Wisconsin Department of Transportation

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January 21, 2016

NOTICE TO ALL CONTRACTORS:

Proposal #08:

5121-09-63
La Crosse - Cashton
Shady Pines Road to CTH OA
STH 33
La Crosse County

5121-09-73
La Crosse - Cashton
Kirschner Rd to Monroe Co Line
STH 33
La Crosse County

5820-01-73
La Crosse – Cashton
STH 33 – Dutch Creek Bridge
STH 33 NLY .57 MI to
Dutch Creek Bridge
STH 162
La Crosse County

Letting of February 9, 2016

This is Addendum No. 01, which provides for the following:

Special Provisions

Added Special Provisions	
Article No.	Description
32	Hot Mix Asphalt Percent Within Limits (PWL) Test Strip, Item SPV.0105.03
33	HMA Pavement Percent Within Limits QMP
Appendix A	Appendix A Test Methods & Sampling for PWL QMP HMA Pavements

Schedule of Items

Revised Bid Item Quantities					
Bid Item	Item Description	Unit	Old Quantity	Revised Quantity	Proposal Total
460.2000	Incentive Density HMA Pavement	DOL	27,150	15,257	42,407

Added Bid Item Quantities					
Bid Item	Item Description	Unit	Old Quantity	Revised Quantity	Proposal Total
460.2010	Incentive Air Voids HMA Pavement	DOL	0	42,407	42,407
SPV.0105.03	Hot Mix Asphalt Percent Within Limits (PWL) Test Strip	LS	0	1	1

Schedule of Items
Attached, dated January 21, 2016, are the revised Schedule of Items Pages 5 and 20.

The responsibility for notifying potential subcontractors and suppliers of these changes remains with the prime contractor.

Sincerely,

Mike Coleman

Proposal Development Specialist
Proposal Management Section

ADDENDUM NO. 01

5121-09-63/5121-09-73/5820-01-73

January 21, 2016

Special Provisions

32. Hot Mix Asphalt Percent Within Limits (PWL) Test Strip, Item SPV.0105.03.

A Description

This item is intended to compensate the contractor for the construction of the test strip for projects paved under the HMA Pavement Percent Within Limits QMP article. Acceptable HMA mixture placed on the project as part of the test strip will be compensated by the appropriate HMA Pavement bid item. All other costs associated with the construction of the test strip will be compensated by this bid item.

This special provision describes the Hot Mix Asphalt (HMA) density and volumetric testing tolerances required for an HMA Test Strip. An HMA Test Strip is required for projects constructed under HMA Percent Within Limits QMP. A test strip is required for each pavement layer. Each project is restricted to a single mix design for each mix type required (e.g., upper layer and lower layer may have different mix type specified).

B (Vacant)

C Construction

C.1 Test Strip

Notify the department at least 48 hours in advance of construction of the test strip. On the first day of production of each new mix design requiring a test strip, produce approximately 750 ton of HMA and cease production until the required testing is completed. Test strips shall be located in a section of the roadway to allow a representative (i.e. not a ramp or shoulder, etc.) rolling pattern.

C.1.1 Sampling and Testing Intervals

Laboratory testing will be conducted from a three-way split sample, with portions designated for QC, QV, and retained. Required field tests include contractor quality control (QC) and department quality verification (QV) nuclear density gauge tests and pavement coring.

During production for the test strip, HMA mixture samples shall be obtained from trucks prior to departure from the plant. Three four-way split samples shall be collected during the production of test strip material. Sampling and splitting shall be in accordance with Appendix C: *Sampling for WisDOT PWL QMP*. These three samples shall be randomly selected from the following production intervals and will be identified by the engineer:

Sample Number	Production Interval (tons)
1	50-250
2	251-500
3	501-750

The engineer is responsible for identifying two zones in which gauge/core correlation is to be performed. These two zones are to be randomly selected within each of two density sublots of the 750 ton test strip. Test strip sublots 1 and 2 are identified as between 50-400 tons and 401-750 tons, respectively. Each zone shall consist of five (5) locations across the mat as identified in Appendix A. The following shall be determined at each of the five locations within both zones:

- two one-minute nuclear density gauge readings for QC team*
- two one-minute nuclear density gauge readings for QV team*
- pavement core sample

*If the two readings performed with the same gauge by the same team are not within +/- 1.0 lb/ft^3 of one another, a third reading shall be conducted at either orientation. In this event, all three readings shall be averaged, discard the initial of the three readings which falls farthest from the average value and then average the remaining two values to represent the location for the gauge.

Both the QV and QC teams shall have two nuclear density gauges present for correlation at the time the test strip is constructed. The above testing shall be conducted in accordance with Appendix A: *Test Methods & Sampling for PWL QMP HMA Pavements*. All test reports shall be submitted to the department upon completion, and approved before paving resumes.

C.1.1.1 Field Tests

Daily standardization of gauges on reference blocks and a reference site shall be performed in accordance with CMM 8-15. Nuclear gauge readings and pavement cores shall be used to determine nuclear gauge correlation in accordance with Appendix A. The two readings per location per gauge shall be averaged. The readings for the five locations across the mat for each of two zones shall be provided to the engineer. The engineer will analyze the readings of each gauge relative to the densities of the cores taken at each location. The engineer shall determine the average difference between the nuclear gauge density readings and the measured core densities to be entered into the gauge as a constant offset value. This offset is to be used to adjust raw density readings for the specific gauge for the remainder of the project and shall appear on the density data sheet along with gauge and project identification. An offset is specific to the mix and layer, and therefore a separate value shall be determined for each layer of each mix of the project. This constitutes correlation of that individual gauge. Each team must have two gauges correlated at the time of the test strip. Any data collected by a team without an acceptable gauge (i.e., correlated during test strip) will not be accepted.

The contractor is responsible for coring of the pavement. Coring and filling of core holes must be approved by the engineer. The QV team is responsible for the labeling and safe transport of the cores from the field to the QC laboratory. Testing of cores shall be conducted by the contractor and witnessed by department personnel. The contractor is responsible for drying the cores following testing. The department will take possession of cores following initial testing and will be responsible for any verification testing.

Each core 100 or 150 mm (4 or 6 inches) in diameter shall be taken at locations identified in Section C.1.1 [Appropriate core diameter shall be selected based on layer thickness and shall be decided at the prepave meeting and remain consistent for the duration of the project.] Each random core shall be full thickness of the layer being placed. Thoroughly dry cores obtained from the mat in accordance with ASTM D 7227 prior to using specimens for in-place density determination in accordance with AASHTO T 166.

All core holes shall be filled with non-shrink grout or HMA. When using rapid hardening mortar or concrete, all water shall be removed from the core holes prior to filling and the mortar or concrete shall be mixed in a separate container prior to placement in the hole. If HMA is used, fill all core holes with hot-mix matching that day's production mix type at that day's compaction temperature +/- 20F. The core holes shall be dry and coated with tack before filling, filled with a minimum of two layers (single layer allowed for pavement layers $\leq$ 2 inches in thickness), and compacted with a Marshall hammer or similar tamping device using approximately 50 blows per layer. The finished surface shall be flush with the pavement surface. Any deviation in the surface of the filled core holes greater than 1/4 inch at the time of final inspection will require removal of the fill material to the depth of the layer thickness and replacement.

All laboratory and field testing associated with the test strip shall be completed the same day as paving of the test strip. All test reports shall be submitted to the department upon completion, and approved before paving resumes. The department will notify the contractor by the end of the day regarding approval to proceed with paving beyond the test strip.

