Bourdon Tube Pressure and Vacuum Gauges.
 - d) AS 2312 Guide to the protection of structural steel against atmospheric corrosion by the use of protective coatings.
 - e) AS 3972 Portland and Blended Cements.
 - f) AS 4672.1 Steel Prestressing Materials – General Requirements.
 - g) AS 4672.2 Steel Prestressing Materials – Testing Requirements.
 - h) AS 5100 Bridge Design.
 - i) AS 9001 Quality Management Systems – Requirements.
 - j) ASTM C940-98 Standard Test Method for Expansion and Bleeding of Freshly Mixed Grouts for Preplaced-Aggregate Concrete in the Laboratory.
 - k) ASTM C939-:2 Standard Test Method for Flow of Grout for Preplaced-Aggregate Concrete (Flow Cone Method).
 - l) Australian Certification Authority for Reinforcing Steel (ACRS), available from <https://www.acrs.net.au/>.
 - m) Worksafe Victoria: “Construction and Erection of Bridge Beams”, available from <https://www.worksafe.vic.gov.au/>.

2 Quality Requirements

- 2.1 Prestressed concrete members shall be manufactured under a quality system certified to AS 9001.
- 2.2 All testing and certification required under this Part shall be carried out by a NATA accredited laboratory.
- 2.3 The Contractor shall prepare and implement a Quality Plan that at a minimum includes the documents, procedures and / or instructions listed below. If not provided beforehand, the procedures shall be submitted at least 28 days prior to the commencement of tensioning.
- 2.4 Provision of the documentation listed in this Clause shall constitute a **Hold Point**.
- 2.5 The required documentation includes:

Safety

- a) Procedures / Safety Plan to ensure the safety of all persons during production, including details of no-go zones and protective barriers to prevent injury in the event of equipment failure;
- b) for precast bridge beams, full details of how the requirements of Section 4 “Manufacture” of the Worksafe Victoria publication: “Construction and Erection of Bridge Beams” will be addressed;

Personnel

- c) details of the experience of personnel supervising tensioning activities;

Tensioning of Tendons

- d) details of proposed tensioning equipment to be used and proof of its ability to carry out the work;
- e) calibration of equipment;
- f) recording of data;
- g) stressing sequence;
- h) method of determination of the initial force;
- i) checking for slippage and friction loss;
- j) handling and storage of tendons both in the coiled and made up states;
- k) safety precautions during tensioning;

Pre-Tensioning – Associated Works

Fabrication and placing of tendons

- l) ensuring traceability of tendons;
- m) method of placing;
- n) layout of tendons at anchorages;
- o) method of deflecting tendons, if appropriate;
- p) protection against corrosion;

Method of tensioning tendons

- q) sequence of tensioning (for deflected strands);
- r) calculation of forces at anchorages and at member mid points;
- s) estimated friction losses;

Method of transfer of prestress

- t) release of tendons at end of stressing bed, including sequence of release;
- u) release of tendons between members;

Post Tensioning – Associated Works

Placing of ducts

- v) method of fixing;
- w) treatment at joints;
- x) temporary stiffening;
- y) details of grout vents;
- z) method of sealing ducts, anchorages and grout vents;
- aa) method of ensuring ducts and grout vents remain clear of obstructions;

Assembly of precast segments

- bb) method of supporting segments for jointing;
- cc) measures to prevent damage to ducts at joints;
- dd) measures to prevent obstructions occurring the ducts;

Fabrication and placing of tendons

- ee) ensuring traceability of tendons delivered to site;
- ff) method of placing;
- gg) method of corrosion protection;

Grouting of tendons

- hh) method of grouting;
- ii) mix design, documentation and testing;
- jj) details of mixing and pumping equipment and evidence of its ability to meet the requirements of this Specification; and
- kk) method of recording quantity of grout usage.

3 Materials

Tendons

- 3.1 The manufacturer / processor of the tendons shall hold a valid certificate of approval issued by the Australian Certification Authority for Reinforcing Steel (ACRS). Refer to <https://www.acrs.net.au/>.
- 3.2 The Contractor shall provide:
 - a) details of the composition of the tendons;
 - b) test results in accordance in accordance with AS 4672.2 demonstrating compliance with AS 4672.1; and
 - c) load-extension graphs covering each coil to be used, taken from 3 representative samples, each 1.4 m long, from each coil.
- 3.3 Provision of the ACRS certification, details of tendon composition, evidence of compliance with AS 4672.2 and load extension graphs shall constitute a **Hold Point**.
- 3.4 Welding is not be permitted on or near tendons nor shall any heat be applied to tendons. Tendons which have been affected by welding, weld splatter and / or heat will be considered as non-conforming. Flame cutting of wire or tendon within 75 mm of where the tendon will be gripped by the anchorage or jacks is not be permitted.

