Deutsches Institut für Bautechnik DIBt

Approval body for construction products and types of construction

Bautechnisches Prüfamt

An institution established by the Federal and Laender Governments

European Technical Assessment

ETA-11/0123 of 22 April 2016

English translation prepared by DIBt - Original version in German language

General Part

Technical Assessment Body issuing the European Technical Assessment:	Deutsches Institut für Bautechnik
Trade name of the construction product	BBV External Post-Tensioning System Type E
Product family to which the construction product belongs	BBV Post-Tensioning System for 3 to 31 strands (140 and 150 mm²) for external prestressing
Manufacturer	BBV Systems GmbH Industriestraße 98 67240 Bobenheim-Roxheim DEUTSCHLAND
Manufacturing plant	BBV Systems GmbH Industriestraße 98 67240 Bobenheim-Roxheim DEUTSCHLAND
This European Technical Assessment contains	48 pages including 42 annexes which form an integral part of this assessment
This European Technical Assessment is issued in accordance with Regulation (EU) No 305/2011, on the basis of	Guideline for European technical approval of "Post-tensioning kits for prestressing of structures", ETAG 013, used as European Assessment Document (EAD) according to Article 66 Paragraph 3 of Regulation (EU) No 305/2011.

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Specific part

1 Technical description of the product

1.1 Definition of the construction product

The present European Technical Assessment applies to a kit:

BBV External Post-Tensioning System Type E

consisting of 3 to 31 strands with a nominal tensile strength 1770 MPa or 1860 MPa (Y1770S7 or Y1860S7 according to prEN 10138-3:2009-08, Table 4), nominal diameter 15.3 mm (0.60" - 140 mm²) or 15.7 mm (0.62" - 150 mm²) which are used in normal-weight concrete with the following anchors (stressing and fixed anchors):

1. Stressing (active) anchor type S and fixed (passive) anchor type F with bearing plate and anchor head for tendons of 3, 4, 5, 7 and 9 strands,
2. Stressing (active) anchor type S and fixed (passive) anchor type F with cast-iron anchor body and anchor head for tendons of 12, 15, 19, 22 and 31 strands,

Additional components of the present Post-Tensioning system are:

1. Bursting reinforcement (helixes and stirrups)
2. Sheathing (ducts)
3. Corrosion protection

The anchorage of the strands in anchor heads is done by means of wedges.

The components and the system setup of the product are given in Annex A.

1.2 Strands

Only 7-wire strands shall be used in accordance with national provisions with the characteristics given in Table 1:

Table 1: Dimensions and properties of 7-wire strands

Designation	Symbol	Unit	Value	
Tensile strength	R_m	MPa	1770 or 1860	
Strand				
Nominal diameter	D	mm	15.3	15.7
Nominal cross section	A_p	mm²	140	150
Nominal mass	M	g/m	1093	1172
Individual wires				
External wire diameter	D	mm	5.0 ± 0.04	5.2 ± 0.04
Core wire diameter	d’	mm	1.02 to 1.04 d	1.02 to 1.04 d

To avoid confusion only strands with one nominal diameter shall be used on one site. If the use of strands with R_m = 1860 MPa is intended on site, these shall solely be used there.

Only strands stranded in the same direction shall be used in a tendon. For further characteristic values of the strands see Annex A17.

1.3 Wedges

Wedges type 30, smooth or knurled, (see Annex A2) are approved. The knurled wedges shall only be used for pre-wedged (pre-locked) fixed anchors. The segments of the wedges for strands Ø 15.7 mm shall be marked with "0.62".

1.4 Anchor heads

The conical boreholes of the anchor heads shall be clean and stainless and provided with corrosion protection agent.

1.5 Bearing plates

For tendons of 3 to 9 strands, rectangular bearing plates shall be used. The long side of the bearing plates shall be installed parallel to the largest centre or edge distance (see Annex A6).

1.6 Cast-iron anchor bodies

For tendons of 12 to 31 strands multi-surfaced cast-iron anchor bodies shall be used (see Annex A6).

1.7 Helixes and stirrups

The steel grades and dimensions of the helixes and of the stirrups shall comply with the values given in the Annexes. The central position in the structural concrete member on site shall be ensured according to Annex B2, section 3.3.

1.8 Corrosion protection of the anchorage zone and of the free tendon length

Each tendon is fully encapsulated in a duct over its whole length.

After tightening, but before stressing of the tendon, the duct will be filled completely on site with hot corrosion protection mass. The corrosion protection mass shall comply with ETAG 013, Annex C.4.1 or C.4.2, respectively, and with national provisions.

The connection duct provides the transition from the PE-duct to the free length of the tendon to the anchorage (see Annexes A8 to A10).

The connection duct overlaps with the trumpet and is swathed with PE-tape for leak tightness.

After the wax has cooled down and before the stressing of the tendon, every high point is reinjected with "cold" corrosion protection mass (see Annexes A14 to A16 and B3).

After stressing, the protection measures for the anchorages shall be carried out according to the description in Annex B3 and as specified in the Annexes A3 and A4.

1.9 Corrosion protection of exposed steel components

Exposed steel components which are not covered sufficiently by concrete (at least 5 cm) or which are not protected by corrosion protection material (e.g. wax) shall be protected against corrosion by one of the following protective paint systems according to EN ISO 12944-5:2008-01:

a) without metallic coating: A5M.02, A5M.04, A5M.06, A5M.07

b) with zinc coating (galvanized): A7.10, A7.11, A7.12, A7.13

The surface preparation of the steel components shall be carried out according to EN ISO 12944-4:1998-07. For execution of the paint work EN ISO 12944-7:1998-07 shall be observed.

Local approved and recognised corrosion protection principles can be used instead, if admissible at the place of use.

1.10 Clearances at anchorages, minimum width of crossbeams

The anchorages are schematically shown in Annexes A3 and A4 and A8 to A10.

At the entrances of the crossbeams, trumpet-like widenings shall be provided, with a minimum of $\Delta\alpha = 3°$. The widenings shall allow for unscheduled deviations from the planned position of the tendon axis (tendon path) without kink up to the angle $\Delta\alpha$.

In the case of fixed anchors at the entrance of the structure/crossbeam, the maximum admissible strand displacement due to stressing shall not exceed 10 cm (see Annex B2, sections 3.9 and 3.11). The minimum width of the crossbeam at both the stressing and the fixed anchors is given in Annexes A8 and A9, in the case of deviations behind the anchorage area in Annex A10. Over the length min. L1 the tendon path must be straight.

1.11 Ducts

Along their free length, the tendons shall be ensheathed with PE-ducts according to Annex A2. The scheme of the duct installation and the duct connectors are shown in Annex A16.

PE-ducts or PE-reducing sockets will be assembled by means of heated tool butt-welding or helical heating element welding. For welding of PE-ducts the regulations at the place of use shall be observed. The welding shall be carried out by professional plastic welders with a certification valid at the place of use.

The trumpets at the active and passive anchors are manufactured from PE-material of at least 3.5 mm thickness. At their ends the trumpets overlap with the connection ducts.

The maximum admissible deviation angle of the strands inside the anchors (at the end of the wedges and in the transition area between trumpet and connection duct) is 2.2°. The connection duct is attached to the trumpet by adhesive tape winding.

At the fixed anchor, the duct is positioned inside the connection duct till approximately 5 cm before the trumpet, and behind (outside) the crossbeam the duct is attached to the connection duct with a tensile-proof connection.

At the stressing anchor, before tightening the tendon, the duct shall extend at least 10 cm the deviated area of the crossbeam. The duct in the free tendon length at the stressing anchor glides into the connection duct during the stressing process.

At the stressing anchor, the tensile-proof connection between connection duct and duct is assembled after the prestressing has been completed.

1.12 Deviators

In the area of deviation, the minimum radius of curvature shall always be above the values given in Annex A2, depending on the grade of the prestressing steel, the tendon size and the diameter of the duct.

The minimum radius of curvature shall also be complied with in the area of the provided trumpet-shaped widenings.

The formation of the area of deviation is shown in the Annexes A11 to A13. At the ends of the areas of deviation (entrance of the crossbeam), there are trumpet-like widenings with at least $\Delta\alpha$ = 3°, which permit tolerances from the planned position of the tendon axis (tendon path) without kink up to the angle $\Delta\alpha$.

In the area of deviation the duct lies inside a deviation duct which on the inside is coated with grease and protrudes about 10 cm out of the area of deviation. In the case of the deviation type S, the maximum admissible deviation length max L_{zul} shall be observed (see Annex A12).

At the stressing and the fixed anchors in the distance min L1 from the anchor heads deviations may be planned (see Annex A10). At the stressing anchor, before the tightening of the tendon, the duct shall protrude from the curved (deviation) zone inside the crossbeam by at least 10 cm.

2 Specification of the intended use in accordance with the applicable European Assessment Document

The performances given in Section 3 are only valid if the PT-System is used in compliance with the specifications and conditions given in Annex B.

The verifications and assessment methods on which this European Technical Assessment is based lead to the assumption of a working life of the PT-System of at least 100 years. The indications given on the working life cannot be interpreted as a guarantee given by the producer, but are to be regarded only as a means for choosing the right products in relation to the expected economically reasonable working life of the works.

3 Performance of the product and references to the methods used for its assessment

3.1 Mechanical resistance and stability (BWR 1)

Essential characteristic	Performance
Resistance to static load	The PT system as described in the ETA meets the acceptance criteria of ETAG 013, Clause 6.1.1-I
Resistance to fatigue	The PT system as described in the ETA meets the acceptance criteria of ETAG 013, Clause 6.1.2-I
Resistance to fatigue	The PT system as described in the ETA meets the acceptance criteria of ETAG 013, Clause 6.1.3-I
Friction coefficient	The PT system as described in the ETA meets the acceptance criteria of ETAG 013, Clause 6.1.4-I See Annex C
Deviation/deflection (limits)	The PT system as described in the ETA meets the acceptance criteria of ETAG 013, Clause 6.1.5-I

4 Assessment and verification of constancy of performance (AVCP) system applied, with reference to its legal base

In accordance with guideline for European technical approval ETAG 013, June 2002, used as European Assessment Document (EAD) according to Article 66 Paragraph 3 of Regulation (EU) No 305/2011, the applicable European legal act is: [98/456/EC].

The system to be applied is: 1+

5 Technical details necessary for the implementation of the AVCP system, as provided for in the applicable EAD

Technical details necessary for the implementation of the AVCP system are laid down in the control plan deposited with Deutsches Institut für Bautechnik.

Issued in Berlin on 22 April 2016 by Deutsches Institut für Bautechnik

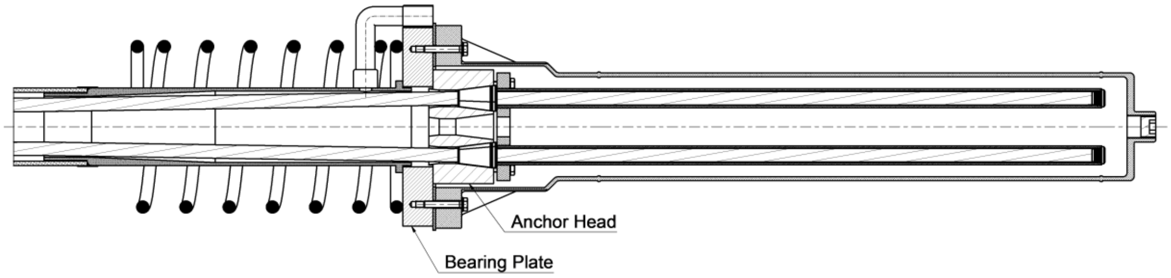
Uwe Bender
Head of Department

Beglaubigt:
Lindorf

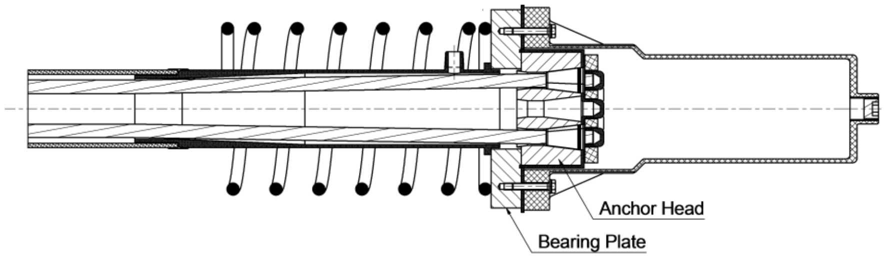
BBV External PT-System Type E

Overview Anchorages

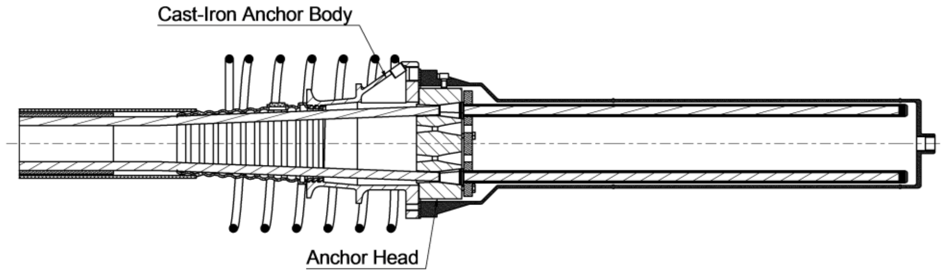
1. Active Anchor (S) BBV L3 E – BBV L9 E



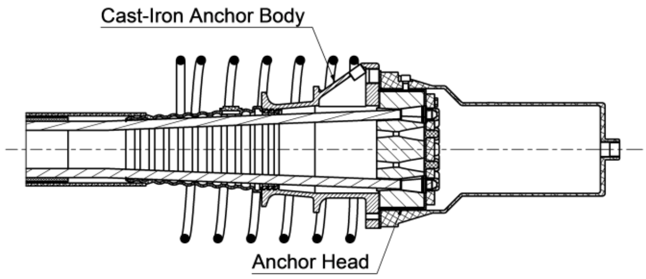
2. Passive Anchor BBV L3 E – BBV L9 E



3. Active Anchor (S) BBV L12 E – BBV L31 E



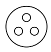
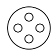
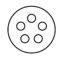
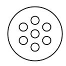
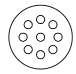
4. Passive Anchor (F) BBV L12 E – BBV L31 E



BBV External Post-Tensioning System Type E	Annex A1
Product Description Overview Anchorages	

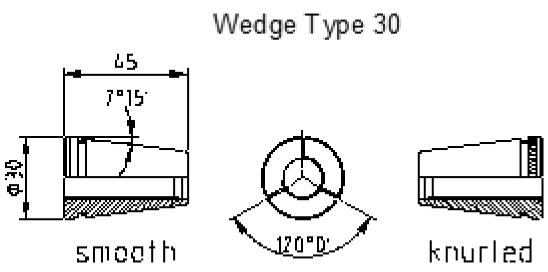
Technical Details BBV L3 E – BBV L9 E

Steel Grade Y1770S7

Tendon Type	Unit	**BBV L3 E**	**BBV L4 E**	**BBV L5 E**	**BBV L7 E**	**BBV L9 E**
Strand Pattern						
Number of Strands, Y1770S7	n	3	4	5	7	9
150 mm² : Nom. Cross Section A_p	mm²	450	600	750	1050	1350
150 mm² : Nom. Mass	kg/m	3.52	4.69	5.86	8.20	10.55
150 mm² : $P_{max} = 0.90 \cdot f_{p0.1k} \cdot A_p$ *	kN	616	821	1026	1436	1847
150 mm² : $P_{m0}(x) = 0.85 \cdot f_{p0.1k} \cdot A_p$ *	kN	581	775	969	1357	1744
150 mm² : F_{pk}	kN	797	1062	1328	1859	2390
140 mm² : Nom. Cross Section A_p	mm²	420	560	700	980	1260
140 mm² : Nom. Mass	kg/m	3.28	4.37	5.47	7.65	9.84
140 mm² : $P_{max} = 0.90 \cdot f_{p0.1k} \cdot A_p$ *	kN	575	766	958	1341	1724
140 mm² : $P_{m0}(x) = 0.85 \cdot f_{p0.1k} \cdot A_p$ *	kN	543	724	904	1266	1628
140 mm² : F_{pk}	kN	743	991	1239	1735	2230
Friction Losses						
Active Anchor $\Delta P_{\mu S}$	%	1.2	1.2	1.2	1.1	1.0
Mean Friction Coefficient μ	-	0.08	0.08	0.08	0.08	0.08
PE- Duct						
Inner Diameter	mm	40.8	53.6	53.6	66.0	66.0
Wall Thickness	mm	4.6	4.7	4.7	4.5	4.5
Outer Diameter	mm	50	63	63	75	75
Min. Bending Radius	m	3.00	3.00	3.00	3.10	3.90
**Strand Protrusion ** **	cm	21.5	21.5	70	71	82

* based on $f_{p0.1k}$ = 1520 MPa (Y1770S7)

** distance from anchor head front face for placing of jack, smaller distances is possible only in consultation with BBV Systems GmbH.

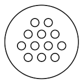
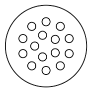
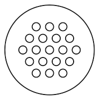
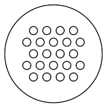
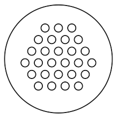
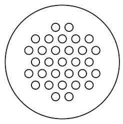


For pre-wedged passive anchors knurled wedges can be used optionally.

Wedges for strands of 150 mm² cross sectional area are marked "0.62" on the front face.