C.1.1.2 Laboratory Tests
Material shall be collected from trucks at the plant according to the frequency described in section C.1.1 above. Sample sizes shall be consistent with the minimums for a three-way split as shown below:

Mixture NMAS	Sample Size
≤ 12.5mm (1/2")	105 lb
19.0mm - 25.0mm (3/4" – 1")	150 lb
≥ 37.5mm (1-1/2")	240 lb

Bulk specific gravities shall be determined for cores in accordance with AASHTO T 166. The bulk specific gravity values determined from field cores shall be used to calculate a correction factor (i.e., offset) for the QC and QV nuclear density gauges to be used throughout the remainder of the project. QC and QV teams may wish to scan with additional gauges at the locations detailed in C.1.1 above, as only gauges used during the test strip correlation phase will be allowed on the remainder of the project.

C.2 Acceptance
Conform to the following limits based on individual QC and QV test results (tolerances based on initial JMF/mix design):

ITEM	CONFORMANCE LIMITS
Percent passing given sieve:	
37.5-mm	+/- 8.0
25.0-mm	+/- 8.0
19.0-mm	+/- 7.5
12.5-mm	+/- 7.5
9.5-mm	+/- 7.5
2.36-mm	+/- 7.0
75-µm	+/- 3.0
Asphaltic content in percent	- 0.5
Air Voids	+/- 2.0%
VMA in percent[1]	- 1.0
Maximum specific gravity	+/- 0.024

[1] VMA limits based on minimum requirement for mix design nominal maximum aggregate size in table 460-1.

QV test results will be determined for air voids and VMA, Gmm, and Gmb, and AC Content.
Compact all layers of test strip HMA mixture to the applicable density shown in the following table:

	MIXTURE TYPE	
LAYER	LT & MT	HT
LOWER	91.5[1]	92.0[2]
UPPER	91.5	92.0

[1] Minimum reduced by 2.0 percent for a lower layer constructed directly on crushed aggregate or recycled base courses.

[2] Minimum reduced by 1.0 percent for lower layer constructed directly on crushed aggregate or recycled base courses.

Differences between the QC and QV split sample test results are acceptably identified by conducting a paired t-test in accordance with the WisDOT PWL Analysis Template.

If QC and QV test results do not correlate as determined by the paired t-test, the retained split sample will be tested by the bureau's AASHTO accredited laboratory and certified personnel as a referee test. Any referee test results will be used for subsequent calculations and material acceptance. Additional investigation shall be conducted to identify the source of the difference between QC and QV data. QV or referee data will be used to determine material acceptance and pay.

Nuclear density gauges are acceptable for use on the project only if correlation is completed for that gauge during the time of the test strip and the department issues documentation of acceptance stating the correlation offset value specific to the gauge and the mix design. The documentation must accompany the gauge any time the gauge appears on the project and the department may confirm at any time that the offset value being used matches that documented.

The core densities collected from the 10 locations of the test strip and the QV results from the three split samples will be used to determine material acceptance and pay. The PWL value is calculated in accordance with Appendix A.

A PWL value for air voids and density shall be calculated after completion of the testing. An acceptable test strip is defined as the individual PWL values for air voids and density are both above 75 or the average of the two are above 80. Full production may not continue until an acceptable test strip has been completed. If a PWL value on the test strip is below 50, the material is considered nonconforming and the test strip is unacceptable. If the material is allowed to remain in place, a second test strip shall be constructed. If the material is determined to be removed and replaced, a new test strip will replace the previous one at no additional cost to the department. If a PWL value is between 50 and 75, the material is considered conforming, although a second test strip will need to be constructed. If the second test strip is not acceptable as defined above, it shall be removed and replaced. A maximum of two test strips may be left in place on the project. Additional guidance on test strip and material acceptance is found in Appendix A.

PWL Value	Test Strip & Material Acceptance
>75 (individual) & 80 (combined)	Material conforms, Test Strip is acceptable
50 < PWL < 75	Material conforms, Test Strip is not acceptable*
< 50	Material nonconforming, may be removed & replaced, Test Strip not acceptable*

* A maximum of two test strips may be left in place on the project.

D Measurement

The department will measure Hot Mix Asphalt Percent Within Limits (PWL) Test Strip as a lump sum unit of work, acceptably completed as passing the required air void, VMA, asphalt content, gradation, and density tests for a Test Strip only. Material quantities shall be determined in accordance with standard spec 450.4 and detailed here within.

E Payment

Pay adjustments will be calculated using a unit price of 80 dollars per ton of HMA pavement. The department will pay for measured quantities of mix based on the unit price multiplied by the following pay adjustment calculated in accordance with Appendix A:

PAY ADJUSTMENT FOR HMA PAVEMENT AIR VOIDS & DENSITY

PERCENT WITHIN LIMITS (PWL)	*PAYMENT FACTOR, PF (percent of contract price)*
> 90 to 100	PF = ((PWL – 90) * 0.4) + 100
≥ 50 to 90	(PWL * 0.5) + 55
<50	50%[1]

where,

PF is calculated per air voids and density, denoted $PF_{air\ voids}$ & $PF_{density}$

[1] Any material resulting in PWL value of 50 or less shall be removed and replaced, unless the engineer allows for such material to remain in place. In the event the material remains in place, it will be paid at 50% of the above stated unit price of 80 dollars per ton of HMA pavement.

For air voids, PWL values will be calculated using lower and upper specification limits of 2.7 and 5.3 percent, respectively. Lower specification limits for density will be in accordance with Table 460-3. Pay adjustment will be determined for an acceptably completed test strip and will be computed as shown in the following equation.

Pay Adjustment = (PF-100)/100 x (WP) x (tonnage) x (unit price)

The following weighted percentage (WP) values will be used for the corresponding parameter:

Parameter	WP
Air Voids	0.5
Density	0.5

Individual Pay Factors for each air voids ($PF_{air\ voids}$) and density ($PF_{density}$) will be determined. $PF_{air\ voids}$ will be multiplied by the total tonnage produced, and $PF_{density}$ will be multiplied by the tonnage used to pave the mainline only (i.e., excluding shoulder) as calculated in accordance with CMM 8-15.

The department will pay incentive for air voids and density under the following bid items:

ITEM NUMBER	DESCRIPTION	UNIT
460.2000	Incentive Density HMA Pavement	DOL
460.2010	Incentive Air Voids HMA Pavement	DOL

The department will administer disincentives under the Disincentive Density HMA Pavement and the Disincentive Air Voids HMA Pavement administrative items.

The department will pay for Hot Mix Asphalt Percent Within Limits (PWL) Test Strip work at the contract unit price under the following bid item:

ITEM NUMBER	DESCRIPTION	UNIT
SPV.0105.03	Hot Mix Asphalt Percent Within Limits (PWL) Test Strip	LS

Payment for Hot Mix Asphalt Percent Within Limits (PWL) Test Strip is full compensation for providing HMA mixture designs; for preparing foundation; for furnishing, preparing, hauling, mixing, placing, and compacting mixture; for volumetric and density testing and aggregate source testing; for asphalt binder from recycled sources, and for warm mix asphalt additives or processes.

33. HMA Pavement Percent Within Limits QMP

A Description

This special provision describes the data collection, statistical analysis, and procedure used for determination of pay adjustments for HMA pavement using Percent Within Limits (PWL) specification methodology. Pay adjustments will be made for the properties of air voids and density.
This special provision describes PWL pay determination, providing and maintaining a contractor Quality Control Program, department Quality Verification Program, required sampling and testing, dispute resolution, corrective action, pavement density, and payment for HMA pavements. Pay is determined by statistical analysis performed on contractor and department results conducted according to the Quality Control Program and Quality Verification Program as specified in standard spec 460 and modified here within.

