National Concrete Consortium Reciprocity Agreement

PORTLAND CEMENTS & BLENDED CEMENTS



Todd Hanson - Iowa DOT Lieska Halsey - Nebraska DOR

National Concrete Consortium September 11, 2014 Omaha, Nebraska

Reciprocity Agreement









National Concrete Consortium (NCC) Cement Reciprocity Agreement is to help unify State Department of Transportation with the Initial Acceptance of Portland and Blended Cements. The intent is to have uniform Department of Transportation procedure to ensure consistency of cement plant acceptance approval source.



Agreement established

Revised
National Concrete Consortium
Reciprocity Agreement

Agreement Benefits

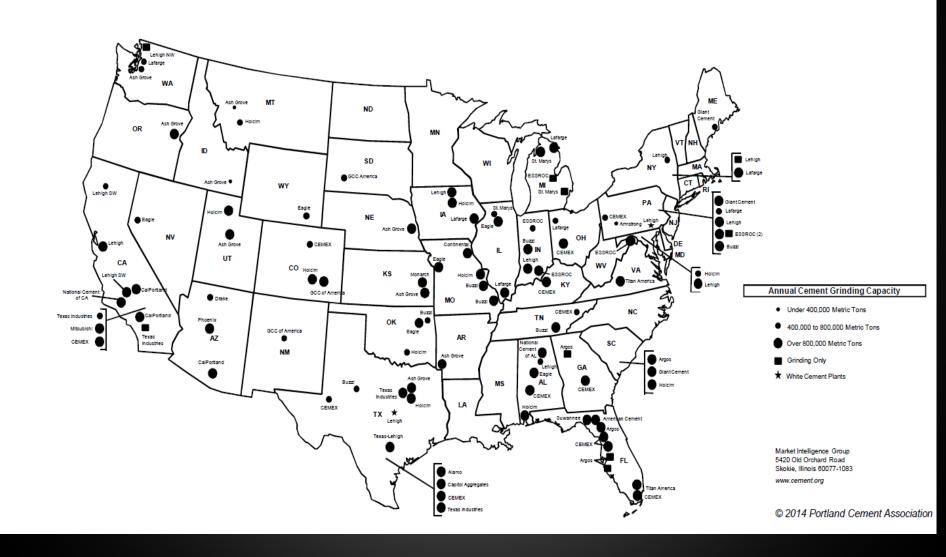
- Uniformity between states for initial cement acceptance
- Uniformity for cement manufacturer's for cement approval for each individual state
- Reduction of Department of Transportation testing for initial cement testing acceptance

Task Force Committee Members

- Lieska Halsey (Nebraska)
- Todd Hanson (lowa)
- John Staton (Michigan)
- Dave Suchorski (Ash Grove)
- Lori Tiefenthaler (Lehigh Cement)
- Tom Cackler (CP Tech Center)
- Maria Masten (Minnesota)
- John Melander (SCA)
- Paul Tennis (PCA)
- Thomas Grisinger (Lehigh Cement)

CEMENT MANUFACTURING PLANTS IN THE US

United States Portland Cement Plant Locations



Articles of Agreement for Portland Cement and Blended Cements sement Plant Acceptance

Standardization Update

Requirements

Participating States Agreement

Revised 08-2014

TASK FORCE

ARTICLES OF AGREEMENT FOR PORTLAND CEMENT AND BLENDED CEMENTS

CEMENT PLANT ACCEPTANCE APPROVAL SOURCE

RETWEEN THE HOST STATE AGENCY OF

AND
THE RECIPROCAL STATE AGENCY OF

CEMENT COMPANY:

FACILITY LOCATED AT

CEMENT TYPE & ASSOCIATED PRODUCT NAME

- The host state agency that performs testing for acceptance of hydraulic cement plants within its
- The data water egency and personal relating the exceptance to growth and certain pains waims as summary and practice file Evaluation of Laboratories Testing Hydraulic Centers.

 3. The host state agency indensity shall be accredited through the AASHTO Accreditation program. The laboratory is authority will be accredited applicable testing on center produced in accordance in an authority will be content applicable testing on center produced in accordance for the produced in accordance of the Content (ASTM CISO/AASHTO (MS)).

