

**SECTION 02620**  
**HIGH DENSITY POLYETHYLENE (HDPE) PIPE AND FITTINGS**

**PART 1 -- GENERAL**

**1.01 SECTION DESCRIPTION**

This specification includes but is not limited to high-density polyethylene (PE 3408) (ductile iron pipe size O.D) pressure pipe primarily intended for the transportation of water and sewage either buried or above grade.

**1.02 REFERENCES**

Reference:	Title:
AWWA C901	Polyethylene (PE) pressure Pipe & Tubing, ½ inch through 3 inch for water
AWWA C906	Polyethylene (PE) pressure Pipe & Fittings, 4 inch through 63 inch for water
ASTM D3035	Standard Spec for PE Pipe (DR-PR) Based on Controlled Outside Diameter
ASTM D3261	Butt Heat Fusion PE Fittings for PE Pipe & Tubing
ASTM D3350	Standard Specification for PE Pipe & Fittings Materials
ASTM D1238	Melt Flow Index
ASTM D1505	Density of Plastics
ASTM D2837	Hydrostatic Design Basis
NSF Std.#14	Plastic Piping Components & Related Materials
TR-33/2005	Generic Butt Fusion Joining Procedure for Field Joining of PE Pipe

**1.03 GENERAL**

**A. USE**

High Density Polyethylene (HDPE) pipes/fittings shall be allowed for use as water, wastewater and reclaimed water pressure pipe where compatible with the specific conditions of the project. The use of material other than HDPE pipe may be required by FPUA if it is determined that HDPE pipe is unsuitable for the particular application. All material used in the production of water main piping shall be approved by the National Sanitation Foundation (NSF).

**B. DOCUMENTATION**

1. Documentation from the resin's manufacturer showing results of the following tests for resin identification:
  - a. Melt Flow Index ASTM D1238
2. Density ASTM D1505

### **C. MANUFACTURER**

All HDPE pipe and fittings shall be from a single manufacturer, who is fully experienced, reputable and qualified in the manufacture of the HDPE pipe to be furnished. The pipe shall be designed, constructed and installed in accordance with the best practices and methods and shall comply with these Specifications. Qualified manufacturers shall be: PLEXCO Division of Chevron Chemical Company, DRISCOPIPE as manufactured by Phillips Products Co., Inc., SCLAIRPIPE as manufactured by DuPont of Canada or equal as approved by the Utilities Engineer.

### **D. FINISHED PRODUCT EVALUATION**

1. Production staff shall check each length of pipe produced for the items listed below. The results of all measurements shall be recorded on production sheets, which become part of the manufacturer's permanent records.
  - a. Pipe in process shall be checked visually, inside and out for cosmetic defects (grooves, pits, hollows, etc.)
  - b. Pipe outside diameter shall be measured using a suitable periphery tape to ensure conformance with ASTM F714 or ASTM D3035, whichever is applicable.
  - c. Pipe wall thickness shall be measured at 12 equally spaced locations around the circumference at both ends of the pipe to ensure conformance with ASTM F714 or ASTM D3035, whichever is applicable.
  - d. Pipe length shall be measured.
  - e. Pipe marking shall be examined and checked for accuracy.
  - f. Pipe ends shall be checked to ensure they are cut square and clean.
  - g. Subject inside surface to a "reverse bend test" to ensure the pipe is free of oxidation (brittleness).

### **E. STRESS REGRESSION TESTING**

The polyethylene pipe manufacturer shall provide certification that stress regression testing has been performed on the specific polyethylene resin being utilized in the manufacture of this product. This stress regression testing shall have been done in accordance with ASTM D2837 and the manufacturer shall provide a product supplying a minimum Hydrostatic Design Basis (HDB) of 1,600 psi as determined in accordance with ASTM D2837.

### **F. COMPATIBILITY**

Contractor is responsible for compatibility between pipe materials, fittings and appurtenances.

