



October 23, 2012

Mr. Reynolds Toney, P.E. Materials Division Engineer Oklahoma Department of Transportation 200 Northeast 21<sup>st</sup> Street Oklahoma City, Oklahoma 73105

Subject: Inspection of Cement, Pozzolan, and Concrete Testing Laboratories

Dear Mr. Toney:

Enclosed is a confirmatory report on Inspection Number R-766, which was completed in your testing laboratories at Oklahoma City, Oklahoma, on September 6, 2012, by representatives of the Cement and Concrete Reference Laboratory.

This letter, and the accompanying report, provide written evidence that your laboratories have been inspected during the 35<sup>th</sup> Inspection Tour.

CCRL has recently changed the report format. Attention is invited to the next page titled *Inspection Report Introduction*.

Very truly yours,

Steven E. Lenker, P.E.

Director, Construction Materials Reference Laboratories

Cement and Concrete Reference Laboratory

**Enclosure** 

cc: J. Thomas

Division Administrator, FHWA



# **Inspection Report Introduction**

This report covers the cement, pozzolan, and concrete inspection conducted in the laboratories of Oklahoma Department of Transportation, at Oklahoma City, Oklahoma. This inspection, designated as Inspection Number R-766, was completed in the laboratories on September 6, 2012.

Inspections generally cover three areas: quality systems; testing equipment; and procedures. Under all material types inspected there will be a Summary of Findings and a Footnote Section. The Summary of Findings will denote items examined, which may include: documents, equipment and procedures performed by the laboratory. Entries in the Summary of Finding Section cover availability, physical condition, and/or conformance to specification requirements. These items, when checked, will indicate whether the items conformed to the ASTM standard or will state briefly any deviation from the standard and will be listed in the Footnote Section. The Footnote Section is also used to convey observations, recommendations or explanations of conditions found. When a footnote of this nature appears in a report it is labeled as an "Informational Footnote" in bold font. These informational footnotes do not require deficiency corrections.

Corrections of minor deficiencies are encouraged during the course of each inspection. In the interest of brevity, any adjustments of this nature which may have been made have not been mentioned in the report.

Several pieces of apparatus in the laboratory have been assigned CCRL identification numbers. Some of these numbers are listed in the Summary and Footnote Sections.

For a more in-depth description of the scope of each inspection, please see <a href="www.ccrl.us/Lip/lip.htm">www.ccrl.us/Lip/lip.htm</a>. The inspection was conducted using the most recent version of the applicable Book of ASTM Standards available at the time of the inspection, unless otherwise indicated in the Footnote Section of this report.

This report confirms the condition of the laboratory on the inspection date noted above. It does not approve, certify or accredit this laboratory; therefore, publicizing the inspection without offering a review of this report is prohibited.

## **CEMENT SUMMARY OF FINDINGS**

## **Quality System**

Inspection Item	<u>Status</u>
Quality System C1222-09	
Organization	Satisfactory
Human Resources	-
· Director of Testing	Satisfactory
· Training	Satisfactory
Performance Evaluation	Satisfactory
Personnel Records	Satisfactory
Operations	-
Standard Operating Procedures	Satisfactory
· Final Report	See footnote (a)
Quality	
Technical Complaints	Satisfactory
External Technical Services	Satisfactory
Proficiency Sample Testing	Satisfactory
Standard Test Methods	Satisfactory
Internal Quality System Review	Satisfactory
Equipment	
Inventory	Satisfactory
Equipment Calibration	Satisfactory
· Records	Satisfactory
· Calibration Procedures	Satisfactory
Qualification of Chemical Analysis C114-11a	
• Frequency	Satisfactory
Records:	
Analyte <u>Method</u>	*Qualified
Analyte	Qualified
Silicon Dioxide X-Ray	Yes
Aluminum Oxide X-Ray	Yes
Ferric Oxide X-Ray	Yes
Calcium Oxide X-Ray	See footnote (b)
Magnesium Oxide X-Ray	Yes
Sulfur Trioxide Reference	Yes
Loss on Ignition Reference	Yes
Sodium Oxide X-Ray	Yes
Potassium Oxide X-Ray	Yes
Titanium Dioxide X-Ray	Yes
Phosphorus Pentoxide X-Ray	Yes
Zinc Oxide X-Ray	Yes
Manganic Oxide X-Ray	Yes
Insoluble Residue Reference	Yes

<sup>\*</sup>Entry covers conformance to permissible variations in data results as listed in Table 1 of C114.

