

# CONCRETE PIPE AND PRECAST PRODUCTS

## Certified Producer Plants

Materials from the companies listed herein are pre-qualified for use on Wisconsin Department of Transportation projects in accordance with all applicable specifications and/or policy memoranda.



CATEGORY A - CONCRETE PIPE PRODUCTS

CATEGORY B - MANHOLES, INLETS, CATCH BASINS

CATEGORY C - BOX CULVERTS, WALL PANELS, TEMP. BARRIERS

CATEGORY D - CONCRETE BRICK/BLOCK, RETAINING WALL BLOCK



### Requirements for Inclusion on WisDOT Pre-qualified List for Concrete Pipe and Precast Elements:

**Department Pre-Qualification** - WisDOT pre-qualification is required to be placed on the Department's list of approved fabricators for Concrete Pipe and Precast Elements. On an annual basis, each plant shall provide required documentation by the date below. WisDOT also conducts annual Quality Verification audits on selected production facilities. QV audits also inform the following year's approval.

**Audit Requirements** - Initial or continuing approval to fabricate any given item requires that a full-scale sample of at least one product type within that item's Category to be available for inspection during the qualifying third-party audit. The qualifying third-party audit must occur during the calendar year prior to the year for which approval is sought. Sample(s) must have been manufactured within the 18 months prior to the third-party audit, at the plant seeking approval. Every approved plant placed in operation during any given year must receive a QV audit during that year, regardless of whether product is delivered to WisDOT. Intermittent operations are required to contact the Department to coordinate a QV audit during production.

**Notification Requirements** - The plant must contact the department regarding plant name changes, ownership changes, plant certification disqualification by the third-party certifier, primary contact changes, plant closings, or any other issues related to the pre-qualification requirements.

**Statement on Material Acceptance** - For materials in Categories A, B, & C, see quality control test frequency requirements in the plant certification form below. Materials in Categories B, C, & D are accepted based on quality control data as required below and by the applicable Special Provision. Compliance of approved vendors with Title 23 CFR 635.410 "Buy America" is managed as part of the approval process; no documentation specifically for Buy America needs to be collected at the project level for materials covered by these lists.

**- Applications due JANUARY 31 of any year for plants prequalifying for that calendar year. See application form and documentation requirements on the last 5 pages of this file.**

- Application documents shall be submitted electronically as a SINGLE FILE\* in Adobe pdf format.
- File name shall contain: Year applying for certification, Company Name, and WisDOT Trade Location (see lists)
- SUBMITTALS CONTAINING MULTIPLE, SECURED, ENCRYPTED, PROTECTED, OR OTHERWISE ACCESS OR REPRODUCIBILITY-LIMITED FILES WILL BE REJECTED WITHOUT NOTICE.

**Department Contact : Please direct all inquiries and email all application materials to:**

Precast Concrete  
Bureau of Technical Services  
Wisconsin Dept. of Transportation  
3502 Kinsman Blvd.  
Madison, WI 53704  
[DOTProductSubmittal@wisconsin.gov](mailto:DOTProductSubmittal@wisconsin.gov)

**CATEGORY A - Pipe Products**

Date last edited: 10/5/2021

Company	Trade Location	Certified By	Products	Date Approved	Notes
County Materials	Humbolt Road, Green Bay, WI	ACPA	1,2	6/1/2012	Product marked as Concrete Industries ok through 8/2022
County Materials	Holmen, WI	WCPA	1,2,3,4	12/21/2012	
County Materials	Rib Falls, WI	WCPA	1,2,3,4	12/21/2012	
County Materials	Springfield, IL	NPCA	1,2	7/24/2018	
County Materials	Roberts, WI	NPCA	1,2,3,4	7/30/2012	
County Materials	Madison, WI	WCPA	1,2,4	12/21/2012	
County Materials	Green Bay, WI	WCPA	1,2,4	12/21/2012	
Forterra Pipe & Precast	Cedar Rapids, IA	ACPA	1	11/23/2011	
Forterra Pipe & Precast	Marshalltown, IA	ACPA	1,2,3,4	11/29/2011	
Forterra Pipe & Precast	Elk River, MN	ACPA	1,2,3,4	7/14/2017	
Forterra Pipe & Precast	Hawley, MN	ACPA	1,2,3,4	4/1/2016	
Forterra Pipe & Precast	Stacy, MN	NPCA	1,3	4/2/2013	
Hancock Concrete Products	Hancock, MN	ACPA	1,3	4/24/2017	
Oldcastle Infrastructure	Romeoville, IL	WCPA	1,2	12/21/2012	
Oldcastle Infrastructure	Elgin, IL	NPCA	1,2	4/16/2021	
U.P. Concrete Pipe	Escanaba, MI	NPCA	1,2,3,4	11/14/2012	
Welch Brothers	Belvidere, IL	WCPA	1,2,4	11/13/2012	
Welch Brothers	Bartlett, IL	WCPA	1,2,4	6/19/2012	