Anchorage

- 3.5 Anchorages shall comply with AS 1314. Provision of the test certificates demonstrating compliance shall constitute a **Hold Point**.
- 3.6 Spiral or other reinforcement specified by the manufacturer for use in conjunction with anchorage devices shall be of the size and dimensions recommended by the manufacturer for the post-tensioning system.
- 3.7 25 mm minimum diameter grout holes shall be provided at both anchorages and shall be placed at the highest point of the anchorage. Each of the grouting holes shall be equipped with a plug valve or similar device capable of withstanding a pressure of 1.0 MPa without loss of water, air or grout.

Ducts

- 3.8 Ducts shall be of a type suitable for the nominated post-tensioning system and shall be strong enough to withstand the placing and compaction of the concrete without suffering damage or deformation. The duct and any splices shall be sealed to resist the entry of grout.
- 3.9 Steel duct shall have a corrugated profile and shall be galvanized. Plastic duct shall be corrugated and shall have sufficient thickness to resist abrasion during installing and stressing of the tendon.
- 3.10 Enlarged portions of the duct at couplings or anchorages shall be of sufficient length to provide for the extension of the tendons. Vents, with plug valves, shall be provided at intervals not greater than

10 metres along the duct. Additional vents with plug valves shall be provided at high and low points in the duct.

Traceability

- 3.11 Wire, strand, bars and anchorages shall be labelled in accordance with the requirements of AS 4672 or AS 1314. Individual lengths of wire, strand or bar shall be traceable from the point of manufacture of coils or lots to their final location by a unique identification number. Each coil shall be clearly identified by use of a durable metal label to enable matching with the appropriate test certificates and load-extension graphs. Wire or strand not clearly identified shall not be used.
- 3.12 Anchorages shall be traceable from the place of manufacture to their final location by a unique identification number.

Handling, Storage and Fabrication of Materials

- 3.13 Materials shall be stored and handled in such a manner so that they are not damaged, contaminated or their physical properties altered. This includes:
- storage under a waterproof shelter;
 - being supported above ground level; and
 - kept free of all foreign matter on the surface.
- 3.14 Tendons shall be free of surface pitting, kinks and other damage. Ducts shall not be damaged or kinked. Anchorage steel components including threads shall be protected from corrosion by greased wrappings or plugs until required for use.

4 Tensioning Equipment

- 4.1 Dynamometers and each set of equipment comprising, pump, jack and pressure gauges shall be calibrated by an approved laboratory immediately prior to first use and then at intervals not exceeding 6 months and the true force at the jack determined from the calibration curve.
- 4.2 Pressure gauges shall:
- be concentric scale type gauges complying with AS 1349;
 - not be less than a nominal size of 150 mm;
 - read between 50% and 80% of its full capacity when the tendon is stressed to 75% of its breaking load; and
 - be fitted with safety devices to protect pressure gauges against sudden release of pressure.
- 4.3 The measuring equipment used shall permit tendon force and elongation to be determined to an accuracy of $\pm 2\%$.

5 Safety

- 5.1 The Contractor's Safety Plan and / or procedures shall identify and manage the hazards to site personnel, other persons who might be affected by the stressing operation and nearby property and shall take the highest standard of care to ensure the safety of all affected persons and property in accordance with the provisions of the Work Health and Safety Act (SA) 2012 and the Work Health and Safety Regulations (SA) 2012.
- 5.2 The Contractor shall establish no-go zones with warning signs and substantial barricades in order to provide a protective barrier for site personnel, other persons and property and to prevent the entry of unauthorised persons into the hazard zone around and behind the jacking equipment.
- 5.3 Jacking and other site personnel shall not be permitted to stand behind the jack or close to the line of the tendons while stressing is in progress. During stressing operations, warning signs that conform to AS 1319 shall be displayed at both ends of the member being tensioned. The stressing jack shall be adequately supported and restrained in order to ensure that it cannot cause injury to personnel

operating the jacking equipment should the jack lose its grip on the tendons or should the tendon fail.