# Apparatus

Inspection Item	<u>Status</u>
Storage Facilities for Test Specimens C511-09  • Moist Air Storage Facilities  • Water Storage Facilities	Satisfactory Satisfactory
Autoclave Soundness Apparatus C151-09 and C490-10	
<ul> <li>Autoclave(s):         <ul> <li>Maker: Boekel</li> <li>Length Comparator(s)</li> <li>Bar Mold(s)</li> </ul> </li> <li>Autoclave(s):         <ul> <li>Serial Number: 1011-24</li> <li>Number Checked: 1</li> <li>Number Checked: 4</li> </ul> </li> </ul>	Satisfactory
Graduates C1005-10  • Capacity: 500 mL CCRL Number: J-237	Satisfactory
Capacity: 250 mL CCRL Number: R-1761	Satisfactory
Flow Table C230-08  • Flow Table(s):  • Maker: Humboldt  • Accessory Apparatus	
Compression Test Apparatus C109-11 and E4-10  • Compression Testing Machine:  • Maker: Tinius Olsen  • Serial Number: 322424 Capacity: 60,000 lbf  • Accuracy of Indication:	
Range: 60,000 lbf From: 10,000 to 40,000 lbf      Mechanical Condition	Satisfactory
Mechanical Condition	Satisfactory
• Design	Satisfactory
	Satisfactory
Cube Molds: Number Checked: 12	Satisfactory
• Tampers	Satisfactory
Mix Balance(s) C1005-10           • Maker: Mettler           • Capacity: 3,100 g         CCRL Number: M1142	Satisfactory
<u>Vicat Apparatus C187-11, C191-08, and C451-08</u> • Vicat Apparatus(es): • CCRL Number: <u>P-280</u>	See footnote (c)
CCRL Number: U-2450	See footnote (d)
Additional Vicat Rings: Number Checked: 6	
Gillmore Needles C266-08  Initial Needles: CCRL Number: T-3011  Mountings:  • Final Needles: CCRL Number: T-3012  • CCRL Number: T-3012	Satisfactory
Mechanical Mixing Apparatus C305-11      Mixer(s):     Maker: Hobart	

<u>Inspection Item</u>

	······································	Satisfactory Satisfactory
<ul> <li>CCRL Number: K-1620</li> </ul>		Satisfactory
<ul> <li>Accessory Apparatus</li> </ul>		Satisfactory
Sample Splitter		Satisfactory Satisfactory
• Sieves		Satisfactory
<ul><li>Relative Humidity of Air in Lab</li><li>Temperature of Mixing Water</li></ul>	ory poratory ting Apparatus	Satisfactory Satisfactory Satisfactory Satisfactory
	Procedures	
<u>Test</u>	Method <u>Reference</u>	Technique in Exact Agreement With Standard Practice
Normal Consistency Test	C187-11 and C305-11	Yes
	C191-08 and C305-11	Yes
	C266-08 and C305-11	Yes
	C151-09 and C305-11	See footnote (e)
Mortar Cubes	C109-11, C305-11, and C1437-07	See footnote (f)
	C151-09	Yes
Testing of Mortar Cubes		See footnote (g)
	C185-08 and C305-11	Yes
	C204-07	See footnote (h)
Handling of Samples	C183-08	Yes

#### **CEMENT FOOTNOTE SECTION**

## Quality System (C1222-09):

(a) Operations: The final test report or associated test records did not include the standard test methods used as required by Section 10.2.8 of C1222.