## **G. WARRANTY**

The pipe MANUFACTURER shall provide a warranty against manufacturing defects of material and workmanship for a period of ten years after the final acceptance of the project by the OWNER. The MANUFACTURER shall replace at no expense to the OWNER any defective pipe/fitting material including labor within the warranty period.

## **PART 2 -- PRODUCTS**

### **2.01 MATERIALS FOR PIPE SIZES 4-INCH DIAMETER AND LARGER**

- A.** Materials used for the manufacture of polyethylene pipe and fittings shall be made from a PE 3408 high density polyethylene resin compound meeting cell classification 345434C per ASTM D3350; and meeting Type III, Class C, Category 5, Grade P34 per ASTM D1238.
- B.** High Density Polyethylene (HDPE) pipe shall comply with AWWA Specifications C906.
- C.** If rework compounds are required, only those generated in the Manufacturer's own plant from resin compounds of the same class and type from the same raw material supplier shall be used.
- D.** Dimensions and workmanship shall be as specified by ASTM F714. HDPE fittings and transitions shall meet ASTM D3261. HDPE pipe shall have a minimum density of 0.955 grams per cubic centimeter. All HDPE pipe and fittings shall have a Hydrostatic Design Basis (HDB) of 1,600 psi.
- E.** HDPE pipe and accessories 4-inch diameter and larger, shall be 160 psi at 73.4°F meeting the requirements of Standard Dimension Ration (SDR) 17 as MINIMUM STRENGTH.
- F.** The pipe Manufacturer must certify compliance with the above requirements.

### **2.02 MATERIALS FOR PIPE SIZES 2-INCH DIAMETER AND LESS**

- A.** Materials used for the manufacture of polyethylene pipe and fittings shall be made from a PE 3408 high density polyethylene resin compound meeting cell classification 345434C per ASTM D3350; and meeting Type III, Class C, Category 5, Grade P34 per ASTM D1238.
- B.** High Density Polyethylene (HDPE) pipes shall comply with AWWA Specifications C901.
- C.** If rework compounds are required, only those generated in the Manufacturer's own plant from resin compounds of the same class and type from the same raw material supplier shall be used.
- D.** Dimensions and workmanship shall be as specified by ASTM D3035. HDPE fittings and transitions shall meet ASTM D3261. HDPE pipe shall have a minimum density of 0.955 grams per cubic centimeter. All HDPE pipe and fittings shall have a Hydrostatic Design Basis (HDB) of 1,600 psi.

- E. HDPE pipe and accessories 2" and less in diameter, shall be 160 psi at 73.4°F meeting the requirements of Standard Dimension Ration (SDR) 9 as MINIMUM STRENGTH.
- F. The pipe Manufacturer must certify compliance with the above requirements.

### 2.03 FITTINGS

- A. All molded fittings and fabricated fittings shall be fully pressure rated to match the pipe SDR pressure rating to which they are made. All fittings shall be molded or fabricated by the manufacturer. No Contractor fabricated fittings shall be used unless approved by the Engineer.
- B. The manufacturer of the HDPE pipe shall supply all HDPE fittings and accessories as well as any adapters and/or specials required to perform the work as shown on the Drawings and specified herein.
- C. All fittings shall be installed using butt-fused fittings, thermo-fused fittings/couplings, or flanged adapters and must be approved by the Engineer. NO size on size wet taps shall be permitted.
- D. All transition from HDPE pipe to ductile iron or PVC shall be made per the approval of FPUA Engineer and per the HDPE pipe manufacturer's recommendations and specifications. A molded flange connector adapter within a carbon steel back-up ring assembly shall be used for pipe type transitions. Ductile iron back-up rings shall mate with cast iron flanges per ANSI B16.1. A 316 stainless steel back-up ring shall mate with a 316 stainless steel flange per ANSI B16.1.
  - 1. Transition from HDPE to ductile iron fittings and valves shall be approved by FPUA Engineer before installation.
  - 2. No solid sleeves shall be allowed between such material transitions.
  - 3. Fittings and transitions shall be as manufactured by Phillips DRISCOPIPE, Inc., 1000 Series Pressure Pipe, Chevron Chemical Company Plexco/Spiralite pipe, or equal.
  - 4. The pipe supplier must certify compliance with the above requirements.