Technical Details BBV L12 E – BBV L31 E

Steel Grade Y1770S7

Tendon Type	Unit	**BBV L12 E**	**BBV L15 E**	**BBV L19 E**	**BBV L22 E**	**BBV L27 E**	**BBV L31 E**
Strand Pattern							
Number of Strands, Y1770S7	n	12	15	19	22	27	31
150 mm² : Nom. Cross Section A_p	mm^2	1800	2250	2850	3300	4050	4650
150 mm² : Nom. Mass	kg/m	14.06	17.58	22.27	25.78	31.64	36.33
150 mm² : $P_{max} = 0.90 \cdot f_{p0.1k} \cdot A_p$ *	kN	2462	3078	3899	4514	5540	6361
150 mm² : $P_{m0}(x) = 0.85 \cdot f_{p0.1k} \cdot A_p$ *	kN	2326	2907	3682	4264	5233	6008
150 mm² : F_{pk}	kN	3186	3983	5045	5841	7169	8231
140 mm² : Nom. Cross Section A_p	mm²	1680	2100	2660	3080	3780	4340
140 mm² : Nom. Mass	kg/m	13.12	16.40	20.77	24.05	29.51	33.88
140 mm² : $P_{max} = 0.90 \cdot f_{p0.1k} \cdot A_p$ *	kN	2298	2873	3639	4213	5171	5937
140 mm² : $P_{m0}(x) = 0.85 * f_{p0.1k} * A_p$ *	kN	2171	2713	3437	3979	4884	5607
140 mm² : F_{pk}	kN	2974	3717	4708	5452	6691	7682
Friction Losses							
Active Anchor $\Delta P_{\mu s}$	%	0.8	0.8	0.8	0.6	0.8	0.8
Mean Friction Coefficient μ	-	0.08	0.08	0.08	0.08	0.08	0.08
PE-Duct (SDR17)							
Inner Diameter	mm	79.2	96,8	96,8	96.8 / 110.2	110.2	123.4
Wall Thickness	mm	5.4	6.6	6.6	6.6 / 7.4	7.4	8.3
Outer Diameter	mm	90	110	110	# 110 / 125	125	140
Min. Bending Radius	m	4.00	3.80	4.80	5.50 / 4.80	6.00	5.80
PE-Duct (SDR22)*							
Inner Diameter	mm	-	100	100	100 / 113,6	113.6	127.2
Wall Thickness	mm	-	5.0	5.0	5.0 / 5.7	5.7	6.4
Outer Diameter	mm	-	110	110	# 110 / 125	125	140
Min. Bending Radius	m	-	4.10	5.20	6.0 / 5.10	6.30	6.10
Strand Protrusion **	cm	80	80	110	110	120	120

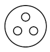
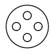
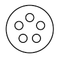
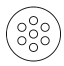
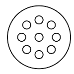
* and ** see Annex A2, page 1

*** optional to be confirmed by BBV Systems GmbH.

use of the smaller duct diameters to be confirmed by BBV Systems GmbH

Technical Details BBV L3 E – BBV L9 E

Steel Grade Y1860S7

Tendon Type	Unit	**BBV L3 E**	**BBV L4 E**	**BBV L5 E**	**BBV L7 E**	**BBV L9 E**
Strand Pattern						
Number of Strands, Y1860S7	n	3	4	5	7	9
150 mm² : Nom. Cross Section A_p	mm²	450	600	750	1050	1350
150 mm² : Nom. Mass	kg/m	3.52	4.69	5.86	8.20	10.55
150 mm² : $P_{max} = 0.90 \cdot f_{p0.1k} \cdot A_p$ *	kN	648	864	1080	1512	1944
150 mm² : $P_{m0}(x) = 0.85 \cdot f_{p0.1k} \cdot A_p$ *	kN	612	816	1020	1428	1836
150 mm² : F_{pk}	kN	837	1116	1395	1953	2511
140 mm² : Nom. Cross Section A_p	mm²	420	560	700	980	1260
140 mm² : Nom. Mass	kg/m	3.28	4.37	5.47	7.65	9.84
140 mm² : $P_{max} = 0.90 \cdot f_{p0.1k} \cdot A_p$ *	kN	605	806	1008	1411	1814
140 mm² : $P_{m0}(x) = 0.85 \cdot f_{p0.1k} \cdot A_p$ *	kN	571	762	952	1333	1714
140 mm² : F_{pk}	kN	781	1042	1302	1823	2344
Friction Losses						
Active Anchor $\Delta P_{\mu S}$	%	1.2	1.2	1.2	1.1	1.0
Mean Friction Coefficient μ	-	0.08	0.08	0.08	0.08	0.08
PE-Duct						
Inner Diameter	mm	40.8	53.6	53.6	66.0	66,0
Wall Thickness	mm	4.6	4.7	4.7	4.5	4.5
Outer Diameter	mm	50	63	63	75	75
Min. Bending Radius	m	3.20	3.10	3.10	3.30	4.10
Strand Protrusion **	cm	21.5	21.5	70	71	82

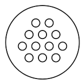
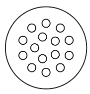
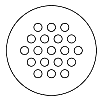
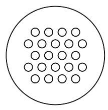
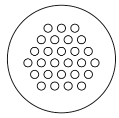
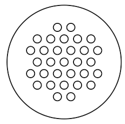
* based on $f_{p0.1k}$ = 1600 MPa (Y1860S7)

** distance from anchor head front face for placing of jack, smaller distances is possible only in consultation with BBV Systems GmbH.

BBV External Post-Tensioning System Type E	Annex A2 Page 3/4
Product Description Technical Details BBV L3 E – BBV L9 E Steel Grade Y1860S7	

Technical Details BBV L12 E – BBV L31 E

Steel Grade Y1860S7

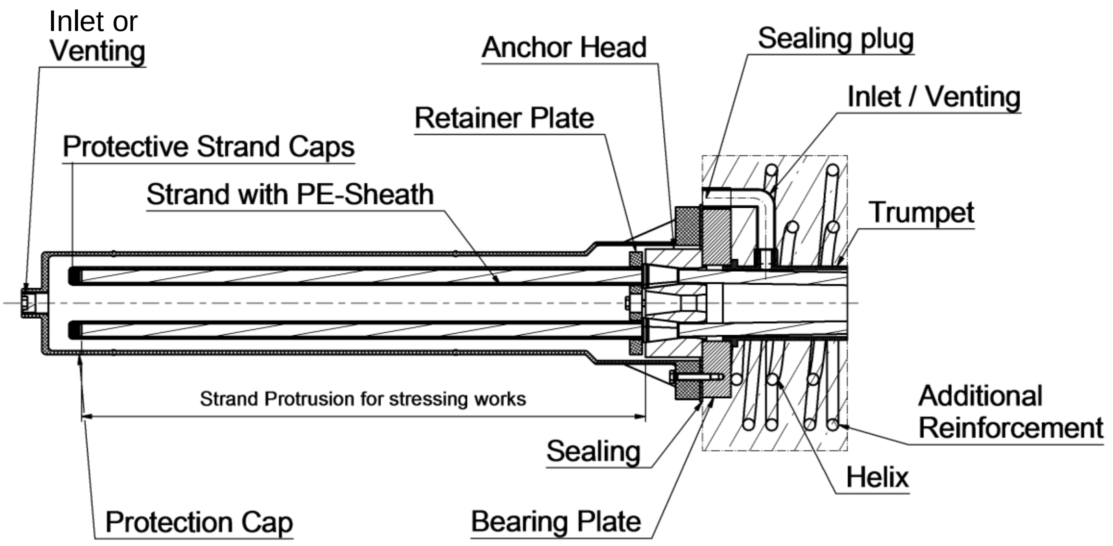
Tendon Type	Unit	**BBV L12 E**	**BBV L15 E**	**BBV L19 E**	**BBV L22 E**	**BBV L27 E**	**BBV L31 E**
Strand Pattern							
Number of Strands, Y1860S7	n	12	15	19	22	27	31
150 mm² : Nom. Cross Section A_p	mm²	1800	2250	2850	3300	4050	4650
150 mm² : Nom. Mass	kg/m	14.06	17.58	22.27	25.78	31.64	36,33
150 mm² : $P_{max} = 0,90 * f_{p0.1k} * A_p$ *	kN	2592	3240	4104	4752	5832	6696
150 mm² : $P_{m0}(x) = 0,85 * f_{p0.1k} * A_p$ *	kN	2448	3060	3876	4488	5508	6324
150 mm² : F_{pk}	kN	3348	4185	5301	6138	7533	8649
140 mm² : Nom. Cross Section A_p	mm²	1680	2100	2660	3080	3780	4340
140 mm² : Nom. Mass	kg/m	13.12	16.40	20.77	24.05	29,51	33,88
140 mm² : $P_{max} = 0.90 * f_{p0.1k} * A_p$ *	kN	2419	3024	3830	4435	5443	6250
140mm² : $P_{m0}(x) = 0.85 * f_{p0.1k} * A_p$ *	kN	2285	2856	3618	4189	5141	5902
140 mm² : F_{pk}	kN	3125	3906	4948	5729	7031	8072
Friction Losses							
Active Anchor $\Delta P_{\mu S}$	%	0.8	0.8	0.8	0.6	0.8	0,8
Mean Friction coefficient μ	%	0.08	0.08	0.08	0,08	0.08	0.08
PE-Duct (SDR 17)							
Inner Diameter	mm	79.2	96.8	96.8	96.8 / 110.2	110.2	123.4
Wall Thickness	mm	5.4	6.6	6.6	6.6 / 7.4	7,4	8,3
Outer Diameter	mm	90	110	110	# 110 / 125	125	140
Min. Bending Radius	m	4.10	4.00	5.00	5.80 / 5.10	6.30	6.10
PE-Duct (SDR22)*							
Inner Diameter	mm	-	100	100	100 / 113,6	113.6	127.2
Wall Thickness	mm	-	5.0	5.0	5.0 / 5.7	5.7	6.4
Outer Diameter	mm	-	110	110	# 110 / 125	125	140
Min. Bending Radius	m	-	4.40	5.50	6.30 / 5.40	6.70	6.40
**Strand Protrusion ** **	cm	80	80	110	110	120	120

* and ** see Annex A2, page 3
*** optional to be confirmed by BBV Systems GmbH.
# use of the smaller duct diameters to be confirmed by BBV Systems GmbH

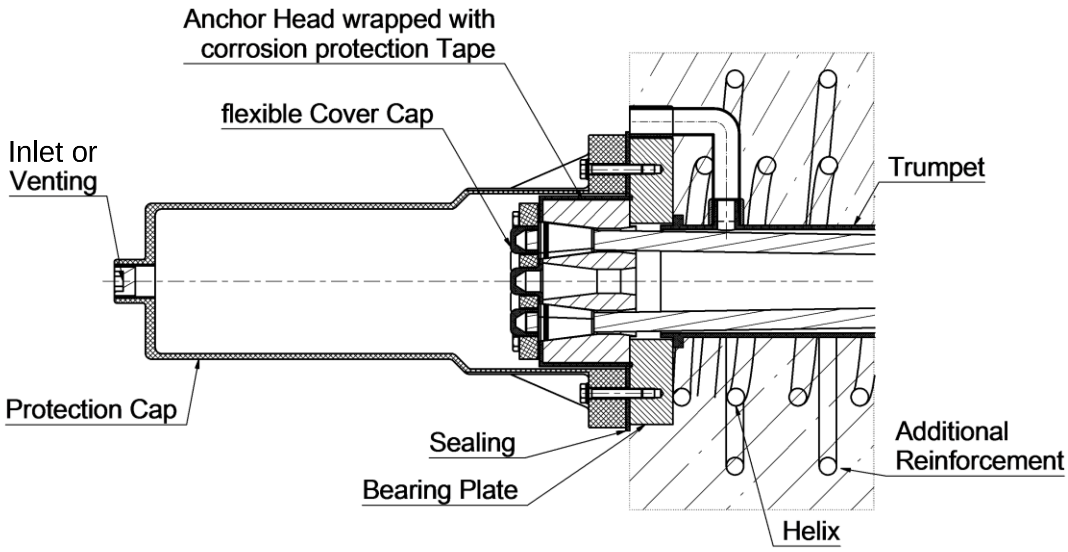
electronic copy of the eta by dibt: eta-11/0123

Anchorage with Bearing Plate L3 E – L9 E

Active Anchor (S)



Passive Anchor (F)

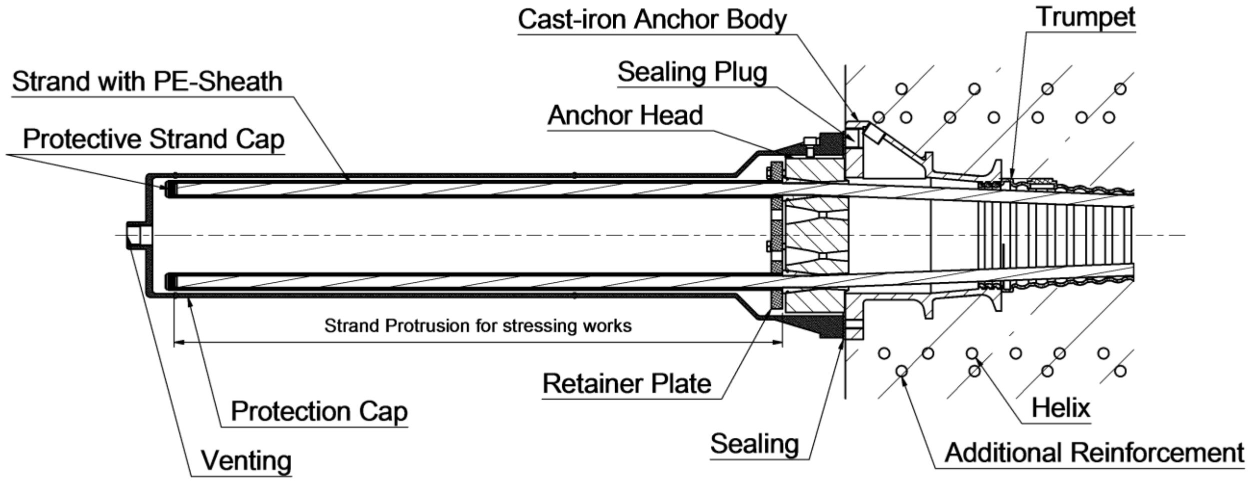


<u>Alternatively:</u>
If the flexible cover cap is omitted, the protection cap has to be filled with corrosion protection mass.

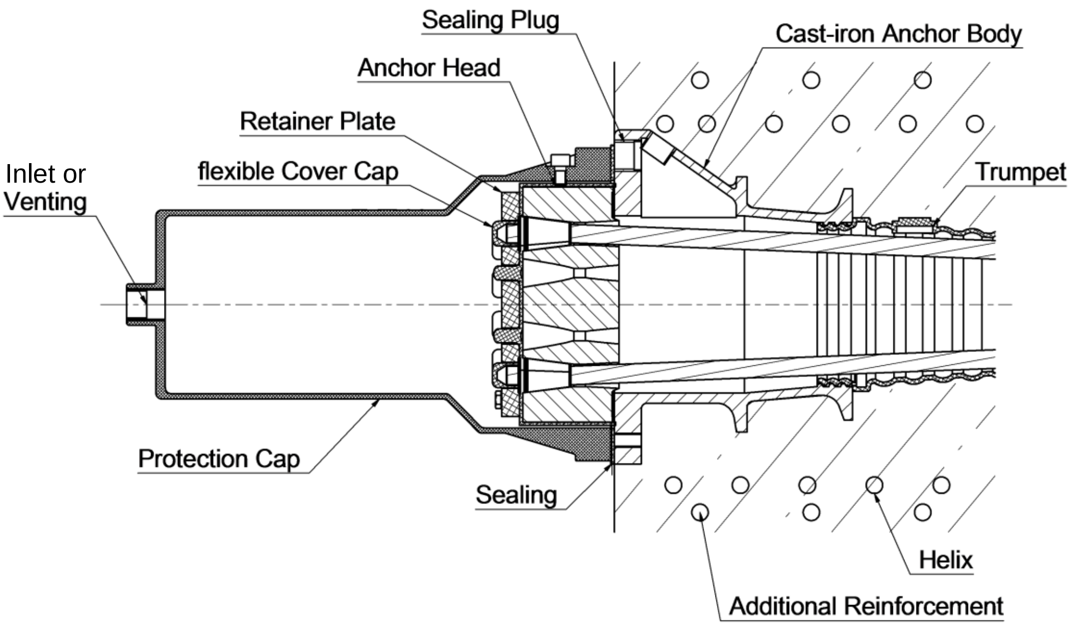
BBV External Post-Tensioning System Type E	Annex A3
Product Description Anchorage with Bearing Plate L3 E – L9 E	

Anchorage with Cast-iron Anchor Body L12 E – L31 E

Active Anchor (S)



Passive Anchor (F)



<u>Alternatively:</u>
If the flexible cover cap is omitted, the protection cap has to be filled with corrosion protection mass.

