

R7780880

Fire Research Information Services
National Bureau of Standards
Bldg. 225, Rm. A46
Washington, D.C. 20234

NATIONAL BUREAU OF STANDARDS REPORT

1817

FINAL REPORT

ON

INVESTIGATION ON AGGREGATES AND CONCRETES
USED IN RIGID PAVEMENTS SUBJECTED TO HIGH
AND FLUCTUATING TEMPERATURES

by

W. L. Pendergast, R. A. Heindl, C. R. Enoch, R. A. Clevenger



U. S. DEPARTMENT OF COMMERCE
NATIONAL BUREAU OF STANDARDS

RECEIVED
FEB 11 1964
NATIONAL BUREAU OF STANDARDS
WASHINGTON, D.C.

U. S. DEPARTMENT OF COMMERCE

Charles Sawyer, *Secretary*

NATIONAL BUREAU OF STANDARDS

A. V. Astin, [REDACTED] *Director*



THE NATIONAL BUREAU OF STANDARDS

The scope of activities of the National Bureau of Standards is suggested in the following listing of the divisions and sections engaged in technical work. In general, each section is engaged in specialized research, development, and engineering in the field indicated by its title. A brief description of the activities, and of the resultant reports and publications, appears on the inside of the back cover of this report.

1. **Electricity.** Resistance Measurements. Inductance and Capacitance. Electrical Instruments. Magnetic Measurements. Electrochemistry.
2. **Optics and Metrology.** Photometry and Colorimetry. Optical Instruments. Photographic Technology. Length. Gage.
3. **Heat and Power.** Temperature Measurements. Thermodynamics. Cryogenics. Engines and Lubrication. Engine Fuels.
4. **Atomic and Radiation Physics.** Spectroscopy. Radiometry. Mass Spectrometry. Physical Electronics. Electron Physics. Atomic Physics. Neutron Measurements. Nuclear Physics. Radioactivity. X-Rays. Betatron. Nucleonic Instrumentation. Radiological Equipment. Atomic Energy Commission Instruments Branch.
5. **Chemistry.** Organic Coatings. Surface Chemistry. Organic Chemistry. Analytical Chemistry. Inorganic Chemistry. Electrodeposition. Gas Chemistry. Physical Chemistry. Thermochemistry. Spectrochemistry. Pure Substances.
6. **Mechanics.** Sound. Mechanical Instruments. Aerodynamics. Engineering Mechanics. Hydraulics. Mass. Capacity, Density, and Fluid Meters.
7. **Organic and Fibrous Materials.** Rubber. Textiles. Paper. Leather. Testing and Specifications. Organic Plastics. Dental Research.
8. **Metallurgy.** Thermal Metallurgy. Chemical Metallurgy. Mechanical Metallurgy. Corrosion.
9. **Mineral Products.** Porcelain and Pottery. Glass. Refractories. Enameled Metals. Building Stone. Concreting Materials. Constitution and Microstructure. Chemistry of Mineral Products.
10. **Building Technology.** Structural Engineering. Fire Protection. Heating and Air Conditioning. Exterior and Interior Coverings. Codes and Specifications.
11. **Applied Mathematics.** Numerical Analysis. Computation. Statistical Engineering. Machine Development.
12. **Electronics.** Engineering Electronics. Electron Tubes. Electronic Computers. Electronic Instrumentation.
13. **Ordnance Development.** Mechanical Research and Development. Electromechanical Fuzes. Technical Services. Missile Fuzing Research. Missile Fuzing Development. Projectile Fuzes. Ordnance Components. Ordnance Tests. Ordnance Research.
14. **Radio Propagation.** Upper Atmospheric Research. Ionospheric Research. Regular Propagation Services. Frequency Utilization Research. Tropospheric Propagation Research. High Frequency Standards. Microwave Standards.
15. **Missile Development.** Missile Engineering. Missile Dynamics. Missile Intelligence. Missile Instrumentation. Technical Services. Combustion.

NATIONAL BUREAU OF STANDARDS REPORT

NBS PROJECT

NBS REPORT

0903-21-4428

June 30, 1952

1817

FINAL REPORT ON

INVESTIGATION ON AGGREGATES AND CONCRETES
USED IN RIGID PAVEMENTS SUBJECTED TO HIGH
AND FLUCTUATING TEMPERATURES

by

W. L. Pendergast, R. A. Heindl, C. R. Enoch, R. A. Clevenger
Refractories Section
Mineral Products Division

Sponsored by

U. S. Naval Civil Engineering Research and
Evaluation Laboratory, Construction Battalion Center,
Port Hueneme, California.

NBS File No. 9.3/1134C



The publication, re-
unless permission
25. D. C. Such
prepared if that

Approved for public release by the
Director of the National Institute of
Standards and Technology (NIST)
on October 9, 2015.

In part, is prohibited
standards, Washington
has been specifically
port for its own use.

FINAL REPORT

June 30, 1952

INVESTIGATION ON AGGREGATES AND CONCRETES USED IN RIGID PAVEMENTS SUBJECTED TO HIGH AND FLUCTUATING TEMPERATURES

Technical Requirements

General: The objective of the project is the design of heat-resisting concretes suitable for use in rigid pavements for general ground circulation of jet-type aircraft and especially for warm-up, power check, and take-off operations of the aircraft.

