

**City of Milwaukee
Department of Public Works**

Milwaukee Water Works

**Material Specifications for
Couplings – Straight and Transition
20" through 54"**



**City of Milwaukee Specification No. 30-D-5
Revised June 21, 2024**

STATEMENT OF GENERAL SPECIFICATION TERMS AND CONDITIONS

NOTE: THIS SPECIFICATION AND ANY ACCOMPANYING SPECIFICATION CAN BE APPEALED.

FORMAL SPECIFICATION APPEALS MUST BE SUBMITTED IN WRITING TO THE CITY PURCHASING DIRECTOR FOR ALL BIDS NO LATER THAN FIVE (5) BUSINESS DAYS PRIOR TO BID OPENING. **REQUESTS RECEIVED AFTER THIS TIMEFRAME WILL NOT BE CONSIDERED.**

FORMAL SPECIFICATION APPEALS MUST NOT ONLY IDENTIFY THE PROVISION THAT IS OF CONCERN, BUT ALSO IDENTIFY A PROPOSED ALTERNATE SOLUTION SUPPORTED BY TECHNICAL DATA AND/OR, TEST RESULTS FOR CONSIDERATION.

NOTICE

AN APPEAL FEE (CHECK OR MONEY ORDER) OF 1.25% OF THE ESTIMATED DOLLAR AMOUNT OF THE ANTICIPATED CONTRACT IS REQUIRED WITH A BID SPECIFICATION APPEAL. THIS FEE IS A PREREQUISITE FOR PURSUING A FORMAL SPECIFICATION APPEAL AND MUST ACCOMPANY THE APPEAL. THE APPEAL FEE WILL BE RETURNED IF THE APPEAL IS UPHeld.

CONTACT THE APPROPRIATE PURCHASING AGENT OR THE PROCUREMENT SPECIALIST IDENTIFIED IN THE BID SOLICITATION FOR THE APPEAL FEE AMOUNT AND FILING INSTRUCTIONS.

CAUTION

A BID THAT DOES NOT FULLY COMPLY WITH ALL OF THE PROVISIONS, TERMS, AND CONDITIONS OF THIS OR ANY ACCOMPANYING SPECIFICATION AND BID, MAY BE DETERMINED AS A COUNTEROFFER AND MAY RESULT IN THE BID BEING REJECTED FOR NON-RESPONSIVENESS.

- I. **GENERAL REQUIREMENTS:** Vendors bidding through the Department of Administration - Business Operations Division, Procurement Services Section shall comply with the latest version of City of Milwaukee Specification No. 70b-D-7, except as modified herein. **MATERIALS FURNISHED UNDER THIS SPECIFICATION SHALL COMPLY WITH AND BE CERTIFIED WITH THE PROVISIONS OF THE CITY OF MILWAUKEE ORDINANCE 310-18.9 AND THE AMERICAN IRON AND STEEL REQUIREMENT (AIS) OF THE DRINKING WATER STATE REVOLVING FUND (DWSRF).**

MATERIALS FURNISHED UNDER THIS SPECIFICATION SHALL COMPLY WITH AND BE CERTIFIED WITH THE PROVISIONS OF BUILD AMERICA, BUY AMERICA (BABA) PROVISIONS UNLESS A WAIVER OF REQUIREMENTS HAS BEEN APPROVED BY THE USEPA.

ADDITIONAL INFORMATION REGARDING BUILD AMERICA, BUY AMERICA (BABA) CAN BE FOUND AT THE FOLLOWING LINK: [HTTPS://WWW.EPA.GOV/CWSRF/BUILD-AMERICA-BUY-AMERICA-BABA](https://www.epa.gov/cwsrf/build-america-buy-america-baba)

II. **TECHNICAL REQUIREMENTS:**

- A. **Description:** Couplings as described herein consist of one (1) steel middle ring /sleeve, two (2) rubber compound wedge style gaskets, two (2) steel followers/flanges and stainless steel nuts and bolts. Straight couplings are to be used to connect equivalent diameter (outside) ductile iron or cast iron pipe. Transition couplings are to be used to connect equivalent diameter (inside) ductile iron pipe to cast iron pipe.
- B. **Standards:** All couplings shall conform to the latest revision of the following American Water Works Association Standards (AWWA):
1. AWWA C219 Bolted, Sleeve-type Couplings for Plain-end Pipe
 2. AWWA C213 Fusion Bonded Epoxy Coating for the Interior and Exterior of Steel Water Pipelines
- C. **Material:**
1. Middle ring shall be made of carbon steel conforming to ASTM A36, A283C, A513, A635 or ASME SA675.
 2. Rubber gaskets shall be virgin Nitrile (Buna-N) NSF 61 listed, unless otherwise noted.
 3. Followers shall be made of carbon steel conforming to AISI C1020, C1012, or ASME SA36.
 4. Bolts, nuts and washers used to join the followers and compress the rubber gaskets shall meet ASME B18.2.2, be a minimum of 5/8" diameter and made of 304 18-8 Stainless Steel. Nuts or bolts shall be coated with an anti-seizing material to prevent galling during tightening.

