



Corrosion Protection

Mechanical Rock Anchors

Williams Spin-Lock mechanical rock anchors are used when anchoring into competent rock. The standard Williams Spin-Lock anchor relies on cement grout for corrosion protection. Williams Spin-Locks can be specified with a hollow anchor bar, allowing the system to be grouted from the lowest gravitational point in both up and down bolting applications. This provides a solid grout cover surrounding the anchor rod. Unlike the bonded rock anchor, the Spin-lock is grouted after the anchor is stressed so cracking of the grout column due to prestressing is eliminated. Spin-Lock anchors have been in service since 1959 and in most cases have relied strictly on cement grout for corrosion protection. If so desired, additional corrosion protection can be provided by step drilling a larger diameter drill hole, which provides additional grout cover, or by galvanizing the steel anchor rod. Protective end caps may also be used to seal the nut and washer from the environment when the outer end of the anchorage will not be encased in concrete.

Anchor Head Protection

The most important section of a ground anchor that needs adequate corrosion protection is the portion of the anchor exposed to air/oxygen. This is typically defined as the "anchor head", which generally consists of a steel bearing plate, a hex nut and washer for a bar system, or a wedge plate and wedges for a strand system. For permanent ground anchors it is best to galvanize the hex nut and plates even if the bar is epoxy coated. Galvanized components, if scratched during shipping, are less likely to cause corrosion concerns than scratched epoxy coated components. The end of the steel bar protruding out from the hex nut is often protected by the use of a plastic or steel end cap packed with grease or cement grout. Williams offers several different types of PVC and metal end caps to provide corrosion protection at otherwise exposed anchor ends.



Fiber Reinforced Nylon Cap



Strand End Cap



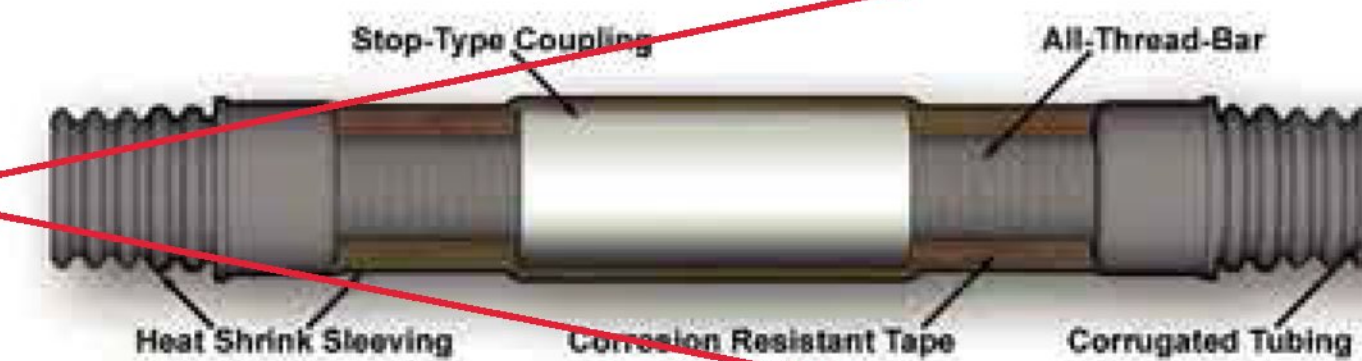
Steel Tube welded on Flange with Threaded Screw Connections



Screw-On PVC Cap

Field Splice for Bars

Continuous corrosion protection can even be accomplished for the MCP Pregouted anchors manufactured from Williams Form Engineering. To achieve the equivalent levels of corrosion protection the coupled sections of bar anchors can be wrapped in a grease impregnated tape that is further protected with heat shrink sleeving. This scheme is acceptable by most governing agencies and is specified in the PTI Recommendations for Prestressed Rock and Soil Anchors.



Methods of Corrosion Protection

Corrosion Protection Method	Abrasion Resistance (4 = best)	Typical Thickness	Relative Cost (4 = highest)	Production Lead Time	Can be Applied to Accessories?	Can be Applied in the Field?
Hot Dip Galvanizing	4	3-4 mils	2	2-4 weeks	yes	no
Epoxy Coating	1	7-12 mils	1	2-3 weeks	yes	no
Pre-Grouted Bars	3	2", 3" or 4" tubing	3	2 weeks	no	yes
Extruded Polyethylene/Polypropylene Coating	2	23-25 mils	1	2-4 weeks	no	no
Corrosion Inhibiting Compound	2	N.A.	2	2-4 weeks	yes	yes

- Other thicknesses can be applied, contact a Williams representative for issues regarding threadability of fasteners
- Combination of protection methods are available (i.e. epoxy bar with a pregout section, galvanizing with epoxy)
- Field patch kits are available for galvanized and epoxy coated products
- Field procedures are available for coupling (2) pregouted anchors
- Contact Williams for more information regarding the appropriate corrosion protection level and corresponding governing reference specifications/documents.