



Designation: A 761/A 761M – 02

American Association State Highway and Transportation
Officials Standard
AASHTO No. M 167/M 167 M

Standard Specification for Corrugated Steel Structural Plate, Zinc-Coated, for Field- Bolted Pipe, Pipe-Arches, and Arches¹

This standard is issued under the fixed designation A 761/A 761M; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ε) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the Department of Defense.

1. Scope

1.1 This specification covers corrugated steel structural plate, zinc-coated, used in the construction of pipe, pipe-arches, arches, underpasses, and special shapes for field assembly. Appropriate fasteners and accessory materials are also described. The pipe, arches, and other shapes are generally used for drainage purposes, pedestrian and vehicular underpasses, and utility tunnels.

1.2 This specification does not include requirements for bedding, backfill, or the relationship between earth cover load and plate thickness of the pipe. Experience has shown that the successful performance of this product depends upon the proper selection of plate thickness, type of bedding and backfill, manufacture in the plant, and care in the installation. The purchaser must correlate the preceding factors and also the corrosion and abrasion requirements of the field installation with the plate thickness. The structural design of corrugated steel structural plate pipe and the proper installation procedures are described in Practices A 796/A 796M and A 807/A 807M.

1.3 This specification is applicable to orders in either inch-pound units (as A 761) or SI units (as A 761M). Inch-pound units and SI units are not necessarily equivalent. SI units are shown in brackets in the text, but they are the applicable values when the material is ordered to A 761M.

1.4 This specification references notes and footnotes which provide explanatory material. These notes and footnotes (excluding those in tables and figures) shall not be considered as requirements of this specification.

2. Referenced Documents

2.1 ASTM Standards:

- A 36/A 36M Specification for Carbon Structural Steel²
- A 90/A 90M Test Method for Weight [Mass] of Coating on Iron and Steel Articles with Zinc or Zinc-Alloy Coatings³
- A 123 Specification for Zinc (Hot-Dip Galvanized) Coat-

ings on Iron and Steel Products³

- A 153 Specification for Zinc Coating (Hot-Dip) on Iron and Steel Hardware³
- A 307 Specification for Carbon Steel Bolts and Studs, 60 000 psi Tensile Strength⁴
- A 370 Test Methods and Definitions for Mechanical Testing of Steel Products⁵
- A 449 Specification for Quenched and Tempered Steel Bolts and Studs⁴
- A 563 Specification for Carbon and Alloy Steel Nuts⁴
- A 563M Specification for Carbon and Alloy Steel Nuts [Metric]⁴
- A 751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products⁵
- A 754 Test Method for Coating Thickness by X-ray Fluorescence³
- A 780 Practice for Repair of Damaged Hot-Dip Galvanized Coatings³
- A 796/A 796M Practice for Structural Design of Corrugated Steel Pipe, Pipe-Arches, and Arches for Storm and Sanitary Sewers and Other Buried Applications³
- A 807/A 807M Practice for Installing Corrugated Steel Structural Plate Pipe for Sewers and Other Applications³
- A 902 Terminology Relating to Metallic Coated Steel Products³
- B 6 Specification for Zinc (Slab Zinc)⁶
- B 695 Specification for Coatings of Zinc Mechanically Deposited on Iron and Steel⁷
- E 29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications⁸
- E 376 Practice for Measuring Coating Thickness by Magnetic-Field or Eddy-Current (Electromagnetic) Test Methods⁹
- F 568 Specification for Carbon and Alloy Steel Externally Threaded Metric Fasteners⁴

¹ This specification is under the jurisdiction of ASTM Committee A05 on Metallic Coated Iron and Steel Products and is the direct responsibility of Subcommittee A05.17 on Corrugated Steel Pipe Specifications.

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² Annual Book of ASTM Standards, Vol 01.04.

³ Annual Book of ASTM Standards, Vol 01.06.

⁴ Annual Book of ASTM Standards, Vol 15.08.

⁵ Annual Book of ASTM Standards, Vol 01.03.

⁶ Annual Book of ASTM Standards, Vol 02.04.

⁷ Annual Book of ASTM Standards, Vol 02.05.

⁸ Annual Book of ASTM Standards, Vol 14.02.

⁹ Annual Book of ASTM Standards, Vol 03.03.

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2.2 *ANSI Standards*:¹⁰

B18.2.1 Square and Hex Bolts and Screws, Inch Series

B18.2.2 Square and Hex Nuts

B18.2.3.6M Bolts, Metric Heavy Hex

B18.2.4.6M Hex Nuts, Heavy, Metric

2.3 *AASHTO Standard*:¹¹

Standard Specifications for Highway Bridges, Division I

3. Terminology

3.1 *Definitions*—See Terminology A 902 for definitions of general terminology relating to metallic-coated steel products.

3.2 *Definitions of Terms Specific to This Standard*:

3.2.1 *arch, n*—a part circle shape spanning an open invert between the footings on which it rests.

3.2.2 *box culvert, n*—a rectangular box with a long-radius crown and short radius corners, and having either a full invert or footings.