Product Key

- 1-Circular reinforced concrete pipe
- 2- Horizontal and vertical elliptical concrete pipe
- 3-Concrete pipe arch
- 4- Concrete cattle pass

WisDOT no longer accepts AASHTO M86/ASTM C14 non-reinforced concrete pipe, contact central office for approval if contract was let prior to 12/31/15.

**CATEGORY B - Catch Basins, Inlets, Manholes**

Date last edited: 10/5/2021

Company	Trade Location	Certified By	Products	Date Approved	Notes
County Materials	Humbolt Road, Green Bay, WI	ACPA	1,2,3,4,5,6	5/11/2017	Product marked as Concrete Industries ok through 8/2022
County Materials	Green Bay, WI	WCPA	1,2,3,4,5,6	12/21/2012	
County Materials	Holmen, WI	WCPA	1,2,3,4,5,6	12/21/2012	
County Materials	Madison, WI	WCPA	1,2,3,4,5,6	12/21/2012	
County Materials	Rib Falls, WI	WCPA	1,2,3,4,5,6	12/21/2012	
County Materials	Roberts, WI	NPCA	1,2,3,4,5,6	7/30/2012	
Crest Precast	LaCrescent, MN	NPCA/PCI	1,2,3,4,5,6	8/2/2012	
Eull's Manufacturing	St. Michael, MN	WCPA	3	1/2/2013	
Forterra Pipe & Precast	Elk River, MN	ACPA	1,2,3,4,5,6	7/14/2017	
Forterra Pipe & Precast	Hawley, MN	ACPA	1,2,4,5,6	4/1/2016	
Forterra Pipe & Precast	Marshalltown, IA	ACPA	1,2,3,4,5,6	11/29/2011	
Forterra Pipe & Precast	Stacy, MN	NPCA	1,2,3,4,5,6	3/30/2018	
Hancock Concrete Products	Hancock, MN	ACPA	1,2,4	4/24/2017	
Oldcastle Infrastructure	Elgin, IL	NPCA	1,2,3,4,5,6	4/16/2021	
Oldcastle Infrastructure	Kenosha, WI	WCPA	1,2,3,4,5,6	11/7/2012	
Oldcastle Infrastructure	Romeoville ,IL	WCPA	6	12/4/2014	
U.P. Concrete Pipe	Escanaba, MI	NPCA	1,2,3,4,5,6	11/14/2012	
Utility Concrete Products	Morris, IL	NPCA/PCI	1,2,3,4,5,6	4/1/2016	
Welch Brothers	Bartlett, IL	WCPA	1,2,3,4,5,6	6/19/2012	
Welch Brothers	Belvidere, IL	WCPA	1,2,3,4,5,6	11/13/2012	
Wieser Concrete Products	Maiden Rock, WI	NCPA	1,2,3,4,5,6	3/29/2012	
Wieser Concrete Products	Portage, WI	NCPA	1,2,3,4,5	3/29/2012	

**Product Key**

1- Manholes

2- Manhole components

3-Riser Rings (grade and adjustment rings)