6 Tensioning of Tendons

General

- 6.1 The Contractor shall provide at least:
 - a) 14 days' notice of the day that tensioning will commence; and
 - b) 24 hours' notice of the time that tensioning of each member will commence.
- 6.2 Provision of the above notices shall constitute a **Hold Point**.
- 6.3 Tensioning shall be performed only by personnel experienced in this type of work and in accordance with the Quality Plan. Concrete shall not be drilled or any portion cut or chipped away or otherwise disturbed after prestressing, unless prior approval has been obtained.

Ducts and Grout Vents

- 6.4 Ducts, grout vents and their connections shall be mortar tight and strong enough to withstand the forces normally encountered in the placing, vibration of concrete and stressing without suffering any damage or deformation.
- 6.5 Grout vents shall be provided at all high and low points in the ducts. Additional vents shall be provided beyond each high point in the direction of grout flow at the point where the duct is $\frac{1}{2}$ diameter lower than the high point, but no further than 1 m. Additional vents shall also be supplied at the highest point of each anchorage.
- 6.6 Vents shall be at least 20 mm in internal diameter and shall extend a minimum height of 1 m from the top of the concrete surface. Grout vents shall be equipped with a plug valve or similar device, capable of withstanding a pressure of 1 MPa without the loss of air pressure or grout.
- 6.7 Where tendons are installed in ducts after concreting, grout vents shall be checked for blockages and cleared if necessary at the following times:
 - a) during and immediately after placing of concrete; and
 - b) prior to installation of tendons.
- 6.8 Ducts in which the permanent tendon will not be in place during concreting shall have a temporary tendon inserted or shall be stiffened by some other approved method.

Couplings

- 6.9 Couplings shall be housed such that complete grout encasement of all coupling components will be accomplished during grouting of the tendons.

Concrete Placement

- 6.10 Care shall be taken during placing and compaction of concrete to avoid damage to ducts, grout vents and their connections.
- 6.11 When the permanent tendons are inserted in the ducts before all concreting has been completed, the tendons shall be moved backwards and forwards approximately 300 mm after the concrete has hardened, and within 24 hours of placing of concrete, in order to ensure that the tendons are free to move during tensioning operations.
- 6.12 Where a permanent tendon is not used and prior to reeving tendons, a wooden or steel dolly shall be drawn through the ducts before the concrete hardens to check for obstructions. Any obstructions which may impede the passage or movement of the tendons in the ducts shall be removed.

Placing Tendons

- 6.13 Where possible, tendons shall not be placed until immediately prior to stressing. When installing tendons, care shall be taken to ensure that each strand or wire maintains its relative position with respect to all other strands or wires throughout the length of the tendon.
- 6.14 Where strands are fabricated into a tendon as a group and subsequently pulled through the ducts the groups of strands or wires shall be pulled simultaneously through a comb. When steam curing is used tendons shall not be installed until steam curing is completed.

Tensioning Procedure

- 6.15 Tendons shall be checked before tensioning to ensure that they are free to move inside the duct.
- 6.16 Tendon ducts shall be cleaned out by blowing oil-free compressed air through them and anchorages shall be thoroughly cleaned prior to commencement of tensioning. The protruding ends of tendons shall be cleaned of any coating, such as rust, mortar, oil or mud which would lessen the grip of wedges or anchorage devices. The jack shall be set accurately in the line of the tendons.
- 6.17 Prior to the commencement of each post-tensioning operation, a **Hold Point** shall apply.
- 6.18 The prestressing force shall not be applied to a member until all the concrete in the member has attained the compressive strength shown on the Drawings. If a member has been steam cured, the prestressing force shall not be applied until the temperature of the concrete has cooled to ambient air temperature.
- 6.19 Once commenced, a tendon stressing operation shall be completed without interruption. No tendon shall be left in a partially stressed condition. The application and release of the prestressing force shall be carried out in such a sequence that produces the minimum of eccentric force in the member.
- 6.20 The tensioning force applied to any tendon shall be measured by direct reading of the pressure gauges and checked by comparison of the measured elongation with the elongation calculated by the Contractor from the load-extension graphs supplied.

