

RESPONSE 11

leaks for at least 10 seconds while subjected to this vacuum. The POR or his/her qualified representative must observe 100% of this testing.

Other Testing. Other non-destructive testing must have prior written approval from the TCEQ.

3.3.3 Destructive Seam Testing

Destructive samples shall be taken at a minimum frequency of one test location, selected randomly, within each 500 linear feet of seam length, inclusive of both primary longitudinal and cross seams, cap strips, and repairs 20 square feet or larger with a total footage of 10 feet or longer in length. Each test sample should be of sufficient length and 12 inches wide with the seam located in the middle. Test specimens, approximately 1 inch wide, shall be cut from both ends of the sample for field testing (peel and shear). The remaining sample should be cut into three parts (one for quality assurance laboratory testing, one for installer quality control laboratory testing, and one for archive storage to be maintained at a location selected by the owner).

The field tests shall be conducted on a certified calibrated tensiometer capable of maintaining a constant extension rate of 2 inches per minute. If one of the field test specimens from the ends of the destructive sample fails, then the seam will be considered to have failed, and repairs shall be initiated as described below. If both specimens pass, then a sample for laboratory testing will be sent to the quality assurance laboratory for testing in both peel and shear. Seam strengths for HDPE geomembranes shall meet the minimum values specified in the most current version of the GRI Test Method GM19 "Seam Strength and Related Properties of Thermally Bonded Polyolefin Geomembranes".

Destructive test results for both field and laboratory tests shall include qualitative data, including the location of the failure and locus-of-break code, as described in ASTM D6392. Peel tests on double-tracked fusion welds shall be performed on both inside and outside tracks of the weld. Seam break classifications for extrusion and fusion welds are shown on Figures III-3F-2 and III-3F-3, respectively.

At a minimum, a destructive test must be done for each welding machine used for seaming or repairs. A sufficient amount of the seam must be removed to conduct field testing, independent laboratory testing, and archiving of enough material to retest the seam when necessary. Destructive seam testing locations shall be cap-stripped and the cap completely seamed by extrusion welding to the geomembrane. Capped sections shall be non-destructively tested. Additional destructive test samples may be taken if deemed necessary by the POR or his/her qualified representative.

Weld Acceptance Criteria: For HDPE seams (both smooth and textured), the minimum passing criteria for destructive seam testing are described in the GRI Test Method GM19. The POR must use the most current version of GM19 when evaluating welded seams.

Seam Failure Delineation: When a sample fails a destructive test, the installer shall trace the welding path to an intermediate location at least 10 feet in each direction, or a distance determined by the POR, from the point of the failed test and take 1-inch wide specimens for an additional set of field tests. If these additional samples pass the tests, then two laboratory

Air Pressure Testing – ASTM D5820. The ends of the air channel of the dual-track fusion weld must be sealed and pressured to approximately 30 pounds per square inch (psi), if possible. The air pump must then be shut off and the air pressure observed after 2 minutes. A loss of less than 3 psi is acceptable if it is determined that the air channel is not blocked between the sealed ends. A loss greater or equal to 3 psi indicates the presence of a seam leak that must then be isolated and repaired by following the procedures described in this OQCP. The POR or his/her qualified representative must observe and record all pressure gauge readings.

Vacuum-Box Testing – ASTM D5641. Apply a vacuum of approximately 4 to 8 psi to all extrusion welded seams that can be tested in this manner. The seam must be observed for leaks for at least 10 seconds while subjected to this vacuum. The POR or his/her qualified representative must observe 100 percent of this testing.

Other Testing. Other non-destructive testing must have prior written approval from the TCEQ.

4.3.3 Destructive Seam Testing

Destructive samples shall be taken at a minimum frequency of one test location, selected randomly, within each 500 linear feet of seam length, inclusive of both primary longitudinal and cross seams, cap strips, and repairs 20 square feet or larger with a total footage of 10 feet or longer in length. Each test sample should be of sufficient length and 12 inches wide with the seam located in the middle. Test specimens, approximately 1 inch wide, shall be cut from both ends of the sample for field testing (peel and shear). The remaining sample should be cut into three parts (one for quality assurance laboratory testing, one for installer quality control laboratory testing, and one for archive storage to be maintained at a location selected by the owner).

