## Contents

<table>
<thead>
<tr>
<th>List of figures</th>
<th>xv</th>
</tr>
</thead>
<tbody>
<tr>
<td>List of tables</td>
<td>xxiii</td>
</tr>
<tr>
<td>Foreword</td>
<td>xxv</td>
</tr>
<tr>
<td>Acknowledgements</td>
<td>xxix</td>
</tr>
</tbody>
</table>

1 Introduction 1

2 Development of the immersed tunnel 5

- Steel shell tunnels 11
- Concrete tunnels 15
- Composite sandwich tunnels 19
- Tunnels in Japan 20
- Growth in immersed tunnels worldwide 21

3 Current forms of immersed tunnel 31

- Monolithic concrete element construction 31
- Segmental concrete element construction 35
- Prestressed concrete 38
- Single steel shell 39
- Double steel shell 41
- Composite concrete steel sandwich 42

4 Developing an immersed tunnel scheme 45

- Selection of bridge or tunnel 46
- Tunnel cross section 47
- Alignment 53
- Junction with cut and cover tunnels 56
- Number of tunnel elements 57
Contents

Geotechnical 58
Structural options 59
Element construction 62
Environmental considerations 64
Disruption to navigation 66
Cost 67
Operation and maintenance costs 72
Construction program 73
Risks and opportunities 77

5 Environmental impact 79

Short-term versus long-term impacts 80
Tunnel approaches 80
Marine works 82
Fisheries 85
Algae 87
Water quality 87
Visual aspects 88
Portals 88
Noise 89
Air quality 91

6 Marine environment 93

Hydrography 94
Water levels 94
   Flood protection 96
   Towing and immersion 97
Wind and waves 98
   Extreme wave conditions 99
Current conditions 100
Salinity and water density 101
Suspected sediment and turbidity 102
Ice formation 103
Summary of data needed for design and construction 103
Hydraulic effects 105
Scour and sedimentation 105
Flooding 107
Forces on tunnel elements 109
7 Mechanical and electrical installations

Road tunnel safety 120
  Incident detection and management 122
  Emergency escape 123
Railway tunnel safety 126
Ventilation 127
  Ventilation standards 128
  Longitudinal ventilation 129
  Ventilation in rail tunnels 132
  Semi-transverse and transverse ventilation 133
Lighting 135
Control systems 137
Power supply 137
Drainage 138

8 Tunnel approaches and service buildings

Forms of approaches 142
Cut and cover tunnels 145
  In situ box construction 145
  Embedded wall structures 147
Approach ramps 150
Interface with immersed tunnel 153
Construction sequence 155
Connection to bored tunnels 156
Use of tunnel approaches as the casting basin 158
Service building facilities 161
  Service building location 162
  Aesthetics 164
9 Design principles

Structure sizing 169
Stability and buoyancy 174
Tunnel approaches 181
Floating stability 183
Metacentric height 183
Righting moment 184
Design loadings 185
Permanent loadings 185
Variable loads due to vehicles 187
Temperature loads 188
Overall temperature range 188
Temperature gradient 189
Temperature difference during curing 189
Water levels, wave, and current loading 190
Ice loads 191
Accidental loads 191
Flooding 191
Loss of support 192
Ship impact 193
Falling and dragging anchor 194
Fire 196
Explosion 196
Propeller scour 197
Construction stage settlement 197
Temporary load conditions 198
Design codes 199
Load combinations 201
U.S. Load combinations for AASHTO for LRFD design 201
Eurocode design 202
Serviceability limit state combinations 202
Ultimate limit state combinations 205
Partial safety factors and combination factors 206
Structural analysis 206
Structural design 213
Shear keys 216
Steel shear keys 217
Dowel shear keys 219
Half-joint arrangement at segment joints 220
Discrete keys in walls 221
Prestressing 222
Special features 225
Drainage sumps 225
Technical rooms 227
Settlement modeling 228
Seismic design 229
Longitudinal compression caused by P waves 231
Horizontal and vertical ground displacement caused by S waves 232
Racking 232
Liquefaction 233
Fault displacement 233
Slope instability 233
Damage criteria 233
Level 1: Service life event 233
Level 2: Maximum credible event 234
Design load effects 234
Longitudinal analysis 236
Important elements of seismic modeling 238
Joints: Segment, immersion, and terminal 238
Interface with soils 239
Geometry of ground 239
Geometry of the tunnel, tunnel backfill and foundation, and tunnel approaches 239
Time phase of loading 240
Racking analysis 240
Free field deformation approach 240
Equivalent static analysis 240
Seismic coefficient methods 241
10 Joints