The Quality Management Program (QMP) detailed in standard spec 460.2.8 is supplemented by this article.

B Materials

Conform to the requirements of standard specs 450, 455, and 460 except where superseded by this special provision. The department will allow only one mix design for each type of mix required for the project unless approved by the engineer. The use of more than one mix design for each HMA pavement layer will require the contractor to construct a new test strip.

Replace standard spec 460.2.8.2.1.3.1 for contracts with 5000 Tons of Mixture or Greater with the following Contracts under Percent Within Limits to require a 3-way split, modify retained sample procedure, add ignition oven for AC determination for information, and modify lot and sublot sizes:

460.2.8.2.1.3.1 Contracts under Percent within Limits

(1) Furnish and maintain a laboratory at the plant site fully equipped for performing contractor QC testing. Have the laboratory on-site and operational before beginning mixture production.

(2) Obtain random samples and perform tests according to Appendix A Test Methods & Sampling for PWL QMP HMA Pavements. Obtain HMA mixture samples from trucks at the plant. The QV-split acts as the QC sample for a sublot where a QV sample is taken. For the sublot in which a QV sample is collected, the QC sample shall be discarded, and the QC team shall test the QV-split in its place.

(3) The department will retain the split portion(s) of the contractor HMA mixture and blended aggregate samples. The department will take possession of retained samples collected to date each day QV samples are collected. Samples shall be labeled in accordance with Appendix A. Additional handling instructions for retained samples are found in CMM 8-36.

(4) Use the test methods identified below, or other methods the engineer approves, to perform the following tests at a frequency greater than or equal to that indicated:

Blended aggregate gradations:
Field extraction by CMM 8-36 WisDOT Test Method or ignition oven according to AASHTO T 308.
Asphalt content (AC) in percent
AC by calculation.
AC by nuclear gauge reading, optional.
AC by inventory, optional.

AC by ignition oven according to AASHTO T 308 (required, but informational only)
Bulk specific gravity of the compacted mixture according to AASHTO T166.
Maximum specific gravity according to AASHTO T209.
Air voids (V_a) by calculation according to AASHTO T269.
VMA by calculation according to AASHTO R35.

(5) Test each design mixture at a frequency of 1 test per 750 tons of mixture produced and placed on the project. Add a random sample for any fraction of 750 tons at the end of a project. Lot size will consist of 3750 tons with sublots of 750 tons. Partial lots with less than three sublot tests shall be included into the previous lot.

(6) Also conduct field tensile strength ratio tests according to ASTM D4867 on all mixtures requiring an antistripping additive. Test each full 50,000 ton production increment, or fraction of an increment, after the first 5000 tons of production. Perform required increment testing in the first week of production of that increment. If field tensile strength ratio values are either below the spec limit or less than the mixture design JMF percentage value by 20 or more, notify the engineer. The engineer and contractor will jointly determine a corrective action.

Delete standard spec 460.2.8.2.1.5 and 460.2.8.2.1.6

Replace standard spec 460.2.8.2.1.7 Corrective Action with the following to add stop criteria and individual test tolerances:

460.2.8.2.1.7 Corrective Action

(1) Material must conform to the following action limits based on individual QC and QV test results (tolerances relative to JMF):

ITEM	ACTION LIMITS	CONFORMANCE LIMITS
Percent passing given sieve:		
37.5-mm	+/- 8.0	
25.0-mm	+/- 8.0	
19.0-mm	+/- 7.5	
12.5-mm	+/- 7.5	
9.5-mm	+/- 7.5	
2.36-mm	+/- 7.0	
75-µm	+/- 3.0	
Asphaltic content in percent	- 0.5	
Air Voids		+/- 2.0%
VMA in percent[1]	- 0.5	-1.0

[1] VMA limits based on minimum requirement for mix design nominal maximum aggregate size in table 460-1.

(2) QV test results will be determined for air voids, VMA, Gmm, and Gmb, and AC Content

(3) If any individual test results fall outside the action limits, notify the engineer, investigate the cause, and take corrective action to return to within limits. If two consecutive test results fall outside the action limits, stop production. Production may not resume until approved by the engineer. An additional QV sample may be collected upon resuming production, at the discretion of the engineer. Any additional QV tests must meet the tolerances of the action limits or be subject to additional stoppage and/or remove and replace.

(4) For any additional tests outside the random number testing conducted for density or volumetrics, the data collected will not be entered into PWL calculations. However, additional QV testing shall meet the tolerances for material acceptance as specified in the Standard Specification and this document. If additional density data identifies nonconforming material, proceed in accordance with CMM 8-15.11.

(5) Remove and replace nonconforming material at no additional expense to the department. The engineer may allow nonconforming material to remain in place. The department will pay for the nonconforming HMA Pavement that remains in place at 50 percent of the contract price. Nonconforming material is defined as individual QC or QV tests resulting in material outside of the conformance limits or a PWL value < 50.

Delete standard spec 460.2.8.2.2

Replace standard spec 460.2.8.3.1.2 with the following:

(1) The department will provide at least one HTCP-certified HMA technician, certified at a level appropriate for sampling and mixture production control testing, to observe QV sampling of project mixtures.

(2) Under departmental observation, a contractor HMA technician certified at a level appropriate for sampling and mixture production control testing will collect and split samples.

(3) For QV testing, a department HMA technician certified at a level appropriate for sampling and mixture production control testing will ensure that all sampling is performed correctly and conduct testing, analyze test results, and post resulting data.

(4) The department will make an organizational chart available at the testing laboratory and to the contractor before mixture production begins. The department's chart will include names, telephone numbers, and current certifications of all QV testing personnel. The department will update the chart with appropriate changes, as they become effective.

Replace standard spec 460.2.8.3.1.4 with the following to require and explain 3-way split testing, add ignition oven for QV tests, and define QV frequency.

(1) HTCP-certified department personnel will obtain random samples by directly supervising HTCP-certified contractor personnel sampling from trucks at the plant. Sample size must be adequate to run the appropriate required tests in addition to one set of duplicate tests that may be required for dispute resolution (i.e., retained). This requires sample sizes which accommodate a three-way split for all random sampling per sublot. All QC samples shall provide the following: QC, QC-split, and QC-retained. All QV samples shall provide the following: QV, QV-split, and QV-retained. The contractor will take possession and test the QC and QV-split portions. The engineer will observe the splitting and take possession of the samples intended for QV testing (i.e., QV and QC-split) and the retained portions. Additional sampling details are found in Appendix A.

(2) The department will verify product quality using the test methods enumerated here in 460.2.8.3.1.4(2), other engineer-approved methods, or other methods the industry and department HMA technical team recognizes. The department will identify test methods before construction starts and use only those methods during production of that material unless the engineer and contractor mutually agree otherwise.

(3) The department will perform all testing conforming to the following standards:

Bulk specific gravity (Gmb) of the compacted mixture according to AASHTO T166.
Maximum specific gravity (Gmm) according to AASHTO T209.
Air voids (Va) by calculation according to AASHTO T269.
VMA by calculation according to AASHTO R35.
AC by ignition oven according to AASHTO T 308 (required, but informational only)

(4) The department will randomly test each design mixture at the minimum frequency of one test for each lot (Normal lot size is 3750 tons).