BBV External Post-Tensioning System Type E	Annex A4
Product Description Anchorage with Cast-iron Anchor Body L12 E – L31 E	

Centre- and Edge Distances

Tendon Type		**L3**	**L4**	**L5**	**L7**	**L7 R**	**L9**	**L9 R**
	Unit	Bearing Plate						
Min. Centre Distance *								
$f_{cmj,cube} \geq 30$ N/mm² **	mm	215 x 190	245 x 220	275 x 245	325 x 285	305 x 305	370 x 325	350 x 350
$f_{cmj,cube} \geq 34$ N/mm²	mm	200 x 175	230 x 205	260 x 230	305 x 270	290 x 290	345 x 305	325 x 325
$f_{cmj,cube} \geq 40$ N/mm²	mm	185 x 160	215 x 185	235 x 210	280 x 245	265 x 265	320 x 275	300 x 300
$f_{cmj,cube} \geq 45$ N/mm²	mm	170 x 150	200 x 175	225 x 195	260 x 230	245 x 245	295 x 265	280 x 280
Min. Edge Distance ***								
$f_{cmj,cube} \geq 30$ N/mm² **	mm	130 x 115	145 x 130	160 x 145	185 x 165	175 x 175	205 x 185	195 x 195
$f_{cmj,cube} \geq 34$ N/mm²	mm	120 x 110	135 x 125	150 x 135	175 x 155	165 x 165	195 x 175	185 x 185
$f_{cmj,cube} \geq 40$ N/mm²	mm	115 x 100	130 x 115	140 x 125	160 x 145	155 x 155	180 x 160	170 x 170
$f_{cmj,cube} \geq 45$ N/mm²	mm	105 x 95	120 x 110	135 x 100	150 x 135	145 x 145	210 x 155	160 x 160

Tendon Type		**L12**	**L15**	**L19**	**L22**	**L27**	**L31**
	Dim.	Cast-iron Anchor Body					
Min. Centre Distance *							
$f_{cmj,cube} \geq 28$ N/mm² (square) **	mm	405	450	505	545	605	645
$f_{cmj,cube} \geq 34$ N/mm² (square)	mm	370	415	465	500	550	595
$f_{cmj,cube} \geq 40$ N/mm² (square)	mm	340	380	430	460	510	545
$f_{cmj,cube} \geq 45$ N/mm² (square)	mm	325	360	405	435	485	520
Min. Edge Distance ***							
$f_{cmj,cube} \geq 28$ N/mm² (square) **	mm	225	245	275	295	325	345
$f_{cmj,cube} \geq 34$ N/mm² (square)	mm	205	230	255	270	295	320
$f_{cmj,cube} \geq 40$ N/mm² (square)	mm	190	210	235	250	275	295
$f_{cmj,cube} \geq 45$ N/mm² (square)	mm	185	200	225	240	265	280

* Distances can be reduced to 85% of the given values in one direction, if increased correspondingly in the other direction.

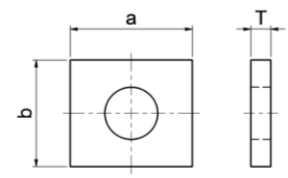
** $f_{cmj,cube} \geq 30$ MPa apply to BBV L3 - L9
$f_{cmj,cube} \geq 28$ MPa apply to BBV L12 - L31

*** Minimum edge distance: min. centre distance/2 + 20mm (rounding up at 5 mm intervals)

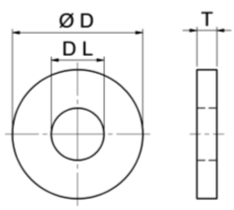
Dimension of Anchor Components

Tendon Type	Unit	**L3**	**L4**	**L5**	**L7**	**L 7R**	**L9**	**L 9R**	**L12**	**L15**	**L19**	**L22**	**L27**	**L31**
Bearing Plate, rect.														
Side Length a	mm	160	180	195	215		250							
Side Length b	mm	140	160	170	190		220							
Thickness T	mm	25	25	30	35		35							
Hole Diameter	mm	72	81	83	93		113							
Bearing Plate, round														
Diameter D	mm					230		265						
Thickness T	mm					35		35						
Hole Diameter DL	mm					93		113						
Cast-iron Anchor														
Diameter D	mm								240	270	300	327	360	382
Height H	mm								182	203	227	248	272	294
Thickness 1^{st} Plane T	mm								22	23	27	28	32	34
Hole - ∅, top Lo	mm								131	150	163	183	199	208
Hole - ∅, bottom Lu	mm								123	139	148	165	176	182
Anchor Head														
Diameter D	mm	104	104	115	132		160		180	200	220	245	265	280
Thickness T	mm	65	65	70	75		75		80	82	92	105	120	125
Diameter A	mm	68	77	79	89		109		127	146	159	179	195	204
Hole Circle e1	mm	45	54	56	66		86		* Grid	120	* Grid	* Grid	* Grid	* Grid
Hole Circle e2	mm									56				
Trumpet														
Max. Outer Diameter	mm	70	79	81	91		111		131	147	156	173	184	190
Min. Length	mm	≥ 325	≥ 355	≥ 375	≥ 425		≥ 475		≥ 265	≥ 265	≥ 340	≥ 365	≥ 465	≥ 320

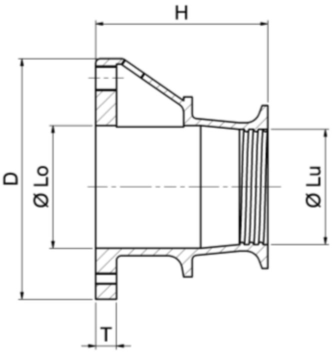
Bearing Plate, rectangular



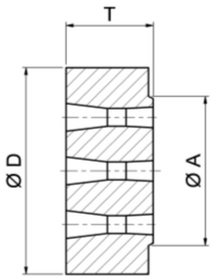
Bearing Plate, round



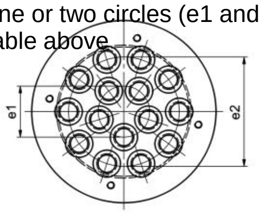
Cast-iron Anchor Body



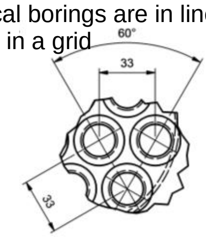
Anchor Head



BBV L3; 4; 5; 7; 9 and 15:
All conical borings are aligned on one or two circles (e1 and e2). See table above



BBV L12; 19; 22; 27 and 31:
Conical borings are in line, lines result in a grid



BBV External Post-Tensioning System Type E	Annex A6
Product Description Dimension of Anchor Components	

Helix and Additional Reinforcement

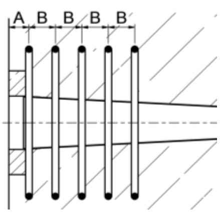
Tendon Type	Unit	**L3**	**L4**	**L5**	**L7**	**L9**	**L12**	**L15**	**L19**	**L22**	**L27**	**L31**
		Bearing Plate					**Cast-iron Anchor Body**					
Helix*												
Bar Diameter												
$f_{cmi.cube}$ ≥ 28/30 N/mm² **	mm	14	14	14	14	14	14	14	16	16	16	16
$f_{cmi.cube}$ ≥ 34 N/mm²	mm	14	14	14	14	14	14	16	16	16	16	16
$f_{cmi.cube}$ ≥ 40 N/mm²	mm	14	14	14	14	14	14	14	16	16	16	16
$f_{cmi.cube}$ ≥ 45 N/mm²	mm	14	14	14	14	14	14	14	16	16	16	16
Outer Diameter *												
$f_{cmi.cube}$ ≥ 28/30 N/mm² **	mm	140	160	180	200	240	300	345	390	430	490	520
$f_{cmi.cube}$ ≥ 34 N/mm² (square)	mm	135	150	170	190	230	300	340	380	410	450	480
$f_{cmi.cube}$ ≥ 40 N/mm²	mm	130	135	160	190	225	285	320	360	380	430	460
$f_{cmi.cube}$ ≥ 45 N/mm²	mm	120	120	140	180	220	270	315	340	365	410	430
Min. Length *												
$f_{cmi.cube}$ ≥ 28/30 N/mm² **	mm	200	230	250	300	350	350	400	450	450	550	550
$f_{cmi.cube}$ ≥ 34 N/mm²	mm	180	210	240	270	310	300	350	400	450	470	470
$f_{cmi.cube}$ ≥ 40 N/mm²	mm	170	200	220	250	290	300	300	350	350	450	450
$f_{cmi.cube}$ ≥ 45 N/mm²	mm	160	180	200	250	275	250	250	300	300	350	350
Min. Pitch *												
$f_{cmi.cube}$ ≥ 28/30 N/mm² **	mm	40	40	40	50	50	50	50	50	50	50	50
$f_{cmi.cube}$ ≥ 34 N/mm²	mm	40	40	40	50	50	50	50	50	50	50	50
$f_{cmi.cube}$ ≥ 40 N/mm²	mm	40	40	40	50	50	50	50	50	50	50	50
$f_{cmi.cube}$ ≥ 45 N/mm²	mm	40	40	40	50	50	50	50	50	50	50	50
Helix Turns *												
$f_{cmi.cube}$ ≥ 28/30 N/mm² **	n	6	7	7.5	7	8	8	9	10	10	12	12
$f_{cmi.cube}$ ≥ 34 N/mm²	n	5.5	6.5	7	6.5	7	7	8	9	10	10.5	10.5
$f_{cmi.cube}$ ≥ 40 N/mm²	n	5.5	6	6.5	6	7	7	7	8	8	10	10
$f_{cmj.cube}$ ≥ 45 N/mm²	n	5.0	5.5	7	6	6.5	6	6	7	7	8	8
Stirrup Reinforcement ***												
$f_{cmi.cube}$ ≥ 28/30 N/mm² **	Qty. x ∅	4 ∅10	4 ∅12	4 ∅14	4 ∅14	5 ∅14	6 ∅12	5 ∅14	6 ∅16	7 ∅16	11 ∅16	12 ∅16
$f_{cmi.cube}$ ≥ 34 N/mm²	Qty. x ∅	4 ∅10	5 ∅10	5 ∅12	5 ∅12	5 ∅14	6 ∅14	8 ∅14	7 ∅16	8 ∅16	9 ∅20	10 ∅20
$f_{cmi.cube}$ ≥ 40 N/mm²	Qty. x ∅	4 ∅8	4 ∅12	5 ∅12	5 ∅12	5 ∅14	5 ∅16	6 ∅16	7 ∅16	6 ∅20	8 ∅20	10 ∅20
$f_{cmi.cube}$ ≥ 45 N/mm²	Qty. x ∅	4 ∅8	4 ∅10	4 ∅12	4 ∅12	6 ∅12	5 ∅16	6 ∅16	8 ∅16	8 ∅16	8 ∅20	9 ∅20
Position behind bearing plate/cast-iron anchor body		A/B	A/B	A/B	A/B	A/B	A/B	A/B	A/B	A/B	A/B	A/B
$f_{cmi.cube}$ ≥ 28/30 N/mm² **	mm	45 / 60	45 / 70	50 / 75	55 / 95	55 / 80	50 / 70	50 / 95	50 / 90	50 / 80	60 / 60	60 / 55
$f_{cmi.cube}$ ≥ 34 N/mm²	mm	45 / 55	45 / 50	50 / 55	55 / 65	55 / 75	50 / 65	50 / 55	50 / 70	50 / 65	60 / 65	60 / 55
$f_{cmi.cube}$ ≥ 40 N/mm²	mm	45 / 55	45 / 60	50 / 50	55 / 60	55 / 70	50 / 70	50 / 65	50 / 60	50 / 75	60 / 65	60 / 55
$f_{cmj.cube}$ ≥ 45 N/mm²	mm	45 / 50	45 / 55	50 / 60	55 / 75	55 / 50	50 / 65	50 / 60	50 / 55	50 / 50	60 / 60	60 / 55

* nominal dimensions, tolerances deposited at DIBt

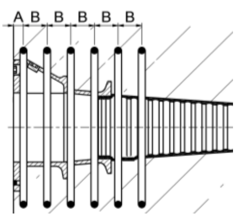
** $f_{cmj,cube}$ ≥ 30 N/mm² apply to BBV L3 - L9 / $f_{cmj,cube}$ ≥ 28 N/mm² apply to BBV L12 - L31

*** side Length Stirrup ≥ Min. Centre Distance – 20 mm

Sketches: **L3 E – L9 E**



L12 E – L 31 E



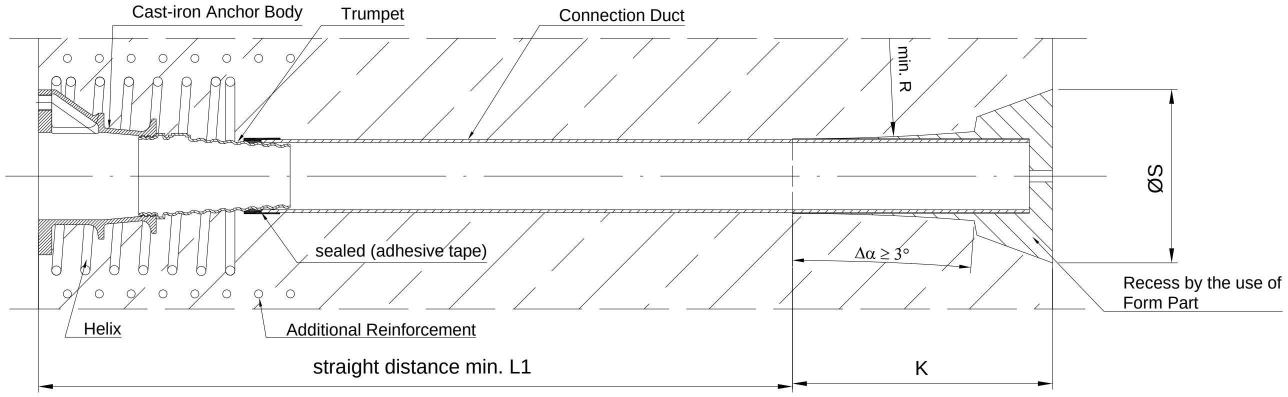
BBV External Post-Tensioning System Type E

Product Description
Helix and Additional Reinforcement

Annex A7

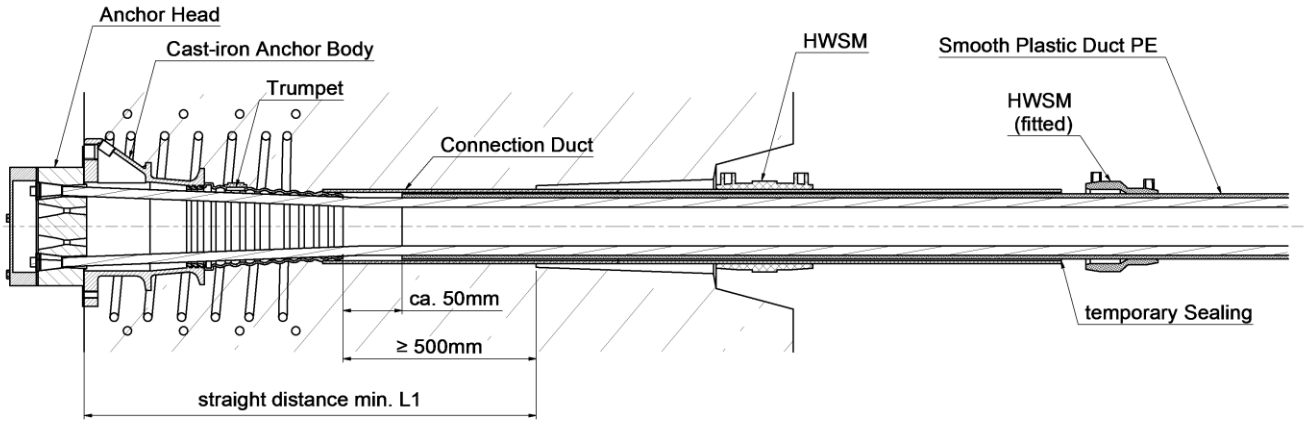
Connection Passive Anchor (F) – Duct

1. State of Construction with Form Parts, straight Connection Duct

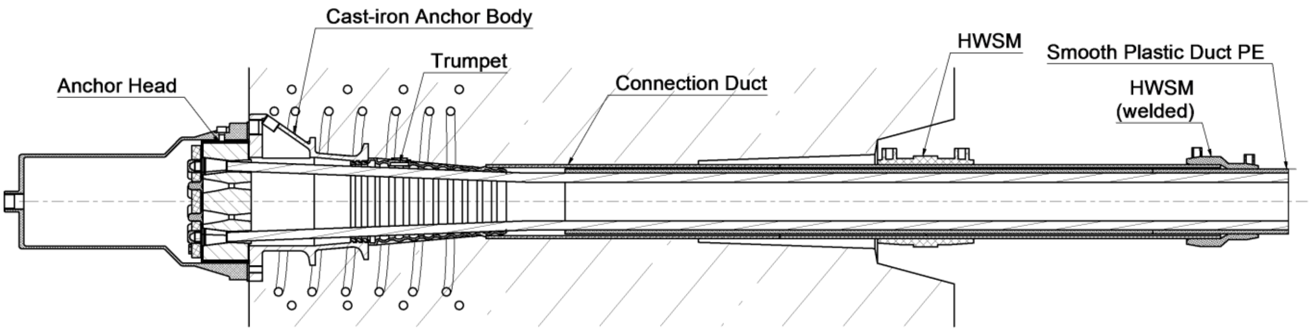


*) Recess Form Part ØS and Length K: Depending on the chosen electro welding sleeve (HWSM) and after consultation with BBV Systems, smaller recesses are possible.