Immiscion joints 248
- Design of gaskets 249
- Design of supporting steelwork 255
- Tolerances 257
- Detailing 258
- Durability 259
- Trial castings 261
- Seal installation 261
- Protection of seals 262
- Temporary works 263
- Joint finishing 264
- Joint leakage 264

Segment joints 265
- Expected joint movement range 268
- Detailing 268
- Construction considerations 269

Terminal joints 269
- Connection to bored tunnels 272

Closure joints 273
- Prestressed segment 277
- Terminal block 279
- V-wedge closure joint 280
- Steel tunnel tremie joint 281

Crown seal joint 282

Seismic joints 283
- Seismic immersion joints 283
- Seismic terminal joints 284

Construction joints 286

11 Durability

Watertightness 287
- Concrete mix design 289
- Objectives 289
- Permeability 289
Density 289
Strength 290
Low heat of hydration and crack control 290
Flow characteristics 290
Other criteria 290
Concrete density and permeability 291
Concrete strength 292
Crack width criteria 293
Early age crack control 294
Causes of cracking 294
Methods to eliminate cracking 297
Concrete cooling 297
Full section casting 299
Simulation software 300
Membranes 302
Corrosion prevention strategies 306
Cathodic protection 312
Causes of corrosion 312
Rates of corrosion 312
Protection methods 313
Sacrificial anode cathodic protection (SACP) 314
Impressed current cathodic protection (ICCP) 316
Monitoring 316
Interference and interface with earthing and bonding strategy 317
Durability of watertight seals 317
Internal coatings 318

12 Foundations 321
Foundation layer 321
Sand foundation layers 322
Sand jetting method 323
Sand flow method 325
Sequence of construction 327
Risk of sedimentation 328
Water depth/currents 329
Construction tolerances 329
Settlement 330
Behavior in seismic conditions 331
Gravel foundation layers 332
   Underwater screeding frames 333
   Scrading™ 334
   Settlement 336
Grouted foundations 337
   Grout bags 340
Piled foundations 340
   Floating pile foundations 343
Ground improvement 344
   Ground replacement 346
Stone columns 347
   Replacement method 347
   Displacement method 347
Soil mixing 348
Sand compaction piles 349
   Validation of ground improvement 350

13 Earthworks 351

   Dredging 351
Backfill 356
   Locking fill 356
   General backfill 357
   Tunnel cover 358
   Release of dragging anchors 359
   Filter criteria 359
Cut-and-cover tunnel earthworks 360
Casting basin 364
Artificial islands 368

14 Construction and placing of tunnel elements 371

   Concrete tunnels 371
   Casting facility 371
   Casting basin 371
   Dry docks and slipways 372
   Construction of concrete tunnel elements 373
   Oresund Tunnel fabrication facility 375
Steel tunnels 378
Utility tunnels 382
   Floating docks 385
Temporary works equipment 386
  Bulkheads 386
  Access shafts 387
  Bollards 389
  Lifting lugs 390
  Temporary supports 391
  Pulling jack 395
  Ballast tanks 395
  Immersion equipment 397
Float up 399
Transportation 401
Immersion 406
  Deep tunnels 408
  Survey techniques 409
Ballast exchange 410
Lessons learned 411

15 Finishing works 417
  Tunnel entry procedures 419
  Joints 420
    Omega seal installation 421
    Bulkhead breakout 423
    Shear keys and joint infill 423
    Cutting prestressing 425
    Installation of seismic joints 427
    Joint finishing for steel tunnels 427
  Ballast concrete 427
  Fire protection 430
    Design criteria 432
    Application 433
  Cladding, kerbs, and crash barriers 434
  Drainage 436
  Rail tracks and road surfacing 436
  M&E installation 437

16 Operation and maintenance 439
  Operation 439
    Operating procedures 439
    Control building 441
    Hazardous loads 441
Contents

Spillages 442
Overheight vehicles 442
Lighting 443
Traffic control 443
Maintenance 444
Planning 444
Implementation 445
Structure 445
Electrical and mechanical systems 449
Rail tunnels 450

17 Contract forms 453

Form of contract 454
Maintenance 456
Contract documents 456
Number of contracts 458
Ground conditions 458
Dispute resolution 459
Insurance 460
Payment 460
Privately financed construction 461

18 The future 463

Going longer 463
Going deeper 466
Materials 467
Submerged floating tunnels 468
Location 471

Glossary 473
References 483
Index 487