

**REVISED CONSTRUCTION QUALITY  
ASSURANCE PLAN  
for the Construction of  
*Cell 4A Lining System***

**White Mesa Mill  
Blanding, Utah**

Prepared for:



Denison Mines (USA) Corporation  
6425 S. Highway 191  
P.O. Box 809  
Blanding, UT 84511  
Phone: (306) 628-7798

Prepared by:



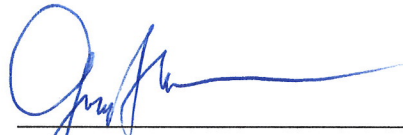
**Geosyntec Consultants**  
10875 Rancho Bernardo Rd.  
Suite 200  
San Diego, California 92127

**SEPTEMBER 2007**

# CERTIFICATION PAGE

**CONSTRUCTION QUALITY ASSURANCE (CQA) PLAN FOR  
CELL 4A LINING SYSTEM CONSTRUCTION  
DENISON MINES (USA) CORPORATION  
WHITE MESA MILL  
BLANDING, UTAH**

The Engineering material and data contained in this CQA Plan were prepared under the supervision and direction of the undersigned, whose seal as a registered Professional Engineer is affixed below.



---

Gregory T. Corcoran, P.E.  
Engineer of Record

## TABLE OF CONTENTS

1.	INTRODUCTION .....	1
1.1	Terms of Reference .....	1
1.2	Purpose and Scope of the Construction Quality Assurance Plan.....	1
1.3	References .....	2
1.4	Organization of the Construction Quality Assurance Plan .....	2
2.	DEFINITIONS RELATING TO CQA.....	3
2.1	Owner .....	3
2.2	Construction Manager .....	3
2.3	Engineer .....	4
2.4	Contractor.....	4
2.5	Resin Supplier .....	5
2.6	Manufacturers .....	5
2.7	Geosynthetic Installer.....	6
2.8	CQA Consultant .....	6
2.9	Surveyor .....	7
2.10	CQA Laboratory.....	8
2.11	Lines of Communication.....	8
2.12	Deficiency Identification and Rectification .....	9
3.	CQA CONSULTANTS PERSONNEL ORGANIZATION AND DUTIES.....	11
3.1	Overview .....	11
3.2	CQA Personnel.....	11
3.3	CQA Officer.....	12
3.4	CQA Site Manager .....	12
4.	SITE AND PROJECT CONTROL.....	14
4.1	Project Coordination Meetings .....	14
4.1.1	Pre-Construction Meeting.....	14
4.1.2	Progress Meetings.....	15
4.1.3	Problem or Work Deficiency Meeting .....	15
5.	DOCUMENTATION .....	17

5.1	Overview .....	17
5.2	Daily Recordkeeping.....	17
5.3	Construction Problems and Resolution Data Sheets.....	18
5.4	Photographic Documentation.....	19
5.5	Design and/or Specifications Changes.....	19
5.6	CQA Report .....	20
6.	EARTHWORK.....	22
6.1	Introduction .....	22
6.2	Subgrade Soil Testing Activities.....	22
6.2.1	Sample Frequency .....	22
6.2.2	Sample Selection .....	23
6.3	CQA Monitoring Activities.....	23
6.3.1	Vegetation Removal .....	23
6.3.2	Grading .....	23
6.3.3	Subgrade Soil.....	24
6.3.4	Anchor Trench Construction .....	24
6.4	Deficiencies.....	24
6.4.1	Notification .....	25
6.4.2	Repairs and Re-Testing .....	25
7.	DRAINAGE AGGREGATE.....	26
7.1	Introduction .....	26
7.2	Testing Activities .....	26
7.2.1	Sample Frequency .....	26
7.2.2	Sample Selection .....	27
7.3	CQA Monitoring Activities.....	27
7.3.1	Drainage Aggregate.....	27
7.4	Deficiencies.....	28
7.4.1	Notification .....	28
7.4.2	Repairs and Re-testing.....	28
8.	POLYVINYL CHLORIDE (PVC) PIPE AND STRIP composite.....	29
8.1	Material Requirements .....	29

8.2	Manufacturer .....	29
8.2.1	Submittals .....	29
8.3	Handling and Laying.....	29
8.4	Perforations .....	30
8.5	Joints .....	30
8.6	Strip Composite.....	30
9.	GEOMEMBRANE .....	31
9.1	General .....	31
9.2	Geomembrane Material Conformance .....	31
9.2.1	Introduction .....	31
9.2.2	Review of Quality Control.....	31
9.2.2.1	Material Properties Certification.....	31
9.2.2.2	Geomembrane Roll MQC Certification .....	32
9.2.3	Conformance Testing.....	33
9.3	Delivery .....	33
9.3.1	Transportation and Handling .....	33
9.3.2	Storage .....	34
9.4	Geomembrane Installation .....	34
9.4.1	Introduction .....	34
9.4.2	Earthwork .....	34
9.4.2.1	Surface Preparation .....	34
9.4.2.2	Geosynthetic Termination .....	35
9.4.3	Geomembrane Placement .....	35
9.4.3.1	Panel Identification .....	35
9.4.3.2	Field Panel Placement .....	36
9.4.4	Field Seaming .....	38
9.4.4.1	Requirements of Personnel .....	38
9.4.4.2	Seaming Equipment and Products .....	38
9.4.4.3	Seam Preparation .....	41
9.4.4.4	Weather Conditions for Seaming .....	41
9.4.4.5	Overlapping and Temporary Bonding .....	41

9.4.4.6	Trial Seams.....	42
9.4.4.7	General Seaming Procedure.....	42
9.4.4.8	Nondestructive Seam Continuity Testing .....	43
9.4.4.9	Destructive Testing .....	45
9.4.5	Defects and Repairs .....	49
9.4.5.1	Identification .....	49
9.4.5.2	Evaluation .....	49
9.4.5.3	Repair Procedures .....	50
9.4.5.4	Verification of Repairs.....	51
9.4.5.5	Large Wrinkles.....	51
9.4.6	Lining System Acceptance .....	52
10.	GEOTEXTILE.....	53
10.1	Introduction .....	53
10.2	Manufacturing .....	53
10.3	Labeling.....	54
10.4	Shipment and Storage .....	54
10.5	Conformance Testing.....	55
10.5.1	Tests.....	55
10.5.2	Sampling Procedures .....	55
10.5.3	Test Results.....	55
10.5.4	Conformance Sample Failure .....	55
10.6	Handling and Placement .....	56
10.7	Seams and Overlaps .....	57
10.8	Repair .....	57
10.9	Placement of Soil or Aggregate Materials .....	58
11.	GEOSYNTHETIC CLAY LINER (GCL).....	59
11.1	Introduction .....	59
11.2	Manufacturing .....	59
11.3	Labeling.....	60
11.4	Shipment and Storage .....	60
11.5	Conformance Testing.....	61

11.5.1	Tests.....	61
11.5.2	Conformance Sample Failure .....	61
11.6	GCL Delivery and Storage.....	62
11.7	GCL Installation.....	62
12.	GEONET .....	64
12.1	Introduction .....	64
12.2	Manufacturing .....	64
12.3	Labeling.....	64
12.4	Shipment and Storage .....	65
12.5	Conformance Testing.....	65
12.5.1	Tests.....	65
12.5.2	Sampling Procedures .....	65
12.5.3	Test Results.....	66
12.5.4	Conformance Test Failure .....	66
12.6	Handling and Placement .....	66
12.7	Geonet Seams and Overlaps.....	67
12.8	Repair .....	67
13.	CONCRETE SPILLWAY .....	69
13.1	Introduction .....	69
13.2	CQA Monitoring Activities.....	69
13.2.1	Subgrade Preparation.....	69
13.2.2	Liner System and Cushion Geotextile Installation .....	69
13.2.3	Welded Wire Reinforcement Installation .....	69
13.2.4	Concrete Installation.....	70
13.2.5	Conformance Testing.....	70
13.3	Deficiencies.....	70
13.3.1	Notification .....	70
13.3.2	Repairs .....	71
14.	SURVEYING .....	72
14.1	Survey Control .....	72
14.2	Precision and Accuracy .....	72

14.3	Lines and Grades.....	72
14.4	Frequency and Spacing .....	72
14.5	Documentation .....	72

**TABLES**

1A	Test Procedures for the Evaluation of Subgrade Soil
1B	Minimum Subgrade Soil Testing Frequencies
2A	Test Procedures for the Evaluation of Aggregate
2B	Minimum Aggregate Testing Frequencies for Conformance Testing
3	Geomembrane Conformance Testing Requirements
4	Geotextile Conformance Testing Requirements
5	GCL Conformance Testing Requirements
6	Geonet Conformance Testing Requirements



## **1. INTRODUCTION**

### **1.1 Terms of Reference**

Geosyntec Consultants (Geosyntec) has prepared this Construction Quality Assurance (CQA) Plan for the construction of liner systems associated with the Cell 4A Lining System Construction at the Denison Mines (USA) Corporation (DMC) White Mesa Mill Facility (site), located at 6425 S. Highway 191, Blanding, UT 84511. This CQA Plan was prepared by Mr. Chad Bird, E.I.T., of Geosyntec Consultants (Geosyntec), and was reviewed by Mr. Gregory T. Corcoran, P.E., also of Geosyntec, in general accordance with the peer review policies of the firm.

### **1.2 Purpose and Scope of the Construction Quality Assurance Plan**

The purpose of the CQA Plan is to address the CQA procedures and monitoring requirements for construction of the project. The CQA Plan is intended to: (i) define the responsibilities of parties involved with the construction; (ii) provide guidance in the proper construction of the major components of the project; (iii) establish testing protocols; (iv) establish guidelines for construction documentation; and (v) provide the means for assuring that the project is constructed in conformance to the *Technical Specifications*, permit conditions, applicable regulatory requirements, and *Construction Drawings*.

This CQA Plan addresses the soils and geosynthetic components of the liner system for the project. The soils, geosynthetic, and appurtenant components include prepared subgrade, geosynthetic clay liner (GCL), geomembrane, geotextile, geonet, drainage aggregate, and polyvinyl chloride (PVC) pipe. It should be emphasized that care and documentation are required in the placement aggregate, and in the production and installation of the geosynthetic materials installed during construction. This CQA Plan delineates procedures to be followed for monitoring construction utilizing these materials.

The CQA monitoring activities associated with the selection, evaluation, and placement drainage aggregate are included in the scope of this plan. The CQA protocols applicable to manufacturing, shipping, handling, and installing all geosynthetic materials are also included. However, this CQA Plan does not specifically

address either installation specifications or specification of soils and geosynthetic materials as these requirements are addressed in the *Technical Specifications*.

### **1.3 References**

The CQA Plan includes references to test procedures in the latest editions of the American Society for Testing and Materials (ASTM).

### **1.4 Organization of the Construction Quality Assurance Plan**

The remainder of the CQA Plan is organized as follows:

- Section 2 presents definitions relating to CQA;
- Section 3 describes the CQA personnel organization and duties;
- Section 4 describes site and project control requirements;
- Section 5 presents CQA documentation;
- Section 6 presents CQA of earthworks;
- Section 7 presents CQA of the drainage aggregates;
- Section 8 presents CQA of the pipe and fittings;
- Section 9 presents CQA of the geomembrane;
- Section 10 presents CQA of the geotextile;
- Section 11 presents CQA of the geosynthetic clay liner;
- Section 12 presents CQA of the geonet;
- Section 13 presents CQA of the concrete spillway;
- Section 14 presents CQA surveying.

## **2. DEFINITIONS RELATING TO CQA**

This CQA Plan is devoted to Construction Quality Assurance. In the context of this document, Construction Quality Assurance and Construction Quality Control are defined as follows:

Construction Quality Assurance (CQA) - A planned and systematic pattern of means and actions designed to assure adequate confidence that materials and/or services meet contractual and regulatory requirements and will perform satisfactorily in service. CQA refers to means and actions employed by the CQA Consultant to assure conformity of the project “Work” with this CQA Plan, the *Drawings*, and the *Technical Specifications*. CQA testing of aggregate, pipe, and geosynthetic components is provided by the CQA Consultant.