3.2.3 *fabricator, n*—the producer of the components for the finished product.

3.2.4 *flat plate, n*—sheet or plate used to fabricate structural plate.

3.2.5 *manufacturer, n*—the producer of the flat plate and accessories.

3.2.6 *pipe, n*—a conduit having full circular shape; also, in a general context, all structure shapes covered by this specification.

3.2.7 *pipe-arch, n*—an arch shape with an approximate semicircular crown, small-radius, corners, and large-radius invert.

3.2.8 *pipe, horizontal ellipse, n*—an elliptically shaped pipe with the horizontal diameter approximately 25 % greater than the nominal diameter.

3.2.9 *pipe, vertically elongated, n*—an elliptically shaped pipe with the vertical diameter up to 10 % greater than the nominal diameter.

3.2.10 *purchaser, n*—the person or agency that purchases the finished pipe structure.

3.2.11 *special shape, n*—a shape, other than described elsewhere in this section, suitable for fabrication with structural plate.

3.2.12 *structural plate, n*—a corrugated and curved plate which is field assembled with other structural plates to form the required structure.

3.2.13 *vehicular underpass, n*—a high arch shape with an approximate semicircular crown, large-radius sides, small-radius corners between sides and invert, and large-radius invert.

4. Ordering Information

4.1 Orders for material under this specification shall include the following information as necessary to adequately describe the desired product:

4.1.1 Name of material (corrugated steel structural plate and accessories),

4.1.2 Description of structure (see Section 3),

4.1.3 Number of structures,

4.1.4 ASTM designation and year of issue, as A 761— ____ for inch-pound units or A 761M — ____ for SI units.

4.1.5 Dimensions of structure (diameter or span and rise, and length, and so forth) (see 8.2 and Note 7),

4.1.6 Thickness of plate (see 8.1),

4.1.7 Description of corrugations (see 6.2),

4.1.8 End treatment (bevel, skew, grade or slope corrections, or other special provision if required by the project plans or specifications),

4.1.9 Seam bolt size and number per corrugation, if different than the minimums specified (see 6.3 and Table 1 and Table 2),

4.1.10 Special requirements (including reinforcement locations, shapes, and thicknesses), if required, and

4.1.11 Certification, if required (see 12.1).

NOTE 1—Typical ordering descriptions are as follows: (1) Structural plates and fasteners for two corrugated steel structural plate pipes, in accordance with ASTM A 761 — ____, 180-in. diameter, 0.168-in. plate thickness, 6 by 2-in. corrugations, each 140-ft nominal centerline length with end treatment as shown on plans; (2) Structural plates and fasteners for one corrugated steel structural plate pipe-arch, in accordance with ASTM A 761M — ____, 3860-mm span by 2460-mm rise, 5.54-mm plate thickness, 150 by 50-mm corrugations, 27.0-m nominal centerline length with square ends, longitudinal seams with four M20 bolts per corrugation.

5. Materials

5.1 *Flat Plate*:

5.1.1 *Manufacture*—The base steel shall be made by any of the following processes: open-hearth, basic-oxygen, or electric-furnace.

5.1.2 *Chemical Composition*—The base metal heat analysis shall conform to the chemical requirements of Table 3. The requirements of this specification shall be met in continuous mass production during which the manufacturer has made analysis of individual heats so as to ensure that material is controlled within the specified limits.

TABLE 1 Bolt and Nut Requirements

	Bolts ^A	Nuts
	<i>A 761 (in.)</i>	
General dimensions ^B	ANSI B18.2.1 Heavy Hex	ANSI B18.2.2 Heavy Hex
Seam bolts and nuts ^C	A 449	A 563 Grade C
Anchorage bolts and nuts	A 307	A 563 Grade A
Zinc coating	A 153 or B 695, Class 55	A 153 or B 695, Class 55
Nominal diameter, min, in. ^D	¾	¾
	<i>A 761M [mm]</i>	
General dimensions ^B	ANSI B18.2.3.4M Heavy Hex	ANSI B18.2.4.6M Heavy Hex
Seam bolts and nuts ^C	F 568 Class 8.8	A 563M Class 12
Anchorage bolts and nuts	F 568 Class 4.6	A 563M Class 5
Zinc coating	A 153 or B 695, Class 55	A 153 or B 695, Class 55
Nominal diameter, min, metric size ^D	M20	M20

^ABolts with a special hemispherical base under the head are only available in inch sizes. They are also intended for use with metric plate.

^BSee 5.4.1 for requirements for bolt and nut bearing surfaces.

^CBolts and nuts also used for connecting arch plates to bearings and structural reinforcement to structural plates.

^DBolt size of ¾ in. or 1 in. [M22, M24, or M27] shall be furnished when specified in the order (see 5.4 and Note 4).

¹⁰ Available from American National Standards Institute, 25 W. 43rd St., 4th Floor, New York, NY 10036.

¹¹ Available from American Association of State Highway and Transportation Officials, 444 N. Capitol St., NW, Suite 249, Washington, DC 20001.