 - ii. Standard Specification for Blended Hydraulic Cements (ASTM
 - CS95/AASHTO M 240)
 Standard Performance Specification for Hydraulic Cement (ASTM C1157)
- Agency laboratories used for verification testing must meet the same criteria as prescribed in paragraph 1. a.

Revised 08-2014

TASK FORCE

- 2. The host state agency will require the cement plant within its boundaries to issue mill test
 - a. The certified mill analysis test report shall include the following:
 - i. Mill Location ii. Type of Cement

 - iii. Production Period iv. Manufacturer v. Product Name
 - vi. A statement that (a) Portland Cement conforms to ASTM C150/AASHTO M 85, (b) Blended Cements conforms to ASTM C595/AASHTO M 240, or (c) Performance Specification Cements conforms to ASTM C1157.
- 3. The host state agency shall require the cement manufacturer to comply with ASTM C1222, "Standard Practice for Evaluation of Laboratories Testing Hightranic Cement" and ASTM C133, "Standard Practice for Simpling and the Ausour of Testing elf-Hydranic Cement" as. The host state agency shall require the cement manufacturer to solvent a written quality control plan In his plan shall include the following:
 - - Type and associated product name of cement produced
 b. Location, procedure and frequency of sampling
 - c. Report standard specification used in testing
 - The host state agency will verify compliance with the quality control plan for the production of cements used by state agency.
 The manufacturer's plan must include commitments to comply with sampling and
- 4. The host state agency will require the cement producer to submit two split samples of a portland cement (ASTM C150/ASSHTO M189) and a blended cement (ASTM C150/AASSHTO M199) or performance specification cement (ASTM C1157) if produced, semiammally for verification leading. The exceed sample shall be retained for independent
- 5. The host state agency will require the cement manufacturer to sobmit reports for "Standard Text Method for Evaluation of Cement Strength Uniformity from a Single Source" (ASTM CNT) for thost postular General and Beharded cement, if produced a late stateminantly. In list of ASTM CNT sampling and testing, production data may be analyzed and reported for the non-preclumnar Generals summitted and a cement plant.
- The host state agency will require the cement producer to maintain production and quality control/quality assurance records for at least seven years and make those records available if requester.
- The host state agency will review submittals from the cement producer along with agency test results. If deficiencies are discovered, the state agency will monitor corrective actions taken by the producer until the deficiencies are corrected. The reciprocal agreement state agency will be notified of the deficiencies and of each occurrence.

- Any test results or submittals collected by the host state agency may be made available to the reciprocal agreement state agency upon request.
- 9. All cement plant information and data is confidential within the limits of a public agency and is for state agencies information and inspection only.
- Quality assurance test results of field samples, performed by a reciprocal state, shall be reported to the host state agency when a non-compliance occurs. The reciprocal state agency will deal directly with the cement producer. The host state agency will take action as described in paragragh. 7. The host state agency shall notify all reciprocal agreement state agencies when
- This agreement shall be reviewed once every 5 years or when a change occurs in the source, type, or brand name or upon request by either the host state or and reciprocal state agencies.
- 12. Cement tests or requirements beyond the standards stated above may be provided to reciprocal state agencies by agreement between the host state and reciprocal state agencies

Materials Engineer

Materials Engineer

Articles of Agreement for Portland Cement and Blended Cements Cement Plant Acceptance Lightingts

Standardization Update

ARTICLES OF AGREEMENT FOR PORTLAND CEMENT
AND
BLENDED CEMENTS

CEMENT PLANT ACCEPTANCE
APPROVAL SOURCE

BETWEEN
THE HOST STATE AGENCY OF

AND
THE RECIPROCAL STATE AGENCY OF

CEMENT COMPANY:

FACILITY LOCATED AT

CEMENT TYPE & ASSOCIATED PRODUCT NAME

The biost state agency that performs testing for acceptance of hydrasilic centest plants within its boundaries shall have a laboratory meeting the requirements of ASTM C1222, "Standard Practice for Evaluation of Laboratories Testing Hydralic Centest"

The boot state agency thorstory in athority will perform applicable testing on center plants program The Boot state agency bloostery in the property will perform applicable testing on center plants of program The Boot state agency bloostery in the performance plants within its location of the protection of the protection of the protection of the performance plants within its location of the performance of the performan

- Cement Plant Acceptance approval source will not replace an individual state's acceptance requirements from individual projects.
- Host State performing acceptance testing of hydraulic cement plants shall be accredited through the AASHTO Accreditation program.