Construction Quality Control (CQC) - Actions which provide a means to measure and regulate the characteristics of an item or service in relation to contractual and regulatory requirements. Construction Quality Control refers to those actions taken by the Contractor, Manufacturer, or Geosynthetic Installer to verify that the materials and the workmanship meet the requirements of this CQA Plan, the *Drawings*, and the *Technical Specifications*. In the case of the geosynthetic components and piping of the Work, CQC is provided by the Manufacturer, Geosynthetic Installer, and Contractor.

### **2.1 Owner**

The Owner of this project is Denison Mines (USA) Corporation.

### **2.2 Construction Manager**

#### *Responsibilities*

The Construction Manager is responsible for managing the construction and implementation of the *Drawings*, and *Technical Specifications* for the project work. The Construction Manager is selected/appointed by the Owner.

## **2.3 Engineer**

### *Responsibilities*

The Engineer is responsible for the design, *Drawings*, and *Technical Specifications* for the project work. In this CQA Plan, the term “Engineer” refers to Geosyntec.

### *Qualifications*

The Engineer of Record shall be a qualified engineer, registered as required by regulations in the State of Utah. The Engineer should have expertise, which demonstrates significant familiarity with piping, geosynthetics and soils, as appropriate, including design and construction experience related to liner systems.

## **2.4 Contractor**

### *Responsibilities*

In this CQA Plan, Contractor refers to an independent party or parties, contracted by the Owner, performing the work in accordance with this CQA Plan, the *Drawings*, and the *Technical Specifications*. The Contractor will be responsible for the installation of the soils, pipe, drainage aggregate, and geosynthetic components of the liner systems. This work will include subgrade preparation, anchor trench excavation and backfill, placement of drainage aggregate for the slimes drain and the leak detection system, installation of PVC piping, placement of cast-in-place concrete, and coordination of work with the Geosynthetic Installer and other subcontractors.

The Contractor will be responsible for constructing the liner system and appurtenant components in accordance with the *Drawings* and complying with the quality control requirements specified in the *Technical Specifications*.

### *Qualifications*

Qualifications of the Contractor are specific to the construction contract. The Contractor should have a demonstrated history of successful earthworks, piping, and liner system construction and shall maintain current state and federal licenses as appropriate.

## **2.5      Resin Supplier**

### *Responsibilities*

The Resin Supplier produces and delivers the resin to the Geosynthetics Manufacturer.

### *Qualifications*

Qualifications of the Resin Supplier are specific to the Manufacturer's requirements. The Resin Supplier will have a demonstrated history of providing resin with consistent properties.

## **2.6      Manufacturers**

### *Responsibilities*

The Manufacturers are responsible for the production of finished material (geomembrane, geotextile, geosynthetic clay liner, geonet, and pipe) from appropriate raw materials.

### *Qualifications*

The Manufacturer(s) will be able to provide sufficient production capacity and qualified personnel to meet the demands of the project. The Manufacturer(s) must be a well established firm(s) that meets the requirements identified in the *Technical Specifications*.

## **2.7 Geosynthetic Installer**

### *Responsibilities*

The Geosynthetic Installer is responsible for field handling, storage, placement, seaming, ballasting or anchoring against wind uplift, and other aspects of the geosynthetic material installation. The Geosynthetic Installer may also be responsible for specialized construction tasks (i.e., including construction of anchor trenches for the geosynthetic materials).

### *Qualifications*

The Geosynthetic Installer will be trained and qualified to install the geosynthetic materials of the type specified for this project. The Geosynthetic Installer shall meet the qualification requirements identified in the *Technical Specifications*.

## **2.8 CQA Consultant**

### *Responsibilities*

The CQA Consultant is a party, independent from the Owner, Contractor, Manufacturer, and Geosynthetic Installer, who is responsible for observing, testing, and documenting activities related to the CQC and CQA of the earthwork, piping, and geosynthetic components used in the construction of the Project as required by this CQA Plan and the *Technical Specifications*. The CQA Consultant will also be responsible for issuing a CQA report at the completion of the Project construction, which documents construction and associated CQA activities. The CQA report will be signed and sealed by the CQA Officer who will be a Professional Engineer registered in the State of Utah.

### *Qualifications*

The CQA Consultant shall be a well established firm specializing in geotechnical and geosynthetic engineering that possess the equipment, personnel, and licenses necessary to conduct the geotechnical and geosynthetic tests required by the project plans and *Technical Specifications*. The CQA Consultant will provide qualified

staff for the project, as necessary, which will include, at a minimum, a CQA Officer and a CQA Site Manager. The CQA Officer will be a professionally licensed engineer as required by State of Utah regulations.

The CQA Consultant will be experienced with earthwork and installation of geosynthetic materials similar to those materials used in construction of the Project. The CQA Consultant will be experienced in the preparation of CQA documentation including CQA Plans, field documentation, field testing procedures, laboratory testing procedures, construction specifications, construction *Drawings*, and CQA reports.

The CQA Site Manager will be specifically familiar with the construction of earthworks, piping, and geosynthetic lining systems. The CQA Manager will be trained by the CQA Consultant in the duties as CQA Site Manager.

## **2.9 Surveyor**

### *Responsibilities*

The Surveyor is a party, independent from the Contractor, Manufacturer, and Geosynthetic Installer, that is responsible for surveying, documenting, and verifying the location of all significant components of the Work. The Surveyor's work is coordinated and employed by the Contractor. The Surveyor is responsible for issuing *Record Drawings* of the construction.

### *Qualifications*

The Surveyor will be a well established surveying company with at least 3 years of surveying experience in the State of Utah. The Surveyor will be a licensed professional as required by the State of Utah regulations. The Surveyor shall be fully equipped and experienced in the use of total stations and the recent version of AutoCAD. All surveying will be performed under the direct supervision of the Contractor.

## **2.10 CQA Laboratory**

### *Responsibilities*

The CQA Laboratory is a party, independent from the Contractor, Manufacturer, Geosynthetic Installer, that is responsible for conducting tests in accordance with ASTM and other applicable test standards on samples of geosynthetic materials, soil, and in the field and in either an on-site or off-site laboratory.

### *Qualifications*

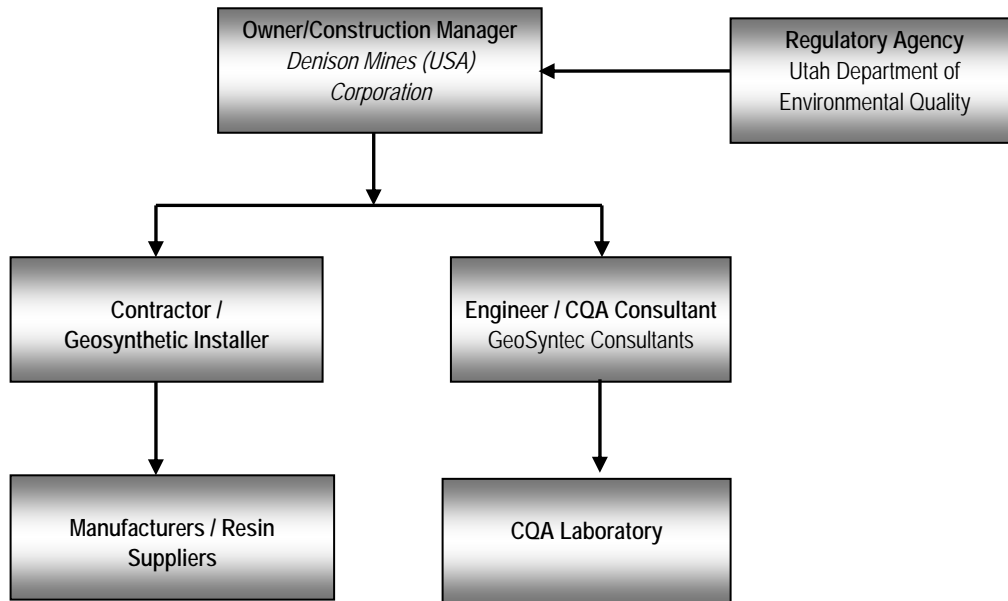
The CQA Laboratory will have experience in testing soils and geosynthetic materials and will be familiar with ASTM and other applicable test standards. The CQA Laboratory will be capable of providing test results within a maximum of seven days of receipt of samples and will maintain that capability throughout the duration of earthworks construction and geosynthetic materials installation. The CQA Laboratory will also be capable of transmitting geosynthetic destructive test results within 24 hours of receipt of samples and will maintain that capability throughout the duration of geosynthetic material installation.

## **2.11 Lines of Communication**

The following organization chart indicates the lines of communication and authority related to this project.



**Project Organization Chart  
International Uranium (USA) Corporation  
White Mesa Mill Cell 4A**



**2.12 Deficiency Identification and Rectification**

If a defect is discovered in the work, the CQA Engineer will evaluate the extent and nature of the defect. If the defect is indicated by an unsatisfactory test result, the CQA Engineer will determine the extent of the deficient area by additional tests, observations, a review of records, or other means that the CQA Engineer deems appropriate.

After evaluating the extent and nature of a defect, the CQA Engineer will notify the Construction Manager and schedule appropriate re-tests when the work deficiency is corrected by the Contractor.

The Contractor will correct the deficiency to the satisfaction of the CQA Engineer. If a project specification criterion cannot be met, or unusual weather conditions hinder work, then the CQA Engineer will develop and present to the Design

Engineer suggested solutions for approval. Major modification to the Construction Drawings, Technical Specifications, or this CQA Plan must be provided to the regulatory agency for review prior to implementation.

Defect corrections will be monitored and documented by CQA personnel prior to subsequent work by the Contractor in the area of the deficiency.

### **3. CQA CONSULTANTS PERSONNEL ORGANIZATION AND DUTIES**

#### **3.1 Overview**

The CQA Officer will provide supervision within the scope of work of the CQA Consultant. The scope of work for the CQA Consultant includes monitoring of construction activities including the following:

- subgrade preparation;
- installation of geosynthetic clay liner;
- installation of geomembrane;
- installation of geonet;
- installation of drainage aggregate;
- installation of piping; and
- installation of geotextile.

Duties of CQA personnel are discussed in the remainder of this section.

#### **3.2 CQA Personnel**

The CQA Consultant's personnel will include:

- the CQA Officer, who works from the office of the CQA Consultant and who conducts periodic visits to the site as required; and
- the CQA Site Manager, who is located at the site.

### 3.3 **CQA Officer**

The CQA Officer shall supervise and be responsible for monitoring and CQA activities relating to the construction of the earthworks, piping, and installation of the geosynthetic materials of the Project. Specifically, the CQA Officer:

- reviews the project design, this CQA Plan, *Drawings*, and *Technical Specifications*;
- reviews other site-specific documentation; unless otherwise agreed, such reviews are for familiarization and for evaluation of constructability only, and hence the CQA Officer and the CQA Consultant assume no responsibility for the liner system design;
- reviews and approves the Geosynthetic Installer's Quality Control (QC) Plan;
- attends Pre-Construction Meetings as needed;
- administers the CQA program (i.e., provides supervision of and manages on-site CQA personnel, reviews field reports, and provides engineering review of CQA related activities);
- provides quality control of CQA documentation and conducts site visits;
- reviews the *Record Drawings*; and
- with the CQA Site Manager, prepares the CQA report documenting that the project was constructed in accordance with the Construction Documents.

### 3.4 **CQA Site Manager**

The CQA Site Manager:

- acts as the on-site representative of the CQA Consultant;
- attends CQA-related meetings (e.g., pre-construction, daily, weekly (or designates a representative to attend the meetings));

- oversees the ongoing preparation of the *Record Drawings*;
- reviews test results provided by Contractor;
- assigns locations for testing and sampling;
- oversees the collection and shipping of laboratory test samples;
- reviews results of laboratory testing and makes appropriate recommendations;
- reviews the calibration and condition of on-site CQA equipment;
- prepares a daily summary report for the project;
- reviews the MQC documentation;
- reviews the Geosynthetic Installer's personnel Qualifications for conformance with those pre-approved for work on site;
- notes on-site activities in daily field reports and reports to the CQA Officer and Construction Manager;
- reports unresolved deviations from the CQA Plan, *Drawings*, and *Technical Specifications* to the Construction Manager; and
- assists with the preparation of the CQA report.