Delete standard spec 460.2.8.3.1.6

Replace standard spec 460.2.8.3.1.7 Dispute Resolution with the following Data Acceptance for Volumetrics to define statistical analysis and dispute resolution process:

460.2.8.3.1.7 Data Acceptance for Volumetrics

(1) Acceptance of test data for pay determination will be contingent upon test results from both the contractor (QC) and the department (QV). Statistical analysis will be conducted on maximum specific gravity (Gmm) and bulk specific gravity (Gmb) data. The analysis determines the appropriate Gmm and Gmb to be used to calculate air voids. If either Gmm or Gmb result in non-comparable data as described in 460.2.8.3.1.7(2), the subsequent testing will be performed for both parameters.

(2) The engineer, upon completion of the lot, will compare the variances (F-test) and the means (t-test) of the verification test results with the quality control test results. If the F- and t-tests report comparable, the QC and QV data sets are determined to be statistically similar and QC data will be used to calculate air voids which in turn are used for PWL and pay adjustment calculations. If the F- and t-tests result in non-comparable data, proceed to the *dispute resolution* steps found below. Dispute resolution via further investigation is as follows:

[1] The QV-retained portion of the split from the most recent lot in the analysis window (specifically the sublot which triggered the warning that variances or means do not compare) shall be referee tested by the bureau's AASHTO accredited laboratory and certified personnel. This referee test result will replace the QV data of the sublot.

[2] A secondary statistical analysis shall be conducted inclusive of the referee test result. If The F- and t-tests now indicate that variances and means compare, no further testing is needed for the lot as QC data is determined to be appropriate to carry forward into subsequent calculations.

[3] If, however, the secondary statistical analysis inclusive of the referee test result yields an F- or t-test indicating non-comparable variances or means, the QC-splits will be tested by the department’s regional lab for the remaining 4 sublots of the lot which generated the warning. This data shall be used with the initial referee test result in subsequent calculations.

[4] The contractor may choose to *dispute* the QC-split data collected on a lot basis. In this event, the QC-retained portion of each sublot shall be referee tested by the bureau's AASHTO accredited laboratory and certified personnel and the referee test results will supersede the regional results for the disputed lot. Dispute resolution testing shall include both Gmm and Gmb, i.e., not solely the individual parameter causing the warning.

[5] If the referee testing results in an increased calculated pay factor, the department will absorb the cost of the additional referee testing.

[6] If the additional referee testing of a disputed lot results in a lower calculated pay factor, the contractor pays for the additional referee testing.

[7] The cost of referee testing is $2000/lot.

(3) The department will notify the contractor of the referee test results within 3 working days after receipt of the samples by the bureau's AASHTO accredited laboratory. The intent is to provide referee test results within approximately 7 calendar days from completion of the lot.

(4) The department will determine mixture conformance and acceptability by analyzing referee test results, reviewing mixture project data, and inspecting the completed pavement all according to Standard Spec, this document, and accompanying Appendices.

(5) Nonconforming mix (i.e., resulting in a PWL value less than 50 or not meeting the requirements of 460.2.8.2.1.7 as modified here within) may be subject to remove and replace, at the discretion of the engineer. Replacement may be conducted on a sublot basis. If an entire PWL sublot is removed and replaced, the test results of the newly placed material shall replace the original data for the sublot. Any remove and replace shall be performed at no additional cost to the department. If the engineer approves the nonconforming material to remain in place, it will be paid at 50% of the HMA Pavement

contract price. (See the *About* worksheet of the WisDOT PWL Analysis Template for additional information regarding Dispute Resolution.)

Delete standard spec 460.2.8.3.1.8 Corrective Action.

C Construction

Replace standard spec 460.3.3.2 Pavement Density Determination with the following to define lot sizes and locations of density testing:

460.3.3.2 Pavement Density Determination

(1) The engineer will determine the target maximum density using department procedures described in CMM 8-15. The engineer will determine density as soon as practicable after compaction and before placement of subsequent layers or before opening to traffic.

(2) Do not re-roll compacted mixtures with deficient density test results. Do not operate continuously below the specified minimum density. Stop production, identify the source of the problem, and make corrections to produce work meeting the specification requirements.

(3) A lot is defined as 7500 lane feet with sublots of 1500 lane feet (excluding shoulder, even if paved integrally) and placed within a single layer for each location and target maximum density category indicated in table 460-3. The contractor is required to complete 15 QC tests per complete lot (3 randomly per sublot) and the department will randomly conduct one (1) QV test per sublot. A partial quantity less than 1500 lane feet will be included with the previous sublot at the end of the project. Partial lots with less than three sublots shall be included into the previous lot. [Exclusions such as shoulders and appurtenances shall be tested in accordance with CMM 8-15. However, all acceptance testing of shoulders and appurtenances will be conducted by the department.]

(4) The three QC locations per sublot will represent the outside, middle, and inside of the paving lane (i.e., the lane width will be divided into thirds as shown in Appendix A and random numbers will be used to identify the specific transverse location within each third in accordance with CMM 8-15). Each location will be measured with two one-minute gauge readings oriented 180 degrees from one another, in the same footprint as detailed in Appendix A. Each location will be the average of the two readings. If the two readings are not within +/- 1.0 lb/ft^3 of one another, a third reading shall be conducted at either orientation. In this event, all three readings shall be averaged, discard the initial of the three readings which falls farthest from the average value and then average the remaining two values to represent the location for the gauge. Multiple locations are not to be averaged together.

(5) QV nuclear testing will consist of a randomly selected location per sublot. The QV is also comprised of two one-minute readings, averaged as described in (4) above.

(6) A certified nuclear density technician shall locate samples and perform the testing. The responsible certified technician shall ensure that sample location and testing is performed correctly, analyze test results, and provide density results to the contractor weekly, at the completion of each lot.

Replace standard spec 460.3.3.3 Waiving Density Testing with Acceptance of Density Data to define statistical analysis and dispute resolution:

460.3.3.3 Acceptance of Density Data

(1) Acceptance of test data for pay determination will be contingent upon test results from both the contractor (QC) and the department (QV).

(2) The engineer, upon completion of the lot, will compare the variances (F-test) and the means (t-test) of the verification test results with the quality control test results. If the F- and t-tests indicate variances and means compare, the QC and QV data sets are determined to be statistically similar and QC data will be used for PWL and pay adjustment calculations.

(3) If the F- and t-tests indicate variances and means compare, QC data is determined to be appropriate to carry forward into subsequent calculations. If the F- and t-tests indicate variances or means do not compare, the QV data will be used for subsequent calculations.

(4) The department will determine mixture density conformance and acceptability by analyzing test results, reviewing mixture project data, and inspecting the completed pavement all according to Standard Spec, this document, and accompanying Appendices.

(5) Nonconforming mix (i.e., resulting in a PWL value less than 50 or not meeting the requirements of 460.3.3.1) may be subject to remove and replace, at the discretion of the engineer. Replacement may be conducted on a sublot basis. If an entire PWL sublot is removed and replaced, the test results of the newly placed material shall replace the original data for the sublot. Any remove and replace shall be performed at no additional cost to the department. If the engineer approves the nonconforming material to remain in place, it will be paid for at 50% of the HMA Pavement contract price.

D Measurement

The department will measure the HMA Pavement bid items acceptably completed by the ton as specified in standard spec 450.4 and as follows in standard spec 460.5 as modified here within.