4-Inlets

5-Catch basins

6- Apron endwalls

**CATEGORY C - Box Culverts, Wall Panels, Temporary Barrier Walls**

Date last edited: 10/5/2021

Company	Trade Location	Certified By	Products	Date Approved	Notes
County Materials	Humbolt Road, Green Bay, WI	ACPA	1	4/21/2021	Product marked as Concrete Industries ok through 8/2022
County Materials	Rib Falls, WI	WCPA	1,3,4	12/21/2012	
County Materials	Holmen, WI	WCPA	1,2,3,4	12/21/2012	
County Materials	Roberts, WI	NPCA	3,4	7/30/2012	
County Materials	Green Bay, WI	WCPA	1,2,3,4	12/21/2012	
County Materials	Madison, WI	WCPA	1,3,4	12/21/2012	
Crest Precast	LaCrescent, MN	NPCA/PCI	1,2,3,4	8/2/2012	
Forterra Pipe & Precast	Elk River, MN	ACPA	1,2,4	7/14/2017	
Forterra Pipe & Precast	Marshalltown, IA	ACPA	1,2,4	11/29/2011	
Forterra Pipe & Precast	Stacy, MN	NPCA	1,2,4	3/30/2018	
Hancock Concrete Products	Cannon Falls, MN	ACPA	1	4/1/2016	
Hancock Concrete Products	Hancock, MN	ACPA	1	4/24/2017	
Oldcastle Infrastructure	Kenosha, WI	WCPA	1,4	4/1/2016	
Oldcastle Infrastructure	Romeoville, IL	WCPA	1,4	12/21/2012	
Oldcastle Infrastructure	Elgin, IL	NPCA	1,4	4/16/2021	
S&S Precast	Winamac, IN	NPCA	2	4/1/2016	
U.P. Concrete Pipe	Escanaba, MI	NPCA	1,2,3,4	11/14/2012	
Utility Concrete Products	Morris, IL	NPCA/PCI	1,2,3,4	4/1/2016	
Welch Brothers	Belvidere, IL	WCPA	1,4	11/13/2012	
Welch Brothers	Bartlett, IL	WCPA	1,4	6/19/2012	
Wieser Concrete Products	Maiden Rock, WI	NCPA	1,2,3,4	3/29/2012	
Wieser Concrete Products	Portage, WI	NCPA	1,2,3,4	3/29/2012	

Past Production

<u>603.8000 Concrete Barrier Temporary</u>	<u>Trade Location</u>	<u>Products</u>	<u>Approved Manufactured Dates</u>
County Materials Corporations	Janesville, WI	3	4/5/2013 - 11/24/2015
Michels	Neenah, WI	3	3/30/2018 - 5/1/2018
Stress-Con Industries	Kalamazoo, MI	3	7/1/2013 - 3/1/2016
Zignego Ready Mix, Inc	Richfield, WI	3	4/29/2013 - 5/1/2018

Product Key

- 1-Box Culverts
- 2-Wall Panels\*
- 3-Temporary Traffic Barrier
- 4-Special Structures (Pre-Cast Slabs)

\*This list covers non-prestressed wall panels only

**CATEGORY D - Masonry Block**

Date last edited: 7/8/2021

<u>Company</u>	<u>Trade Location</u>	<u>Products</u>	<u>Date Approved</u>	<u>Notes</u>
County Materials	Janesville, WI	1	4/27/2020	
County Materials	Custer, WI	2	4/26/2021	
County Materials	Marathon, WI	2	4/26/2021	
Ledgeview Precast Products, Inc.	Fond du Lac, WI	2	7/7/2021	
U.P. Concrete Pipe	Escanaba, MI	1	4/27/2020	
Wieser Concrete Products	Maiden Rock, WI	2	4/27/2020	
Wieser Concrete Products	Portage, WI	2	4/27/2020	
Willow Creek Concrete Products, Inc.	Faribault, MN	2	4/26/2021	
Willow Creek Concrete Products, Inc.	Willow Creek, MN	2	4/26/2021	

Product Key

1-Stormwater Structure Block (ASTM C139)

2-Retaining Wall Block (ASTM C1372/WisDOT Wall Modular Block SPV)



# Wisconsin Department of Transportation CONCRETE PIPE AND PRE-CAST PRODUCTS PLANT

## 2022 Certified Producer Plant Pre-Qualification Application

Application Date: \_\_\_\_\_

Plant Name: \_\_\_\_\_

Trade Location: \_\_\_\_\_ (See approved list for WisDOT-assigned trade location)

Plant Physical Address: \_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

### Plant Status:

Is this plant currently approved – Yes  No

Did this plant produce any material during 2020 - Yes  No

Date of most recent WisDOT QV audit - \_\_\_\_\_ (N/A if not currently approved)

Third-party pre-qualifying entity – WCPA  NPCA  ACPA  PCI

Date of most recent third-party audit - \_\_\_\_\_

(Third-party QC audit/certification not required if applying for Category D only)

Identify product types & sizes for which samples were inspected during the third-party audit in each category for which the plant is seeking approval –