## **4. SITE AND PROJECT CONTROL**

### **4.1 Project Coordination Meetings**

Meetings of key project personnel are necessary to assure a high degree of quality during installation and to promote clear, open channels of communication. Therefore, Project Coordination Meetings are an essential element in the success of the project. Several types of Project Coordination Meetings are described below, including: (i) pre-construction meetings; (ii) progress meetings; and (iii) problem or work deficiency meetings.

#### **4.1.1 Pre-Construction Meeting**

A Pre-Construction Meeting will be held at the site prior to construction of the Project. At a minimum, the Pre-Construction Meeting will be attended by the Contractor, the Geosynthetic Installer's Superintendent, the CQA Consultant, and the Construction Manager.

Specific items for discussion at the Pre-Construction Meeting include the following:

- appropriate modifications or clarifications to the CQA Plan;
- the *Drawings* and *Technical Specifications*;
- the responsibilities of each party;
- lines of authority and communication;
- methods for documenting and reporting, and for distributing documents and reports;
- acceptance and rejection criteria;
- protocols for testing;
- protocols for handling deficiencies, repairs, and re-testing;
- the time schedule for all operations;

- procedures for packaging and storing archive samples;
- panel layout and numbering systems for panels and seams;
- seaming procedures;
- repair procedures; and
- soil stockpiling locations.

The Construction Manager will conduct a site tour to observe the current site conditions and to review construction material and equipment storage locations. A person in attendance at the meeting will be appointed by the Construction Manager to record the discussions and decisions of the meeting in the form of meeting minutes. Copies of the meeting minutes will be distributed to all attendees.

#### **4.1.2 Progress Meetings**

Progress meetings will be held between the CQA Site Manager, the Contractor, Construction Manager, and other concerned parties participating in the construction of the project. This meeting will include discussions on the current progress of the project, planned activities for the next week, and revisions to the work plan and/or schedule. The meeting will be documented in meeting minutes prepared by a person designated by the CQA Site Manager at the beginning of the meeting. Within 2 working days of the meeting, draft minutes will be transmitted to representatives of parties in attendance for review and comment. Corrections and/or comments to the draft minutes shall be made within 2 working days of receipt of the draft minutes to be incorporated in the final meeting minutes.

#### **4.1.3 Problem or Work Deficiency Meeting**

A special meeting will be held when and if a problem or deficiency is present or likely to occur. The meeting will be attended by the Contractor, the Construction Manager, the CQA Site Manager, and other parties as appropriate. If the problem requires a design modification, the Engineer should either be present at, consulted prior to, or notified immediately upon conclusion of this meeting. The purpose of the work deficiency meeting is to define and resolve the problem or work deficiency as follows:

- define and discuss the problem or deficiency;
- review alternative solutions;
- select a suitable solution agreeable to all parties; and
- implement an action plan to resolve the problem or deficiency.

The Construction Manager will appoint one attendee to record the discussions and decisions of the meeting. The meeting record will be documented in the form of meeting minutes and copies will be distributed to all affected parties. A copy of the minutes will be retained in facility records.



## **5. DOCUMENTATION**

### **5.1 Overview**

An effective CQA Plan depends largely on recognition of all construction activities that should be monitored and on assigning responsibilities for the monitoring of each activity. This is most effectively accomplished and verified by the documentation of quality assurance activities. The CQA Consultant will document that quality assurance requirements have been addressed and satisfied.

The CQA Site Manager will provide the Construction Manager with signed descriptive remarks, data sheets, and logs to verify that monitoring activities have been carried out. The CQA Site Manager will also maintain, at the job site, a complete file of *Drawings* and *Technical Specifications*, a CQA Plan, checklists, test procedures, daily logs, and other pertinent documents.

### **5.2 Daily Recordkeeping**

Preparation of daily CQA documentation will consist of daily field reports prepared by the CQA Site Manager which may include CQA monitoring logs and testing data sheets. This information may be regularly submitted to and reviewed by the Construction Manager. Daily field reports will include documentation of the observed activities during each day of activity. The daily field reports may include monitoring logs and testing data sheets. At a minimum, these logs and data sheets will include the following information:

- the date, project name, location, and other identification;
- a summary of the weather conditions;
- a summary of locations where construction is occurring;
- equipment and personnel on the project;
- a summary of meetings held and attendees;
- a description of materials used and references of results of testing and documentation;

- identification of deficient work and materials;
- results of re-testing corrected “deficient work;”
- an identifying sheet number for cross referencing and document control;
- descriptions and locations of construction monitored;
- type of construction and monitoring performed;
- description of construction procedures and procedures used to evaluate construction;
- a summary of test data and results;
- calibrations or re-calibrations of test equipment and actions taken as a result of re-calibration;
- decisions made regarding acceptance of units of work and/or corrective actions to be taken in instances of substandard testing results;
- a discussion of agreements made between the interested parties which may affect the work; and
- signature of the respective CQA Site Manager.

### **5.3 Construction Problems and Resolution Data Sheets**

Construction Problems and Resolution Data Sheets, to be submitted with the daily field reports prepared by the CQA Site Manager, describing special construction situations, will be cross-referenced with daily field reports, specific observation logs, and testing data sheets and will include the following information, where available:

- an identifying sheet number for cross-referencing and document control;
- a detailed description of the situation or deficiency;
- the location and probable cause of the situation or deficiency;

- how and when the situation or deficiency was found or located;
- documentation of the response to the situation or deficiency;
- final results of responses;
- measures taken to prevent a similar situation from occurring in the future; and
- signature of the CQA Site Manager and a signature indicating concurrence by the Construction Manager.

The Construction Manager will be made aware of significant recurring nonconformance with the *Drawings*, *Technical Specifications*, or CQA Plan. The cause of the nonconformance will be determined and appropriate changes in procedures or specifications will be recommended. These changes will be submitted to the Construction Manager for approval. When this type of evaluation is made, the results will be documented and any revision to procedures or specifications will be approved by the Contractor and Engineer.

A summary of supporting data sheets, along with final testing results and the CQA Site Manager's approval of the work, will be required upon completion of construction.

#### **5.4 Photographic Documentation**

Photographs will be taken and documented in order to serve as a pictorial record of work progress, problems, and mitigation activities. These records will be presented to the Construction Manager upon completion of the project. Photographic reporting data sheets, where used, will be cross-referenced with observation and testing data sheet(s), and/or construction problem and solution data sheet(s).

#### **5.5 Design and/or Specifications Changes**

Design and/or specifications changes may be required during construction. In such cases, the CQA Site Manager will notify the Engineer. Design and/or specification changes will be made with the written agreement of the Engineer and will take the form of an addendum to the *Drawings* and *Technical Specifications*.

## 5.6 CQA Report

At the completion of the Project, the CQA Consultant will submit to the Owner a CQA report signed and sealed by the Professional Engineer licensed in the State of Utah. The CQA report will acknowledge: (i) that the work has been performed in compliance with the *Drawings* and *Technical Specifications*; (ii) physical sampling and testing has been conducted at the appropriate frequencies; and (iii) that the summary document provides the necessary supporting information. At a minimum, this report will include:

- MQC documentation;
- a summary report describing the CQA activities and indicating compliance with the *Drawings* and *Technical Specifications* which is signed and sealed by the CQA Officer;
- a summary of CQA/CQC testing, including failures, corrective measures, and retest results;
- Contractor and Installer personnel resumes and qualifications as necessary;
- documentation that the geomembrane trial seams were performed in accordance with the CQA Plan and *Technical Specifications*;
- documentation that field seams were non-destructively tested using a method in accordance with the applicable test standards;
- documentation that nondestructive testing was monitored by the CQA Consultant, that the CQA Consultant informed the Geosynthetic Installer of any required repairs, and that the CQA Consultant monitored the seaming and patching operations for uniformity and completeness;
- records of sample locations, the name of the individual conducting the tests, and the results of tests;
- *Record Drawings* as provided by the Surveyor;
- daily field reports.

The *Record Drawings* will include scale drawings depicting the location of the construction and details pertaining to the extent of construction (e.g., plan dimensions and appropriate elevations). *Record Drawings* and required base maps will be prepared by a qualified Professional Land Surveyor registered in the State of Utah. These documents will be reviewed by the CQA Consultant and included as part of the CQA Report.

## **6. EARTHWORK**

### **6.1 Introduction**

This section prescribes the CQA activities to be performed to monitor that prepared subgrade is constructed in accordance with *Drawings* and *Technical Specifications*. The prepared subgrade construction procedures to be monitored by the CQA Consultant, if required, shall include:

- vegetation removal;
- subgrade preparation;
- fine-grading; and
- anchor trench excavation and backfill.

### **6.2 Subgrade Soil Testing Activities**

Testing of subgrade soil to be used for subgrade, if required to attain grade, will be performed for material conformance. The CQA Laboratory will perform the conformance testing and CQC testing. Subgrade soil testing will be conducted in accordance with the current versions of the corresponding American Society for Testing and Materials (ASTM) test procedures. The test methods indicated in Table 1 are those that will be used for this testing unless the test methods are updated or revised prior to construction. Revisions to the test methods will be reviewed and approved by the Engineer and the CQA Site Manager prior to their usage.

#### **6.2.1 Sample Frequency**

The frequency of subgrade soil testing for material qualification and material conformance will conform to the minimum frequencies presented in Table 1A. The frequency of subgrade soil testing shall conform to the minimum frequencies presented in Table 1B. The actual frequency of testing required will be increased by the CQA Site Manager, as necessary, if variability of materials is noted at the site, during adverse conditions, or to isolate failing areas of the construction.

## 6.2.2 Sample Selection

Sampling locations will be selected by the CQA Site Manager. Conformance samples will be obtained from borrow pits and/or stockpiles of material. The Contractor must plan the work and make subgrade soil available for sampling in a timely and organized manner so that the test results can be obtained before the material is installed. The CQA Site Manager must document sample locations so that failing areas can be immediately isolated. The CQA Site Manager will follow standard sampling procedures to obtain representative samples of the proposed subgrade soil materials.

## 6.3 CQA Monitoring Activities

### 6.3.1 Vegetation Removal

The CQA Site Manager will monitor and document that vegetation is sufficiently cleared and grubbed in areas where geosynthetics are to be placed. Vegetation removal shall be performed as described in the *Technical Specification* and the *Drawings*.

### 6.3.2 Grading

Construction of the Cell 4A liner system will require minor re-grading in certain areas. The CQA Site Manager shall monitor and document that site re-grading performed meets the requirements of the *Technical Specifications* and the *Drawings*. At a minimum, the CQA Site Manager shall monitor that:

- the subgrade surface is free of sharp rocks, debris, and other undesirable materials;
- the subgrade surface is smooth and uniform by visually monitoring proof rolling activities; and
- the subgrade surface meets the lines and grades shown on the *Drawings*.

### 6.3.3 Subgrade Soil

During construction, the CQA Site Manager will monitor the subgrade soil placement and compaction methods are consistent with the requirements specified in the *Technical Specifications* and the *Drawings*. The CQA Site Manager will monitor, at a minimum, that:

- the subgrade soil is free of debris and other undesirable materials and that particles are no larger than 6-inches in longest dimension;
- the subgrade soil is constructed to the lines and grades shown on the *Drawings*; and
- compaction requirements are met as specified in the *Technical Specifications*.

### 6.3.4 Anchor Trench Construction

During construction, the CQA Site Manager will monitor the anchor trench excavation and backfill methods are consistent with the requirements specified in the *Technical Specifications* and the *Drawings*. The CQA Site Manager will monitor, at a minimum, that:

- the anchor trench is free of sharp rocks, debris and other undesirable materials and that particles are no larger than 6-inches in longest dimension;
- the anchor trench is constructed to the lines and grades shown on the *Drawings*; and
- compaction requirements are met, through visual observations, as specified in the *Technical Specifications*.