### 2.04 PIPE IDENTIFICATION

- A. The following shall be continuously indent printed on the pipe or spaced at intervals not exceeding 5-feet:
  - 1. Name and/or trademark of the pipe manufacturer.
  - 2. Nominal pipe size.
  - 3. Dimension ratio.

4. The letters PE followed by the polyethylene grade in accordance with ASTM
  5. D1248 followed by the hydrostatic design basis in 160's of psi, e.g., PE 3408.
  6. Manufacturing standard reference, e.g., ASTM F714 or D-3035, as required.
  7. A production code from which the date and place of manufacture can be determined.
  8. Color Identification, either stripped by co-extruding longitudinal identifiable color markings or shall be solid in color and as follows:
    - a. BLUE – Potable Water
    - b. GREEN – Sanitary Sewer
    - c. LAVENDER – IQ cover all
- B. Tracing Wire**
1. Open trench installation of HDPE shall be identifiable per FPUA Specification Sec. 02600, Part 2, 2.01 (A).
  2. Directional Drilled HDPE shall have wire conforming to Copperhead Industries Reinforced #1245 Extra-High Strength Tracer Wire and affixed to the drilling head/reamer per Detail M-17.
- C. Marking Tape:** Marking tape shall be installed per FPUA Engineer approval.

## **PART 3 – EXECUTION**

### **3.01 JOINING METHOD**

- A.** The pipe shall be joined with butt, heat fusion joints as outlined in ASTM D2657 and conform to the Generic Butt Fusion Joining Procedure for Field Joining of Polyethylene Pipe, Technical Report TR-33/2005, published by the Plastic Pipe Institute (PPI). All joints shall be made in strict compliance with the manufacturer's recommendations. A factory qualified joining technician as designated by pipe manufacturer or experienced, trained technician shall perform all heat fusion joints in the presence of the FPUA inspector.
- B.** Lengths of pipe shall be assembled into suitable installation lengths by the butt-fusion process. All pipes so joined shall be made from the same class and type of raw material made by the same raw material supplier. Pipe shall be furnished in standard laying lengths not to exceed 50 feet and no shorter than 20 feet.
- C.** On days butt fusions are to be made, the first fusion shall be a trial fusion in the presence of an FPUA Inspector. The following shall apply:

1. Heating plate surfaces shall be inspected for cuts and scrapes and shall be free of dirt and residue. Heater surfaces should be between 400<sup>o</sup>F (minimum) to 450<sup>o</sup>F (maximum). Measure the temperature @ 12:00, 3:00, 6:00 and 9:00 o'clock positions using a pyrometer or infrared thermometer at locations where the heating plate will contact the pipe/fitting ends. The maximum temperature difference between any two points on a single heating surface must not exceed 24<sup>o</sup>F. If this temperature is exceeded, the heating plate shall be cleaned per the manufacturer's recommendations.
  2. The fusion or test section shall be cut out after cooling completely for inspection.
  3. The test section shall be 12" or 30 times (minimum) the wall thickness in length and 1" or 1.5 times the wall thickness in width (minimum).
  4. The joint shall be visually inspected as to continuity of "beads" from the melted material, and for assurance of "cold joint" prevention (i.e. – joint shall have visible molded material between walls of pipe). Joint spacing between the walls of the two ends shall be a minimum of 1/16" to a maximum 3/16".
- D.** The polyethylene flange adapters at pipe material transitions shall be backed up by stainless steel flanges conforming to ANSI B16.1 and shaped as necessary to suit the outside dimensions of the pipe. The flange adapter assemblies shall be connected with corrosion resisting bolts and nuts of Type 316 Stainless Steel as specified in ASTM A726 and ASTM A307. All bolts shall be tightened to the manufacturer's specified torques. Bolts shall be tightened alternatively and evenly. After installation, apply a bitumastic coating to bolts and nuts.