#### Qualification of Chemical Analysis (C114-11a):

(b) Records: In the qualification of calcium oxide by Rapid Test Method using Certified Reference Material (CRM) samples, less than 77% of the samples were within the tolerance, listed in Table 1, Column 2 of C114, specified for the difference between duplicate tests. Also, the difference between duplicate tests exceeded twice the tolerance allowed in Column 2 of Table 1 of C114. Attention is invited to Table 1 Note A of C114 which requires that all qualification testing be within twice the tolerance.

## Vicat Apparatus (C187-11, C191-08, and C451-08):

- (c) **Informational Footnote**: It was understood that the Vicat apparatus bearing CCRL Number P-280, was only used to determine the Vicat time of set; therefore, no check of the attached plunger was made.
- (d) **Informational Footnote**: It was understood that the Vicat apparatus bearing CCRL Number U-2450, was only used to determine the normal consistency; therefore, no check of the attached needle was made.

#### Procedures:

- (e) Preparation of Autoclave Bars (C151-09 and C305-11): It was understood that the gage studs used in the autoclave bar molds were not kept free of oil as required.
- (f) Preparation of Mortar Cubes (C109-11, C305-11, and C1437-07): It was understood that the halves of the molds were not sealed with a light cup grease and the excess removed as is required in Section 9.2 of C109.
- (g) Testing of Mortar Cubes (C109-11): Prior to testing the mortar cubes, the contact surfaces of the cubes were not checked for curvature with a straightedge as required by Section 10.6.2 of C109. In addition, prior to testing each cube, it was not ascertained that the upper block was free to tilt as required by Section 10.6.3 of C109.
- (h) Air Permeability Fineness Test (C204-07): It was understood that the sample weight of cement used for this test was not the most current sample weight calculated.

# **POZZOLAN SUMMARY OF FINDINGS**

## Apparatus

Inspection Item	<u>Status</u>
Storage Facilities for Test Specimens C511-09  Moist Air Storage Facilities  Water Storage Facilities	
<u>Sieves C441-05 and E11-09</u>	Satisfactory
Wet Sieving Apparatus C311-11a and C430-08           • 45-μm (No. 325) Sieve(s)	See footnote (a) Satisfactory
Autoclave Soundness Apparatus C151-09 and C490-10  • Autoclave(s):  • Maker: Boekel Serial Number: 1011-24  • Length Comparator(s) Number Checked: 1  • Bar Mold(s) Number Checked: 4	Satisfactory
Graduates C1005-10         Capacity: 500 mL         CCRL Number: J-237            • Capacity: 250 mL         CCRL Number: R-1761	Satisfactory Satisfactory
Flow Table C230-08  • Flow Table(s):  • Maker: Humboldt  • Accessory Apparatus	
Compression Test Apparatus C109-11 and E4-10  Compression Testing Machine:  Maker: Tinius Olsen Serial Number: 322424 Capacity: 60,000 lbf	
Accuracy of Indication:     Range: 60,000 lbf From: 10,000 to 40,000 lbf      Mechanical Condition     Design     Bearing Blocks      Cube Molds: Number Checked: 12      Tampers	Satisfactory Satisfactory Satisfactory Satisfactory Satisfactory Satisfactory Satisfactory
Mix Balance(s) C1005-10  • Maker: Mettler  Capacity: 3,100 g CCRL Number: M-1142	Satisfactory
Mechanical Mixing Apparatus C305-11  • Mixer(s):  • Maker: Hobart Serial Number: 31-391-318  • Accessory Apparatus:	Satisfactory Satisfactory
Air Content Apparatus C185-08  • 400 mL Measure(s)  • Accessory Apparatus	Satisfactory Satisfactory