Multi-Strand Tensioning

- 6.21 Anchor blocks shall be set parallel to the anchorage prior to any force being applied to the tendon. The force which is applied initially to take up the slack of the tendon shall be sufficient to seat the jack firmly but shall not exceed the amount normally associated with the particular method of prestressing.
- 6.22 After taking up the slack, individual strands shall be accurately marked at both ends so that any slip may be observed. The strands located on the perimeter of the tendon shall be used to measure draw-in. Allowance shall be made for any draw-in of the tendon at the anchored end.
- 6.23 Where the tendons are required to be tensioned by jacks at each end operating simultaneously, arrangements shall be made to keep almost identical forces at each jack throughout the tensioning operation which shall continue until the required force in the jacks is reached.

Monostrand Tensioning

- 6.24 All strands shall be accurately marked prior to any force being applied to the tendon. An initial force equal to 10% of the final force shall be applied to take up the slack of the tendon.
- 6.25 After taking up the slack and where applicable the tendon shall be marked at the anchored end so that any slip or draw-in may be measured. Readings of force and elongation shall be taken at the initial and final stage of tensioning of each tendon. Elongations shall be recorded from the jack ram.
- 6.26 If, during tensioning, the check measurement of any individual strand elongation differs from its required value by +10% or -5%, a **Hold Point** shall apply. If the average measured extension of a group of tendons anchored at the same anchorage differs by more than $\pm 7\%$, a **Hold Point** shall apply.

Requirements after Stressing

- 6.27 The maximum jacking force shall not exceed:
- 80% of the rated capacity of the jacking equipment used;
 - 85% of the specified minimum ultimate strength of the tendon; or
 - 75% of the minimum ultimate strength of the bar.
- 6.28 If, during tensioning, the check measurement of elongation differs from its required value by $\pm 7\%$ a **Hold Point** shall apply.
- 6.29 After stressing of a member has been completed, and prior to grouting and cutting back tendons at anchorages, a **Hold Point** shall apply.
- 6.30 Subject to prior approval, a precast, post-tensioned member may be lifted from the assembly bed before the stressed tendons have been grouted but all ungrouted tendons shall be marked for measurement of slip. Tendons which slip or become damaged shall be considered as non-conforming.

Friction Loss Check

- 6.31 The friction coefficient of the tendons within the ducts shall be established as directed or as required on the Drawings. The Contractor shall have on site the appropriate equipment to enable the friction loss to be measured between anchorages.

Tendon Failure

- 6.32 Where one or more components or tendons of a group stressed together slips or breaks during stressing operations, a **Hold Point** shall apply.
- 6.33 Subject to prior approval, a compensating increase in the force of the remaining tendons of the group may be permitted, provided that the jacking force does not exceed 85% of the minimum ultimate tensile strength of the remaining tendons. If this cannot be achieved the tendon shall be considered as non-conforming.

Data to be Recorded

- 6.34 The following data, where applicable, shall be recorded during the stressing process:
- identification number of each dynamometer, gauge, pump and jack;
 - identification particulars of tendons;
 - initial forces / pressures and elongations;
 - final forces / pressures and elongations;
 - elongations obtained at all stages during tensioning, together with corresponding forces / pressures;
 - elongations and forces / pressures when resetting of jacks is required;
 - draw-in at both ends of tendons (where applicable); and
 - draw-in of auxiliary wedges at the rear of the jack (where applicable).

7 Grouting

General

- 7.1 All cable ducts containing stressed cables are to be grouted unless otherwise shown on the drawings. Grouting shall be carried out as soon as practical after stressing and in any case no later than:
- one week under severe corrosivity level;
 - two weeks under moderate corrosivity level;

- c) three weeks under low corrosivity level.
- 7.2 Corrosivity is as defined in AS 2312.
- 7.3 The grouting shall be carried out in such a manner that the cable ducts are completely filled with a dense and uniform grout. Grouting shall not be performed if:
- the air temperature is greater than 29°C when the shade temperature is rising;
 - the air temperature is greater than 32°C when the shade temperature is falling; or
 - the temperature of the concrete is below 10°C or above 30°C.