## 6.4 Deficiencies

If a defect is discovered in the earthwork product, the CQA Site Manager will immediately determine the extent and nature of the defect. If the defect is indicated by an unsatisfactory test result, the CQA Site Manager will determine the extent of the



defective area by additional tests, observations, a review of records, or other means that the CQA Site Manager deems appropriate. If the defect is related to adverse site conditions, such as overly wet soils or non-conforming particle sizes, the CQA Site Manager will define the limits and nature of the defect.

#### **6.4.1 Notification**

After evaluating the extent and nature of a defect, the CQA Site Manager will notify the Construction Manager and Contractor and schedule appropriate re-evaluation when the work deficiency is to be corrected.

#### **6.4.2 Repairs and Re-Testing**

The Contractor will correct deficiencies to the satisfaction of the CQA Site Manager. If a project specification criterion cannot be met, or unusual weather conditions hinder work, then the CQA Site Manager will develop and present to the Construction Manager suggested solutions for his approval.

Re-evaluations by the CQA Site Manager shall continue until it is verified that defects have been corrected before any additional work is performed by the Contractor in the area of the deficiency.

## **7. DRAINAGE AGGREGATE**

### **7.1 Introduction**

This section prescribes the CQA activities to be performed to monitor that drainage aggregates are constructed in accordance with *Drawings* and *Technical Specifications*. The drainage aggregates construction procedures to be monitored by the CQA Consultant include drainage aggregate placement.

### **7.2 Testing Activities**

Aggregate testing will be performed for material qualification and material conformance. These two stages of testing are defined as follows:

- Material qualification tests are used to evaluate the conformance of a proposed aggregate source with the *Technical Specifications* for qualification of the source prior to construction.
- Aggregate conformance testing is used to evaluate the conformance of a particular batch of aggregate from a qualified source to the *Technical Specifications* prior to installation of the aggregate.

The Contractor will be responsible for submitting material qualification test results to the Construction Manager and to the CQA Site Manager for review. The CQA Laboratory will perform the conformance testing and CQC testing. Aggregate testing will be conducted in accordance with the current versions of the corresponding American Society for Testing and Materials (ASTM) test procedures. The test methods indicated in Table 2 are those that will be used for this testing unless the test methods are updated or revised prior to construction. Revisions to the test methods will be reviewed and approved by the Engineer and the CQA Site Manager prior to their usage.

#### **7.2.1 Sample Frequency**

The frequency of aggregate testing for material qualification and material conformance will conform to the minimum frequencies presented in Table 2A. The frequency of aggregate testing shall conform to the minimum frequencies presented in

Table 2B. The actual frequency of testing required will be increased by the CQA Site Manager, as necessary, if variability of materials is noted at the site, during adverse conditions, or to isolate failing areas of the construction.

### **7.2.2 Sample Selection**

With the exception of qualification samples, sampling locations will be selected by the CQA Site Manager. Conformance samples will be obtained from borrow pits and/or stockpiles of material. The Contractor must plan the work and make aggregate available for sampling in a timely and organized manner so that the test results can be obtained before the material is installed. The CQA Site Manager must document sample locations so that failing areas can be immediately isolated. The CQA Site Manager will follow standard sampling procedures to obtain representative samples of the proposed aggregate materials.

## **7.3 CQA Monitoring Activities**

### **7.3.1 Drainage Aggregate**

The CQA Site Manager will monitor and document the installation of the drainage aggregates. In general, monitoring of the installation of drainage aggregate includes the following activities:

- reviewing documentation of the material qualification test results provided by the Contractor;
- sampling and testing for conformance of the materials to the *Technical Specifications*;
- documenting that the drainage aggregates are installed using the specified equipment and procedures;
- documenting that the drainage aggregates are constructed to the lines and grades shown on the *Drawings*; and
- monitoring that the construction activities do not cause damage to underlying geosynthetic materials.

## **7.4      Deficiencies**

If a defect is discovered in the drainage aggregates, the CQA Site Manager will evaluate the extent and nature of the defect. If the defect is indicated by an unsatisfactory test result, the CQA Site Manager will determine the extent of the deficient area by additional tests, observations, a review of records, or other means that the CQA Site Manager deems appropriate.

### **7.4.1      Notification**

After evaluating the extent and nature of a defect, the CQA Site Manager will notify the Construction Manager and Contractor and schedule appropriate re-tests when the work deficiency is to be corrected.

### **7.4.2      Repairs and Re-testing**

The Contractor will correct the deficiency to the satisfaction of the CQA Site Manager. If a project specification criterion cannot be met, or unusual weather conditions hinder work, then the CQA Site Manager will develop and present to the Construction Manager suggested solutions for approval.

Re-tests recommended by the CQA Site Manager shall continue until it is verified that the defect has been corrected before any additional work is performed by the Contractor in the area of the deficiency. The CQA Site Manager will also verify that installation requirements are met and that submittals are provided.

## **8. POLYVINYL CHLORIDE (PVC) PIPE AND STRIP COMPOSITE**

### **8.1 Material Requirements**

PVC pipe, fittings, and strip composite must conform to the requirements of the *Technical Specifications*. The CQA Consultant will document that the PVC pipe, fittings, and strip composite meet those requirements.

### **8.2 Manufacturer**

#### **8.2.1 Submittals**

Prior to the installation of PVC pipe and strip composite, the Manufacturer will provide to the CQA Consultant:

- a properties' sheet including, at a minimum, all specified properties, measured using test methods indicated in the *Technical Specifications*, or equivalent; and

The CQA Consultant will document that:

- the property values certified by the Manufacturer meet the *Technical Specifications*; and
- the measurements of properties by the Manufacturer are properly documented and that the test methods used are acceptable.

### **8.3 Handling and Laying**

Care will be taken during transportation of the pipe such that it will not be cut, kinked, or otherwise damaged. Ropes, fabric, or rubber-protected slings and straps will be used when handling pipes. Chains, cables, or hooks inserted into the pipe ends will not be used. Two slings spread apart will be used for lifting each length of pipe. Pipe or fittings will not be dropped onto rocky or unprepared ground.

Pipes will be handled and stored in accordance with the Manufacturer's recommendation. The handling of joined pipe will be in such a manner that the pipe is not damaged by dragging it over sharp and cutting objects. Slings for handling the pipe will not be positioned at joints. Sections of the pipes with deep cuts and gouges will be removed and the ends of the pipe rejoined.

#### **8.4      Perforations**

The CQA Site Manager shall monitor and document that the perforations of the PVC pipe conform to the requirements of the *Drawings* and the *Technical Specifications*.

#### **8.5      Joints**

The CQA Monitor shall monitor and document that pipe and fittings are joined by the methods indicated in the *Technical Specifications*.

#### **8.6      Strip Composite**

The CQA Site Monitor shall monitor and document that the strip composite and sandbags meet and are installed in accordance with the requirements outlined on the drawings and in the *Technical Specifications*.

## **9. GEOMEMBRANE**

### **9.1 General**

This section discusses and outlines the CQA activities to be performed for high density polyethylene (HDPE) geomembrane installation. The CQA Site Manager will review the *Drawings*, *Technical Specifications*, and any approved Addenda regarding this material.

### **9.2 Geomembrane Material Conformance**

#### **9.2.1 Introduction**

The CQA Site Manager will document that the geomembrane delivered to the site meets the requirements of the *Technical Specifications* prior to installation. The CQA Site Manager will:

- review the manufacturer's submittals for compliance with the *Technical Specifications*;
- document the delivery and proper storage of geomembrane rolls; and
- conduct conformance testing of the rolls before the geomembrane is installed.

The following sections describe the CQA activities required to verify the conformance of geomembrane.

#### **9.2.2 Review of Quality Control**

##### 9.2.2.1 Material Properties Certification

The Manufacturer will provide the Construction Manager and the CQA Site Manager with the following:

- Property data sheets, including, at a minimum, all specified properties, measured using test methods indicated in the *Technical Specifications*, or equivalent;
- sampling procedures and results of testing.

The CQA Site Manager will document that:

- the property values certified by the Manufacturer meet all of the requirements of the *Technical Specifications*; and
- the measurements of properties by the Manufacturer are properly documented and that the test methods used are acceptable.

#### 9.2.2.2 Geomembrane Roll MQC Certification

Prior to shipment, the Manufacturer will provide the Construction Manager and the CQA Site Manager with MQC certificates for every roll of geomembrane provided. The MQC certificates will be signed by a responsible party employed by the Geomembrane Manufacturer, such as the production manager. The MQC certificates shall include:

- roll numbers and identification; and
- results of MQC tests - as a minimum, results will be given for thickness, specific gravity, carbon black content, carbon black dispersion, tensile properties, and puncture resistance evaluated in accordance with the methods indicated in the *Technical Specifications* or equivalent methods approved by the Construction Manager.

The CQA Site Manager will document that:



- that MQC certificates have been provided at the specified frequency, and that the certificates identify the rolls related to the roll represented by the test results; and
- review the MQC certificates and monitor that the certified roll properties meet the specifications.

### **9.2.3 Conformance Testing**

The CQA Site Manager shall obtain conformance samples (at the manufacturing facility or site) at the specified frequency and forward them to the Geosynthetics CQA Laboratory for testing to monitor conformance to both the *Technical Specifications* and the list of properties certified by the Manufacturer. The test procedures will be as indicated in Table 3. Where optional procedures are noted in the test method, the requirements of the *Technical Specifications* will prevail.

Samples will be taken across the width of the roll and will not include the first linear 3 ft of material. Unless otherwise specified, samples will be 3 ft long by the roll width. The CQA Site Manager will mark the machine direction on the samples with an arrow along with the date and roll number. The required minimum sampling frequencies are provided in Table 3.

The CQA Site Manager will examine results from laboratory conformance testing and will report any non-conformance to the Construction Manager and the Geosynthetic Installer. The procedures prescribed in the *Technical Specifications* will be followed in the event of a failing conformance test.

## **9.3 Delivery**

### **9.3.1 Transportation and Handling**

The CQA Site Manager will document that the transportation and handling does not pose a risk of damage to the geomembrane.

Upon delivery of the rolls of geomembrane, the CQA Site Manager will document that the rolls are unloaded and stored on site as required by the *Technical*

*Specifications*. Damage caused by unloading will be documented by the CQA Site Manager and the damaged material shall not be installed.

### **9.3.2 Storage**

The Geosynthetic Installer will be responsible for the storage of the geomembrane on site. The Contractor will provide storage space in a location (or several locations) such that on-site transportation and handling are optimized, if possible, to limit potential damage.

The CQA Site Manager will document that storage of the geomembrane provides adequate protection against sources of damage.

## **9.4 Geomembrane Installation**

### **9.4.1 Introduction**

The CQA Consultant will document that the geomembrane installation is carried out in accordance with the *Drawings*, *Technical Specifications*, and Manufacturer's recommendations.

### **9.4.2 Earthwork**

#### 9.4.2.1 Surface Preparation

The CQA Site Manager will document that:

- the prepared subgrade meets the requirements of the *Technical Specifications* and has been approved; and
- placement of the overlying materials does not damage, create large wrinkles, or induce excessive tensile stress in any underlying geosynthetic materials.

The Geosynthetic Installer will certify in writing that the surface on which the geomembrane will be installed is acceptable. The Certificate of Acceptance, as presented in the *Technical Specifications*, will be signed by the Geosynthetic Installer

and given to the CQA Site Manager prior to commencement of geomembrane installation in the area under consideration.

After the subgrade has been accepted by the Geosynthetic Installer, it will be the Geosynthetic Installer's responsibility to indicate to the Construction Manager any change in the subgrade soil condition that may require repair work. If the CQA Site Manager concurs with the Geosynthetic Installer, then the CQA Site Manager shall monitor and document that the subgrade soil is repaired before geosynthetic installation begins.

