



SPECIFY ACPA QCAST CERTIFIED PRODUCTS



American
Concrete Pipe
Association

The greatest strength of the precast concrete pipe and box culvert industry is its ability to manufacture durable products with a service life of more than 100 years. The ACPA's "Quality Cast" Plant Certification Program provides an industry-wide quality control program to ensure superior production throughout the country. QCast is a 124-point audited inspection program which covers the inspection of materials, finished products and handling/storage procedures, as well as performance testing and quality control documentation.

QCast continues to grow with more than 100 certified plants and additional plants being certified each year. Many plants have benefited so much from the lower costs and higher efficiencies that go along with pipe certification that they have also become QCast-certified in the Box Culvert Certification Program.

Experts in Concrete Pipe and Box Culverts

The American Concrete Pipe Association, the voice of the concrete pipe industry since 1907, is the recognized source for technical information regarding precast concrete pipe, box culverts and other precast concrete products.

ACPA member plants account for 90% of the tonnage for precast concrete pipe and box culverts manufactured in the United States. ACPA staff and members work with ASTM and AASHTO in developing and maintaining applicable Standards and lend their expertise to owners and engineers in compilation of specification. The ACPA is likewise the definitive source for computer design software, creating such concrete pipe and box culvert design software as PipePac, PipeCar and BoxCar.



Certification Requirements

QCast applicants must meet the requirements defined in the QCast Plant Certification Manual. In order to receive certification, Plant Quality Assurance Programs must meet all of the minimum requirements, which include the following:

- o Equipment calibration and testing
- o Internal plant testing and inspection
- o Product tests and documentation
- o Raw material certification documentation



- o Third party audit verification
- o Product design documentation
- o Product storage, handling and repair procedures

Plants undergo a yearly, unannounced audit by a third-party firm to ensure they meet the requirements of the manual and must receive a minimum overall score of 80 out of a possible 100 and pass all critical elements in order to receive certification. These critical items include reinforcing inspections, concrete testing and three-edge-bearing testing.

State DOT's Requiring QCast

States that currently either accept or require QCast are shown shaded below. Every year, more states consider implementation. Many others shown in white below implement their own programs that are based on the QCast requirements.

On many occasions, individuals from DOTs or engineers from local jurisdictions have shadowed our outside auditor during QCast audits and were impressed with the thoroughness of the auditors. The ACPA and our auditors welcome this type of scrutiny, because we are very proud of the professional way in which it was developed and the positive impact the QCast program has made on the quality of product produced in the industry.



Audits by ACPA

Wiss, Janney Elstner Associates, Inc. (WJE) is a national consulting engineering firm of engineers, architects and material scientists that has been serving clients for over 50 years. They routinely work with state highway agency staff and other clients to solve difficult problems. WJE was selected to be the third-party audit agency for the ACPA based on the qualifications of the firm and the quality of the people that work for them. Since the inception of the program in 1998, they have performed more than 850 audits and not only exceeded the expectation of the ACPA with regard to their detailed and thorough approach to auditing to the requirements of the QCast manual, but have helped push the industry forward by continuously working with the ACPA to “raise the bar,” by developing and implementing additional requirements to the program.

Please review the QCast Plant Certification Manual at www.concretepipe.org. For more information about QCast, contact the ACPA at (972) 506-7216 or info@concretepipe.org.