<u>Inspection Item</u> <u>Status</u>

Vicat Apparatus C187-11  • Vicat Apparatus(es):  • CCRL Number: U-2450  • Additional Vicat Rings: Number Check	кed: <u>7</u>	Satisfactory Satisfactory
Density C188-09  Density Equipment  Accessory Apparatus		Satisfactory Satisfactory
Loss on Ignition C114-11a and C311-11a  Crucible  Muffle Furnace  Miscellaneous		Satisfactory Satisfactory Satisfactory
Standard Sands C778-06 and E11-09  Sand Verification Sample Splitter Sieves		Satisfactory Satisfactory Satisfactory
Miscellaneous  Temperature of Air in Laboratory Relative Humidity of Air in Laboratory Temperature of Mixing Water ASTM Standards		Satisfactory Satisfactory Satisfactory Satisfactory
	Procedures	Technique in Exact
<u>Test</u>	Method <u>Reference</u>	Agreement With Standard Practice
Normal Consistency Test	C187-11 and C305-11	Yes
Autoclave Bars  Mortar Cubes  Testing of Autoclave Bars	C151-09, C305-11, and C311-11a C109-11, C311-11a, and C1437-07 C151-09	See footnote (b) See footnote (c) Yes
Testing of Mortar Cubes	C109-11	Yes See footnote (d)
Moisture Content  Loss on Ignition  Density	C311-11a	Yes Yes See footnote (e)

## POZZOLAN FOOTNOTE SECTION

## Wet Sieving Apparatus (C311-11a and C430-08):

(a) It was noted that the sieve cloth on one of the five sieves examined was damaged, and it was recommended that a new sieve cloth be installed.

## Procedures:

- (b) Preparation of Autoclave Bars (C151-09, C305-11, and C311-11a): It was understood that the gage studs used in the autoclave bar molds were not kept free of oil as required.
- (c) Preparation of Mortar Cubes (C109-11, C311-11a, and C1437-07): It was understood that the halves of the molds were not sealed with a light cup grease and the excess removed as is required by Section 9.2 of C109.
- (d) No. 325 Sieve Fineness Test (C311-11a and C430-08): After washing the sample, the bottom of the sieve was not blotted with a damp cloth, as is required by Section 5.1 of C430.
- (e) Density (C188-09 and C311-11a): It was noted that the procedure used to free the entrapped air from the cement was different than that specified by Section 4.3 of C188.

# **CONCRETE SUMMARY OF FINDINGS**

# Quality System

Inspection Item	<u>Status</u>
Quality System C1077-11a  Organization Human Resources Operations Quality Assurance Equipment  Apparatus	Satisfactory Satisfactory Satisfactory See footnote (a) Satisfactory
Аррагаtus — — — — — — — — — — — — — — — — — — —	
Curing Facilities C511-09      Moist Air Storage Facilities     Water Storage Facilities	
Cylinder Type(s) Presented for Inspection: 4" x 8"	
Compression Test Apparatus C39-10 and E4-10  • Compression Testing Machine:  • Maker: Forney  • Serial Number: 06129 Capacity: 400,000 lbf  • Accuracy of Indication:  • Range: 400,000 lbf From: 40,000 to 150,000 lbf  • Mechanical Condition  • Design  • Bearing Blocks for Cylinders	Satisfactory Satisfactory
Molds for Concrete Testing C31-10 and C470-09  • Cylinder Molds  • Beam Molds	Satisfactory Satisfactory
Specimen Shipping Containers C31-10	See footnote (c)
Capping Equipment and Materials C617-10  Capping Equipment  Capping Material  Conditions of Caps  Qualification for Design Strengths Greater than 7000 psi	Satisfactory Satisfactory Satisfactory
Unbonded Caps C1231-10a  Retaining Rings Pads Accessory Apparatus	Satisfactory Satisfactory Satisfactory
Slump Cone(s) C143-10a	Satisfactory
<u>Tamping Rod(s) C31-10</u>	Satisfactory
Concrete Vibrators C31-10, C138-10b, and C231-10	Satisfactory
Temperature of Concrete C1064-08	Satisfactory