2. Situation before Stressing Process, Connection with the Duct



3. Final State, Connection with the Duct

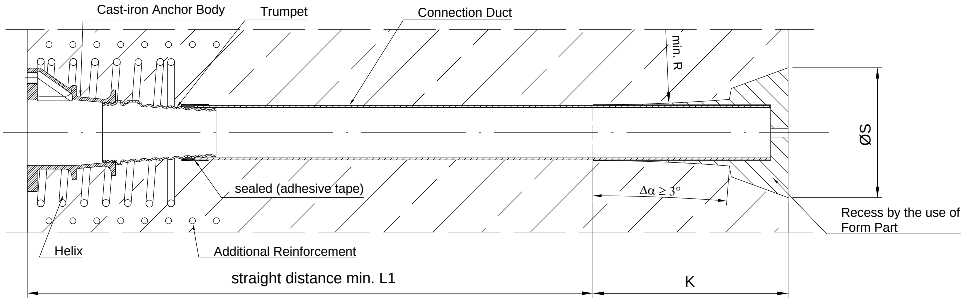


HWSM ≥ Electro welding Sleeve

BBV External Post-Tensioning System Type E	Annex A8
Product Description Connection Passive Anchor (F) – Duct	

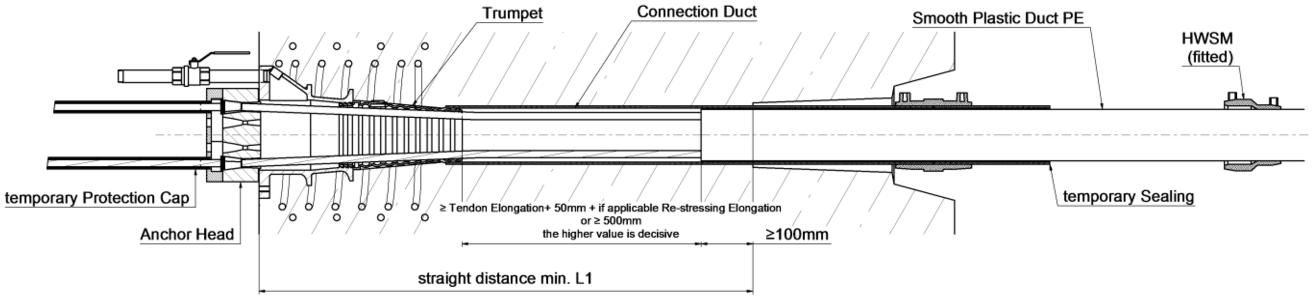
Connection Active Anchor (S) – Duct

1. State of Construction with Form Parts, straight Connection Duct

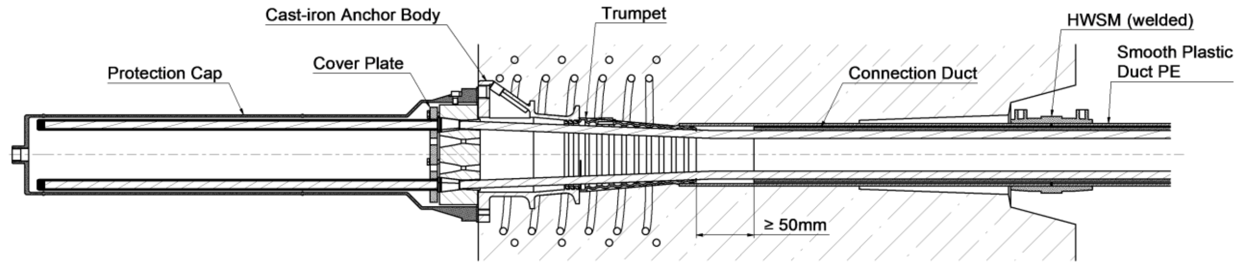


*) Recess Form Part ØS and Length K: Depending on the chosen electro welding sleeve and after consultation with BBV Systems, smaller recesses are possible.

2. Situation before Stressing Process, Connection with the Duct



3. Final State, Connection with the Duct



Tendon Type	Unit	L3 E	L4 E	L5 E	L7 E	L9 E	L12 E	L15 E	L19 E	L22 E	L27 E	L31 E
Outer Diameter Plastic Duct	mm	50	63	63	75	75	90	110	110	110/125	125	140
Connection Duct												
Outer Diameter	mm	63	75	75	90	90	110	125	125	140	140	160
Min. Wall Thickness	mm	4.3	4.3	4.3	5.1	5.1	6.3	4.8	4.8	4.3	4.3	6.2
Recess Form Part ØS *)	mm	201	213	213	233	238	263	279	285	288/285	311	330
Length Form Part K *)	mm	338	331	331	348	411	421	435	519	575/512	613	592
Straight Distance min. L1												
Smooth Plastic Duct PE SDR 17	mm	660	780	860	870	1100	1270	1530	1440	1420/1710	1870	2370
Smooth Plastic Duct PE SDR 22	mm	-	-	-	-	-	-	1580	1500	1480/1760	2020	2430

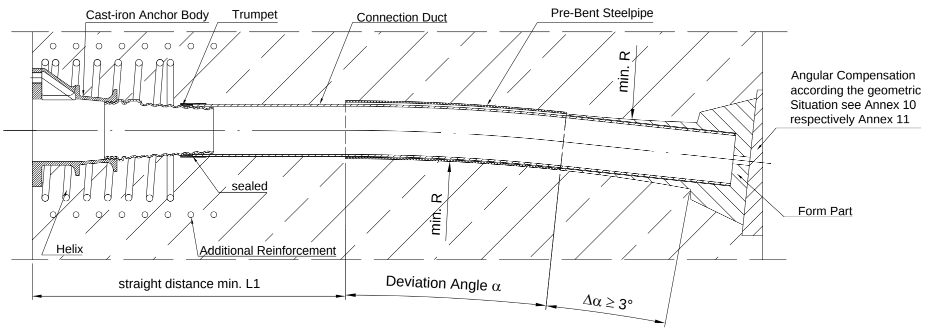
BBV External Post-Tensioning System Type E

Product Description
Connection Active Anchor (S) – Duct

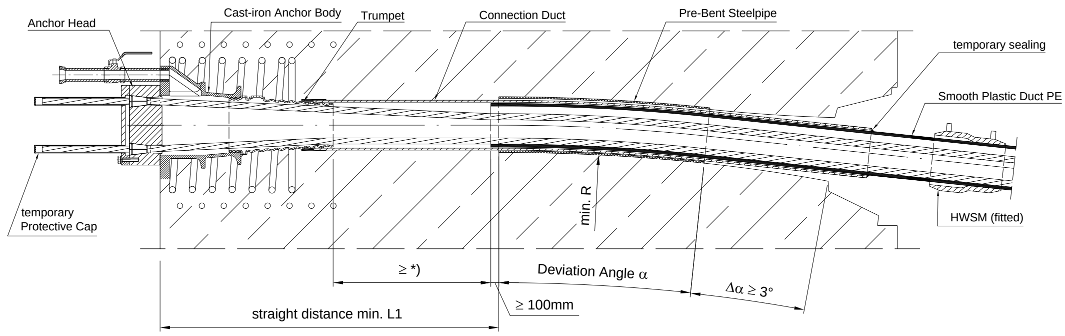
Annex A9

Connection Anchor Close Deviation – Active Anchor

1. State of Construction with Form Part, Connection Duct, Pre-Bent Steel Pipe

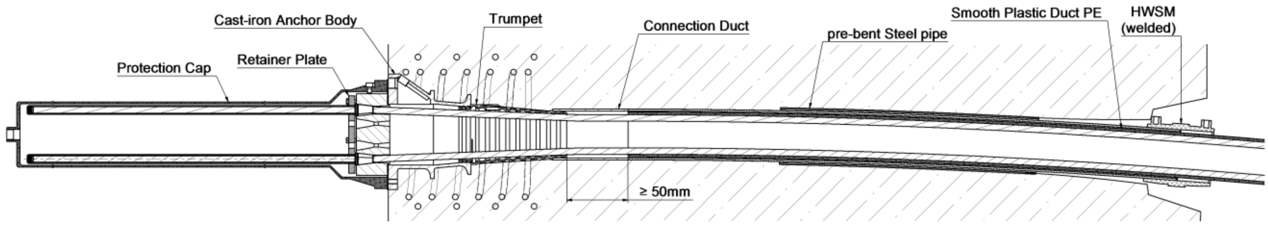


2. Situation before the Stressing Process, Connection with the Duct



***)** ≥ Tendon Elongation + 50mm + if applicable re-stressing Elongation ≥ 500mm, the higher value is decisive!

3. Final State, Connection with the Duct



Tendon Type	Dim.	**L3 E**	**L4 E**	**L5 E**	**L7 E**	**L9 E**	**L12 E**	**L15 E**	**L19 E**	**L22 E**	**L27 E**	**L31 E**
Outer Diameter Plastic Duct	mm	50	63	63	75	75	90	110	110	110/125	125	140
Connection Duct												
Outer Diameter	mm	Dimensions see Annex A9										
Min. Wall Thickness	mm											
Recess Form Part ØS	mm											
Length Form Part K	mm											
Straight Distance min. L1												
Smooth Plastic Duct PE SDR 17	mm	910	1150	910	1270	1300	1410	1940	1650	1660/1940	2080	2360
Smooth Plastic Duct PE SDR 22	mm	-	-	-	-	-	-	1940	1650	1670/1940	2080	2420
Pre-Bent Steel Pipe												
Outer Diameter d_s	mm	76.1	88.9	88.9	101.6	101.6	127	139.7	139.7	159	159	177.8
Wall Thickness	mm	2.9	3.2	3.2	3.6	3.6	4.0	4.0	4.0	4.5	4.5	5

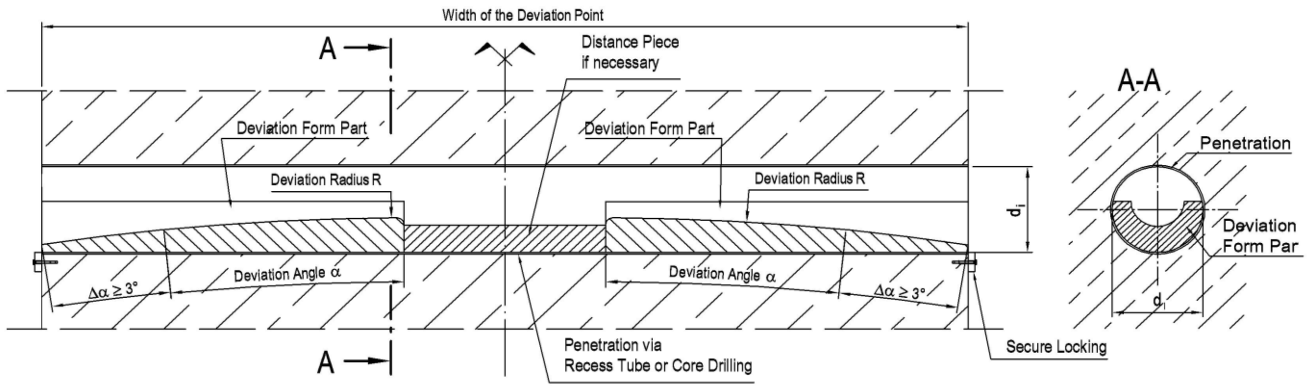
BBV External Post-Tensioning System Type E

Product Description
Connection Anchor Close Deviation – Active Anchor

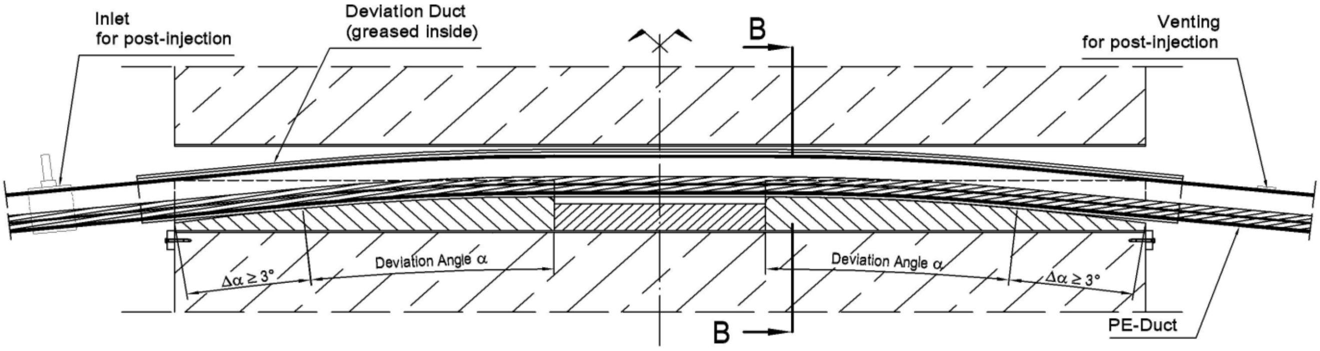
Annex A10

Deviation Type F: Penetration with Inserted Deviation Form Parts

State of Construction



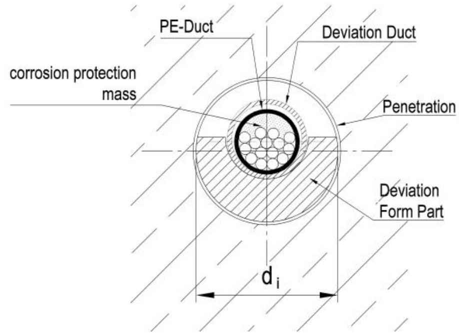
Final State



During construction, misalignment of the penetration tubes shall be avoided.

The deviation form parts are made of plastic and steel.

The penetration consists of galvanized steel-, PVC- or PE-tube or can be made by core drilling.



Tendon Type	Unit	**L3 E**	**L4 E**	**L5 E**	**L7 E**	**L9 E**	**L12 E**	**L15 E**	**L19 E**	**L22 E**	**L27 E**	**L31 E**
Outer Diameter Plastic Duct	mm	50	63	63	75	75	90	110	110	110/125	125	140
Additional Deviation Angle Δα	°	≥3										
Deviation Duct												
Outer Diameter	mm	63	75	75	90	90	110	125	125	125/140	140	160
Wall Thickness	mm	4.3	4.3	4.3	5.1	5.1	6.3	4.8	4.8	4.8/4.3	4.3	6.2
Penetration d_i	mm	to be confirmed by BBV Systems GmbH										

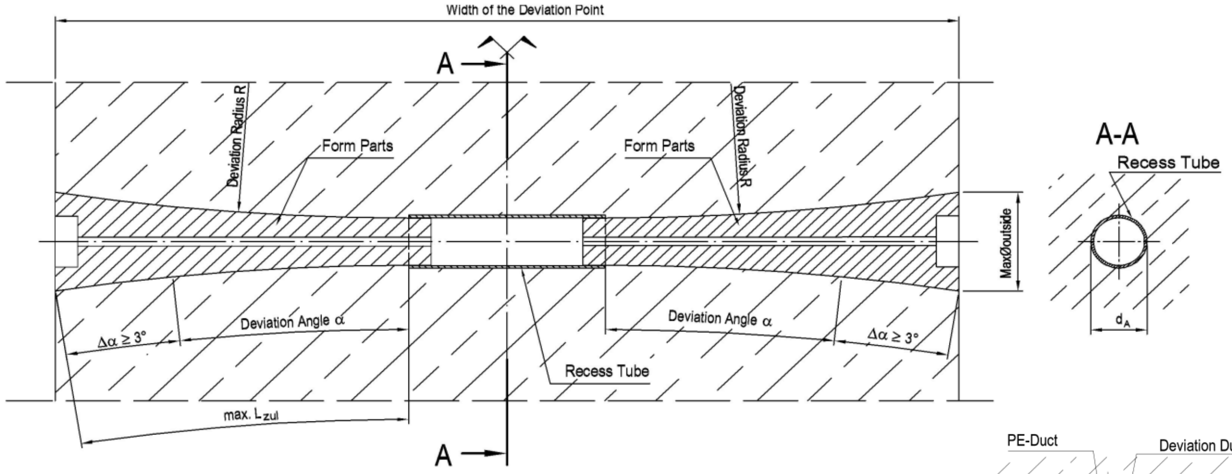
BBV External Post-Tensioning System Type E

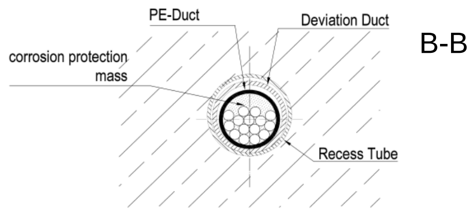
Product Description
Deviation Type F

Annex A11

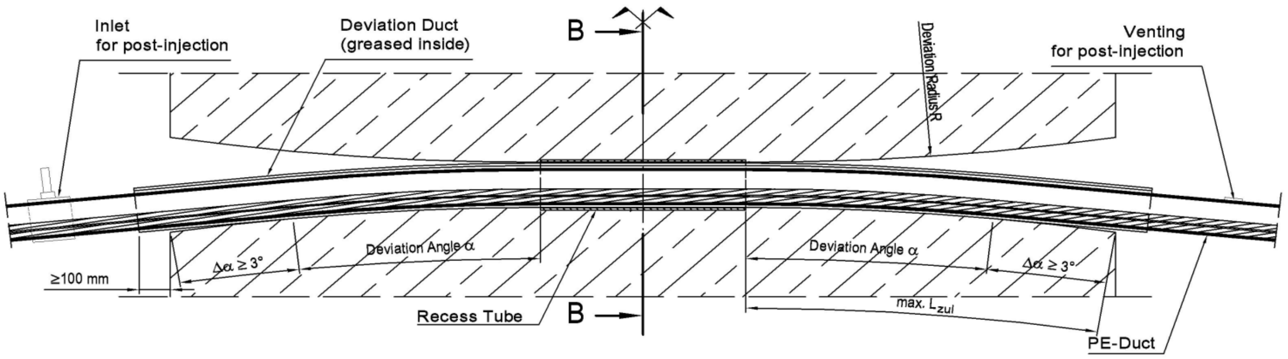
Deviation Type S: Penetration with placed Form Parts

State of Construction





Installation Deviation Duct and Duct:



During construction, misalignment of the form parts and the recess tube shall be avoided.
The recess tube can be made of galvanized steel, PVC or PE or can be made by core drilling.