E Payment

Replace standard spec 460.5.2 HMA Pavement with the following to add payment for PWL:

460.5.2 HMA Pavement

460.5.2.1 General

(1) Payment for HMA Pavement Type E-0.3, E-1, E-3, E-10, E-30, and E-30X mixes is full compensation for providing HMA mixture designs; for preparing foundation; for furnishing, preparing, hauling, mixing, placing, and compacting mixture; for QMP testing and aggregate source testing; for warm mix asphalt additives or processes; for stabilizer, hydrated lime and liquid antistripping agent, if required; and for all materials including asphaltic materials.

(2) If provided for in the plan quantities, the department will pay for a leveling layer, placed to correct irregularities in an existing paved surface before overlaying, under the pertinent paving bid item. Absent a plan quantity, the department will pay for a leveling layer as extra work.

460.5.2.2 Calculation of Pay Adjustment for HMA Pavement using PWL

(1) Pay adjustments will be calculated using a unit price of 80 dollars per ton of HMA pavement. The analysis template, including data, will be provided to the contractor by the department as soon as practicable upon completion of each lot. The department will pay for measured quantities of mix based on the unit price multiplied by the following pay adjustment calculated in accordance with the *Calculations* worksheet of the WisDOT PWL Analysis Template:

PAY FACTOR FOR HMA PAVEMENT AIR VOIDS & DENSITY

PERCENT WITHIN LIMITS (PWL)	*PAYMENT FACTOR, PF (percent of contract price)*
> 90 to 100	PF = ((PWL – 90) * 0.4) + 100
≥ 50 to 90	(PWL * 0.5) + 55
<50	50%[1]

where PF is calculated per air voids and density, denoted $PF_{air\ voids}$ & $PF_{density}$

[1] Any material resulting in PWL value of 50 or less shall be removed and replaced unless the engineer allows for such material to remain in place. In the event the material remains in place, it will be paid at 50% of the above stated unit price of 80 dollars per ton of HMA pavement.

For air voids, PWL values will be calculated using lower and upper specification limits of 2.7 and 5.3 percent, respectively. Lower specification limits for density shall be in accordance with Table 460-3. Pay adjustment will be determined on a lot basis and will be computed as shown in the following equation.

Pay Adjustment = (PF-100)/100 x (WP) x (tonnage) x (unit price)

The following weighted percentage (WP) values will be used for the corresponding parameter:

Parameter	WP
Air Voids	0.5
Density	0.5

Individual Pay Factors for each air voids ($PF_{air\ voids}$) and density ($PF_{density}$) will be determined. $PF_{air\ voids}$ will be multiplied by the total tonnage produced, and $PF_{density}$ will be multiplied by the tonnage used to pave the mainline only (i.e., excluding shoulder) as calculated in accordance with CMM 8-15.

The department will pay incentive for air voids and density under the following bid items:

ITEM NUMBER	DESCRIPTION	UNIT
460.2000	Incentive Density HMA Pavement	DOL
460.2010	Incentive Air Voids HMA Pavement	DOL

The department will administer disincentives under the Disincentive Density HMA Pavement and the Disincentive Air Voids HMA Pavement administrative items.

Note: PWL value determination is further detailed in the *Calculations* worksheet of the WisDOT PWL Analysis Template.

Appendix A

TEST Methods & Sampling for PWL QMP HMA Pavements

TEST Methods & Sampling for PWL QMP HMA Pavement.

The following are included as incidental to the HMA Pavement Percent Within Limits Quality Management Program (PWL QMP) special provision:

- WisDOT Test Strip for Nuclear Gauge/Core Correlation
- WisDOT Test Method for PWL QMP Density Measurements for Main Production
- Sampling for WisDOT PWL QMP

WisDOT Test Strip for Nuclear Gauge/Core Correlation

The engineer is responsible for identifying the two zones in which gauge/core correlation is to be performed. These two zones are to be randomly selected within each of two sublots of the 750 ton test strip. Test strip sublots 1 and 2 are identified as between 50-400 tons and 401-750 tons, respectively.

Required field tests include contractor quality control (QC) and department quality verification (QV) nuclear density gauge tests and pavement coring. Each zone shall consist of five (5) locations across the mat as identified in Figure 1. The following shall be determined at each of the five locations within both zones:

- two one-minute nuclear density gauge readings for QC team*
- two one-minute nuclear density gauge readings for QV team*
- one pavement core sample

*If the two readings performed with the same gauge by the same team are not within +/- 1.0 lb/ft^3 of one another, a third reading shall be conducted. In this event, all three readings shall be averaged, discard the initial of the three readings which falls farthest from the average value and then average the remaining two values to represent the location for the gauge.

This appears as follows, in the field:

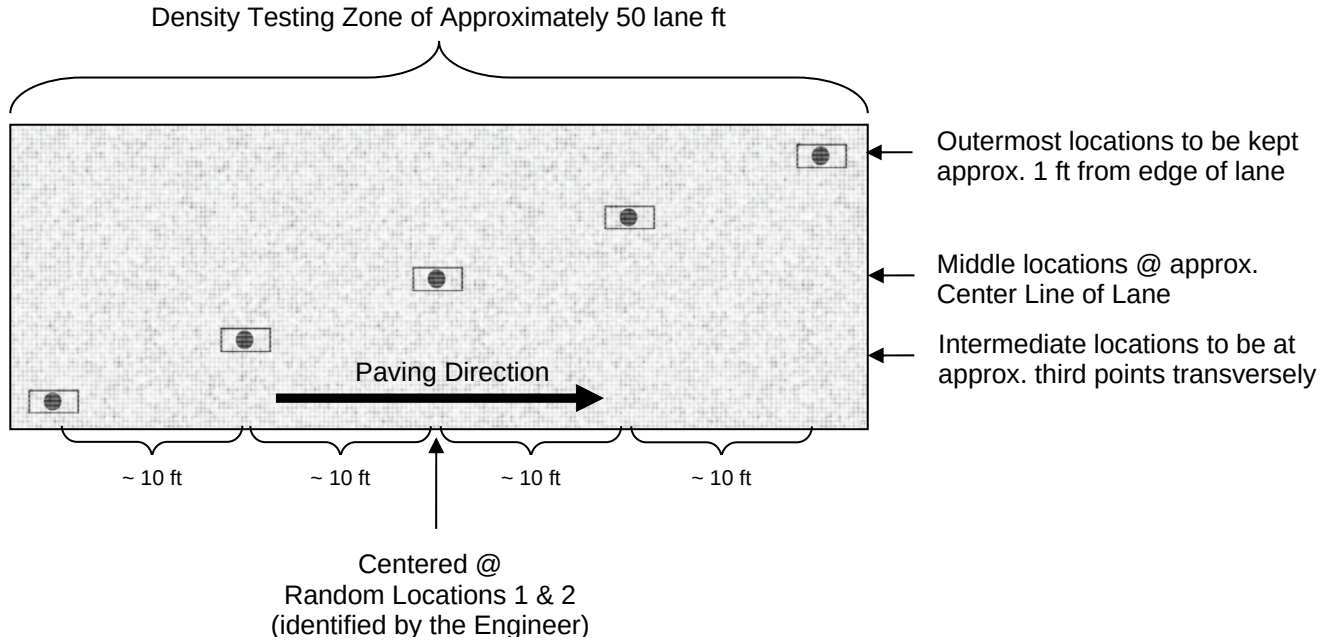
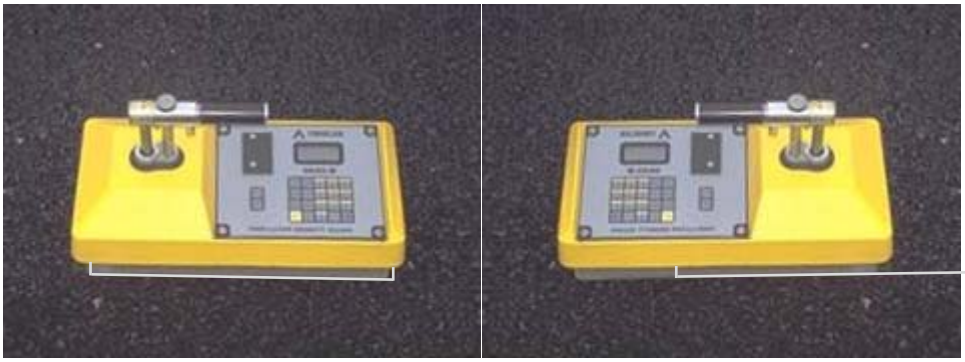