Articles of Agreement for Portland Cement and Blended Cemen Sement Plant Acceptance

Requirements

Revised 08,2014

- 2. The host state agency will require the cement plant within its boundaries to issue mill test
 - a. The certified mill analysis test report shall include the following
 - i. Mill Location ii. Type of Cement
 - i. Production Period Manufacturer
 - v Product Name
 - A statement that (a) Portland Cement conforms to ASTM C150/AASHTO M 85, (b) Blended Cements conforms to ASTM C95/AASHTO M 240, or (c) Performance Specification Cements conforms to ASTM C1157.
- 3. The best state apercy shall require the center immediates to comply with ASTM (1232).

 "Standard Protects for Evaluation of Laboratilities Testing Plefaults Center and ASTM (1833). Standard Protects for Simpling and the Amount of Testing of Hydrathic Centers (1834). Standard Protects for Simpling and the Amount of Testing of Hydrathic Centers (1834). The best sitted apercyloid require for center immediates to submit a written quality control plan. This plan shall archite the following:

 a Type and associated product time of General produced.

 - A 1 yee and associated product name of cement produced b Location procedure and frequency of ampling c. Report standard specification used in testing b. The host state agency will verify compliance with the quality control plan for the production of cemeras used by state agency.

 The name that the control of the control of the complex of the control of the co
- 4. The host state agency will require the cement producer to submit two split samples of a portinad cement (ASTM CISO/ASHTO M85) and a blended cement (ASTM CISO/ASHTO M90) or performance specification center(ASTM CIISO) if produce, semisimutally for verification testing. The second sample shall be retained for independent
- 5. The host state agency will require the cement manufacturer to submit reports for "Standard Test Method for Evaluation of Cement Strength Uniformity from a Single Source" (ASTM C017) for told portrated cement and behaded cement, if produced a least sentimentally. In lise of ASTM C017 imaging and testing, production data may be malyzed and reported for the non-preclumate rements imanufactured at a cement plant.
- The host state agency will require the cement producer to maintain production and quality control quality assurance records for at least seven years and make those records available if requested.
- 7. The host state agency will review submittals from the cement producer along with agency test results. If deficiencies are discovered, the state agency will monitor corrective actions taken by the producer until the deficiencies are corrected. The reciprocal agreement state agency will be notified of the deficiencies and of each occurrence.

The host state agency will require the cement producers to submit mill test reports, perform split sample testing semiannually, comply with C1222, submit C 917 data semiannually and maintain quality control records.

Articles of Agreement for Portland Cement and Blended Cements Cement Plant Acceptance Highlights

Participating
States
Agreement

8. Any test results or submittals collected by the host state agency may be made available to the reciprocal agreement state agency upon request.

9. All cement plant information and data is confidential within the limits of a public agency and is five state agencies information and impection only.

10. Quality assurance test results of field samples, performed by a reciprocal state, shall be reported to the host state agency when a non-compliance occus. The reciprocal state agency will dead disertly with the center producer. The bott state agency will dead disertly with creamer producer. The bott state agency mit also accompliance occus: an one-compliance occus and an one-compliance occus.

11. This agreement shall be reviewed once every 5 years or when a change occus in the source, type, or than dame or upon request by either the joint state ordan exceptional state agencies.

12. Cement tests or requirements beyond the standards stated above may be provided to reciprocal state agencies by agreement between the first state and reciprocal state agencies.

Materials Engineer

State Reciprocal Agency

Date

Materials Engineer

State Reciprocal Agency

Date

This agreement will be reviewed every 5 years or when a change occurs in the source, type, or brand name by either the host state or and reciprocal state.



Comments ?