Tendon Type	Unit	**L3 E**	**L4 E**	**L5 E**	**L7 E**	**L9 E**	**L12 E**	**L15 E**	**L19 E**	**L22 E**	**L27 E**	**L31 E**
Outer Diameter Plastic Duct	mm	50	63	63	75	75	90	110	110	110/125	125	140
Deviation Angle α	°	≤5										
Additional Deviation Angle Δα	°	≥3										
Max. Deviation Length max. L_{zul}		100	170	170	240	240	410	750	750	750/1100	1100	1500
Deviation Duct												
Outer Diameter	mm	63	75	75	90	90	110	125	125	125/140	140	160
Wall Thickness	mm	4.3	4.3	4.3	5.1	5.1	6.3	4.8	4.8	4.8/4.3	4.3	6.2
Recess tube												
Outer Diameter d_A	mm	75	90	90	110	110	125	140	140	140/160	160	180
Wall Thickness	mm	3.6	4.3	4.3	5.3	5.3	6	4.1	4.1	4.1/7.7	7.7	8.6
Form Parts MaxØoutside	mm	Depending on Tendon Size and Chosen Deviation Angle **α**										

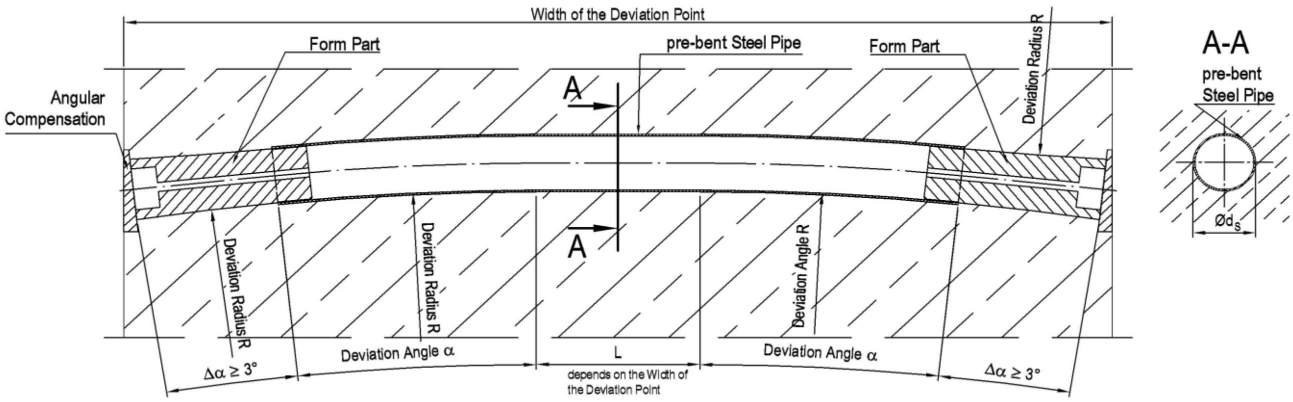
BBV External Post-Tensioning System Type E

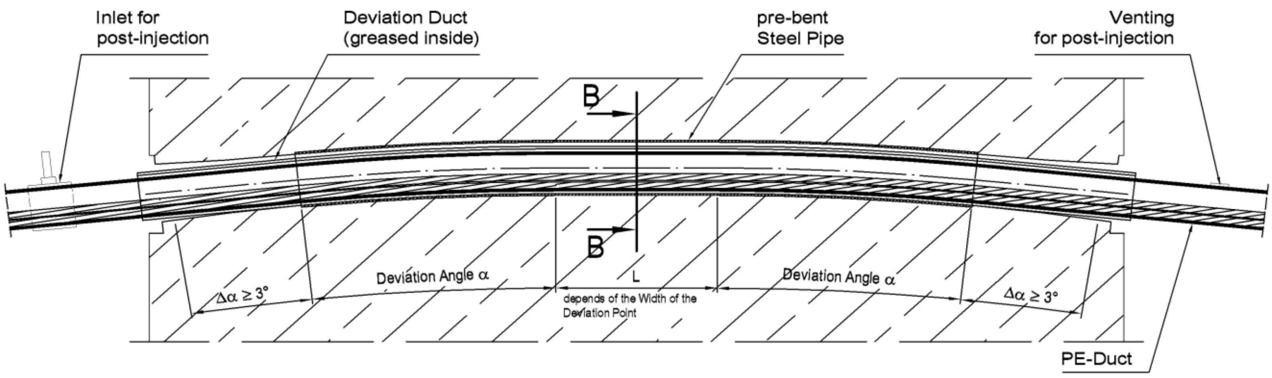
Product Description
Deviation Type S

Annex A12

Deviation Type R: Penetration with a (pre-bent) Pipe

State of Construction:



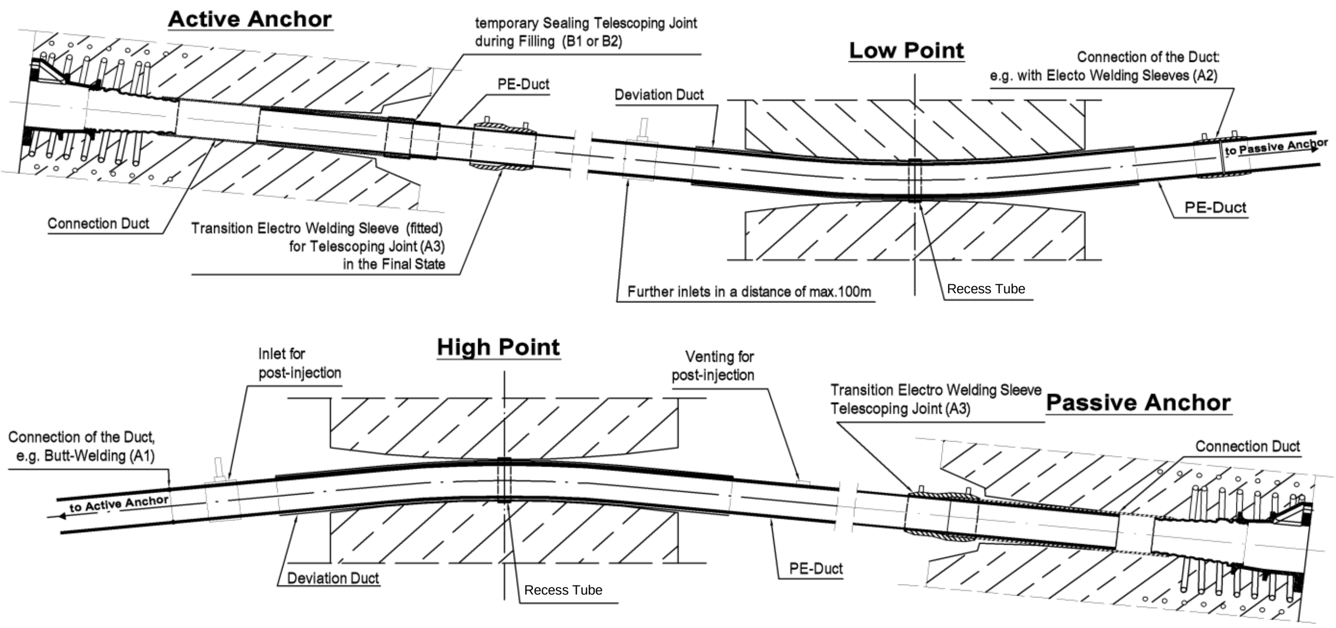


The form parts (see Deviation Type S) will be connected to both ends of the penetration tube (steel, galvnized) and allow an unintentional deviation of Δα.

Tendon Type	Unit	L3 E	L4 E	L5 E	L7 E	L9 E	L12 E	L15 E	L19 E	L22 E	L27 E	L31 E
Outer Diameter Duct	mm	50	63	63	75	75	90	110	110	110/125	125	140
Additional Deviation Angle Δα	°	≥3										
Deviation Duct												
Outer Diameter	mm	63	75	75	90	90	110	125	125	125/140	140	160
Wall Thickness	mm	4.3	4.3	4.3	5.1	5.1	6.3	4.8	4.8	4.8/1.3	4.3	6.2
Pre-bent Steel Pipe												
Outer Diameter d_A	mm	76.1	88.9	88.9	101.6	101.6	127	139.7	139.7	139.7/159	159	177.8
Wall Thickness	mm	2.9	3.2	3.2	3.6	3.6	4.0	4.0	4.0	4.0/4.5	4.5	5

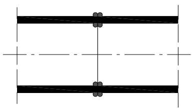
BBV External Post-Tensioning System Type E	Annex A13
Product Description Deviation Type R	

Duct Scheme with Connections and Joints

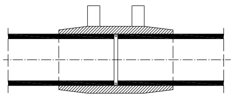


A Tension Resistant Connections and Joints

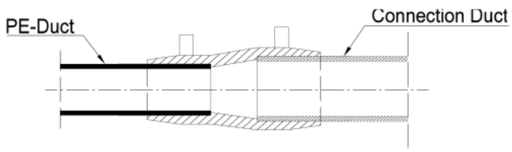
A1) Heated Tool Butt-Welding (HS)



A2) Electro Welding Sleeves (HM)
(Helical Heating Element Welding)

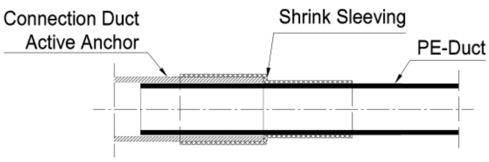


A3) Transition Electro Welding Sleeve (Telescoping Joint)

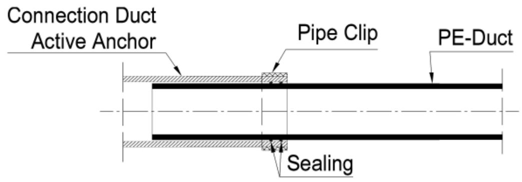


B Temporary Sealing of the Telescoping Joint

B1) Shrink Sleeving



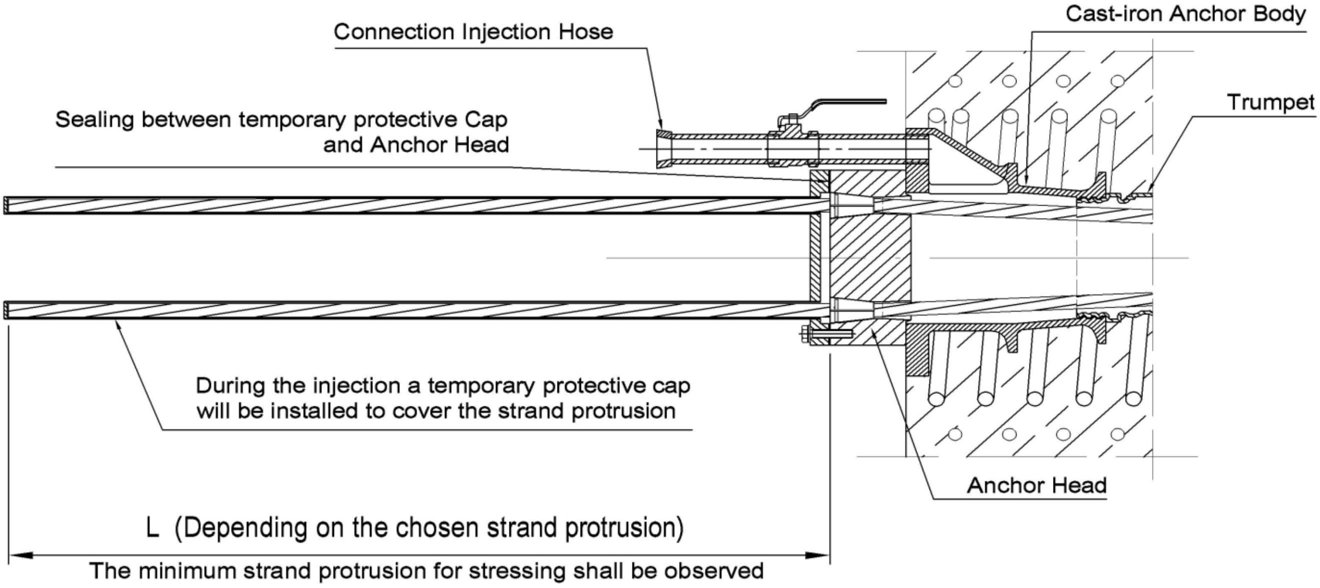
B2) Sealing O-Ring / Pipe Clip



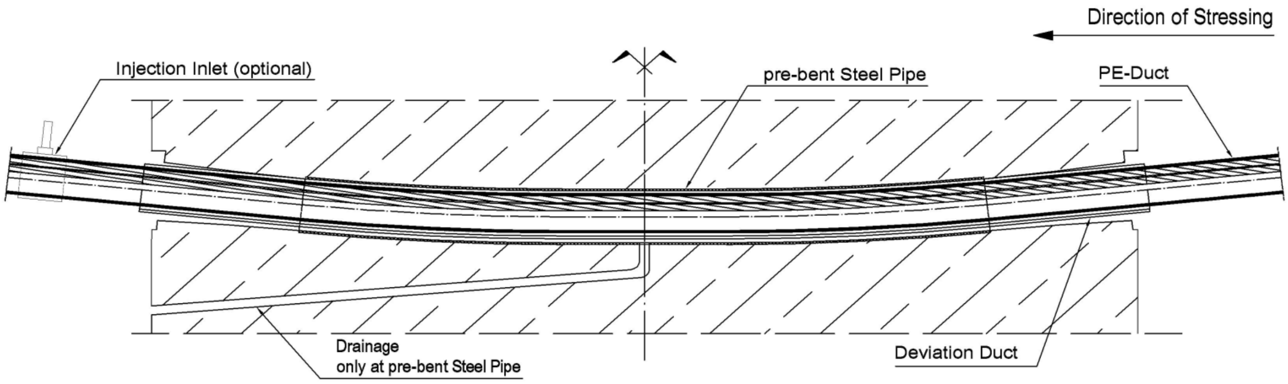
BBV External Post-Tensioning System Type E	Annex A14
Product Description Duct Scheme with Connections and Joints	

Injection of the Duct, Connection Points

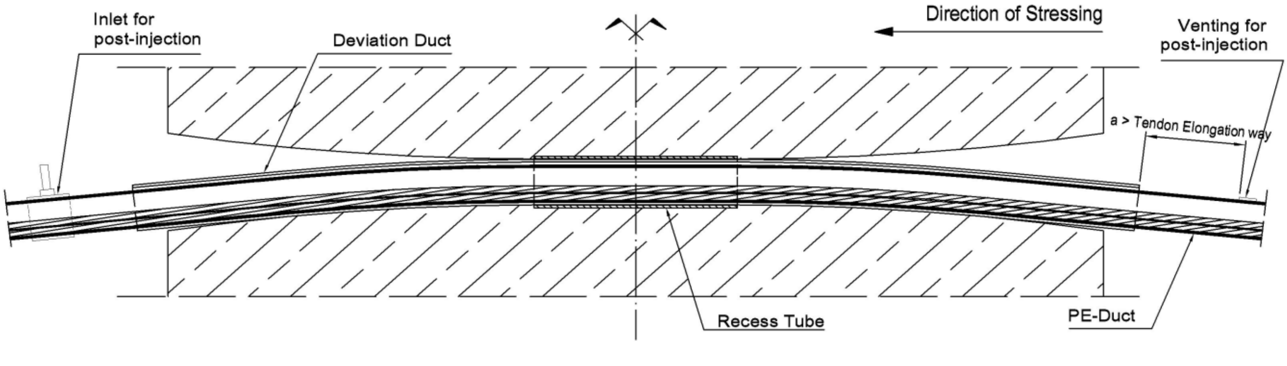
Anchorage (in case of S)



Low Point (Optional additional Injection Opening)



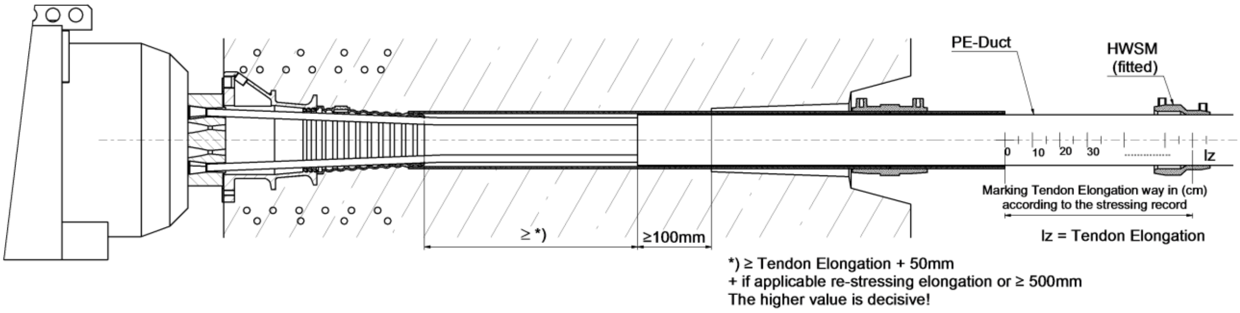
High Point (Post-Injection)



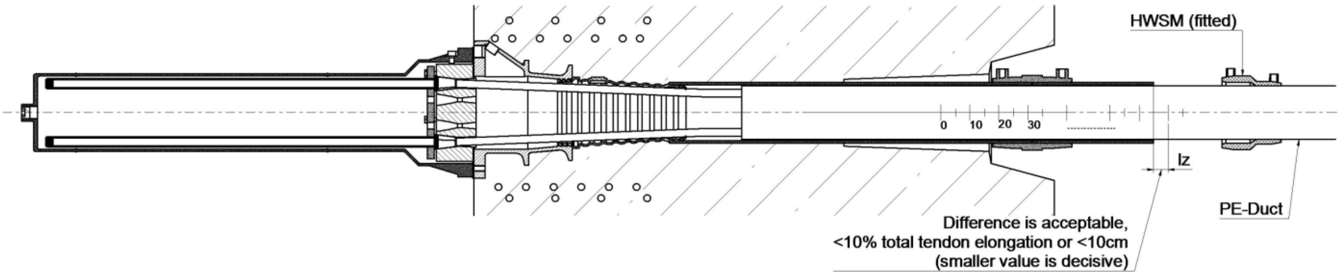
BBV External Post-Tensioning System Type E	Annex A15
Product Description Injection of the Duct, Connection Points	