Figure 1: Nuclear/Core correlation locations depicted

Individual locations are represented by the  symbol as seen in Figure 1 above. The symbol is two-part, comprised of the nuclear test locations and the location for coring the pavement, as distinguished here:

The nuclear site is the same for QC and QV readings for the test strip, i.e., the QC and QV teams are to take nuclear density gauge readings in the same footprint. Each of the QC and QV teams are to take two one-minute readings per nuclear site, with the gauge rotated 180 degrees between readings, as seen here:



(a) (b)

Figure 2: Nuclear gauge orientation for (a) 1st one-minute reading and (b) 2nd one-minute reading

The core shall then be taken from the center of said footprint to be used to correlate each gauge with laboratory measured bulk specific gravities of the pavement cores. One core in good condition must be obtained from each of the 10 locations. If a second core is needed, it shall be obtained from within the same gauge footprint. The contractor is responsible for coring of the pavement. Coring and filling of core holes must be approved by the engineer. The QV team is responsible for the labeling and safe transport of the cores from the field to the QC laboratory. Core density testing shall be conducted by the contractor and witnessed by department personnel. The contractor is responsible for drying the cores following testing. The department shall take possession of cores following initial testing and shall be responsible for any verification testing.

Each core 100 or 150 mm (4 or 6 inches) in diameter will be taken at locations identified in Figure 1. [Appropriate core diameter shall be selected based on layer thickness and shall be decided at the prepave meeting and remain consistent for the duration of the project.] Each random core will be full thickness of the layer being placed. The contractor is responsible for thoroughly drying cores obtained from the mat in accordance with ASTM D 7227 prior to using specimens for in-place density determination in accordance with AASHTO T 166.

All core holes shall be filled with non-shrink grout or HMA. When using rapid hardening grout, all water shall be removed from the core holes prior to filling and the mortar or concrete shall be mixed in a separate container prior to placement in the hole. If HMA is used, fill all core holes with hot-mix matching that day's production mix type at that day's compaction temperature +/- 20F. The core holes shall be dry and coated with tack before filling, filled with a minimum of two layers (single layer allowed for pavement layers $\leq$ 2 inches in thickness), and compacted with a Marshall hammer or similar tamping device using approximately 50 blows per layer. The finished surface shall be flush with the pavement surface. Any deviation in the surface of the filled core holes greater than 1/4 inch at the time of final inspection will require removal of the fill material to the depth of the layer thickness and replacement.

The core densities collected from the 10 locations of the test strip and the QV results from the three split samples will be used to determine material acceptance and pay. The PWL value is calculated in accordance with the calculations worksheet in the WisDOT PWL Analysis Template.

A PWL value for air voids and density shall be calculated after completion of the testing. An acceptable test strip is defined as the individual PWL values for air voids and density are both above 75 or the average of the two are above 80. Full production may not continue until an acceptable test strip has been completed. If a PWL value on the test strip is below 50, the material is considered nonconforming and the test strip is unacceptable. If the material is allowed to remain in place, a second test strip shall be constructed. If the

material is determined to be removed and replaced, a new test strip will replace the previous one at no additional cost to the department. If a PWL value is between 50 and 75, the material is considered conforming, although a second test strip will need to be constructed. If the second test strip is not acceptable as defined above, it shall be removed and replaced. A maximum of two test strips may be left in place on the project. Additional guidance on test strip and material acceptance is found in Figure 3.

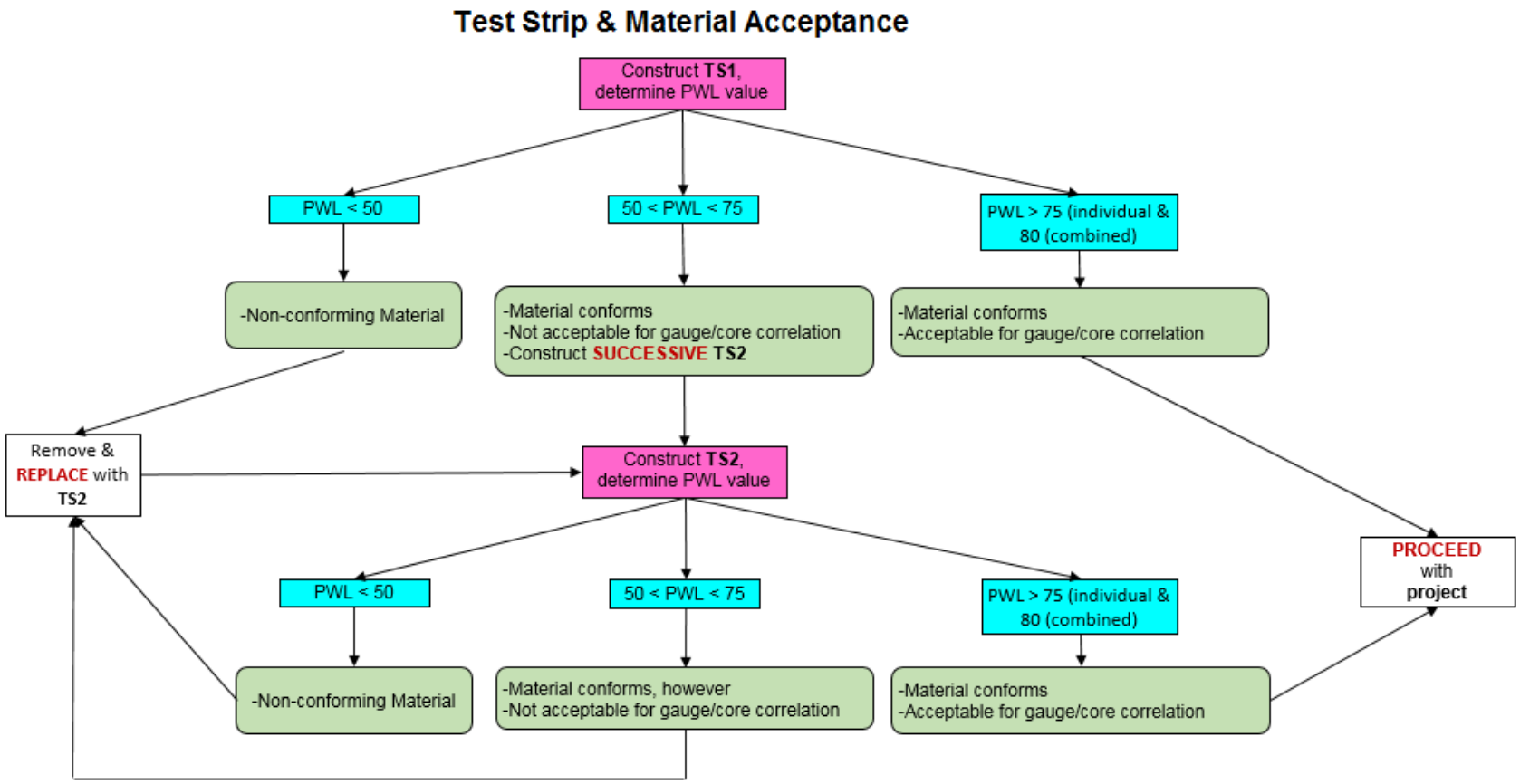
.