At any time before and during the geomembrane installation, the CQA Site Manager will indicate to the Construction Manager locations that may not provide adequate support to the geomembrane.

#### 9.4.2.2 Geosynthetic Termination

The CQA Site Manager will document that the geosynthetic terminations (Anchor Trench) have been constructed in accordance with the *Drawings*. Backfilling above the terminations will be conducted in accordance with the *Technical Specifications*.

### 9.4.3 Geomembrane Placement

#### 9.4.3.1 Panel Identification

A field panel is the unit area of geomembrane which is to be seamed in the field, i.e., a field panel is a roll or a portion of roll cut in the field. It will be the responsibility of the CQA Site Manager to document that each field panel is given an "identification code" (number or letter-number) consistent with the Panel Layout Drawing. This identification code will be agreed upon by the Construction Manager, Geosynthetic Installer and CQA Site Manager. This field panel identification code will be as simple and logical as possible. Roll numbers established in the manufacturing plant must be traceable to the field panel identification code.

The CQA Site Manager will establish documentation showing correspondence between roll numbers, and field panel identification codes. The field panel identification code will be used for all CQA records.

### 9.4.3.2 Field Panel Placement

#### *Location*

The CQA Site Manager will document that field panels are installed at the location indicated in the Geosynthetic Installer's Panel Layout Drawing, as approved or modified by the Construction Manager.

#### *Installation Schedule*

Field panels may be installed using one of the following schedules:

- all field panels are placed prior to field seaming in order to protect the subgrade from erosion by rain;
- field panels are placed one at a time and each field panel is seamed after its placement (in order to minimize the number of unseamed field panels exposed to wind); and
- any combination of the above.

If a decision is reached to place all field panels prior to field seaming, it is usually beneficial to begin at the high point area and proceed toward the low point with "shingle" overlaps to facilitate drainage in the event of precipitation. It is also usually beneficial to proceed in the direction of prevailing winds. Accordingly, an early decision regarding installation scheduling should be made if and only if weather conditions can be predicted with reasonable certainty. Otherwise, scheduling decisions must be made during installation, in accordance with varying conditions. In any event, the Geosynthetic Installer is fully responsible for the decision made regarding placement procedures.

The CQA Site Manager will evaluate every change in the schedule proposed by the Geosynthetic Installer and advise the Construction Manager on the acceptability of that change. The CQA Site Manager will document that the condition of the subgrade soil has not changed detrimentally during installation.

The CQA Site Manager will record the identification code, location, and date of installation of each field panel.

#### *Weather Conditions*

Geomembrane placement will not proceed unless otherwise authorized when the ambient temperature is below 40°F or above 122°F. In addition, wind speeds and direction will be monitored for potential impact to geosynthetic installation. Geomembrane placement will not be performed during any precipitation, in the presence of excessive moisture (e.g., fog, dew), and/or in an area of ponded water.

The CQA Site Manager will document that the above conditions are fulfilled. Additionally, the CQA Site Manager will document that the subgrade soil has not been damaged by weather conditions. The Geosynthetics Installer will inform the Construction Manager if the above conditions are not fulfilled.

#### *Method of Placement*

The CQA Site Manager will document the following:

- equipment used does not damage the geomembrane by handling, trafficking, excessive heat, leakage of hydrocarbons or other means;
- the surface underlying the geomembrane has not deteriorated since previous acceptance, and is still acceptable immediately prior to geomembrane placement;
- geosynthetic elements immediately underlying the geomembrane are clean and free of debris;
- personnel working on the geomembrane do not smoke, wear damaging shoes, or engage in other activities which could damage the geomembrane;
- the method used to unroll the panels does not cause scratches or crimps in the geomembrane and does not damage the supporting soil;
- the method used to place the panels minimizes wrinkles (especially differential wrinkles between adjacent panels); and

- adequate temporary loading and/or anchoring (e.g., sand bags, tires), not likely to damage the geomembrane, has been placed to prevent uplift by wind (in case of high winds, continuous loading, e.g., by adjacent sand bags, is recommended along edges of panels to minimize risk of wind flow under the panels).

The CQA Site Manager will inform the Construction Manager if the above conditions are not fulfilled.

Damaged panels or portions of damaged panels that have been rejected will be marked and their removal from the work area recorded by the CQA Site Manager. Repairs will be made in accordance with procedures described in Section 9.4.5.

#### **9.4.4 Field Seaming**

This section details CQA procedures to document that seams are properly constructed and tested in accordance with the Manufacturer's specifications and industry standards.

##### **9.4.4.1 Requirements of Personnel**

All personnel performing seaming operations will be qualified by experience or by successfully passing seaming tests, as outlined in the *Technical Specifications*. The most experienced seamer, the "master seamer", will provide direct supervision over less experienced seamers.

The Geosynthetic Installer will provide the Construction Manager and the CQA Site Manager with a list of proposed seaming personnel and their experience records. These documents will be reviewed by the Construction Manager and the Geosynthetics CQA Manager.

##### **9.4.4.2 Seaming Equipment and Products**

Approved processes for field seaming are fillet extrusion welding and double-track fusion welding.

### *Fillet Extrusion Process*

The fillet extrusion-welding apparatus will be equipped with gauges giving the temperature in the apparatus.

The Geosynthetic Installer will provide documentation regarding the extrusion welding rod to the CQA Site Manager, and will certify that the extrusion welding rod is compatible with the *Technical Specification*, and in any event, is comprised of the same resin as the geomembrane.

The CQA Site Manager will log apparatus temperatures, ambient temperatures, and geomembrane surface temperatures at appropriate intervals.

The CQA Site Manager will document that:

- the Geosynthetic Installer maintains, on site, the number of spare operable seaming apparatus decided at the Pre-construction Meeting;
- equipment used for seaming is not likely to damage the geomembrane;
- the extruder is purged prior to beginning a seam until all heat-degraded extrudate has been removed from the barrel;
- the electric generator is placed on a smooth base such that no damage occurs to the geomembrane;
- a smooth insulating plate or fabric is placed beneath the hot welding apparatus after usage; and
- the geomembrane is protected from damage in heavily trafficked areas.

### *Fusion Process*

The fusion-welding apparatus must be automated vehicular-mounted devices. The fusion-welding apparatus will be equipped with gauges giving the applicable temperatures and pressures.

The CQA Site Manager will log ambient, seaming apparatus, and geomembrane surface temperatures as well as seaming apparatus speeds.

The CQA Site Manager will also document that:

- the Geosynthetic Installer maintains on-site the number of spare operable seaming apparatus decided at the Pre-construction Meeting;
- equipment used for seaming is not likely to damage the geomembrane;
- for cross seams, the edge of the cross seam is ground to a smooth incline (top and bottom) prior to welding;
- the electric generator is placed on a smooth cushioning base such that no damage occurs to the geomembrane from ground pressure or fuel leaks;
- a smooth insulating plate or fabric is placed beneath the hot welding apparatus after usage; and
- the geomembrane is protected from damage in heavily trafficked areas.



#### 9.4.4.3 Seam Preparation

The CQA Site Manager will document that:

- prior to seaming, the seam area is clean and free of moisture, dust, dirt, debris, and foreign material; and
- seams are aligned with the fewest possible number of wrinkles and “fishmouths.”

#### 9.4.4.4 Weather Conditions for Seaming

The normally required weather conditions for seaming are as follows unless authorized in writing by the Engineer:

- seaming will only be approved between ambient temperatures of 40°F and 122°F.

If the Geosynthetic Installer wishes to use methods that may allow seaming at ambient temperatures below 40°F or above 122°F, the Geosynthetic Installer will demonstrate and certify that such methods produce seams which are entirely equivalent to seams produced within acceptable temperature, and that the overall quality of the geomembrane is not adversely affected.

The CQA Site Manager will document that these seaming conditions are fulfilled and will advise the Geosynthetics Installer if they are not.

#### 9.4.4.5 Overlapping and Temporary Bonding

The CQA Site Manager will document that:

- the panels of geomembrane have a finished overlap of a minimum of 3 in. for both extrusion and fusion welding;
- no solvent or adhesive bonding materials are used; and

- the procedures utilized to temporarily bond adjacent panels together does not damage the geomembrane.

The CQA Site Manager will log appropriate temperatures and conditions, and will log and report non-compliances to the Construction Manager.

#### 9.4.4.6 Trial Seams

Trial seams shall be prepared with the procedures and dimensions as indicated in the *Technical Specifications*. The CQA Site Manager will observe trial seam procedures and will document the results of trial seams on trial seam logs. Each trial seam samples will be assigned a number. The CQA Site Manager, will log the date, time, machine temperature(s), seaming unit identification, name of the seamer, and pass or fail description for each trial seam sample tested.

Separate trial seaming logs shall be maintained for fusion welded and extrusion welded trial seams.

#### 9.4.4.7 General Seaming Procedure

Unless otherwise specified, the general production seaming procedure used by the Geosynthetic Installer will be as follows:

- Fusion-welded seams are continuous, commencing at one end to the seam and ending at the opposite end.
- Cleaning, overlap, and shingling requirements shall be maintained.
- If seaming operations are carried out at night, adequate illumination will be provided at the Geosynthetic Installer's expense.
- Seaming will extend to the outside edge of panels to be placed in the anchor trench.

The CQA Site Manager shall document geomembrane seaming operations on seaming logs. Seaming logs shall include, at a minimum:

- Seam identifications (typically associated with panels being joined);
- Seam starting time and date;
- Seam ending time and date;
- Seam length;
- Identification of person performing seam; and
- Identification of seaming equipment.

Separate logs shall be maintained for fusion and extrusion welded seams. In addition, the CQA Site Manager shall monitor during seaming that:

- Fusion-welded seams are continuous, commencing at one end of the seam and ending at the opposite end.
- Cleaning, overlap, and shingling requirements are maintained.

#### 9.4.4.8 Nondestructive Seam Continuity Testing

##### *Concept*

The Geosynthetic Installer will non-destructively test field seams over their length using a vacuum test unit, air pressure test (for double fusion seams only), or other method approved by the Construction Manager. The purpose of nondestructive tests is to check the continuity of seams. It does not provide information on seam strength. Continuity testing will be carried out as the seaming work progresses, not at the completion of field seaming.

The CQA Site Manager will:

- observe continuity testing;
- record location, date, name of person conducting the test, and the results of tests; and
- inform the Geosynthetic Installer of required repairs.

The Geosynthetic Installer will complete any required repairs in accordance with Section 9.4.5.

The CQA Site Manager will:

- observe the repair and re-testing of the repair;
- mark on the geomembrane that the repair has been made; and
- document the results.

The following procedures will apply to locations where seams cannot be non-destructively tested:

All such seams will be cap-stripped with the same geomembrane.

- If the seam is accessible to testing equipment prior to final installation, the seam will be non-destructively tested prior to final installation.
- If the seam cannot be tested prior to final installation, the seaming and cap-stripping operations will be observed by the CQA Site Manager and Geosynthetic Installer for uniformity and completeness.

The seam number, date of observation, name of tester, and outcome of the test or observation will be recorded by the CQA Site Manager.

### *Vacuum Testing*

Vacuum testing shall be performed utilizing the equipment and procedures specified in the Technical Specifications. The CQA Site Manager shall observe the vacuum testing procedures and document that they are performed in accordance with the *Technical Specifications*. The result of vacuum testing shall be recorded on the CQA seaming logs. Results shall include, at a minimum, the personnel performing the vacuum test and the result of the test (pass or fail), and the test date. Seams failing the vacuum test shall be repaired in accordance with the procedures listed in the *Technical Specifications*. The CQA Site Manager shall document seam repairs in the seaming logs.