Marking of the Tendon Elongation on the Smooth Plastic Duct

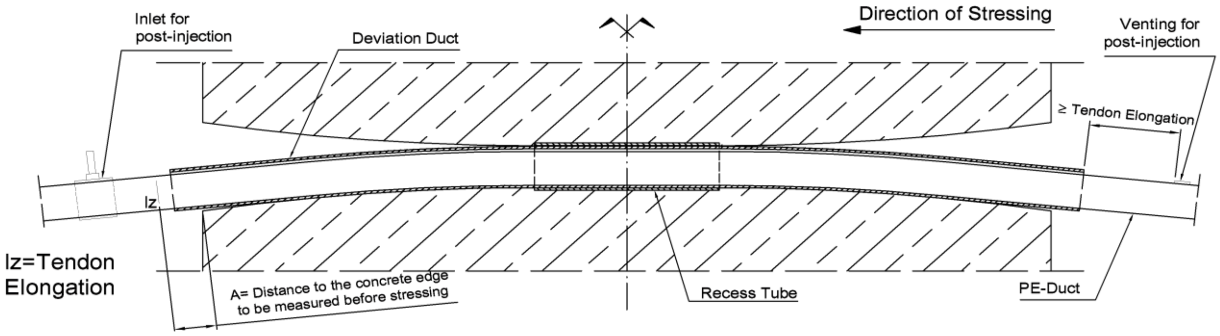
Active Anchor (S), before stressing (Reference measurement for determination of internal slip after tightening)



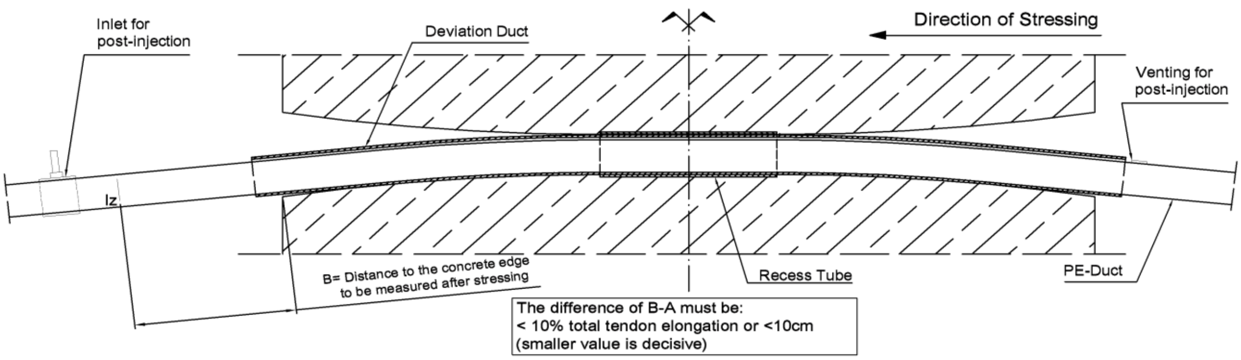
Active Anchor (S), after stressing



Deviation Point, before stressing (reference measurement after tightening)



Deviation Point, after stressing



BBV External Post-Tensioning System Type E	Annex A16
Product Description Marking of the Tendon Elongation on the Smooth Plastic Duct	

Dimensions and Properties of 7-wire Strands

Designation	Symbol	Unit	Value	
Tensile strength	R_m/F_{pk}	MPa	1770 or 1860	
Strand				
Nominal diameter	D	mm	15.3	15.7
Nominal cross section	A_p	mm²	140	150
Nominal mass	M	g/m	1093	1172
Surface configuration	-	-	plain	
Strength at 0,1%	$f_{p0.1k}$	MPa	1520 or 1600*	
Strength at 0,2%	$f_{p0.2}$	MPa	1570 or 1660	
Modulus of elasticity	E	MPa	≈ 195,000	
Individual wires				
External wire diameter	d	mm	5.0 ± 0.04	5.2 ± 0.04
Core wire diameter	d'	mm	1.02 to 1.04 d	1.02 to 1.04 d

* If admissible in the place of use, strands with higher characteristic yield stresses might be used, but not more than $f_{p0,1k} \geq$ 1560 MPa (Y1770S7) or 1640 MPa (Y1860S7).

As long as prEN 10138-3:2009-08 has not been adopted 7-wire strands in accordance with national provisions and with the characteristics given in the table above shall be used.

1 Intended use

The Post-Tensioning System is assumed to be used for external prestressing of normal-weight concrete structures or elements. The tendon path shall be placed outside of the cross section of the concrete element but inside its envelope. The structural members are to be designed in accordance with national regulations.

Optional use categories:

- Resstressable tendon
- Exchangeable tendon
- Tendon for use in composite structures

2 Methods of verification

2.1 General

The structural members which are prestressed by means of the BBV External Strand Post-Tensioning System Type E have to be designed in accordance with national regulations.

2.2 Tendons

Prestressing and overtensioning forces are specified in the respective national provisions.

The maximum force P_{max} applied to a tendon shall not exceed the force $P_{max} \geq 0.9\ A_p\ f_{p0,1k}$ laid down in Table B1 (140 mm²) or in Table B2 (150 mm²). The value of the initial prestressing force $P_{m0}(x)$ applied to the concrete after tensioning and anchoring shall not exceed the force $P_{m0}(x) \geq 0.85\ A_p\ f_{p0,1k}$ laid down in Table B1 (140 mm²) or in Table B2 (150 mm²).

Table B1: Maximum prestressing forces[1] for tendons with $A_p \geq 140$ mm²

Tendon Designation	Number of strands	Cross section A_p [mm²]	Prestressing force Y1770S7 $f_{p0,1k} \geq 1520$ MPa		Prestressing force Y1860S7 $f_{p0,1k} \geq 1600$ MPa	
			$P_{m0}(x)$ [kN]	P_{max} [kN]	$P_{m0}(x)$ [kN]	P_{max} [kN]
BBV L3 E	3	420	543	575	571	605
BBV L4 E	4	560	724	766	762	806
BBV L5 E	5	700	904	958	952	1008
BBV L7 E	7	980	1266	1341	1333	1411
BBV L9 E	9	1260	1628	1724	1714	1814
BBV L12 E	12	1680	2171	2298	2285	2419
BBV L15 E	15	2100	2713	2873	2856	3024
BBV L19 E	19	2660	3437	3639	3618	3830
BBV L22 E	22	3080	3979	4213	4189	4435
BBV L27 E	27	3780	4884	5171	5141	5443
BBV L31 E	31	4340	5607	5937	5902	6250

[1] The forces stated in Tables B1 to B3 are maximum values based on $f_{p0,1k}$ = 1520 MPa or 1600 MPa. The actual prestressing forces are to be found in national regulations valid in the place of use. If admissible in the place of use, strands with higher characteristic yield stresses might be used, but not more than $f_{p0,1k}$ = 1560 MPa (Y1770S7) or 1640 MPa (Y1860S7). In this case the prestressing forces of Tables B1 to B3 can be linearly increased by multiplying them with the factor ($f_{p0.1k}$ / 1520) or ($f_{p0.1k}$ / 1600).
Compliance with the stabilisation and crack width criteria in the load transfer test was verified to a load level of 0.80 F_{pk}.

Table B2: Maximum prestressing forces[1] for tendons with $A_p \geq 150$ mm²

Tendon Designation	Number of strands	Cross section A_p [mm²]	Prestressing force Y1770S7 $f_{p0,1k} \geq 1520$ MPa		Prestressing force Y1860S7 $f_{p0,1k} \geq 1600$ MPa	
			$P_{m0}(x)$ [kN]	P_{max} [kN]	$P_{m0}(x)$ [kN]	P_{max} [kN]
BBV L3 E	3	450	581	616	612	648
BBV L4 E	4	600	775	821	816	864
BBV L5 E	5	750	969	1026	1020	1080
BBV L7 E	7	1050	1357	1436	1428	1512
BBV L9 E	9	1350	1744	1847	1836	1944
BBV L12 E	12	1800	2326	2462	2448	2592
BBV L15 E	15	2250	2907	3078	3060	3240
BBV L19 E	19	2850	3682	3899	3876	4104
BBV L22 E	22	3300	4264	4514	4488	4752
BBV L27 E	27	4050	5233	5540	5508	5832
BBV L31 E	31	4650	6008	6361	6324	6696

The number of strands in a tendon may be reduced by leaving out strands lying radial-symmetrically in the anchor head (not more than four strands). The provisions for tendons with completely filled anchor heads (basic types) apply also to tendons with only partly filled anchor heads. Into the free drills in the anchor head short pieces of strands with wedges have to be pressed to prevent slipping out. The admissible prestressing force is reduced per left-out strand as shown in Table B3.

Table B3: Reduction of the prestressing force[1] when leaving out a strand

A_p	Y1770S7		Y1860S7	
	$\Delta P_{m0}(x)$ [kN]	ΔP_{max} [kN]	$\Delta P_{m0}(x)$ [kN]	ΔP_{max} [kN]
140 mm²	181	192	190	201
150 mm²	194	205	204	216

For further characteristic values of the tendons (mass per meter, ultimate stressing force F_{pk}) see Annex A2.

2.3 Radius of curvature of the tendons in the structure

The smallest admissible radii of curvature (minimum bending radii) are given in Annex A2. An analysis of the edge stresses in the strands can be omitted while following these radii of curvature. The acceptance of the forces due to the deviation of the tendon in the structure shall be verified.

The given smallest admissible radii of curvature are based on the maximum presstressing forces $P_{m0}(x)$ according to Tables B1 and B2. If admissible in the place of use, and if strands with higher characteristic yield stressed are used, the given radii of curvature shall be linearly increased by multiplying them with the factor ($f_{p0,1k}$ / 1520) or ($f_{p0,1k}$ / 1600) and rounded up in steps of 0.1 m (see also Annex B1, section 2.2).

2.4 Concrete strength

At the time of transmission of the full prestressing force the mean concrete strength of the normal weight concrete $f_{cmj,cube}$ or $f_{cmj,cyl}$ in the anchor zone shall be at least according to Table B4. The mean concrete strength shall be verified by means of at least three specimens (cube with the edge length of 150 mm or cylinder with diameter of 150 mm and height of 300 mm), which shall be stored under the same conditions as the concrete member, with the individual values of specimen not differ more than 5 %.

Table B4: Necessary mean concrete strength f_{cmj} of the specimens at time of prestressing

$f_{cmj,cube}$ [N/mm²]	$f_{cmj,cyl}$ [N/mm²]
28*)/30**)	23*)/25**)
34	28
40	32
45	35

*) 12 to 31 strands

**) 3 to 9 strands

For partial prestressing with 30 % of the full prestressing force the minimum value of the concrete compressive strength to be proved is 0.5 $f_{cmj,cube}$ or 0.5 $f_{cmj,cyl}$; intermediate values can be interpolated linearly.

2.5 Centre and edge distances of the tendon anchorages, concrete cover

The centre and edge distances of the tendon anchorages must not be smaller than the values given in the Annexes depending on the minimum concrete strength. In case of anchorages BBV L3 to BBV L9 the large side of the bearing plate (side length a according to Annex A6) shall be installed parallel to the large concrete side (maximum value of minimum centre distance).

The values of the centre or edge distances of the anchors given in the Annexes may be reduced in one direction up to 15 %, however, not to a smaller value than the external dimensions of the stirrup reinforcement or the outer diameter of the helix. In this case the centre and the edge distances in the other direction shall be increased for keeping the same concrete area in the anchor zone.

All centre and edge distances have only been specified with a view to load transfer to the structure; therefore, the concrete cover given in national standards and provisions shall be taken into account additionally.

2.6 Reinforcement in the anchorage zone

The anchorages (including reinforcement) are verified by means of tests for the transfer of the prestressing forces to the structural concrete.

The resistance to the forces occurring in the structural concrete in the anchorage zone outside (behind) the helix shall be verified. An adequate transverse reinforcement shall be provided here in particular for the occurring transverse tension forces (not shown in the attached drawings).

The steel grades and dimensions of the additional reinforcement (stirrups) shall follow the values given in the Annexes. This reinforcement must not be taken into account as part of the statically required reinforcement. However, existing reinforcement in a corresponding position exceeding the statically required reinforcement may be taken into account for the additional reinforcement. The given reinforcement consists of closed stirrups (stirrups closed by means of bends or hooks or an equivalent method). The stirrup locks (bends or hooks) shall be placed mutually offset.

In the anchorage zone vertically led gaps shall be provided for proper concreting.

If in exceptional cases[2] – due to an increased amount of reinforcement – the helix or the concrete cannot be properly placed, the helix can be replaced by other equivalent reinforcement.

[2] This requires the approval for individual case according to the national regulations and administrative provisions.

2.7 Slip at the anchorages

The slip at the anchorages (see Annex B2, section 3.7) shall be taken into account in the static calculation and the determination of the tendon elongation.

2.8 Fatigue resistance

With the fatigue tests for the anchors carried out in accordance with ETAG 013, the stress range of 80 N/mm² of the strands at the maximum stress of 0.65 f_{pk} at 2×10^6 load cycles was verified.

In the areas of deviation of tendons a stress range of 35 N/mm² at 2×10^6 load cycles can be assumed as verified. Due to national provisions at the place of use, higher stress ranges up to 80 N/mm² might be assumed as verified in the areas of deviation.

2.9 Guidance of Tendons through Construction Members

Where tendons are guided through a straight penetration of a construction member, an appropriate size of the opening in the construction member, taking into account the construction tolerances, shall be provided to ensure that the tendons have no contact with the construction member.

2.10 Protection of the Tendons

The tendons shall be protected against failure resulting from extraneous cause (e.g. vehicle impact, elevated temperatures in case of fire, vandalism). The requirements shall be investigated on a case by case basis and rated according to the specific project conditions. Tendons enclosed by a box girder are classified as sufficiently protected.

Tendons enclosed by a box girder are supposed to be sufficiently protected against corrosion. For tendons placed outside a box girder, especially in corrosion enhancing conditions, the applicability of the tendons shall be verified.

3 Installation

3.1 General

The assembly of the tendons has to be carried out at building site. Assembly and installation of the tendons shall only be performed by qualified post-tensioning specialist companies which have the required technical skills and experiences with the BBV External Post-Tensioning System Type E. The company's site manager shall have a certificate of the manufacturer certifying that he is instructed by the manufacturer and has the required knowledge and experience with this post-tensioning system. Standards and regulations valid on site shall be considered.

The manufacturer is responsible to inform anyone concerned about the use of the BBV-External Post-tensioning System Type E. Additional information as listed in ETAG 013, Section 9.2 shall be held available by the manufacturer and shall be distributed as needed.

The tendons and the components shall be handled carefully.

3.2 Welding

Welding at the anchorages is only permitted at the following parts:

a) Welding of the end of the helix to a closed ring.

b) For ensuring the central positioning, the helix may be attached to the bearing plate by tack-welding.

After placing the strands in the ducts no further welding shall be performed at the anchorages.

3.3 Installation of the anchorages, the helixes and the additional reinforcement

The conical boreholes of the anchor heads shall be clean, stainless and coated with corrosion protection mass. The central position of the helix and the stirrups shall be ensured by tack-welding to the bearing plate or the cast-iron anchor body or by means of mounting brackets. The bearing plate or cast-iron anchor body and the anchor head shall be positioned perpendicular to the axis of the tendon.

The tendon shall be placed straight over the length min. L1 behind the anchor head (see Annexes A8 to A10). Distinction shall be drawn between anchorages where the tendon is placed straightforward and anchorages with anchor close deviation.

The joint between trumpet and connection duct shall be sealed carefully with PE-tape, first to avoid the penetration of concrete and later to avoid leakage of corrosion protection material.

The minimum width of the crossbeam at both the active and passiv anchorages is shown in Annexes A8 to A10.

3.4 Installation of the strands and the ducts

All recess ducts (in the area of anchorages and deviations) shall be fastened in such a way that they cannot be moved during concreting.

At all locations where the tendons exit from the construction member trumpet-like widenings $\Delta\alpha$ shall be provided, which allow for unscheduled deviation from the planned position of the tendon axis without kink up to a minimum of 3°. The installation of the ducts and the strands shall be carried out according to the description in Annex B3. The duct scheme with connections and joints is shown in Annex A16. At both the stressing and fixed anchors, connection ducts are installed (see Annexes A8 to A10).

At the fixed anchors, the duct ends about 5 cm in front of the trumpet and is permanently connected with the duct of the free tendon length. At stressing anchors the duct is shifted into the crossbeam until it reaches beyond the deviation zone by at least 10 cm.

The required insertion length of the duct at stressing and fixed anchors shall be measured in advance and marked. Before tightening the right position of the tendon at the stressing anchor shall be checked once more and it shall be recorded in writing how far the tendon reaches inside the crossbeam.

Recess clearances, deviation form parts and deviation ducts at the deviation points shall be clean and smooth. Before pulling in the ducts, the deviation ducts shall be greased inside.

3.5 Prohibition of transversal oscillation of tendons

Critical transversal oscillations of the tendons caused by traffic, wind or other excitations shall be avoided by constructive measures.

If at the place of the use no other regulation is valid for bridges of box girders a fixing distance for the tendons of about 35 m is recommended. Transversal oscillations which occur nevertheless usually do not have any harmful effects.