PWL Value	Test Strip & Material Acceptance
>75 (individual) & 80 (combined)	Material conforms, Test Strip is acceptable
50 < PWL < 75	Material conforms, Test Strip is not acceptable*
< 50	Material nonconforming, may be removed & replaced, Test Strip not acceptable*

* A maximum of two test strips may be left in place on the project.

All test reports shall be submitted to WisDOT upon completion, and approved before paving resumes. The department shall notify the contractor within as soon as practicable after completion of the test strip regarding approval to proceed with paving beyond the test strip.

Figure 3: Flowchart for guidance of material and test strip acceptance for PWL



FOOTNOTES:
TS1 = First Test Strip
TS2 = Second Test Strip

WisDOT Test Method for PWL QMP Density Measurements for Main Production

For nuclear density testing of the pavement beyond the test strip, QC tests will be completed at three locations per sublot, with a sublot defined as 1500 lane feet. The three locations will represent the outside, middle, and inside of the paving lane (i.e., the lane width will be divided into thirds as shown by the dashed longitudinal lines in Figure 3 and random numbers will be used to identify the specific transverse location within each third in accordance with CMM 8-15). Longitudinal locations within each sublot shall be determined with a second random number. Each location will be measured with two one-minute gauge readings oriented 180 degrees from one another, in the same footprint as detailed above. Each location will be the average of the two readings. Multiple locations are not to be averaged together. QV nuclear testing will consist of randomly selected location per sublot. The QV is also comprised of two one-minute readings. This is depicted as follows, with QC test locations shown as solid lines and QV as dashed.

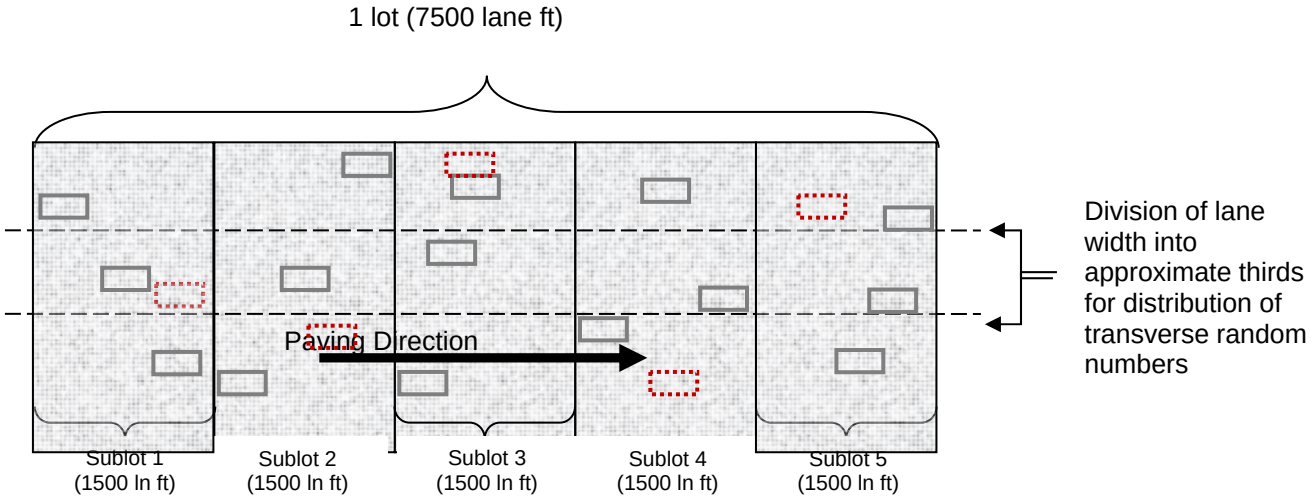


Figure 3: Locations of main lane HMA density testing (QC=solid lines, QV=dashed)

QC and QV nuclear density gauge readings will be statistically analyzed in accordance with the following section of this Appendix. (Note: For density data, if F- and t-tests pass, QC data will be used for the subsequent calculations of PWL value and pay determination. However, if an F- or t-test failure occur, the QV data will be used in subsequent calculations.)

Sampling for WisDOT PWL QMP

Delete CMM 8-36.4 Sampling Hot Mix Asphalt and replace with the following to update sublot tonnages:

Sampling Hot Mix Asphalt

At the beginning of each day the contractor determines the anticipated tonnage to be produced. The frequency of sampling (minimum number of required tests for the day's anticipated production) is defined by the PWL QMP SPV. A test sample is obtained randomly from each sublot.

Example 1

Expected day's production is 2,400 tons. The number of required samples is determined based on this expected production (per PWL QMP SPV) and is determined by the random sample calculation.

Sample 1 – from 50 to 750 tons
Sample 2 – from 751 to 1500 tons
Sample 3 – from 1501 to 2250 tons
Sample 4 – from 2251 to 3000 tons

The approximate location of each sample within the prescribed sublots is determined by selecting random numbers using ASTM Method D-3665 or by using a calculator or computerized spreadsheet that has a random number generator. The random numbers selected are used in determining when a sample is to be taken and will be multiplied by the sublot tonnage. This number will then be added to the final tonnage of the previous sublot to yield the approximate cumulative tonnage of when each sample is to be taken.

To allow for plant start-up variability, the procedure calls for the first random sample to be taken at 50 tons or greater per production day (not intended to be taken in the first two truckloads). Random samples calculated for 0-50 ton should be taken in the next truck (51-75 ton).

Example 2

Required Sample	Sublot Sample Tonnage Range	Random No. ASTM D-3665	Sublot Sample Ton (Random No. x Sublot ton)	End of Previous. Range	Cumulative Sample Tonnage
1	50 - 750	0.572	RN x 750= 429	0	429
2	751 - 1500	0.353	RN x 750= 265	750	1015
3	1501 - 2250	0.656	RN x 750= 492	1500	1992
4	2251-3000	0.251	RN x 750= 188	2250	2438

This procedure is to be used for any number of samples per day.

If the day's production is less than the final randomly generated sample tonnage for that day, then the random sample is to be collected from the remaining portion of that sublot on a subsequent day of production. If the randomly generated sample is calculated to be within the first 0-50 tons of the subsequent day of production, it should be taken in the next truck. Add a random sample for any fraction of 750 tons at the end of the project. Lot size will consist of 3750 tons with sublots of 750 tons. Partial lots with less than three sublot tests shall be included into the previous lot.

It's intended that the plant operator not be advised ahead of time when samples are to be taken. If the plant

operator is involved in recording a Pb (%AC) to match up with the mix sample tonnage, then notification need not be earlier than 60 minutes before the mix sample being taken.

If belt samples are used during troubleshooting, the blended aggregate will be obtained when the mixture production tonnage reaches approximately the sample tonnage. For plants with storage silos, this could be up to 60 minutes in advance of the mixture sample that's taken when the required tonnage is shipped from the plant.