The field tests shall be conducted on a certified calibrated tensiometer capable of maintaining a constant extension rate of 2 inches per minute. If one of the field test specimens from the ends of the destructive sample fails, then the seam will be considered to have failed, and repairs shall be initiated as described below. If both specimens pass, then a sample for laboratory testing will be sent to the quality assurance laboratory for testing in both peel and shear. Seam strengths for linear low-density polyethylene (LLDPE) geomembranes shall meet the minimum values specified the most current version of the GRI Test Method GM19 (included in Appendix III-3H-1).

Destructive test results for both field and laboratory tests shall include qualitative data, including the location of the failure and locus-of-break code, as described in ASTM D6392. Peel tests on double-tracked fusion welds shall be performed on both inside and outside tracks of the weld. Seam break classifications for extrusion and fusion welds are shown on Figures III-3H-1 and III-3H-2, respectively.

At a minimum, a destructive test must be done for each welding machine used for seaming or repairs. A sufficient amount of the seam must be removed to conduct field testing, independent laboratory testing, and archiving of enough material to retest the seam when necessary. Destructive seam testing locations shall be cap-stripped and the cap completely seamed by extrusion welding to the geomembrane. Capped

inner and outer welds for dual track fusion welding) and shall be compared to the minimum seam strength requirements specified in the most current version of the GRI Test Method GM19. The current versions of the GRI test methods are included in Appendix III-7A-1.

If any of the trial seam specimens fail, the entire trial seam operation shall be repeated. If an additional specimen fails during the second trial seam, the seaming machine and seamer shall not be used for seaming until the deficiencies are corrected and two consecutive successful trial seams are achieved. Additional trial seams shall be made at each occurrence of significantly different environmental conditions, including, but not limited to, temperature, humidity, and dust, and after any machine is turned off for more than 30 minutes.

3.3.2 Non-Destructive Testing

Continuous, non-destructive testing shall be performed on all seams by the installer. All leaks must be isolated and repaired by following the procedures described in this FCQCP.

Air Pressure Testing – ASTM D5820. The ends of the air channel of the dual-track fusion weld must be sealed and pressured to approximately 30 pounds per square inch (psi), if possible. The air pump must then be shut off and the air pressure observed after 2 minutes. A loss of less than 4 psi is acceptable if it is determined that the air channel is not blocked between the sealed ends. A loss greater or equal to 4 psi indicates the presence of a seam leak that must then be isolated and repaired by following the procedures described in this FCQCP. The POR or his/her qualified representative must observe and record all pressure gauge readings.

Vacuum-Box Testing – ASTM D5641. Apply a vacuum of approximately 4 to 8 psi to all extrusion welded seams that can be tested in this manner. The seam must be observed for leaks for at least 10 seconds while subjected to this vacuum. The POR or his/her qualified representative must observe 100 percent of this testing.

Other Testing. Other non-destructive testing must have prior written approval from the TCEQ.

3.3.3 Destructive Seam Testing

Destructive samples shall be taken at a minimum frequency of one test location, selected randomly, within each 500 linear feet of seam length, inclusive of both primary longitudinal and cross seams, cap strips, and repairs 20 square feet in total area or larger with a total footage 10 feet or more in length. Each test sample should be of sufficient length and 12 inches wide with the seam located in the middle. Test specimens, approximately 1 inch wide, shall be cut from both ends of the sample for field testing (peel and shear). The remaining sample should be cut into three parts (one for quality assurance laboratory testing, one for installer quality control laboratory testing, and one for archive storage to be maintained at a location selected by the owner).

The field tests shall be conducted on a certified calibrated tensiometer capable of maintaining a constant extension rate of 2 inches per minute. If one of the field test specimens from the ends of the destructive sample fails, then the seam will be considered to have failed, and repairs shall be initiated, as described