Outside of box girders smaller fixing distances are required.

The fixings shall be performed in such a way that the duct will not be damaged and the movement in longitudinal direction of the tendon is not obstructed.

3.6 Unscheduled contact of the tendon and free lift-off at entrances of the building/crossbeams

Unscheduled contact of the tendon with the building structure is inadmissible.

At entrances of anchorages or deviation points the tendon shall lift-off freely (the tendon shall have no unscheduled contact (no kink), see also Annex B2, section 3.9). After the tightening of the tendon and before filling in hot corrosion protection mass the free lift-off should be checked at all entrances.

3.7 Wedging force, slip, wedge securing and corrosion protection mass in the wedge-seating area

The wedges of fixed anchors shall be pre-wedged with 1.1 $P_{m0}(x)$ (see Annex B1, section 2.2), if knurled wedges type 30 are used.

Without pre-wedging the slip to be taken into account for the determination of the elongations/movements of the strands is 4 mm at fixed anchorages. In the case of hydraulic pre-wedging with 1.1 $P_{m0}(x)$ no slip shall be taken into account for the determination of the elongations/movements of the strands.

The wedges of stressing anchors shall be pre-wedged after tensioning with the minimum force of 0.1 $P_{m0}(x)$. In this case the slip is 3 mm. If the wedges are not compressed, the slip shall be about 6 mm (a reset plate shall be used to fix the wedges).

The wedges shall be secured by a retaining plate.

3.8 Tightening and filling with corrosion protection mass

At the stressing anchorage, the way of the duct shall already be documented during the tightening (see also Annex B2, section 3.4).

Before the stressing and the filling with hot corrosion protection mass the tendon shall be tightened with a minimum of 5 % and a maximum of 10 % F_{pk}.

After the temporary sealing of the duct at the stressing anchor, the duct shall be injected from one anchor with hot corrosion protection mass with a maximum temperature of 100 °C (usually from one point close to an anchor and in proximity to the next low point).

In a distance of not more than 100 m intermediate inlets on the tendon at the low points shall be provided, which shall be supplied with containers with hot corrosion protection mass or their supply pipes, respectively.

Once corrosion protection mass emerges from an inlet, further injection shall be carried out from this inlet. In the case of short tendons (tendon length < 50 m) injection of hot corrosion material shall be carried out until hot liquid corrosion protection mass emerges from the venting.

Before further work is carried out, the corrosion protection material shall have cooled down to ambient air temperature (about 30 °C). For that, usually one day is sufficient.

After cooling down of the corrosion protection mass, all high points shall be post-injected with cold corrosion protection mass (see Annex A14 and A15 and B3). After the drilling of the necessary inlets and vents, the temperature of the corrosion protection mass in the duct shall be measured, in order to check whether it has cooled down sufficiently.

All voids shall be filled completely with corrosion protection material. Complete filling with corrosion protection material shall be checked by tapping along the tendon over its full length.

Possible defects shall be post-injected. When setting the inlets and ventings care must be taken to ensure that their distance to the deviation zone is sufficient so that they will not been pulled inside the deviation zone during stressing or re-stressing.

3.9 Prestressing and admissible elongation way/prestressing path

All strands of a tendon shall be stressed simultaneously. In the case of straight tendons it is permitted to stress strand by strand. The order of the strands to be stressed shall be determined in such a way that the anchor carries only the eccentricity of the prestressing force of one stand at a time, in order to keep the eccentric load of the anchor head at a minimum.

At the fixed anchor the elongation/ movement of the strands resulting from stressing and restressing at the entrance from the structure/crossbeam shall not exceed 10 cm.

At every deviation point and at the stressing anchor, during stressing the amount of inner gliding (difference of the movement of the strand and the movement of the duct at the marking) and outer gliding (movement of the duct) shall be documented by the company carrying out the work.

At the stressing anchor, the movement of the duct shall already be documented during the tightening. At the stressing anchor, during stressing or re-stressing the duct in the free length of the tendon glides into the connection duct.

For determination of the way/ movement with inner gliding the measured values between 10 % F_{pk} and 100 % of the prestressing force (target load) shall be taken into account. The movement of the strands shall be recorded in the stressing manual for each deviation point and for the stressing anchor.

After the tightening and the cooling of the corrosion protection mass markings shall be provided at the stressing anchorage and at all deviators the duct. The initial positions of the markings shall be measured (see Annex A16).

At the stressing anchor the temporary sealing of the telescoping joint shall be opened again and a clamp for fastening of a chain hoist at the duct shall be installed.

If necessary, for achieving outer gliding of the duct at the stressing anchor as well, simultaneous pulling of the chain hoist and the duct together with the movement (stressing) of the strands is possible. In the case of tendons deviated in proximity behind the stressing anchor (see Annex A10) pulling of the duct usually is not necessary.

The movements of the ducts shall be measured and compared with the calculated elongations/movements of the strands (each deviation point and stressing anchor). The amount of inner gliding (difference of the movement of the strands and the movement of the duct at the marking) during stressing (after tightening) must not exceed 10 % of the total elongation or 10 cm (the lower of the two values is decisive). The amount of outer gliding of the duct (movement of the duct) shall be at least 90 % of the total elongation. When fulfilling this requirement no limitation of the prestressing way (elongation) is necessary. This requirement is not relevant for straight tendons without scheduled or unscheduled deviations.

At the stressing anchor the duct shall not be compressed. So the initial position and the full movement of the duct shall be additionally measured and documented, in order to verify that in the final state the position of the duct is according to Annexes A8 or A10, Drawing C, respectively.

It is admissible to re-stress the tendons by releasing and re-using the wedges. After re-stressing and setting of the wedges, wedge marks on the strands resulting from first stressing shall be moved to the outside by at least 15 mm. Re-stressing paths < 15 mm are not admissible.

Not later than after the stressing to the full target load at the entrances of anchors and deviators it shall be checked whether the tendons lift-off freely. In cases where the tendon does not lift-off freely, the tendon shall be dismantled and the corresponding place in the concrete member shall be repaired. Whether the same tendon may be re-installed, shall be decided after consultation with the client.

3.10 Corrosion protection measures after prestressing

Anchors shall be protected against corrosion with protection caps and a system consisting of retainer plates and flexible cover caps or tubes (see Annexes A3 and A4 and B3, section 4.2.3).

At the stressing anchor, the joint between the connection duct and the duct shall be closed permanently with a transition electro welding sleeve (see Annexes A8 and A9 and B3, section 4.3).

Voids in the ducts shall be filled completely with corrosion protection mass (see Annex B2, section 3.8 and Annex B3, section 4.5.6).

3.11 Re-stressing

Re-stressing of the tendons by releasing and re-using of the wedges is admissible (see Annex B2, section 3.9).

Preparatory works are: removing the protection caps and the joints between the connection duct and the duct at the stressing anchorage. In the same way as for prestressing, the duct shall be provided with markings and their initial positions shall be measured.

The movements of the duct shall be measured and compared with the calculated elongations/movement of the strands (each deviation point and stressing anchorage). The amount of inner gliding (difference of the movements of the strands and the movement of the duct at the marking) during stressing shall not exceed 10 % of the total elongation or 10 cm (the lower of the two values is decisive).

The movements achieved during prestressing shall be taken into account. When fulfilling this requirement, limitation of the re-stressing elongation is not necessary. In case the value of 10 cm for inner gliding at one point of the structure is reached, further re-stressing of the tendon is not allowed. In the case that the value of 10 cm already has been reached during prestressing, re-stressing is not admissible.

At the stressing anchor the duct shall not be compressed (see Annex B2, section 3.9). After re-stressing corrosion protection measures according to Annex B2, section 3.10 shall be carried out.

3.12 Exchange of tendons

The dismounting of tendons and the following installation of new tendons is possible (see Annex B3, section 4.10). The conditions for future displacement of tendons, the number of tendons that can be dismounted at the same time and the on-site provisions, which already shall be planned during the design of the building, shall be determined for each single case.

For every cutting of tendons the relevant working instructions and the safety provisions for workers shall be determined by the operating company and agreed upon by the client.

3.13 Packaging, transport and storage

The components and the tendons shall be protected against moisture and staining.

The tendons shall be kept away from areas where welding procedures are performed.

For transport and handling of the strands the provisions of the strand manufacturer shall be observed.

The PE-ducts are delivered as straight.

4 Description of the Post-Tensioning System

4.1 Tendons

For the tendons 7-wire strands with a nominal diameter of 15.3 mm (nominal cross-section 140 mm²) or with a nominal diameter of 15.7 mm (nominal cross-section 150 mm²) are used. Steel grades Y1770S7 or Y1860S7 are allowed. The stressing system covers tendons from 3 to 31 strands. The anchors are identical for both prestressing steel grades.

The number of strands in the tendons may be reduced by omitting strands in such a way that the pattern maintains radially symmetric in the anchorage (not more than four strands). Into the free drills in the anchor head short pieces of strands with wedges have to be pressed to prevent slipping out. The strands of the tendons are combined in a duct without spacers. Strands are stressed simultaneously and then anchored individually with round wedges. PE-tubes in accordance with EN 12201-1:2011-11 and EN 12201-2:2011-02 are used. The scheme of the duct installation is shown in Annex A14. The tendons may be re-stressed and replaced since the ducts are filled with non-hardening corrosion protection mass. The length of the tendons is unlimited.

4.2 Anchorages

4.2.1 Wedge anchorages

The anchorage with anchor plate or cast-iron anchor body and anchor head usually is used as an active anchor (S) or a passive anchor (F). In the anchorage zone, the duct is replaced by a trumpet, in which the strands are deflected by a maximum of 2.2°. For anchorages with 150 mm² strands, wedges with markings "0.62" on the front face shall be installed. The bursting forces caused by the load transfer to the concrete member shall be carried by a helix made of ribbed reinforcing steel. Additional reinforcement is also installed. Within the structural design resistance to the forces behind the helix as the result of stressing force transfer shall be verified.

4.2.2 Strand protrusion for stressing and re-stressing

The strand protrusion beyond the anchor head serves the purpose of fitting the stressing jack for initial stressing and re-stressing. Annex A2 specifies the strand protrusion generally required for initial stressing. The required strand protrusion and the required space for the stressing jack could be adapted to specific project requirements after consulting BBV Systems.

4.2.3 Corrosion protection of the anchor

The corrosion protection system of the anchors is shown in Annexes A3 and A4. Strand protrusion and anchor head at passive anchor shall be protected with flexible cover cap. Anchor head for the passive anchor shall be additionally wrapped with DENSO tape. Retainer plate has to be placed on flexible cover cap. PE protective cap is set on wedge disc, cover cap and wedge protection disc and screwed together with front side of the anchor plate / cast iron anchor body. Between them a NBR-sealing is arranged.

Contact area between retainer plate and anchor head is coated with corrosion protection mass on active anchor side. Wedge disc is wrapped with DENSO tape. Greased strand protrusions are overlaid with covering tubes. Every covering tube is placed in wedge protection disc and closed with a plug. PE protective cap is set on wedge disc, wedge protection disc and strand protrusions and screwed together with front side of the anchor plate / cast iron anchor body. Between them is a NBR-sealing arranged.

4.3 Ducts

PE tubes in accordance with EN 12201-1:2011-11 und EN 12201-2:2011-02 are used as ducts. The trumpet is connected to the connection duct in area of the active and passive anchor. The transition is sealed with adhesive PE tape or equivalent (e.g. pipe sleeve). During the stressing operations the duct moves into the larger connection duct at the active anchor.

The connection on the active anchor between the connection duct and the duct shall be temporarily closed during filling with corrosion protection mass, to prevent the escape of corrosion protection mass. The temporary seal is removed after filling and cooling of the corrosion protection mass. The transition is finally closed permanently after completion of the stressing works.

4.4 Deviators

4.4.1 General

The transition of the area of the deviation to the free length of the tendon features a trumpet-shaped widening. In addition to the designed deviation angle α the widening permits an unintended deviation angle free of kinks with at least $\Delta\alpha \geq 3°$ in all directions. The minimal deviation radius of curvature R specified in Annex A2. It refers to the tendon's plane of curvature (this may also be inclined with respect to the vertical). The mini-mum permitted radius of curvature R shall also be complied with on the trumpet-shaped opening.

Three types of deviation points are available:

- Deviation type F: Penetration with inserted deviation form parts
- Deviation type S: Creation of the deviation contour with form parts
- Deflection type R: Penetration with a (pre-bent) pipe

In all types of deviators the duct is guided through a greased deviation duct. A minimum protrusion of the deviation duct of at least 10 cm beyond the cross-beam dimensions is required on both sides. The prestressed tendon must lift off free of kinks at the end of the deviation area.

4.4.2 Deviation type F: Penetration with inserted form parts

For this, a tubular penetration is made, generally by installing a recess pipe. The penetration can also be made by core drilling or equivalent. The tendon is deflected only with the aid of form parts made of plastic or steel, inserted into the penetration. The form parts have the required geometry for guiding the tendon and must be adequately secured to the building structure so that the duct and form parts are not misaligned when stressing. The form parts can be modified by addition of spacer to match the cross beam dimensions.

4.4.3 Deviation type S: Creation of the deviator contour with form parts

The deviation is produced by rotationally symmetric form parts which helps to form the deviation geometry in the structural concrete or in the precast element. A recess pipe can be installed centrally for adapting the deviation point to various lengths of crossbeams.

The intended deviation is limited to a maximum permitted angle per rotationally symmetric form part. In addition, the intended and unintended deflections are limited to a maximum permitted length max. L_{zul} (see Annex A12).

4.4.4 Deviation Type R: Penetration with a (pre-bent) pipe

The deviation arrangement is produced by a pre-bent steel pipe (corrosion-protected). Rotationally symmetric form parts which allow for an unintended deviation of $\Delta\alpha \geq 3°$ on all sides are attached to the ends of the pipe, free of knicks. One option of deviation type R is that a deviation exceeding the unintended deviation can be provided with form parts.

Deviation Type R can be formed at the active anchor (anchor close deviation), whereby the requirements regarding the slip conditions shall be observed. Deflection Type R can be formed at the passive anchor if the elongation (stressing and, possibly, restressing) at the exit point of the building structure does not exceed 10 cm.

4.4.5 Unintended contact

Unintended contact of the tendon with the structure is not permitted. Additional unintended deviations of $\Delta\alpha \geq 3°$ shall be arranged at the ends of the areas of deviation and the exit of the tendon from the concrete member at the active and passive anchors. The minimum radius of curvature shall also be complied with in the area of unintended deviations. The tendon shall lift off free at the exit from the structure.

4.4.6 Corrosion protection of exposed steel components

see section 1.9 of the Specific Part of the European Technical Assessment

4.5 Assembly of the tendons

4.5.1 Components for casting

On site, bearing plates, cast-iron anchor bodies, trumpets connection ducts, form parts of the anchor zones, helixes and additional reinforcement are cast in concrete. According to the design, penetration tubes (straight or curved) and, if necessary, form parts are cast in concrete at the deviation points. Deviation points can be made also only with form parts and if necessary with recess tubes depending on length of the cross beam. At existing structures, recesses can also be produced e.g. by core drilling.

4.5.2 Installation of the ducts

Initially, ducts are pulled into the structure. A transition electro welding sleeve shall be used for providing a strain resistant connection between the duct and the connection duct at the active anchor.

The duct is slid into the connection duct at the passive anchor that the duct lays approx. 5 cm before the trumpet. The connection of the duct and connection duct shall be created strain resistant.

The duct is then slid into the connection duct at the active anchor to such an extent that the duct lays approx. 10 cm beyond the intended and unintended deviation area (deviation α or $\Delta\alpha$) in the direction of the active anchor before tightening. The length of the connection duct from trumpet to the duct at the active anchor shall permit movements with complete outer gliding of the duct while tightening, stressing and possible re-stressing process. The connection of the duct to the connection duct and duct joints on the free length shall be created strain resistant connection by butt welding with heat elements or by electro welding sleeves.

4.5.3 Installation of the strands

The strands shall be inserted into the ducts either by means of a strand pushing machine or cable winch.

4.5.4 Tightening of the strands

If tendons have deviation points, they are tightened to a pre-load after strand insertion. Deviated tendons shall have a pre-load at least 5% and a maximum 10 % of F_{pk}. The joint between duct and connection duct at the active anchor is temporarily sealed before filling with corrosion protection mass.

In case of straight tendons (without intended or unintended deviation), the strands can be stressed completely up to the required load. No shifting of the duct occurs during tightening and subsequent stressing. No chain hoist in accordance to Annex B3, section 4.6 is used. No measures are required for influencing the gliding conditions.

4.5.5 Filling of the ducts with corrosion protection mass

see Annex B2, section 3.8 and Annex A14 and A15

4.5.6 Post-Injection at high points

After the filled tendon has cooled, all high points shall be post-injected with cold corrosion protection mass. In order to do this, an inlet or a venting opening must be drilled in front and behind each deviation point. A thermometer is used to measure the temperature of the corrosion protection mass. In case of temperatures ≤ 30 °C, the high point can be post-injected. A pressure-resistant inlet connecting branch is fixed at the inlet and the supply hose is connected to it. The distance between venting openings of the tendon and the deviation points must be selected in each case so that the definite filling of the tendons high point is ensured.

The distance between the inlet or venting openings and the deviation points must be selected adequately large that the inlet or venting openings do not move into the deviation area during stressing and re-stressing.

Post-injection is finished as soon as corrosion protection mass emerges from the venting opening. Continuous escape of the corrosion protection mass from the venting opening ensures that the high point is reliably permanently protected against corrosion. Subsequently, the openings are sealed professionally with press-fit or sealing-lip closure plugs. By knocking on the duct, it is checked that the duct has been filled completely. Any not filled points shall be post-injected (see Annex A14 and A15).