### *Air Pressure Testing*

Air channel pressure testing shall be performed on double-track seams created with a fusion welding device, utilizing the equipment and procedures specified in the *Technical Specifications*. The CQA Site Manager shall observe the vacuum testing procedures and document that they are performed in accordance with the *Technical Specifications*. The result of air channel pressure testing shall be recorded on the CQA seaming logs. Results shall include, at a minimum, personnel performing the air pressure test, the starting air pressure and time, the final air pressure and time, the drop in psi during the test, and the result of the test (pass or fail). Seams failing the air pressure test shall be repaired in accordance with the procedures listed in the *Technical Specifications*. The CQA Site Manager shall document seam repairs in the seaming logs.

## 9.4.4.9 Destructive Testing

### *Concept*

Destructive seam testing will be performed on site and at the independent CQA laboratory in accordance with the *Drawings* and the *Technical Specifications*. Destructive seam tests will be performed at selected locations. The purpose of these tests is to evaluate seam strength. Seam strength testing will be done as the seaming work progresses, not at the completion of all field seaming.

### *Location and Frequency*

The CQA Site Manager will select locations where seam samples will be cut out for laboratory testing. Those locations will be established as follows.

- The frequency of geomembrane seam testing is a minimum of one destructive sample per 500 feet of weld. The minimum frequency is to be evaluated as an average taken throughout the entire facility.
- A minimum of one test per seaming machine over the duration of the project.
- Additional test locations may be selected during seaming at the CQA Site Manager's discretion. Selection of such locations may be prompted by suspicion of excess crystallinity, contamination, offset welds, or any other potential cause of imperfect welding.

The Geosynthetic Installer will not be informed in advance of the locations where the seam samples will be taken.

### *Sampling Procedure*

Samples will be marked by the CQA Site Manager following the procedures listed in the *Technical Specifications*. Preliminary samples will be taken from either side of the marked sample and tested before obtaining the full sample per the requirements of the *Technical Specifications*. Samples shall be obtained by the Geosynthetic Installer. Samples shall be obtained as the seaming progresses in order to have laboratory test results before the geomembrane is covered by another material. The CQA Site Manager will:

- observe sample cutting and monitor that corners are rounded;
- assign a number to each sample, and mark it accordingly;
- record sample location on the Panel Layout Drawing; and
- record reason for taking the sample at this location (e.g., statistical routine, suspicious feature of the geomembrane).

Holes in the geomembrane resulting from destructive seam sampling will be immediately repaired in accordance with repair procedures described in Section 9.4.5. The continuity of the new seams in the repaired area will be tested in accordance with Section 9.4.4.8.

#### *Size and Distribution of Samples*

The destructive sample will be 12 in. (0.3 m) wide by 42 in. (1.1 m) long with the seam centered lengthwise. The sample will be cut into three parts and distributed as follows:

- one portion, measuring 12 in. × 12 in. (0.30 m × 0.30 m), to the Geosynthetic Installer for field testing;
- one portion, measuring 12 in. × 18 in. (0.30 m × 0.45 m), for CQA Laboratory testing; and
- one portion, measuring 12 in. × 12 in. (0.30 m × 0.30 m), to the Construction Manager for archive storage.

Final evaluation of the destructive sample sizes and distribution will be made at the Pre-Construction Meeting.

#### *Field Testing*

Field testing will be performed by the Geosynthetic Installer using a gauged tensiometer. Prior to field testing the Geosynthetic Installer shall submit a calibration certificate for gauge tensiometer to the CQA Consultant for review. Calibration must have been performed within one year of use on the current project. The destructive sample shall be tested according to the requirements of the *Technical Specifications*. The specimens shall not fail in the seam and shall meet the strength requirements outlined in the *Technical Specifications*. If any field test specimen fails, then the procedures outlined in *Procedures for Destructive Test Failures* of this section will be followed.

The CQA Site Manager will witness field tests and mark samples and portions with their number. The CQA Site Manager will also document the date and time, ambient temperature, number of seaming unit, name of seamer, welding apparatus temperatures and pressures, and pass or fail description.

#### *CQA Laboratory Testing*

Destructive test samples will be packaged and shipped, if necessary, under the responsibility of the CQA Site Manager in a manner that will not damage the test sample. The Construction Manager will be responsible for storing the archive samples. This procedure will be outlined at the Pre-construction Meeting. Samples will be tested by the CQA Laboratory. The CQA Laboratory will be selected by the CQA Site Manager with the concurrence of the Engineer.

Testing will include “Bonded Seam Strength” and “Peel Adhesion.” The minimum acceptable values to be obtained in these tests are given in the *Technical Specifications*. At least five specimens will be tested for each test method. Specimens will be selected alternately, by test, from the samples (i.e., peel, shear, peel, shear...). A passing test will meet the minimum required values in at least four out of five specimens.

The CQA Laboratory will provide test results no more than 24 hours after they receive the samples. The CQA Site Manager will review laboratory test results as soon as they become available, and make appropriate recommendations to the Construction Manager.

#### *Geosynthetic Installer’s Laboratory Testing*

The Geosynthetic Installer’s laboratory test results will be presented to the Construction Manager and the CQA Site Manager for comments.

#### *Procedures for Destructive Test Failure*

The following procedures will apply whenever a sample fails a destructive test, whether that test conducted by the CQA Laboratory, the Geosynthetic Installer’s



laboratory, or by gauged tensiometer in the field. The Geosynthetic Installer has two options:

- The Geosynthetic Installer can reconstruct the seam between two passed test locations.
- The Geosynthetic Installer can trace the welding path to an intermediate location at 10 ft (3 m) minimum from the point of the failed test in each direction and take a small sample for an additional field test at each location. If these additional samples pass the test, then full laboratory samples are taken. If these laboratory samples pass the tests, then the seam is reconstructed between these locations. If either sample fails, then the process is repeated to establish the zone in which the seam should be reconstructed.

Acceptable seams must be bounded by two locations from which samples passing laboratory destructive tests have been taken. Repairs will be made in accordance with Section 9.4.5.

The CQA Site Manager will document actions taken in conjunction with destructive test failures.

#### **9.4.5 Defects and Repairs**

This section prescribes CQA activities to document that defects, tears, rips, punctures, damage, or failing seams shall be repaired.

##### 9.4.5.1 Identification

Seams and non-seam areas of the geomembrane shall be examined by the CQA Site Manager for identification of defects, holes, blisters, undispersed raw materials and signs of contamination by foreign matter. Because light reflected by the geomembrane helps to detect defects, the surface of the geomembrane shall be clean at the time of examination.

##### 9.4.5.2 Evaluation

Potentially flawed locations, both in seam and non-seam areas, shall be non-destructively tested using the methods described in Section 9.4.4.8 as appropriate. Each location that fails the nondestructive testing will be marked by the CQA Site Manager and repaired by the Geosynthetic Installer. Work will not proceed with any materials that will cover locations which have been repaired until laboratory test results with passing values are available.

#### 9.4.5.3 Repair Procedures

Portions of the geomembrane exhibiting a flaw, or failing a destructive or nondestructive test, will be repaired. Several procedures exist for the repair of these areas. The final decision as to the appropriate repair procedure will be at the discretion of the CQA Consultant with input from the Construction Manager and Geosynthetic Installer. The procedures available include:

- patching, used to repair large holes, tears, undispersed raw materials, and contamination by foreign matter;
- grinding and re-welding, used to repair small sections of extruded seams;
- spot welding or seaming, used to repair small tears, pinholes, or other minor, localized flaws;
- capping, used to repair large lengths of failed seams;
- removing bad seam and replacing with a strip of new material welded into place (used with large lengths of fusion seams).

In addition, the following provisions will be satisfied:

- surfaces of the geomembrane which are to be repaired will be abraded no more than 20 minutes prior to the repair;
- surfaces must be clean and dry at the time of the repair;
- all seaming equipment used in repairing procedures must be approved;

- the repair procedures, materials, and techniques will be approved in advance by the CQA Consultant with input from the Engineer and Geosynthetic Installer;
- patches or caps will extend at least 6 in. (150 mm) beyond the edge of the defect, and all corners of patches will be rounded with a radius of at least 3 in. (75 mm);
- cuts and holes to be patched shall have rounded corners; and
- the geomembrane below large caps should be appropriately cut to avoid water or gas collection between the two sheets.

#### 9.4.5.4 Verification of Repairs

The CQA Monitor shall monitor and document repairs. Records of repairs shall be maintained on repair logs. Repair logs shall include, at a minimum:

- panel containing repair and approximate location on panel;
- approximate dimensions of repair;
- repair type, i.e. fusion weld or extrusion weld
- date of repair;
- seamer making the repair; and
- results of repair non-destructive testing (pass or fail).

Each repair will be non-destructively tested using the methods described herein, as appropriate. Repairs that pass the non-destructive test will be taken as an indication of an adequate repair. Large caps may be of sufficient extent to require destructive test sampling, per the requirements of the *Technical Specifications*. Failed tests shall be redone and re-tested until passing test results are observed.

#### 9.4.5.5 Large Wrinkles

When seaming of the geomembrane is completed (or when seaming of a large area of the geomembrane liner is completed) and prior to placing overlying

materials, the CQA Site Manager will observe the geomembrane wrinkles. The CQA Site Manager will indicate to the Geosynthetic Installer which wrinkles should be cut and re-seamed. The seam thus produced will be tested like any other seam.

#### **9.4.6 Lining System Acceptance**

The Geosynthetic Installer and the Manufacturer(s) will retain all responsibility for the geosynthetic materials in the liner system until acceptance by the Construction Manager.

The geosynthetic liner system will be accepted by the Construction Manager when:

- the installation is finished;
- verification of the adequacy of all seams and repairs, including associated testing, is complete;
- all documentation of installation is completed including the CQA Site Manager's acceptance report and appropriate warranties; and
- CQA report, including "as built" drawing(s), sealed by a registered professional engineer has been received by the Construction Manager.

The CQA Site Manager will document that installation proceeded in accordance with the *Technical Specifications* for the project.

## **10. GEOTEXTILE**

### **10.1 Introduction**

This section of the CQA Plan outlines the CQA activities to be performed for the geotextile installation. The CQA Consultant will review the *Drawings*, and the *Technical Specifications*, and any approved addenda or changes.

### **10.2 Manufacturing**

The Manufacturer will provide the Construction Manager with a list of guaranteed “minimum average roll value” properties (defined as the mean less two standard deviations), for each type of geotextile to be delivered. The Manufacturer will also provide the Construction Manager with a written quality control certification signed by a responsible party employed by the Manufacturer that the materials actually delivered have property “minimum average roll values” which meet or exceed all property values guaranteed for that type of geotextile.

The quality control certificates will include:

- roll identification numbers; and
- results of MQC testing.

The Manufacturer will provide, as a minimum, test results for the following:

- mass per unit area;
- grab strength;
- tear strength;
- puncture strength;
- permittivity; and
- apparent opening size.

MQC tests shall be performed at the frequency listed in the *Technical Specifications*. CQA tests on geotextile produced for the project shall be performed according to the test methods specified and frequencies presented in Table 4.

The CQA Site Manager will examine Manufacturer certifications to evaluate that the property values listed on the certifications meet or exceed those specified for the particular type of geotextile and the measurements of properties by the Manufacturer are properly documented, test methods acceptable and the certificates have been provided at the specified frequency properly identifying the rolls related to testing. Deviations will be reported to the Construction Manager.

### **10.3      Labeling**

The Manufacturer will identify all rolls of geotextile with the following:

- manufacturer's name;
- product identification;
- lot number;
- roll number; and
- roll dimensions.

The CQA Site Manager will examine rolls upon delivery and deviation from the above requirements will be reported to the Construction Manager.

### **10.4      Shipment and Storage**

During shipment and storage, the geotextile will be protected from ultraviolet light exposure, precipitation or other inundation, mud, dirt, dust, puncture, cutting or any other damaging or deleterious conditions. To that effect, geotextile rolls will be shipped and stored in relatively opaque and watertight wrappings.

Protective wrappings will be removed less than one hour prior to unrolling the geotextile. After the wrapping has been removed, a geotextile will not be exposed

to sunlight for more than 15 days, except for UV protection geotextile, unless otherwise specified and guaranteed by the Manufacturer.