Satisfactory

Satisfactory

Satisfactory

	Inspection Number R-766
Inspection Item	<u>Status</u>
Reference Temperature Measuring Devices C511-09 and C1064-08  Reference Thermometer(s) - C511 Reference Thermometer(s) - C1064  Unit Weight Apparatus C138-10b Unit Weight Measure(s) Accessory Apparatus Scale or Balance  Air Content Apparatus (Volumetric) C173-10b Air Meter(s) Accessory Apparatus Air Content Apparatus (Pressure) C231-10 Air Meter(s) Accessory Apparatus	Satisfactory
Aggregate Correction Factors	. <u>Satisfactory</u>
Procedures  Method <u>Test</u> <u>Reference</u>	Technique in Exact Agreement With Standard Practice
Slump of Concrete	. <u>Yes</u>
Air Content (Volumetric Method)	. See footnote (d)
Fabrication of Beams	. See footnote (e)
Measuring Temperature of Concrete	. <u>Yes</u>
Bonded Caps:  • Capping of Cylinders	Yes Yes
Unbonded Caps:  • Cylinder and Pad Cap Checks C1231-10a	. Yes
Alignment Checks	
Cylinder Measurements	
Compressive Strength of Cylinders	. Yes
Additional Test Methods	
	<u>Status</u>
	<u>Status</u>

Re-approved December 2011 Page 11

• Procedure .....

• Procedure .....

# <u>Status</u>

Measuring Thickness of Concrete Elements Using Drilled Concrete Cores C174-06	
• Equipment	Satisfactory
• Procedure	See footnote (g)
	,
Making and Curing Concrete Test Specimens in the Laboratory C192-07	
• Equipment	Satisfactory
• Procedure	Satisfactory
Fundamental Transverse, Longitudinal and Torsional Resonant Frequencies of Conc Specimens C215-08  • Equipment	
• Procedure	
Resistance of Concrete to Rapid Freezing and Thawing C666-03	,
• Equipment	Satisfactory
• Procedure	Satisfactory

#### CONCRETE FOOTNOTE SECTION

#### Quality System (C1077-11a):

(a) Quality Assurance: Records of the laboratory's investigation and corrective action taken when receiving low proficiency sample ratings were not maintained by the laboratory as required by Section 9.2.5 of C1077.

#### Compression Test Apparatus (C39-10 and E4-10):

(b) The bearing surface of upper spherically seated bearing block with which the machine was equipped did not conform to the planeness requirement specified by Section 5.2 of C39.

## Specimen Shipping Containers (C31-10):

(c) **Informational Footnote:** It was understood that, normally, laboratory personnel did not fabricate cylinders outside the laboratory; therefore, containers for transporting cylinders from the field to the laboratory were not maintained.

#### Procedures:

- (d) Air Content (Pressure Method) (C231-10): It was noted that air was pumped into the chamber prior to injecting water through the petcocks.
- (e) Fabrication of Beams (C31-10): After the completion of vibration, the outside of the mold was not tapped with a mallet to close the holes left by vibrating and to release entrapped air voids as required by Section 9.4.2.2 of C31.

#### Additional Tests:

- (f) Obtaining and Testing Drilled Cores and Sawed Beams of Concrete (C42-10a): With reference to the upper spherically seated bearing block, which is required for this test, attention is invited to footnote (b).
- (g) Measuring Thickness of Concrete Elements Using Drilled Concrete Cores (C174-06): It was understood that the measurements taken were recorded to the nearest 0.1 inches, rather than the nearest 0.05 inches as required by Section 6.1 of C174.

## **CLOSURE**

This inspection was performed by Megan Karr and Jordan Beckler. While the work was in progress, many of the details covered by this report were discussed with laboratory personnel. At the conclusion of the inspection the special work sheets, on which all observations were recorded, were made available for review by members of the laboratory staff, and all of the entries thereon were discussed in detail.

Identification of the testing equipment used by the CCRL inspector during the inspection can be found on the CCRL website at <a href="https://www.ccrl.us">www.ccrl.us</a> under the heading of traceability.

It is recommended that this report be compared with the report of the preceding inspection which was made in October 2009. For further reference the CCRL laboratory number is 35.

This report does not approve, certify or accredit this laboratory. Publicizing the inspection without full disclosure of this report is not permitted.

Cement and Concrete Reference Laboratory

Jordan C. Beckler

Inspector

Report Approved By:

Ja A. Promell

Page 14