4.6 Initial stressing/stressing

Before initial stressing, the ducts are marked at all deviation points in the direction of the active anchor and at the active anchor. The distance between these markings and the deviation point (e.g. edge of cross beam) shall be measured and recorded before stressing. The mobility of the telescoping joint at the active anchor must be ensured before starting stressing (removal of the temporary seal). On tendons with deviation point(s), mainly outer gliding is required when stressing. Suitable measures must be taken to ensure that the elongation / movement of the strands and the movement of the duct are parallel. This can be done by means of a chain hoist or equivalent (see Annex B2, section 3.9).

A hydraulic pump unit and a stressing jack are used to stress the tendons. All strands of a tendon are gripped and stressed simultaneously. In case of straight tendons, a single-strand stressing jack can be used. Step-by-step stressing and re-setting of the jack is possible. When stressing, it must be ensured that the duct moves continuously in accordance with the elongation / movement of the strands (for instance by using a chain hoist for assistance). The duct shall be marked in order to confirm the duct movement (see Annex A16).

The strands are stressed to the required load. The duct is moved in parallel in accordance with the elongation by frictional connection between strand and duct at the deviation points (outer gliding). The movement of the ducts during stressing at the deviation points and in front of the active anchor is determined by measuring the change in spacing between the markings made beforehand and the reference point. These movements are compared with theoretical elongation of the strands.

The relative movement (difference between the movements) between strands and duct (inner gliding) must not exceed 10 % of the elongation of the strands or 10 cm respectively (the lower of the two values is the decisive value). The duct may not be compressed at the active anchor.

After stressing, the wedges will be pressed into the wedge seat using a wedge seating device. A wedge slip of approx. 3 mm occurs when the stressing force is released. In case of not pressed wedges, the slip amount is 6 mm. The slip has to be considered in statically calculations.

4.7 Final works

After completion of the stressing works, the joint between duct and connection duct is closed by a transitional electro welding sleeve or equivalent. Active and passive anchor are protected against corrosion with a protective cap (see Annex B3, section 4.2.3).

4.8 Re-stressing

A strand protrusion can be planned at the active anchor / passive anchor for future re-stressing of the tendon after removal of the protective cap. Based on gliding conditions recorded in the stressing record, it will be decided whether the connection between duct and connection duct at the active anchor shall be opened. If openings are necessary, the connection has to be suitable reclosed after re-stressing. Corrosion protection of the anchorage shall be reinstalled correctly. During re-stressing, it must be ensured that the relative movement between strands and duct (inner gliding) does not exceed 10% of the total elongation / movement of the strands or 10 cm respectively (the lower of the two values is the decisive value). The movements already achieved when stressing have to be considered additionally, regardless of stressing direction). The duct may be pulled in longitudinal direction at the active anchor in order to assist outer gliding, e.g. with a chain hoist. If using a chain hoist, use an accurately fitting steel clamp for connection to the duct (drawing submitted to DIBt).

4.9 Check of stressing force

The stressing force may be checked by lifting off the anchor head approximately 1-2 mm of the bearing plate / cast-iron anchor body by means of a stressing jack. The required stressing force for lifting off is considered to be the current stressing force. The stressing jack is positioned on a stressing chair in order to transfer the force directly on the bearing plate / cast-iron anchor body. The wedges are not released during this operation.

4.10 Replacing a tendon

If it becomes necessary to replace a tendon, the tendon must be cut close to an anchor or deviation point (safety aspects are to be considered). Subsequently, all movable anchorage and deviation components are removed. The bearing plate / cast-iron anchor body, trumpet, connection duct and other cast-in parts remain in the building structure. The new tendon can then be installed in the same way as the original tendon. Before inserting the strands, the transitional area between trumpet and the connection duct at the stressing anchorage shall be examined for any signs of damage and if necessary replaced / repaired. All previously described installation steps shall be followed.

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Prestressing losses due to friction and wobble effects

The losses due to friction may be determined in the calculation by using the friction coefficient μ = 0,08 given in the Annex A2 and the unintentional angular displacement k = 0 (wobble coefficient).

For the determination of the elongation/movement and the forces of prestressing steel, friction losses $\Delta P_{\mu S}$ in the stressing anchor zone (see Annex A2) shall be taken into account.

1 System of assessment and verification of constancy of performance

The manufacturer shall draw up the declaration of performance and determine the product-type on the basis of the assessments and verifications of constancy of performance carried out under the following system:

System 1+

(a) The manufacturer shall carry out:
  - (1) factory production control;
  - (2) further testing of samples taken at the manufacturing plant by the manufacturer in accordance with a prescribed test plan.

(b) The notified product certification body shall decide on the issuing, restriction, suspension or withdrawal of the certificate of constancy of performance of the construction product on the basis of the outcome of the following assessments and verifications carried out by that body:
  - (1) initial inspection of the manufacturing plant and of factory production control;
  - (2) continuing surveillance, assessment and evaluation of factory production control;
  - (3) audit-testing of samples taken by the notified product certification body at the manufacturing plant or at the manufacturer's storage facilities.

2 Responsibilities

2.1 Tasks of the manufacturer

2.1.1 Factory production control

The kit manufacturer shall keep available an updated list of all component manufacturers. The list is to be made available to the notified product certification body and to the Technical Assessment Body.

The kit manufacturer shall exercise permanent internal control of production. All the elements, requirements and provisions adopted by the kit manufacturer shall be documented in a systematic manner in the form of written policies and procedures, including records of results performed. This production control system shall insure that the product is in conformity with this European Technical Assessment.

The kit manufacturer may only use basic materials stated in the technical documentation of this European Technical Assessment.

The factory production control shall be in accordance with the Control Plan relating to the European Technical Assessment ETA-11/0123 (latest version) which is part of the technical documentation of this European Technical Assessment. The Control Plan is laid down in the context of the factory production control system operated by the manufacturer and deposited at Deutsches Institut für Bautechnik.[3]

The basic elements of the Control Plan comply with ETAG 013, Annex E.1.

[3] The Control Plan is a confidential part of the European Technical Assessment and only handed over to the notified product certification body involved in the system of assessment and verification of constancy of performance (see Annex D1, section 2.2).

The records shall contain at least the following information:

- Designation of the product or of the basic material and the components;
- Type of control or testing;
- Date of manufacture and of testing of product or components and of basic material of components;
- Results of controls and tests and, where relevant, comparison with the requirements;
- Signature of person responsible for the factory production control.

The records shall be kept for at least ten years and submitted to the notified product certification body. On request, they shall be presented to Deutsches Institut für Bautechnik.

If the test result is not satisfactory, the kit manufacturer shall take immediate measures to eliminate the deficiency. Construction products and components which do not comply with the requirements shall be handled in such way that they cannot be mistaken for products complying with the requirements. After elimination of the deficiency the relevant test shall be immediately repeated as far as is technically possible and necessary for verifying the deficiency elimination.

2.1.2 Declaration of performance and other tasks of manufacturer

The kit manufacturer shall, on the basis of a contract, involve a product certification body which is notified for the tasks referred to in Annex D1, section 1 in the field of Post-Tensioning Kits for prestressing of structures in order to undertake the actions laid down in Annex D1, section 2.2. For this purpose, the control plan referred to in Annex D1, sections 2.1.1 and 2.2 shall be handed over to the notified product certification body by the manufacturer.

For the product a declaration of performance shall be drawn up. The manufacturer can make a declaration of performance for the essential characteristics due to section 3 of specific part of this European Technical Assessment if the acceptance criteria due to ETAG 013 are fulfilled and the certificate of constancy of performance of a notified product certification body is available.

The control of the manufacturer of the components, the sampling and tests in the factory production control as well as a series of single tensile element tests shall be carried out in consideration of ETAG 013, section 8.2.1.1. The results of this test series must be given to the notified product certification body for information.

2.2 Tasks of the notified product certification body

2.2.1 General

The notified product certification product certification body shall perform the measures according to Annex D1, sections 2.2.2 to 2.2.4 and in accordance with the provisions laid down in the Control Plan in the latest version.

The notified product certification body shall retain the essential points of its actions referred to above and state the results obtained and conclusions drawn in written reports.

The notified product certification body involved by the kit manufacturer shall issue a certificate of constancy of performance of the product stating that all provisions for the assessment and verification of constancy of performance and the performance named in the European Technical Assessment are applied due to System 1+ and stating compliance of the construction product with all applicable requirements.

In cases where the provisions of the European Technical Assessment and its "Control Plan" are no longer fulfilled the notified product certification body shall withdraw the declaration of conformity and inform Deutsches Institut für Bautechnik without delay.

2.2.2 Initial inspection of the manufacturing plant and of factory production control

The notified product certification body shall ascertain that, in accordance with the "Control Plan", the factory, in particular the staff and equipment, and the factory production control are suitable to ensure a continuous and orderly manufacturing of the Post-tensioning system with the specifications mentioned in section 1 of the Specific Part of the European Technical Assessment as well as in the Annexes to the European Technical Assessment.

2.2.3 Continuing surveillance, assessment and evaluation of factory production control

The notified product certification body shall inspect the manufacturing plant at least once a year. The production of components shall be included in the surveillance with consideration of ETAG 013, Section 8.2.2.4 (8). It has to be verified that the system of factory production control and the specified manufacturing process are carried out in accordance with the control plan's latest version.

Continuing surveillance, assessment and evaluation of factory production control have to be performed according to the latest version of the control plan.

The results of continuing surveillance, assessment and evaluation of factory production control shall be made available on demand by the notified product certification body to the Deutsches Institut für Bautechnik.

2.2.4 Audit-testing of samples

During surveillance inspections, the notified product certification body shall take samples of components of the Post-tensioning system for independent testing. For the most important components, Annex D3 contains the minimum procedures which have to be performed by the notified product certification body.

The basic elements of the Audit testing comply with ETAG 013, Annex E.2 (see Annex D3).

3 CE marking

The CE marking shall be affixed on the delivery note. The letters "CE" shall be followed by the following additional information:

- the two last digits of the year in which it was first affixed;
- the name and the registered address of the manufacturer, or the identifying mark allowing identification of the name and address of the manufacturer easily and without any ambiguity;
- the unique identification code of the product-type;
- the reference number of the declaration of performance;
- the level or class of the performance declared;
- the reference to the harmonised technical specification applied;
- the identification number of the notified product certification body, if applicable;
- the intended use as laid down in the harmonised technical specification applied.

Criteria of the Control Plan

Component	Item	Test/ Check	Traceability [4]	Minimum frequency	Documen-tation
Bearing Plate for 3 to 9 strands	material	check	bulk	100 %	"2.2" [1]
	detailed dimensions [5]	test		3 % ≥ 2 specimen	yes
	visual inspection [3]	check		100 %	no
Cast-iron Anchor Body for 12 to 31 strands	material	check	full	100 %	"3.1" [2]
	detailed dimensions [5]	test		5% ≥ 2 specimen	yes
	visual inspection [3]	check		100 %	no
Anchor Head	material	check	full	100 %	"3.1" [2]
	detailed dimensions [5]	test		5 % ≥ 2 specimen	yes
	visual inspection [3]	check		100 %	no
Wedge	material	check	full	100 %	"3.1" [2]
	treatment, hardness	test		0,5 % ≥ 2 specimen	yes
	detailed dimensions [5]	test		5 % ≥ 2 specimen	yes
	visual inspection [3]	check		100 %	no
Duct	material	check	full	100 %	yes
	visual inspection [3]	check		100 %	no

Continued table and footnotes see Annex D2, page 2

Criteria of the Control Plan – continued

Component	Item	Test/ Check	Traceability [4]	Minimum frequency	Documentation
Tensile element (strand)	material [6]	check	full	100 %	yes
	diameter	test		each coil/bundle	no
	visual inspection [3]	check		each coil/bundle	no
Helix	material	check	bulk	100 %	yes
	visual inspection [3]	check		100 %	no
Grease	material [7]	check	full	100 %	"CE" [9]
Wax	material [8]	check	full	100 %	"CE" [9]

1 "2.2": Test report type "2.2" according to EN 10204

2 "3.1": Inspection certificate type "3.1" according to EN 10204

3 visual inspections means e.g.: main dimensions, gauge testing, correct marking or labelling, appropriate performance, surface, fins, kinks, smoothness, corrosion, coating, etc., as given in the control plan

4 full: Full traceability of each component to its raw material.
bulk: Traceability of each delivery of components to a defined point.

5 detailed dimensions, measuring of all dimensions and angles according to the specification as given in the control plan

6 characteristic material properties, see Annex E1

7 corrosion protection mass (grease), according to component deposited at the Deutsches Institut für Bautechnik. Characteristics shall comply with ETAG 013, Annex C.4.1.

8 corrosion protection mass (wax), according to component deposited at the Deutsches Institut für Bautechnik. Characteristics shall comply with ETAG 013, Annex C.4.2.

9 If the basis of CE marking is not available, the prescribed control plan has to include appropriate measures. The certificate shall be based on specific testing on the fabrication lot from which the supply has been produced, to confirm specified properties, and shall be prepared by a department of the supplier which is independent of the production department.

All samples shall be randomly selected and clearly identified.

Criteria of Audit Testing

Component	Item	Test/ Check	Sampling Number of components per audit
Anchor Head	material according to specification	check / test	1
	detailed dimensions	test	
	visual inspection [1]	check	
Cast-iron Anchor Body	material according to specification	check / test	1
	detailed dimensions	test	
	visual inspection [1]	check	
Wedge	material according to specification	check / test	2
	treatment	test	2
	detailed dimensions	test	1
	main dimensions, surface hardness	test	5
	visual inspection [1]	check	5
Single tensile element test	ETAG 013, Annex E.3	test	1 series

[1] visual inspections means e.g.: main dimensions, gauge testing, correct marking or labelling, appropriate performance, surface, fins, kinks, smoothness, corrosion, etc.

All samples shall be randomly selected and clearly identified.

BBV External Post-Tensioning System Type E	Annex D3
Constancy of Performance and CE marking Criteria of Audit Testing	

Material of Components

Designation	Material	Number	Standard
Anchorage			
Bearing Plate	deposited at DIBt		EN 10025-2:2005-04
Cast-iron Anchor Body	deposited at DIBt		
Wedges	deposited at DIBt		
Anchor Head	deposited at DIBt		EN 10083-2:2006-10
Helix and Additional Reinforcement	ripped reinforcing steel $R_e \geq 500$ MPa		valid provisions at the place of use
Trumpet	PE, deposited at DIBt		
Retainer Plate	PE, deposited at DIBt		
Protection Cap	PE or steel, deposited at DIBt		
Connection Duct	PE		EN 12201-1:2011-11 EN 12201-2:2013-12
Duct			
Duct	PE		EN 12201-1:2011-11 EN 12201-2:2013-12
PE- Electro Welding Sleeve / Transition Welding Sleeve	PE		DIN 16963-7:1989-10
Shrink Sleeve	deposited at DIBt		DIN 30672-1:1991-09
Corrosion Protection Mass			
Vaseline FC 284 *)	deposited at DIBt		
Unigel 128F-1 *)	deposited at DIBt		
Deviation			
Deviation Duct	PE		EN 12201-1:2011-11 EN 12201-2:2013-12
Deviation form parts (Type F) Steel (coated or galvanized)	minimum S235JR or EN GJS-400-15 or EN GJS-400-15U		EN 10025:2005-04 EN 1563: 2012-03 EN 1563: 2012-03
Deviation form parts (Type F) Plastic Material	PE (deposited at DIBt)		EN ISO 1872-1:1999-10
Penetration Pipe (Type F) and Recess Tube (Type S)	steel S235JR (galvanized) PVC-U PE		EN 10025-2:2005-04 DIN 8061: 2009-10 DIN 8062: 2009-10 EN 12201-1:2011-11 EN 12201-2:2013-12
Pre-bent Pipe (Deviation Type R)	steel S235JR (galvanized)		EN 10025-2:2005-04
Form Parts (Deviation Type R and S)	PE or PA, deposited at DIBt		
Grease	deposited at DIBt		

further details (e.g. minimum strength) of the components in deposited delivery conditions

*) according to the supplier's material composition deposited at the Deutsches Institut für Bautechnik, characteristic material properties shall comply with ETAG 013, Annex C.4.1 or C.4.2

Codes and References

prEN 10138-3:2009-08	Prestressing Steels – Part 3: Strand
ETAG 013:2002-06	Guideline for European Technical Approval of post-tensioning kits for prestessing of structures
EN 10204:2005-01	Metallic products – Types of inspection documents
EN 12201-1:2011-11	Plastics piping systems for water supply and for drainage and sewerage under pressure - Polyethylene (PE) – Part 1: General
EN 12201-2:2013-12	Plastics piping systems for water supply and for drainage and sewerage under pressure – Polyethylene (PE) – Part 2: Pipes
EN ISO 12944-4:1998-07	Paints and varnishes – Corrosion protection of steel structures by protective paint systems – Part 4: Types of surface and surface preparation (ISO 12944-4:1998)
EN ISO 12944-5:2008-01	Paints and varnishes –Corrosion protection of steel structures by protective paint systems – Part 5: Protective paint systems (ISO 12944-5:2007)
EN ISO 12944-7:1998-07	Paints and varnishes – Corrosion protection of steel structures by protective paint systems – Part 7: Execution and supervision of paint work (ISO 12944-7:1998)
EN 10025-2:2005-04	Hot rolled products of structural steels – Part 2: Technical delivery conditions for non-alloy structural steels
EN 10083-2:2006-10	Steels for quenching and tempering – Part 2: Technical delivery conditions for non-alloy steels
EN 1563:2012-03	Founding – Spheroidal graphite cast irons