The CQA Site Manager will observe rolls upon delivery at the site and deviation from the above requirements will be reported to the Geosynthetic Installer.

## **10.5 Conformance Testing**

### **10.5.1 Tests**

Upon delivery of the rolls of geotextiles, the CQA Site Manager will obtain conformance samples and forward to the Geosynthetics CQA Laboratory for testing to evaluate conformance to *Technical Specifications*. Required test and testing frequency for the geotextiles are presented in Table 4. These conformance tests will be performed in accordance with the test methods specified in the *Technical Specifications* and will be documented by the CQA Site Manager.

### **10.5.2 Sampling Procedures**

Samples will be taken across the width of the roll and will not include the first three feet. Unless otherwise specified, samples will be 3 ft long by the roll width. The CQA Site Manager will mark the machine direction on the samples with an arrow.

Unless otherwise specified, samples will be taken at a rate as indicated in Table 4 for geotextiles.

### **10.5.3 Test Results**

The CQA Site Manager will examine results from laboratory conformance testing and will report non-conformance with the *Technical Specifications* and this CQA Plan to the Construction Manager.

### **10.5.4 Conformance Sample Failure**

The following procedure will apply whenever a sample fails a conformance test that is conducted by the CQA Laboratory:

- The Manufacturer will replace every roll of geotextile that is in nonconformance with the *Technical Specifications* with a roll(s) that meets *Technical Specifications*; or
- The Geosynthetic Installer will remove conformance samples for testing by the CQA Laboratory from the closest numerical rolls on both sides of the failed roll. These two samples must conform to the *Technical Specifications*. If either of these samples fail, the numerically closest rolls on the side of the failed sample will be tested by the CQA Laboratory. These samples must conform to the *Technical Specifications*. If any of these samples fail, every roll of geotextile on site from this lot and every subsequently delivered roll that is from the same lot must be tested by the CQA Laboratory for conformance to the *Technical Specifications*. This additional conformance testing will be at the expense of the Manufacturer.

The CQA Site Manager will document actions taken in conjunction with conformance test failures.

## **10.6 Handling and Placement**

The Geosynthetic Installer will handle all geotextiles in such a manner as to document they are not damaged in any way, and the following will be complied with:

- In the presence of wind, all geotextiles will be weighted with sandbags or the equivalent. Such sandbags will be installed during placement and will remain until replaced with earth cover material.
- Geotextiles will be cut using an approved geotextile cutter only. If in place, special care must be taken to protect other materials from damage, which could be caused by the cutting of the geotextiles.
- The Geosynthetic Installer will take all necessary precautions to prevent damage to underlying layers during placement of the geotextile.
- During placement of geotextiles, care will be taken not to entrap in the geotextile stones, excessive dust, or moisture that could damage



the geotextile, generate clogging of drains or filters, or hamper subsequent seaming.

- A visual examination of the geotextile will be carried out over the entire surface, after installation, to document that no potentially harmful foreign objects, such as needles, are present.

The CQA Site Manager will note non-compliance and report it to the Construction Manager.

### **10.7 Seams and Overlaps**

All geotextiles will be continuously sewn in accordance with *Technical Specifications*. Geotextiles will be overlapped 12 in. prior to seaming. No horizontal seams will be allowed on side slopes (i.e. seams will be along, not across, the slope), except as part of a patch.

Sewing will be done using polymeric thread with chemical and ultraviolet resistance properties equal to or exceeding those of the geotextile.

### **10.8 Repair**

Holes or tears in the geotextile will be repaired as follows:

- On slopes: A patch made from the same geotextile will be double seamed into place. Should a tear exceed 10 percent of the width of the roll, that roll will be removed from the slope and replaced.
- Non-slopes: A patch made from the same geotextile will be spot-seamed in place with a minimum of 6 in. (0.60 m) overlap in all directions.

Care will be taken to remove any soil or other material that may have penetrated the torn geotextile.

The CQA Site Manager will observe any repair, note any non-compliance with the above requirements and report them to the Construction Manager.

**10.9 Placement of Soil or Aggregate Materials**

The Contractor will place all soil or aggregate materials located on top of a geotextile, in such a manner as to document:

- no damage of the geotextile;
- minimal slippage of the geotextile on underlying layers; and
- no excess tensile stresses in the geotextile.

Non-compliance will be noted by the CQA Site Manager and reported to the Construction Manager.

## **11. GEOSYNTHETIC CLAY LINER (GCL)**

### **11.1 Introduction**

This section of the CQA Plan outlines the CQA activities to be performed for the geosynthetic clay liner (GCL) installation. The CQA Consultant will review the *Drawings*, and the *Technical Specifications*, and approved addenda or changes.

### **11.2 Manufacturing**

The Manufacturer will provide the Construction Manager with a list of guaranteed “minimum average roll value” properties (defined as the mean less two standard deviations), for the GCL to be delivered. The Manufacturer will also provide the Construction Manager with a written quality control certification signed by a responsible party employed by the Manufacturer that the materials actually delivered have property “minimum average roll values” which meet or exceed all property values guaranteed for that GCL.

The quality control certificates will include:

- roll identification numbers; and
- results of quality control testing.

The Manufacturer will provide, as a minimum, test results for the following:

- mass per unit area; and
- index flux.

Quality control tests must be performed, in accordance with the test methods specified in Table 5, on GCL produced for the project.

The CQA Site Manager will examine Manufacturer certifications to verify that the property values listed on the certifications meet or exceed those specified for the GCL and the measurements of properties by the Manufacturer are properly

documented, test methods acceptable and the certificates have been provided at the specified frequency properly identifying the rolls related to testing. Deviations will be reported to the Construction Manager.

### **11.3      Labeling**

The Manufacturer will identify all rolls of GCL with the following:

- manufacturer's name;
- product identification;
- lot number;
- roll number; and
- roll dimensions.

The CQA Site Manager will examine rolls upon delivery and deviation from the above requirements will be reported to the Construction Manager.

### **11.4      Shipment and Storage**

During shipment and storage, the GCL will be protected from ultraviolet light exposure, precipitation or other inundation, mud, dirt, dust, puncture, cutting or any other damaging or deleterious conditions. To that effect, GCL rolls will be shipped and stored in relatively opaque and watertight wrappings.

The CQA Site Manager will observe rolls upon delivery at the site and any deviation from the above requirements will be reported to the Construction Manager.

## **11.5 Conformance Testing**

### **11.5.1 Tests**

CQA personnel will sample the GCL either during production at the manufacturing facility or after delivery to the construction site. The samples will be forwarded to the Geosynthetics CQA Laboratory for testing to assess conformance with the *Technical Specifications*. The test methods and minimum testing frequencies are indicated in Table 5.

Samples will be taken across the width of the roll and will not include the first 3 ft if the sample is cut on site. Unless otherwise specified, samples will be 3 ft long by the roll width. The CQA Consultant will mark the machine direction with an arrow and the manufacturer's roll number on each sample.

During GCL installation, the CQA Site Manager will deploy a small container to collect water as it is being applied to the surface of the GCL. The depth of water within the container will be measured and compared to the requirements outlined in the *Technical Specifications*. In addition, the CQA Site Manager will collect 6 inch square samples of the hydrated GCL for testing for moisture content. Samples will be collected once the overlying secondary geomembrane is in place and taken from within a destructive sample location. The test methods and minimum testing frequencies are indicated in Table 5.

The CQA Site Manager will examine results from laboratory conformance testing and will report non-conformance to the Construction Manager.

### **11.5.2 Conformance Sample Failure**

The following procedure will apply whenever a sample fails a conformance test that is conducted by the CQA Laboratory:

- The Manufacturer will replace every roll of GCL that is in nonconformance with the *Technical Specifications* with a roll(s) that meets *Technical Specifications*; or

- The Geosynthetic Installer will remove conformance samples for testing by the CQA Laboratory from the closest numerical rolls on both sides of the failed roll. These two samples must conform to the *Technical Specifications*. If either of these samples fail, the numerically closest rolls on the side of the failed sample will be tested by the CQA Laboratory. These samples must conform to the *Technical Specifications*. If any of these samples fail, every roll of GCL on site from this lot and every subsequently delivered roll that is from the same lot must be tested by the CQA Laboratory for conformance to the *Technical Specifications*. This additional conformance testing will be at the expense of the Manufacturer.

The CQA Site Manager will document actions taken in conjunction with conformance test failures.

#### **11.6 GCL Delivery and Storage**

Upon delivery to the site, the CQA Consultant will check the GCL rolls for defects (e.g., tears, holes) and for damage. The CQA Consultant will report to the Construction Manager and the Geosynthetics Installer:

- any rolls, or portions thereof, which should be rejected and removed from the site because they have severe flaws; and
- any rolls which include minor repairable flaws.

The GCL rolls delivered to the site will be checked by the CQA Consultant to document that the roll numbers correspond to those on the approved Manufacturer's quality control certificate of compliance.

#### **11.7 GCL Installation**

The CQA Consultant will monitor and document that the GCL is installed in accordance with the *Drawings* and the *Technical Specifications*. The Geosynthetics Installer shall provide the CQA Consultant a certificate of subgrade acceptance prior to

the installation of the GCL as outlined in the *Technical Specifications*. The GCL installation activities to be monitored and documented by the CQA Consultant include:

- monitoring that the GCL rolls are stored and handled in a manner which does not result in any damage to the GCL;
- monitoring that the GCL is not exposed to UV radiation for extended periods of time without prior approval;
- monitoring that the GCL are seamed in accordance with the *Technical Specifications* and the Manufacturer's recommendations;
- monitoring and documenting that the GCL is installed on an approved subgrade, free of debris, protrusions, or uneven surfaces;
- monitoring that the subgrade surface is moist to within a minimum of 1 inch from the subgrade surface;
- monitoring that the GCL is hydrated prior to installation of the overlying geomembrane; and
- monitoring that any damage to the GCL is repaired as outlined in the *Technical Specifications*.

The CQA Site Manager will note non-compliance and report it to the Construction Manager.

## **12. GEONET**

### **12.1 Introduction**

This section of the CQA Plan outlines the CQA activities to be performed for the geonet installation. The CQA Consultant will review the *Drawings*, and the *Technical Specifications*, and any approved addenda or changes.

### **12.2 Manufacturing**

The Manufacturer will provide the CQA Consultant with a list of certified “minimum average roll value” properties for the type of geonet to be delivered. The Manufacturer will also provide the CQA Consultant with a written certification signed by a responsible representative of the Manufacturer that the geonet actually delivered have “minimum average roll values” properties which meet or exceed all certified property values for that type of geonet.

The CQA Consultant will examine the Manufacturers’ certifications to document that the property values listed on the certifications meet or exceed those specified for the particular type of geonet. Deviations will be reported to the Construction Manager.

### **12.3 Labeling**

The Manufacturer will identify all rolls of geonet with the following:

- Manufacturer’s name;
- product identification;
- lot number;
- roll number; and
- roll dimensions.

The CQA Site Manager will examine rolls upon delivery and deviation from the above requirements will be reported to the Construction Manager.



## **12.4      Shipment and Storage**

During shipment and storage, the geonet will be protected from mud, dirt, dust, puncture, cutting or any other damaging or deleterious conditions. The CQA Site Manager will observe rolls upon delivery to the site and deviation from the above requirements will be reported to the Construction Manager. Damaged rolls will be rejected and replaced.

The CQA Site Manager will observe that geonet is free of dirt and dust just before installation. The CQA Site Manager will report the outcome of this observation to the Construction Manager, and if the geonet is judged dirty or dusty, they will be cleaned by the Geosynthetic Installer prior to installation.

## **12.5      Conformance Testing**

### **12.5.1      Tests**

The geonet material will be tested for transmissivity (ASTM D 4716) and for thickness (ASTM D 5199) at the frequencies presented in Table 6.

### **12.5.2      Sampling Procedures**

Upon delivery of the geonet rolls, the CQA Site Manager will document that samples are obtained from individual rolls at the frequency specified in this CQA Plan. The geonet samples will be forwarded to the CQA Laboratory for testing to evaluate conformance to both the *Technical Specifications* and the list of physical properties certified by the Manufacturer.

