



Recommended General Repair Procedures for Concrete Pipe

Damage during handling may be repaired such that the repaired pipe joint surface upon which the gasket is capable of bearing is smooth, free from spalls, cracks or fractures, and imperfections that would adversely affect the performance of the joint.

The circumferential length of a single area to be repaired should not exceed one fourth of the inside diameter or equivalent diameter of the pipe and the circumferential length of several areas combined to be repaired on one piece should not exceed one half of the inside diameter or equivalent diameter of the pipe.

1. Remove dirt and other foreign matter such that the area to be repaired is clean, sound, and free of contaminants.
2. Saturate the repair surface to SSD (Saturated, Surface-dry) condition, if using a water-based repair material.
3. Follow the manufacturer's instruction for patching/repair, using an approved patching/repair material.
4. Allow repaired unit to cure at least 85% of design strength before moving.

Other repairs may be acceptable upon engineer's approval.

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