Category A - \_\_\_\_\_

Category B - \_\_\_\_\_

Category C - \_\_\_\_\_

Category D - \_\_\_\_\_

### Specific product types to be pre-qualified:

#### CATEGORY A - Concrete Pipe Products

- 1. Circular reinforced concrete pipe (AASHTO M170/ASTM C76)  
List sizes: \_\_\_\_\_
- 2. Horizontal and vertical elliptical concrete pipe (AASHTO M207/ASTM C507)
- 3. Concrete arch pipe (AASHTO M206/ASTM C506)
- 4. Concrete cattle pass (AASHTO M170/ASTM C76)

**CATEGORY B - Precast, Catch Basins, Inlets, Manholes**

- 1. Manholes (ASTM C913 & AASHTO M199/ASTM C478)
- 2. Manhole components (ASTM C913 & AASHTO M199/ASTM C478)
- 3. Riser rings (ASTM C913 & AASHTO M199/ASTM C478)
- 4. Inlets (ASTM C913 & AASHTO M199/ASTM C478)
- 5. Catch basins (ASTM C913 & AASHTO M199/ASTM C478)
- 6. Apron endwalls (AASHTO M170/ASTM C76)

List sizes: \_\_\_\_\_

**CATEGORY C - Precast Box Culverts, Wall Panels, Temporary Barrier Walls**

- 1. Box culverts (WisDOT Std. Spec. 504 & ASTM C1577)
- 2. Wall panels (WisDOT SPV)
- 3. Temporary traffic barrier (WisDOT Std. Spec. 603)
- 4. Special structures (WisDOT SPV)

**CATEGORY D - Block/Brick**

- 1. Concrete Block/Brick (ASTM C139)
- 2. Retaining Wall Block (ASTM C1372, WisDOT SPV)

**Plant contact and quality control personnel qualifications:**

**Primary Plant Contact, phone, email**

**Name:** \_\_\_\_\_

**Phone No.:** \_\_\_\_\_

**Cell Phone:** \_\_\_\_\_

**Email Address:** \_\_\_\_\_

**Plant Mailing Address:**

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

**QC Manager and Certifications**

- \_\_\_\_\_

**QC Testing Personnel and Certifications  
(Include staff certified for aggregate and concrete sampling)**

- \_\_\_\_\_
- \_\_\_\_\_
- \_\_\_\_\_
- \_\_\_\_\_
- \_\_\_\_\_



## **Submit the following with all applications:**

### ➤ **Third-party plant certification:**

- A copy of the audit inspection report and all supporting documentation from the qualifying agency (NPCA, ACPA, WCPA, PCI as applicable), including deficiencies and corrective recommendations noted during the audit. Provide the plant response to deficiencies and corrective recommendations. Label attached pages as Audit Attachments.
- A copy of the qualifying agencies certification document and transmittal letter. Label attached certification as Certification Attachment.
- Third-party audit/certification is not required for applicants seeking approval for Category D items only

### ➤ **Buy America certification:**

- Producer certification that all product and incorporated materials were manufactured in compliance with Title 23 Code of Federal Regulations Section 635.410, see form below.

### ➤ **Aggregate Data:**

#### ❖ **All Sources:**

- Producer Certificate of Compliance that aggregate conforms to 501.2.5 of the department's Standard Specifications, see form below.
- Submit one (1) current, annual verification test as shown (taken during the year prior to that being applied for) for all sources:
  - Sieve analysis (AASHTO T27/ASTM C136)  
*(Size requirements of 501.2.5.3.4 and 501.2.5.4.5 are waived for precast materials)*
  - Specific gravity and absorption (AASHTO T85/ASTM C127)
- Label pages with corresponding Source # used below.

#### ❖ **Sources in WisDOT General Testing System:**

*Test ID's must be acceptable and certified on the WisDOT approved products lists.*

- WisDOT Source #1 – Name:  
Test ID:
- WisDOT Source #2 – Name:  
Test ID:
- WisDOT Source #3 – Name:  
Test ID:
- WisDOT Source #4 – Name:  
Test ID:

❖ **Out-of-State Sources:**

- For sources not in the WisDOT general testing system, list all data as required below. Attach certified reports of test corroborating all test results listed.  
*Certified test reports must be no older than 3 years. Submit test reports for all sources. The same source may be used for coarse and fine aggregate.*

*Label attached pages using source number assigned in following charts.*

COARSE (D50>1/4")			AASHTO T96/ASTM C131 (LA Wear)	AASHTO T103 (F/T)	AASHTO T104/ASTM C88 (S. Soundness)	ASTM C1260/C1567 (ASR)
Source	Source	Testing Lab				
1			Date: Result:	Date: Result:	Date: Result:	Date: Result:
2			Date: Result:	Date: Result:	Date: Result:	Date: Result:
3			Date: Result:	Date: Result:	Date: Result:	Date: Result:

**Coarse Aggregate quality target test values:**

- AASHTO T96 – 50% max. (Std. Spec. 501.2.5.4.3(1))
- AASHTO T103 – 18% max. (Std. Spec. 501.2.5.4.3(1))
- AASHTO T104 – 12% max. (Std. Spec. 501.2.5.4.3(1))
- ASTM C1260 – 0.15% max. @ 14 days (Std. Spec. 501.2.5.4.4(2)) If seeking waiver from ASR testing (ASTM C1260) for an out-of-state source, supply a certified report from a qualified geologist or geotechnical engineer that the source can be excluded under the provisions of WisDOT std. spec. 501.2.5.4.4(1).

FINE (D50<1/4")			AASHTO T27/T11 (Deleterious Substances/P200)	AASHTO T21 or T71 (Organics)
Source	Source (Include Pit or Quarry designation)	Testing Lab		
1			Date: Del. %:                      P200%:	Date: T21:                              T71:
2			Date: Del. %:                      P200%:	Date: T21:                              T71:
3			Date: Del. %:                      P200%:	Date: T21:                              T71:

Fine Aggregate quality target test values see Std. Spec. 501.2.5.3

➤ **Portland Cement**

- List Manufacturer Name & Mill location
- Manufacturer #1 \_\_\_\_\_
- Manufacturer #2 \_\_\_\_\_

➤ **Reinforcing Steel**

- List Name & Location of producer mill. Include distributor if applicable
- Buy America Certifications on file for all (Check if internal records are complete, do not attach vendor certs.)
- Vendor #1 \_\_\_\_\_
- Vendor #2 \_\_\_\_\_
- Vendor #3 \_\_\_\_\_
- Vendor #4 \_\_\_\_\_

## **WisDOT 2021 Precast Concrete Materials Certification**

Precast concrete producer \_\_\_\_\_ (insert facility name and location)

Herewith certifies the following:

- All materials incorporated into products manufactured at the above-named facility for delivery to WisDOT contracts were produced in compliance with Title 23 Code of Federal Regulations Section 635.410, "Buy America".
- All aggregate materials incorporated into products manufactured at the above-named facility for delivery to WisDOT contract comply with Section 501.2.5 of the WisDOT Standard Specifications as required for precast concrete fabrications.
- All Portland cement incorporated into products manufactured at the above-named facility for delivery to WisDOT contract comply with Section 501.2.1 of the WisDOT Standard Specifications as required for precast concrete fabrications.
- All Category A materials are tested in accordance with AASHTO T280 (3-Edge Bearing) at the following minimum frequencies:
  - 12 - 15" Class V and below: 1/1000 pieces
  - 18 - 36" Class IV and below: 1/800 pieces
  - 18 - 36" Class V: 1/400 pieces
  - 42 - 60" Class III and below: 1/400 pieces
  - 42 - 60" Class IV and V: 1/200 pieces and at least 1 piece per project
  - 66" and larger All Classes: 1/200 pieces and at least 1 piece per project
- All Category A, B, and C materials are tested in accordance with AASHTO T22/ASTM C39 (Compressive Strength of Concrete Cylinders), and AASHTO T152/ASTM C231 (Air Content, wet cast only) at the following frequencies:
  - Once per day per mix produced (minimum 2 cylinders cast, and one air test)
- All Category D materials are tested in accordance with the following:
  - Minimum once per the lesser of 1 day's production or 150 CY produced, per mix produced for wet-cast materials
  - Minimum once per 5000 blocks produced for dry-cast materials

Test	Method	Applicability	
		Dry-cast	Wet-cast
Compressive Strength (psi)	ASTM C140	Yes	Yes
Air Content (%)	AASHTO T152	No	Yes
*Water Absorption (%)	ASTM C140	Yes	No
*Freeze-Thaw Loss (%)	ASTM C1262	**Yes	No

\*Water Absorption and Freeze-Thaw Loss must be performed in a qualified independent lab.

\*\*Freeze-Thaw Loss testing is not required for C139 drainage structure block under Category D-1.

Signed \_\_\_\_\_ Date \_\_\_\_\_

Print name \_\_\_\_\_

*Must be signed by a member of management with authority to legally bind the precast contractor operating the facility*