Delete CMM 8-36.4.2.1 through 8-36.4.2.3 and replace with the following PWL (3-way) Split Sample Sizes

PWL (3-way) Split Sample Sizes

- Minimum sample sizes are referenced below and are guidance for meeting requirements for test completion.

Mixture NMAS	Sample Size
≤ 12.5mm (1/2")	105 lb
19.0mm - 25.0mm (3/4" – 1")	150 lb
≥ 37.5mm (1-1/2")	240 lb

- The total sample for larger NMAS (nominal maximum aggregate size) mixtures will be enough to provide the required minimum testing sample size as defined in Figure 3.

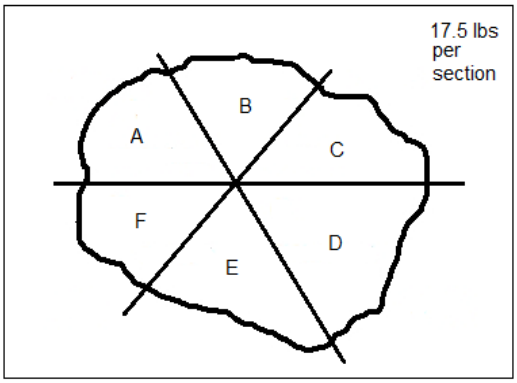
Delete 8-36.5.1.1 Step 1 and replace with the following Initial Splitting of Sample

Initial Splitting of Sample

For QC sample reduction the HMA sample in the containers is mixed and quartered. The quartering process should then proceed as follows:

i. Collect the minimum sample size given in the *PWL Split Sample Size* section above. Split the sample into "Test" and "Retained" samples. Place entire sample on table, quickly re-mix and split to minimize temperature loss. Split the Test & Retained samples as shown on Figure 3. For 1/2" mixes start with at least a total of 105 lbs of HMA.

Figure 3 Superpave Sample for 105 lbs for three-way split for QC, QV, and retained samples



(a) *(b)*

ii. For a three-way split shown in Figure 3, *diagonal sections*, as indicated on the sketch, must be combined to form the QV sample (A+D), retained sample (B+E) and the QC test sample (C+F). The retained sample must be bagged, labeled, and stored in a safe dry place. The retained samples may be tested using the "rule of retained" (see "Definitions" section).

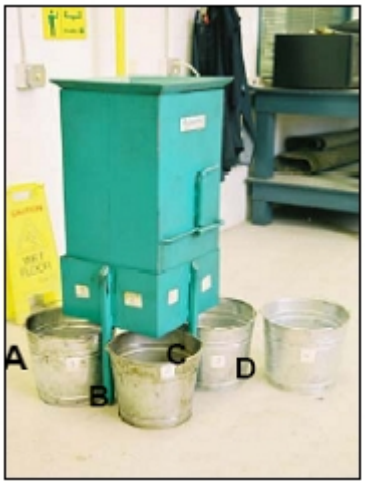
iii. The QC & QV test samples are then further split for the specified tests. Continue the splitting process in *Further Reduction of Samples to Test Sizes* for the test materials until individual samples are in the oven.

Delete CMM 8-36.5.2 Use of Alternative Sampling / Quartering Devices (ex: Quartermaster) and replace with the following:

Use of Alternative Sampling / Quartering Devices (ex: Quartermaster)

Use of other devices to assist in the sampling and splitting procedures may be used with approval of the department. The Quartermaster is one such device. A picture of a Quartermaster device is shown in Figure 6.

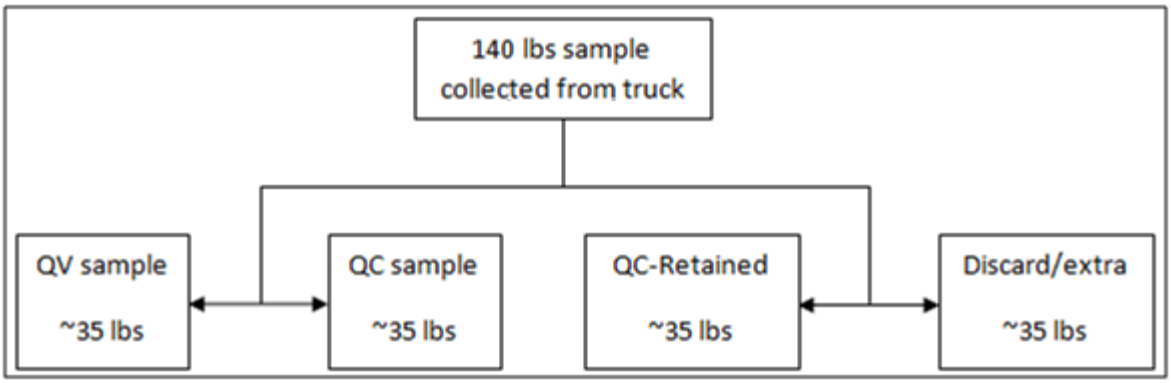
Figure 6 Quartermaster Quartering Device



Example 3

If a quartermaster is used to reduce a three-way split sample into the proper quanitites, it is required to collect approximately 133% the minimum sample size shown in *PWL Split Sample Sizes* (e.g. 133% of 105 is

approximately 140 lbs), use the selected device to split, and discard the extra quadrant of material.



END OF ADDENDUM

CONTRACT: 20160209008

PROJECT(S): 5121-09-63, 5121-09-73, 5820-01-73

FEDERAL ID(S): N/A, N/A, N/A

CONTRACTOR :_____

LINE NO	ITEM DESCRIPTION	APPROX. QUANTITY AND UNITS	UNIT PRICE DOLLARS	UNIT PRICE CTS	BID AMOUNT DOLLARS	BID AMOUNT CTS
0410	460.1101 HMA Pavement Type E-1	42,407.000 TON		.		.
0420	460.2000 Incentive Density HMA Pavement	42,407.000 DOL	1.00000		42407.00	
0430	460.4000 HMA Cold Weather Paving	8,255.000 TON		.		.
0440	460.4110.S Reheating HMA Pavement Longitudinal Joints	82,779.000 LF		.		.
0450	465.0120 Asphaltic Surface Driveways and Field Entrances	325.000 TON		.		.
0460	465.0305 Asphaltic Surface Safety Islands	15.000 TON		.		.
0470	465.0315 Asphaltic Flumes	451.000 SY		.		.
0480	465.0425 Asphaltic Shoulder Rumble Strips 2-Lane Rural	51,642.000 LF		.		.
0490	465.0475 Asphalt Center Line Rumble Strips 2-Lane Rural	41,776.000 LF		.		.
0500	502.0100 Concrete Masonry Bridges	196.000 CY		.		.

CONTRACT:	PROJECT(S):	FEDERAL ID(S):
20160209008	5121-09-63	N/A
	5121-09-73	N/A
	5820-01-73	N/A

CONTRACTOR :_____

LINE NO	ITEM DESCRIPTION	APPROX. QUANTITY AND UNITS	UNIT PRICE DOLLARS	UNIT PRICE CTS	BID AMOUNT DOLLARS	BID AMOUNT CTS
1900	SPV.0195 Special 01. Management of Contaminated Soil	50.000 TON	.			.
1910	460.2010 Incentive Air Voids HMA Pavement	42,407.000 DOL	1.00000		42407.00	
1920	SPV.0105 Special 03. Hot Mix Asphalt Percent Within Limits (PWL) Test Strip	LUMP	LUMP			.
	SECTION 0001 TOTAL					.
	TOTAL BID					.