

SECTION 320 CORRUGATED STEEL PIPE

320.1 General - The Section covers the material and fabrication requirements for corrugated steel pipe, spiral rib pipe, and structural plate corrugated steel pipe products for applications such as culverts, storm sewers, sanitary sewers, subdrains, ground recharge systems, well casings, underpasses, stream enclosures, shelters, and tunnels.

Abbreviations for the various types of metal pipe are as follows:

CSP - Corrugated Steel Pipe

SPCSP - Structural Plate Corrugated Steel Pipe

320.2 Supply and Fabrication

320.2.1 Standards - The supply and fabrication of Corrugated Steel Pipe (CSP) and Structural Plate Corrugated Steel Pipe (SPCSP) including couplers

and appurtenances shall be in accordance with the CSA Standard G401

This specification is available on-line, free of charge, courtesy of the Corrugated Steel Pipe Institute at www.cspi.ca

320.6 Quality of Work

320.6.1 Inspection – Products shall be made available for inspection and acceptance at the point and time of incorporation into the Work.

320.6.2 Quality Management - The manufacturer shall establish the quality control plan and demonstrate its implementation. The purchaser's Quality Management Plan shall incorporate measures to assure the quality of the materials supplied by the manufacturer.

320.6.3 Quality Assurance Testing – Minimum QA tests and inspection shall be per the following Table

Element	Description	Minimum QA Testing / Inspection Frequencies	CSA Standard G401-06 Clause No.
Manufacturer's QC	Demonstration of effectiveness	For each Designated Supplier (for over \$200,000) : Once per Contract	6
Material	Mill Certificate	1 per Contract	3.1.2.2; 8.3
	Mill Markings	1 per Contract and one additional per load of material delivered	3.2.3
Fabrication	Thickness	1 per Contract per product	CSP: Table 2 SPCSP: Table 3
	Corrugation profile	Visual each piece, plus measurements of 1 per Contract and one additional per load of material delivered	CSP: Table 5 SPCSP: Table 6
	Circumference	1 per Contract per product	CSP: Table 9
	Lock seam	For Contracts with 10 or more pieces supplied: 1 per Contract	4.1.3.4
	Perforation size	1 per shipment	4.1.5
Coating	Type	Visual, each pipe or plate	
	Thickness	For each material coating specified: 1 per Contract and one additional per load of material delivered	
	Staining or damage	Visual, each piece	7.2
	Damage Repair	Each	5.1; 5.2
Couplers	Type	Visual, each piece	4.1.7
SPCSP	Drawing and Plate Identification	Each installation	4.2.7