Properties of Grout

- 7.4 The grout shall be a mixture of Type GP Portland Cement to AS 3972 and water having a water / cement ratio of not more than 0.40 by mass. Cement and water shall conform to the requirements for these materials given in Division ST-SC Concrete, except the water shall not contain more than 500 milligrams per litre of chloride ions and cement shall be less than 21 days old.
- 7.5 No additives will be permitted in the grout mixture unless the Contractor can demonstrate that they have no harmful effect whatsoever on the prestressing steel, do not contain iron or aluminium powder and do not generate gases from chemical reaction between grout mix constituents or other materials in contact with the grout. Grout shall have high bleed resistance, low shrinkage and high fluidity.
- 7.6 Grout shall comply with the requirements of Table ST-SC-C2 7-1.

Table ST-SC-C2 7-1 Performance Requirements for Grout

Property	Test Method	Criteria	Comments	Frequency
Bleeding	ASTM C94011	Final Bleeding <0.5%	Measured when two successive readings show no further expansion or bleeding	One test per day
Early Expansion	ASTM C940	<2% at 3 hours	Temperature tolerances are 20°C ±5°C	One test per day
Fluidity	ASTM C93922	Immediately after mixing: Efflux time <20s 45 minutes after mixing: Change in efflux time <+3s	Contractor's target efflux time for the site conditions shall not vary from nominated value by more than +2s	One test per day
Minimum Compressive strength ³	AS 1012	32MPa at 7 days		Three cubes per day or lot, whichever is larger

7.7 Notes:

- ASTM C9401 shall be modified to simulate wicking of strands as follows: Cut a 1000mm long piece of 15.2mm 7-wire prestressing strand (wrap strand at cuts with suitable tape to prevent splaying the wires when it is cut). Degrease and clean the cut strand. Insert the piece of strand vertically and centrally into the grout cylinder using a centraliser and secure in position. Introduce the grout into the graduated cylinder as per the test method. Take readings as per the test method.
- ASTM C9392 may be modified as follows: Fill the flow cone to the top instead of to the standard level. Measure the efflux time as the time measured to fill the one litre container placed directly under the flow cone.
- Additional cubes may be taken if testing is required at other than 7 days.

Trial Mix

- 7.8 The Contractor shall provide details of the grout mix design, prepare grout trial mixes and undertake the tests listed in Table ST-SC-C2 7-1 on the trial mixes.
- 7.9 Provision of conforming test results shall constitute a **Hold Point**.

Air Testing of Ducts before Grouting

- 7.10 Air testing of ducts before grouting shall be carried out under the supervision of the specialist stressing personnel. Any water in the duct shall first be blown out with oil-free air. After sealing the anchorage ends, each duct shall be tested as follows:
- With all valves closed, pressurise the duct at the inlet with oil-free air to 250kPa to confirm the installed system has sufficient integrity for grouting.
 - Hold the pressure at 250kPa for 30 seconds. A sudden drop in pressure of more than 100kPa, or a need to continuously inject compressed air to maintain pressure indicates that the system is not sufficiently sealed for grouting. All leaks shall be located and repaired and the test repeated.
 - Reduce the pressure to 100kPa.
 - Lock off the air source.
 - Record the air pressure loss over time. A pressure loss greater than 40% shall not be permitted within a duration of $D = (1.1V + 5)/60$, where D = duration in minutes and V = volume of the duct minus the strand volume, in litres.
- 7.11 If the pressure loss over time is greater than 40%, a thorough inspection and repairs shall be undertaken prior to re-test. Where air testing detects leakage between two adjacent ducts that cannot be practically rectified, both shall be air tested together as a single system and then shall be grouted simultaneously with two lines controlled by individual lock off valves.
- 7.12 If the air loss criterion cannot be achieved after rectifying all detected leakages, assessment shall be undertaken by the specialist stressing personnel who shall provide a recommendation whether grouting should proceed.
- 7.13 Provision of conforming test results shall constitute a **Hold Point**.