II. TECHNICAL REQUIREMENTS: (Continued)

D. Design Features:

1. Nominal Sizes: The nominal water main sizes are 20", 24", 30", 36", 42", 48" and 54" diameter.
- a. The straight couplings in each size shall be suitable to connect pipe having the following outside diameters. All dimensions are in inches:

Nominal Size	O.D. of Class 55 D.I. Pipe ¹	O.D. of Pit Cast Pipe ¹
20"	21.60" +/-0.08	----
24"	25.80" +/-0.10	----
30"	32.00" +/-0.10	----
36"	38.30" +/-0.10	----
42"	44.50" +/-0.12	45.22" +0.12 / -0.24**
48"	50.80" +/-0.12	51.52" +0.12 / -0.24**
54"	57.56" +/-0.12	57.92" +0.12 / -0.24**

- b. The transition couplings in each size shall be suitable to transition from cast iron pipe (Class C) to ductile iron pipe having the following outside diameters. All dimensions are in inches:

Nominal Size	O.D. of Pit Cast Pipe ¹	O.D. of Class 55 D.I. Pipe ¹
20"	22.14" +0.08 / -0.16**	21.60" +/-0.08
24"	26.42" +0.10 / -0.20**	25.80" +/-0.10
30"	32.50" +0.10 / -0.20**	32.00" +/-0.10
36"	38.80" +0.10 / -0.20**	38.30" +/-0.10
42"	45.22" +0.12 / -0.24**	44.50" +/-0.12
48"	51.52" +0.12 / -0.24**	50.80" +/-0.12
Alt#1* - 54"	57.92" +0.12 / -0.24**	57.10" +/-0.12
Alt#2* - 54"	57.92" +0.12 / -0.24**	57.56" +/-0.12

* As of 6/16/2010, both 54" D.I. pipe sizes are currently in City pipe stock – Alt # to be specified in bid or purchase documents

** Specified tolerance to be obtained by use of gaskets of differing thickness.

II. TECHNICAL REQUIREMENTS: (Continued)

- c. The middle ring shall have a minimum width of 12" for all sizes and in each size shall have the following minimum wall thickness. All dimensions are in inches:

<u>Pipe Size</u>	<u>Thickness</u>
20, 24, 30	$\frac{3}{8}$ "
36, 42, 48, 54	$\frac{1}{2}$ "

2. Accessories: The coupling shall be furnished complete with all followers, gaskets, bolts, nuts and washers. A coating repair kit shall be furnished with each coupling.
 3. Pressure: Couplings shall be designed for water working pressure of 150 psi and a test pressure of 250 psi.
 4. A minimum of one lifting eye shall be attached by welding to the middle ring before coating.
- E. Coating:** Interior and exterior of middle ring and followers shall be coated with fusion bonded epoxy in accordance with AWWA C213.
- F. Instructions:** Installation instructions shall be furnished with each coupling.
- G. Certifications:** Upon request, the manufacturer or the vendor shall submit manufacturer's certifications in duplicate to the Superintendent of Milwaukee Water Works attesting to the following:
1. Couplings are manufactured and tested in accordance with all applicable parts of AWWA C219 standard.
 2. Manufacturer's certification of material compliance with the provisions of Build America Buy America (BABA).

III. ACCEPTABLE BRANDS:

The following brands and model numbers are acceptable to the City of Milwaukee:

Dresser – Style 38 and 62
JCM – Style 201 and 203
Smith-Blair – Style 411 and 413

Manufacturers may request approval from the City of Milwaukee in accordance with City of Milwaukee Specification No. 70b-D-7.

IV. INSPECTION BY THE CITY:

- A.** All required submittals and certifications shall be furnished before any materials will be inspected and accepted.
- B.** The Superintendent of Milwaukee Water Works or a duly authorized representative shall inspect the materials furnished under this specification.
- C.** Any coupling found not conforming to this specification will be rejected and must be replaced at no cost to the City, including all freight costs.
- D.** On projects where couplings are to be furnished by a contractor and inspected by the City, the contractor is required to excavate, expose and measure O.D. of existing pipe and/or verify the O.D. of the proposed pipe prior to ordering couplings.