Samples will be taken across the width of the roll and will not include the first 3 linear ft. Unless otherwise specified, samples will be 3 ft long by the roll width. The CQA Consultant will mark the machine direction on the samples with an arrow.

### 12.5.3 Test Results

The CQA Site Manager will examine results from laboratory conformance testing and compare results to the *Technical Specifications*. The criteria used to evaluate acceptability are presented in the *Technical Specifications*. The CQA Site Manager will report any nonconformance to the Construction Manager.

### 12.5.4 Conformance Test Failure

The following procedure will apply whenever a sample fails a conformance test that is conducted by the CQA Laboratory:

- The Manufacturer will replace every roll of geonet that is in nonconformance with the *Technical Specifications* with a roll that meets specifications; or
- The Geosynthetic Installer will remove conformance samples for testing by the CQA Laboratory from the closest numerical rolls on both sides of the failed roll. These two samples must conform to the *Technical Specifications*. If either of these samples fail, the numerically closest rolls on the side of the failed sample that is not tested, will be tested by the CQA Laboratory. These samples must conform to the *Technical Specifications*. If any of these samples fail, every roll of geonet on site from this lot and every subsequently delivered roll that is from the same lot must be tested by the CQA Laboratory for conformance to the *Technical Specifications*.

The CQA Site Manager will document actions taken in conjunction with conformance test failures.

## 12.6 Handling and Placement

The Geosynthetic Installer will handle all geonet in such a manner as to document they are not damaged in any way. The Geosynthetic Installer will comply with the following:

- If in place, special care must be taken to protect other materials from damage, which could be caused by the cutting of the geonet.
- The Geosynthetic Installer will take any necessary precautions to prevent damage to underlying layers during placement of the geonet.
- During placement of geonet, care will be taken to prevent entrapment of dirt or excessive dust that could cause clogging of the drainage system, and/or stones that could damage the adjacent geomembrane. If dirt or excessive dust is entrapped in the geonet, it should be cleaned prior to placement of the next material on top of it. In this regard, care should be taken with the handling of sandbags, to prevent rupture or damage of the sandbag.
- A visual examination of the geonet will be carried out over the entire surface, after installation to document that no potentially harmful foreign objects are present.

The CQA Site Manager will note noncompliance and report it to the Construction Manager.

### **12.7 Geonet Seams and Overlaps**

Adjacent geonet panels will be joined in accordance with Construction Drawings and Technical Specifications. As a minimum, the adjacent rolls will be overlapped by at least 4 in. and secured by tying, in accordance with the Technical Specifications.

The CQA Consultant will note any noncompliance and report it to the Construction Manager.

### **12.8 Repair**

Holes or tears in the geonet will be repaired by placing a patch extending 2 ft beyond edges of the hole or tear. The patch will be secured by tying with approved tying devices every 6 in. If the hole or tear width across the roll is more than 50 percent

of the width of the roll, the damaged area will be cut out and the two portions of the geonet will be joined in accordance with Section 11.7.

The CQA Site Manager will observe repairs, note non-compliances with the above requirements and report them to the Construction Manager.

## **13. CONCRETE SPILLWAY**

### **13.1 Introduction**

This section prescribes the CQA activities to be performed to monitor that the concrete spillway is constructed in accordance with *Drawings* and *Technical Specifications*. The concrete spillway construction procedures to be monitored by the CQA Consultant, if required, shall include:

- subgrade preparation;
- liner system and cushion geotextile installation;
- welded wire reinforcement installation; and
- concrete placement and finishing.

### **13.2 CQA Monitoring Activities**

#### **13.2.1 Subgrade Preparation**

The CQA Site Manager will monitor and document that the subgrade is prepared in accordance with the *Technical Specifications* and the *Drawings*.

#### **13.2.2 Liner System and Cushion Geotextile Installation**

The CQA Site Manager shall monitor and document that the liner system components, along with the anchor trench and cushion geotextile, are installed in accordance with the requirements of the *Technical Specifications* and the *Drawings*.

#### **13.2.3 Welded Wire Reinforcement Installation**

The CQA Site Manager shall monitor and document that the welded wire fabric reinforcement is installed in accordance with the requirements of the *Technical Specifications* and the *Drawings*.

### **13.2.4 Concrete Installation**

The CQA Site Manager shall test, monitor, and document that the concrete is installed in accordance with the requirements of the *Technical Specifications* and the *Drawings*. At a minimum, the CQA Site Manager shall review the concrete tickets prior to installing the concrete to monitor that the concrete meets the requirements outlined in the *Technical Specifications*.

### **13.2.5 Conformance Testing**

The Contractor shall facilitate the CQA Site Manager in the collection of samples required for testing. Compression test specimens shall be prepared by the CQA Site Manager by the following method:

- compression test cylinders from fresh concrete in accordance with ASTM C 172 and C 31.

Compression testing shall be completed on one cylinder at 7 days, one cylinder at 14 days, and two (2) cylinders at the 28 day strength. The CQA Site Manager will examine results from laboratory conformance testing and will report any non-conformance with the requirements outlined in the *Technical Specifications* to the Construction Manager.

## **13.3 Deficiencies**

If a defect is discovered in the concrete spillway, the CQA Site Manager will immediately determine the extent and nature of the defect. The CQA Site Manager will determine the extent of the defective area by additional observations, a review of records, or other means that the CQA Site Manager deems appropriate.

### **13.3.1 Notification**

After evaluating the extent and nature of a defect, the CQA Site Manager will notify the Construction Manager and Contractor and schedule appropriate re-evaluation when the work deficiency is to be corrected.

### **13.3.2 Repairs**

The Contractor will correct deficiencies to the satisfaction of the CQA Site Manager. If a project specification criterion cannot be met, or unusual weather conditions hinder work, then the CQA Site Manager will develop and present to the Construction Manager suggested solutions for his approval.

Re-evaluations by the CQA Site Manager shall continue until the defects have been corrected before any additional work is performed by the Contractor in the area of the deficiency.

## **14. SURVEYING**

### **14.1 Survey Control**

Survey control will be performed by the Surveyor as needed. A permanent benchmark will be established for the site(s) in a location convenient for daily tie-in. The vertical and horizontal control for this benchmark will be established within normal land surveying standards.

### **14.2 Precision and Accuracy**

A wide variety of survey equipment is available for the surveying requirements for these projects. The survey instruments used for this work should be sufficiently precise and accurate to meet the needs of the projects.

### **14.3 Lines and Grades**

The following structures will be surveyed to verify and document the lines and grades achieved during construction of the Project:

- geomembrane terminations; and
- centerlines of pipes.

### **14.4 Frequency and Spacing**

A line of survey points no further than 50 ft apart must be taken at the top of pipes or other appurtenances to the liner.

### **14.5 Documentation**

Field survey notes should be retained by the Land Surveyor. The findings from the field surveys should be documented on a set of *Survey Record Drawings*, which shall be provided to the Construction Manager in AutoCADD 2000 format or other suitable format as directed by the Construction Manager.



**TABLE 1A****TEST PROCEDURES FOR THE EVALUATION OF SUBGRADE SOIL**

<b>TEST METHOD</b>	<b>DESCRIPTION</b>	<b>TEST STANDARD</b>
Sieve Analysis	Particle Size Distribution	ASTM D 422
Modified Proctor	Moisture Density Relationship	ASTM D 1557

**TABLE 1B****MINIMUM SUBGRADE SOIL TESTING FREQUENCIES**

<b>TEST</b>	<b>TEST METHOD</b>	<b>SUBGRADE SOIL</b>
Sieve Analysis	ASTM D 422	1 per material type
Modified Proctor	ASTM D 1557	1 per material type
Nuclear Densometer – In-situ Density	ASTM D 2922	1 per 500 yd <sup>3</sup>
Nuclear Densometer – In-situ Moisture Content	ASTM D 3017	1 per 500 yd <sup>3</sup>

**TABLE 2A****TEST PROCEDURES FOR THE EVALUATION OF AGGREGATE**

<b>TEST METHOD</b>	<b>DESCRIPTION</b>	<b>TEST STANDARD</b>
Sieve Analysis	Particle Size Distribution of Fine and Coarse Aggregates	ASTM C 136
Hydraulic Conductivity (Rigid Wall Permeameter)	Permeability of Aggregates	ASTM D 2434

**TABLE 2B****MINIMUM AGGREGATE TESTING FREQUENCIES FOR CONFORMANCE TESTING**

<b>TEST</b>	<b>TEST METHOD</b>	<b>DRAINAGE AGGREGATE</b>
Sieve Analysis	ASTM C 136	1 per 5,000 yd <sup>3</sup>
Hydraulic Conductivity	ASTM D 2434	1 per 10,000 yd <sup>3</sup>

**TABLE 3****GEOMEMBRANE CONFORMANCE TESTING REQUIREMENTS**

<b>TEST NAME</b>	<b>TEST METHOD</b>	<b>FREQUENCY</b>
Specific Gravity	ASTM D 792 Method A or ASTM D 1505	200,000 ft <sup>2</sup>
Thickness	ASTM D 5199	200,000 ft <sup>2</sup>
Tensile Strength at Yield	ASTM D 638	200,000 ft <sup>2</sup>
Tensile Strength at Break	ASTM D 638	200,000 ft <sup>2</sup>
Elongation at Yield	ASTM D 638	200,000 ft <sup>2</sup>
Elongation at Break	ASTM D 638	200,000 ft <sup>2</sup>
Carbon Black Content	ASTM D 1603	200,000 ft <sup>2</sup>
Carbon Black Dispersion	ASTM D 5596	200,000 ft <sup>2</sup>
Interface Shear Strength <sup>1,2</sup>	ASTM D 5321	1 per project

Notes:

1. To be performed at normal stresses of 10, 20, and 40 psi between geomembrane and geonet.
2. To be performed at normal stresses of 10, 20, and 40 psi between geomembrane and woven side of GCL. GCL shall be hydrated for 24 hours prior to testing.

**TABLE 4****GEOTEXTILE CONFORMANCE TESTING REQUIREMENTS**

<b>TEST NAME</b>	<b>TEST METHOD</b>	<b>MINIMUM FREQUENCY</b>
Mass per Unit Area	ASTM D 5261	1 test per 260,000 ft <sup>2</sup>
Grab Strength	ASTM D 4632	1 test per 260,000 ft <sup>2</sup>
Puncture Resistance	ASTM D 4833	1 test per 260,000 ft <sup>2</sup>
Permittivity	ASTM D 4491	1 test per 260,000 ft <sup>2</sup>
Apparent Opening Size	ASTM D 4751	1 test per 260,000 ft <sup>2</sup>

**TABLE 5**  
**GCL CONFORMANCE TESTING REQUIREMENTS**

<b>TEST NAME</b>	<b>TEST METHOD</b>	<b>MINIMUM FREQUENCY</b>
Mass per Unit Area	ASTM D 5993	1 test per 100,000 ft <sup>2</sup>
Index Flux	ASTM D 5887	1 test per 400,000 ft <sup>2</sup>
Water Application for GCL Hydration	N/A	1 per acre
Bentonite Moisture Content – Post Field Hydration	ASTM D 2216	1 test per 4 secondary geomembrane destructive samples

Note: Hydraulic index flux testing shall be performed under an effective confining stress of 5 pounds per square inch.

**TABLE 6**  
**GEONET CONFORMANCE TESTING REQUIREMENTS**

<b>TEST NAME</b>	<b>TEST METHOD</b>	<b>MINIMUM FREQUENCY</b>
Thickness	ASTM D 5199	1 test per 200,000 ft <sup>2</sup>
Hydraulic Transmissivity	ASTM D 4716	1 test per 400,000 ft <sup>2</sup>

Note: Transmissivity shall be measured using water at 68°F with a gradient of 0.1 under a confining pressure of 7,000 lb/ft<sup>2</sup>. The geonet shall be placed in the testing device between steel plates. Measurements are taken one hour after application of confining pressure..