Grouting Equipment

- 7.14 The mixing equipment shall be of a type capable of producing a uniform suspension of cement in water.
- 7.15 The injection shall be capable of continuous operation with minimum variation of pressure and shall include a system for recirculating the grout whilst grouting is not in progress.
- 7.16 The grout pump shall be capable of delivering grout at a rate of 1800 litres per hour at pressures up to 1.0MPa. All piping to the grout pump shall have a minimum of bends and valves and changes in diameter. All baffles to the pump shall be fitted with 1.18mm sieve strainers.
- 7.17 The equipment shall have sufficient capacity to continuously fill a tendon, without interruption, at the required rate of injection.
- 7.18 During grouting the Contractor shall have available adequate flushing-out plant to facilitate complete removal of the grout in the event of a breakdown of the grouting equipment or other disruption before the grouting operation has been completed. This equipment shall be ready for operation during grouting.
- 7.19 Piping to the grout pump shall have a minimum of bends, valves and changes in diameter. Pipes and fittings shall have a minimum internal diameter of 20 mm.
- 7.20 A standby grout pump shall be made available on site for use at all times during grouting operations. All equipment shall be thoroughly washed through with clean water after every series of operations and more frequently if necessary. The intervals between washings shall not exceed three hours.

Grout Mixing

- 7.21 Water shall be added to the mixer first then Portland cement. Mixing shall continue for at least two but not more than four minutes until a uniform consistency is obtained. Only as much grout as may be used in one hour shall be mixed in any batch. The Contractor shall ensure that each batch of grout is mixed to the same consistency.

Grout Placement

- 7.22 Before grouting, the volume of grout required for each duct shall be determined for use as a basis for control of volumes and rates of grout injection. Grout shall be injected into the duct from the lowest anchorage in an even continuous flow so that it moves along the duct at a rate of between 6-12 metres per minute. Filling rates for vertical ducts shall not exceed 5 metres per minute.
- 7.23 When the grout reaches the first grout vent it shall be allowed to flow out until all excess water and air has been expelled from the first portion of the duct and it is of the same consistency as the injected grout. This grout vent shall then be sealed off and the procedure repeated at the remaining vents until the duct is completely filled. The vents shall be progressively closed from the pumping end except that at the intermediate high points the vents immediately downstream shall be closed before their associated high point.
- 7.24 In cases where the ducts are longer than 100 metres an alternative grouting procedure may be required.
- 7.25 The Contractor shall supply attachments suitable for injecting grout at the anchorages and all intermediate grout outlets for use as required if a blockage occurs during grouting. After a period of not less than two days the plugs at grout outlets shall be removed and any necessary topping up carried out.
- 7.26 All grout outlet pipes shall be cut off or drilled out as necessary to maintain the specified cover to any metal surfaces. The recess so formed shall be made good with epoxy to give a smooth surface flush with the concrete.
- 7.27 The Contractor shall maintain records of the amount of grout injected into each duct and test results demonstrating compliance with Table ST-SC-C2 7-1.

8 Treatment of Anchorages and Couplings

- 8.1 Tendons shall not be cut back at anchorages until the **Hold Point** in Clause 6.29 "Requirements after Stressing" has been released. Ends of tendons shall be cut with a high speed abrasive disc or wheel to give the cover as required by AS 5100.5 or as specified in the Drawings. Flame cutting of tendons shall not be used.
- 8.2 Prior to placing anchorage encasing concrete or concreting an end beam, the roughened end surface of the beams shall be coated with an approved wet-to-dry epoxy resin bonding agent.
- 8.3 Anchorage encasing concrete that will be visible in the final condition (such as diaphragms) shall be of the same colour as the surrounding concrete. Recesses for stress bars shall be concreted within 7 days of grouting.

9 Hold Points

- 9.1 The following is a summary of Hold Points referenced in this Part:

Document Ref.	Hold Point	Response Time
2.4	Submission of Procedures	7 days
3.3	Supply of Tendons	14 days
3.5	Supply of Anchorages	14 days
6.2	Notification of Tensioning	1 day
6.17	Prior to each post-tensioning operation	2 hours
6.26	Monostrand tensioning	2 hours
6.28	Excessive elongation	1 day

Document Ref.	Hold Point	Response Time
6.29	Prior to grouting and cutting back of tendons	2 hours
6.32	Failure of a tendon	Refer Clause 6.32 "Tendon Failure"
7.9	Grout trial mix test results	7 days
7.13	Air test of ducts results	2 hours

10 Verification Requirements and Records

10.1 The Contractor shall supply written verification that the following requirements have been compiled with and supply the verification with the lot package.

Table ST-SC-C2 10-1 Verification Records

Document Ref.	Subject	Record to be Provided
6.34	Tensioning Data	Refer Clause 6.34 "Data to be Recorded"
7.6	Properties of Grout	Refer Clauses 7.4 – 7.6 "Properties of Grout"