### **3.02 INSTALLATION**

- A.** High Density Polyethylene (HDPE) Pipe shall be installed in accordance with the instruction of the manufacturer, as shown on the Drawings and as specified herein. A factory qualified joining technician as designated by the pipe manufacturer shall perform all heat fusion joints.
- B.** HDPE shall be installed either by Open Trench Construction or Directional Bore Method as outlined in Section 3.02 – Installation, Item Q – Open Trench Installation or Item R – Directional Bore Installation.
- C.** Care shall be taken in loading, transporting and unloading to prevent damage to the pipe. Pipe or fitting shall not be dropped. All pipe or fitting shall be examined before installation, and no piece shall be installed which is found to be defective. Any damage to the pipe shall be repaired as directed by the Engineer. If any defective pipe is discovered after it has been installed, it shall be removed and replaced with a sound pipe in a satisfactory manner by the contractor, at his own expense.
- D.** Under no circumstances shall the pipe or accessories be dropped into the trench or forced through a directional bore upon "pull-back".
- E.** Care shall be taken during transportation of the pipe such that it will not be cut,

kinked or otherwise damaged.

- F.** Ropes, fabric or rubber protected slings and straps shall be used when handling pipes. Chains, cables or hooks inserted into the pipe ends shall not be used. Two slings spread apart shall be used for lifting each length of pipe.
- G.** Pipes shall be stored on level ground, preferably turf or sand, free of sharp objects, which could damage the pipe. Stacking of the polyethylene pipe shall be limited to a height that will not cause excessive deformation of the bottom layers of pipes under anticipated temperature conditions. Where necessary due to ground conditions, the pipe shall be stored on wooden sleepers, spaced suitably and of such width as not to allow deformation of the pipe at the point of contact with the sleeper or between supports.
- H.** Pipe shall be stored on clean level ground to prevent undue scratching or gouging. The handling of the pipe shall be in such a manner that the pipe is not damaged by dragging it over sharp and cutting objects. The maximum allowable depth of cuts, scratches or gouges on the exterior of the pipe is 5 percent of wall thickness. The interior pipe surface shall be free of cuts, gouges or scratches.
- I.** Pipe shall be laid to lines and grade shown on the Drawings with bedding and backfill as shown on the Drawings.
- J.** When laying is not in progress, including lunchtime, the open ends of the pipe shall be closed by fabricated plugs, or by other approved means.
- K.** Sections of pipe with cuts, scratches or gouges exceeding 5 percent of the pipe wall thickness shall be removed completely and the ends of the pipeline rejoined.
- L.** The pipe shall be joined by the method of thermal butt fusion, as outlined in PART 3 – Execution, Section 3.01 Joining Method. All joints shall be made in strict compliance with the manufacturer’s recommendations.
- M.** Mechanical connections of the polyethylene pipe to auxiliary equipment such as valves, pumps and tanks shall be through flanged connections which shall consists of the following:
  - 1. A polyethylene flange shall be thermally butt-fused to the stub end of the pipe.
  - 2. A 316 stainless steel back up ring shall mate with a 316 stainless steel flange.
  - 3. 316 stainless steel bolts and nuts shall be used.
- N.** Flange connections shall be provided with a full-face neoprene gasket.
- O.** All HDPE pipe must be at the temperature of the surrounding soil at the time of backfilling and compaction.
- P.** If a defective pipe is discovered after it has been installed, it shall be removed and replaced with a sound pipe in a satisfactory manner at no additional cost to the Owner. All pipe and fittings shall be thoroughly cleaned before installation, shall be kept clean until they are used in the work and when laid, shall conform to the lines and grades required.

