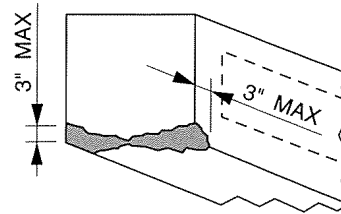


**NCDOT Prestress Standard Repair Procedure for Non-Conformance Report (NCR)  
SRP-06: Corner Spalls for Box Beams and Cored Slabs– 04/05/2022**

**Standard Repair Procedures – In-plant Repairs Only**

These standard procedures will only be applicable for corner spalls that have the following characteristics:

1. 3" maximum depth. (See photo below)
2. Steel may or may not be exposed.
3. The spall may be on the bottom, sides, or top of the end of the member.



**Structures Management Unit Review Comments**

The NCDOT Structures Management Unit recommends that the following standard procedures be followed for all cored slabs and box beams in which a corner spall has been observed:

- Provide sawcut a minimum of 1" beyond the perimeter of the repair area, to a minimum depth of  $\frac{1}{2}$ ".
- Remove all unsound concrete within the repair area. Remove all concrete – unsound and sound – within the sawcut to a minimum depth of  $\frac{1}{2}$ ".
- If more than half the circumference of a reinforcing bar is exposed, remove additional concrete to 1" behind the bar. This does not apply to prestressed strands.
- For areas in which no steel is exposed, use adhesively anchored anchors, with a minimum  $\frac{1}{4}$ " diameter, spaced at 6" grid, and a minimum 2" embedment into member, to provide mechanical bond for repair material. Provide the design concrete cover for studs.
- Do not damage rebar or strand.
- Form and place repair material to original shape.
- The repair material shall have a minimum compressive strength equal to or greater than that of the original beam concrete.
- The maximum size of aggregate in repair material should not exceed  $\frac{2}{3}$  of the minimum depth of the repair area.
- The repair material shall be on the NCDOT Approved Products List.
- Surface preparation, proportioning, mixing, placement, and curing of repair material should follow all manufacturer's recommendations.
- Perform repair operations in the presence of and to the satisfaction of the on-site NCDOT inspector.

There shall be an NCR written and saved in the project file for future reference. The NCR will not be required to be submitted to SMU providing that the procedures outlined above are strictly followed.

If for any reason the above requirements cannot be met a NCR submittal will be required for review.

If you have any questions or comments, please contact James L. Bolden, Jr., PE at (919)707-6408 or Madonna Rorie, PE at (919)707-6508.

Sherry McEntire, PE  
Structures Management Unit  
(919) 707 – 6410  
[srmcentire@ncdot.gov](mailto:srmcentire@ncdot.gov)