**Q.** Open Trench Installation:

1. FPUA Standards and Specification, Section 02200 – Utility Excavation, Trenching, and Backfilling shall apply in its entirety.
2. The centerline of the pipe shall not deviate from a straight line drawn between the centers of the openings at the ends of the pipe by more than 1/16-in per foot of length. If a piece of pipe fails to meet this requirement check for straightness, it shall be rejected and removed from the site. Laying instructions of the manufacturer shall be explicitly followed.
3. Good alignment shall be preserved during installation. Deflection of the pipe shall occur only at those places on design drawings and as approved by the Engineer. Fittings, in addition to those shown on the Drawings, shall be used only if necessary or required by the Engineer.
4. Each length of the pipe shall have the assembly mark aligned with the pipe previously laid and held securely until enough backfill has been placed to hold the pipe in place. Joints shall not be “pulled” or “cramped”.
5. Precautions shall be taken to prevent flotation of the pipe in the trench.
6. When moveable trench bracing such as trench boxes, moveable sheeting, shoring or plates are used to support the sides of the trench, care shall be taken in placing and moving the boxes or supporting bracing to prevent movement of the pipe, or disturbance of the pipe bedding and the backfill. Trench boxes, moveable sheeting, shoring or plates shall not be allowed to extend below top of the pipe. As trench boxes, moveable sheeting, shoring or plates are moved, pipe bedding shall be placed to fill any voids created and the backfill shall be recompacted to provide uniform side support for the pipe.
7. Restrained joints shall be installed where shown on the Drawings or as directed by the Engineer.

**R.** Directional Bore Installation:

1. Refer to FPUA Specification 02320 - Horizontal Directional Drilling in its entirety.

**3.03 CLEANING**

- A.** At the conclusion of the work, thoroughly clean all of the new pipe lines to remove all dirt, stones, pieces of wood or other material which may have entered during the construction period by forcing a cleaning swab through all mains 4” or greater. Flushing velocities shall be a minimum of 2.5 feet per second. All flushing shall be coordinated with FPUA Inspector and Water Resources

Department. Debris cleaned from the lines shall be removed from the job site.

### **3.04 TESTING**

- A.** Pressure testing shall be conducted per Manufacturer's recommendations and as approved by the FPUA Engineer.
- B.** All HDPE water mains shall be disinfected prior to pressure testing as per FPUA specification, Section 02715, Part 3 - Execution, 3.01 - Disinfection.
- C.** All HDPE mains shall be field-tested. Contractor shall supply all labor, equipment, material, gages, pumps, meters and incidentals required for testing. Each main shall be pressure tested upon completion of the pipe laying and backfilling operations, including placement of any required temporary roadway surfacing.
- D.** All mains shall be tested at 150 percent of the operating design pressure of the pipe unless otherwise approved by the Engineer.
- E.** Pressure testing procedure shall be per Manufacturer's recommendations or as follows:
  - 1. Fill line slowly with water. Maintain flow velocity less than 2 feet per second.
  - 2. Expel air completely from the line during filling and again before applying test pressure. Air shall be expelled by means of taps at points of highest elevation.
  - 3. Apply initial test pressure and allow to stand without makeup pressure for two to three hours, to allow for diametric expansion or pipe stretching to stabilize.
  - 4. After this equilibrium period, apply the specified test pressure and turn the pump off. The final test pressure shall be held for one to three hours.
  - 5. Upon completion of the test, the pressure shall be bled off from a location other than the point where the pressure is monitored. The pressure drop shall be witnessed by the resident project representative and FPUA representative at the point where the pressure is being monitored and shall show on the recorded pressure read-out submitted to the Engineer of Record.
- F.** Allowable amount of makeup water for expansion during the pressure test shall conform to Chart 6, Allowance for Expansion Under Test Pressure, Technical Report TR 31/9-79, published by the Plastic Pipe Institute (PPI). If there are no visual leaks or significant pressure drops during the final test period, the installed pipe passes the test.

- G.** If any test of pipe laid disclosed leakage significant pressure drop greater than the manufacturer's recommended loss, the Contractor shall, at his/her own expense, locate and repair the cause of leakage and retest the line. The amount of leakage, which will be permitted, shall be in accordance with AWWA C600 Standards.
- H.** All visible leaks are to be repaired regardless of the amount of leakage.
- I.** The Contractor must submit his plan for testing to the Engineer for review at least 10 days before starting the test and shall notify FPUA Inspector a minimum of 48 hours prior to test.

**END OF SECTION**