Detail Requirements: The concretes must be of sufficient strength to withstand loads to which they will be subjected. Therefore, a minimum compressive strength of 2600 psi is specified. The concretes must have a maximum resistance to destruction when exposed to rapidly increasing and fluctuating temperatures.

I. INTRODUCTION

That phase of the project "Investigation of Aggregates and Concretes Used in Rigid Pavements Subjected to High and Fluctuating Temperatures," to be studied at the National Bureau of Standards was discussed at a meeting during June, 1951. Dr. Herbert Insley, R. L. Blaine, R. A. Heindl, and your Mr. Perry Petersen were present. It was concluded that such properties as refractoriness, thermal expansion, resistance to abrasion, heat transfer, compressive strength, and modulus of elasticity should be determined. The types of cements and aggregates that were to be used in designing the concretes were also selected at this time.

II. MATERIALS

The cements were (1) portland, a product of the North American Cement Company, (2) Green Bag portland pozzolan, a product of the Pittsburgh Coke and Chemical Company in which the pozzolanic agent is a blast furnace slag, and (3) Lumnite, a high-alumina hydraulic cement, manufactured by the Universal Atlas Cement Company.

Twelve aggregates were selected on the basis of both availability and possible suitability. Five of this group were classified as light weight aggregates and the other seven as more refractory and of a non-light weight classification. The light-weight group included two expanded shales "Lelite" and "Haydite," a clay-coated expanded shale "Rocklite," an expanded slag "Waylite," and a pumice from California. The non-light weight group included an olivine (an iron-magnesium silicate from North Carolina), "Bluestone" (a limestone from Western Maryland), a medium dense common building brick, a portland cement clinker, gravel and sand known as "White Marsh," and a Kentucky flint clay. The flint clay, which contained considerable iron pyrites and therefore unsuitable for firebrick manufacture, was submitted in two lots. One lot was received in the green state, that is as mined, the second had been calcined at about 1250°C.

A detailed description of the light weight aggregates was given in a publication by the Housing and Home Finance Agency.^{1/}

III. METHODS OF PREPARATION AND TESTING

A. Refractoriness. The pyrometric cone equivalent^{2/} or refractoriness of the cements, aggregates, and concretes was determined in a gas-heated furnace except the calcined flint clay. A carbon resistance furnace was used for this determination.

1. Cements. The portland and portland pozzolan cements were tested* in accordance with Federal Specifications SS-C-192, Type I, and SS-C-208a, respectively. There are no Federal Specifications for hydraulic cements of the high-alumina type. Lumnite cement, therefore, was tested in accordance with SS-C-192, Type III.

2. Aggregates. The crushing strength of the aggregates was determined by employing the methods described in a Bureau of Reclamation publication.^{3/} All other tests, with slight modifications necessitated by the characteristics of the material, were conducted in accordance with the methods described in the "1950 ASTM Standards on Mineral Aggregates, Concrete, and Nonbituminous Highway Materials."

3. Concretes. The data on aggregate sizing and the cement-aggregate ratio given in the publication,^{1/} issued by the Housing and Home Finance Agency, was used to advantage

* Made by the Mineral Products Division, Concreting Materials Section, National Bureau of Standards.

in designing the concretes. The mixes were adjusted to compensate for differences existing between sizes of the aggregates used in this study and those listed in that publication. The concretes were proportioned by volume and mixed in a three cubic foot tilt-drum mixer. The water and aggregate were mixed for one minute, the cement and an air-entraining agent, vinsol resin, were then added in that order, and the complete batch mixed for an additional three minutes. The concrete was then placed in specimen molds and the surface finished immediately with a wood float. Each batch contained sufficient concrete for the following specimens: four 6 x 12 inch cylinders, two 3 x 4 x 16 inch prisms, one 24 x 24 x 2 1/2 inch slab, and two 8 x 8 x 1 1/4 inch plates. The 24-inch slab, after partial set, received an additional delayed finishing with a steel trowel. All specimens were covered with wet burlap until the end of a 24-hour period. They were then removed from the molds, cured for six days in a fog-room and stored at laboratory temperature and humidity for 21 days. Because it was planned to test each concrete after curing, and also after five different heat treatments, limitations of laboratory facilities made it necessary to fabricate separate lots of specimens of each concrete on subsequent days.

Specimens of each concrete were tested after a curing period of 28 days and also after each of the following heat treatments: 250, 500, 750, and 1000°C respectively. The temperature of the kiln in which the specimens were heat-treated was increased approximately 50°C per hour to the maximum scheduled temperature. After temperature equilibrium was reached, throughout the specimens the kiln was held at the maximum temperature for five hours. The specimens were cooled in the kiln to room temperature.

Fifteen concretes were designed and tested using portland, Green Bag, and Lumnite cement, respectively, with each of five aggregates, namely pumice, Haydite, Waylite, Rocklite, and Lelite.

The linear thermal expansion will be determined of concrete specimens to the maximum possible temperature depending on their refractoriness. For this purpose specimens have been prepared measuring 1 x 1 1/2 x 7 1/2 inches.

Measurements of the thermal conductivity of the concretes were made* using the hot-plate apparatus shown in Figure 1. It consists of an electrically heated hot-plate 8 inches square, set in a horizontal plane, and a cold plate of the same size cooled by n-pentane (C_5H_{12}) boiling at atmospheric pressure (i.e., at approximately 98°F).

* Thermal conductivity measurements were made by the Building Technology Division, Heating and Air Conditioning Section of the National Bureau of Standards.

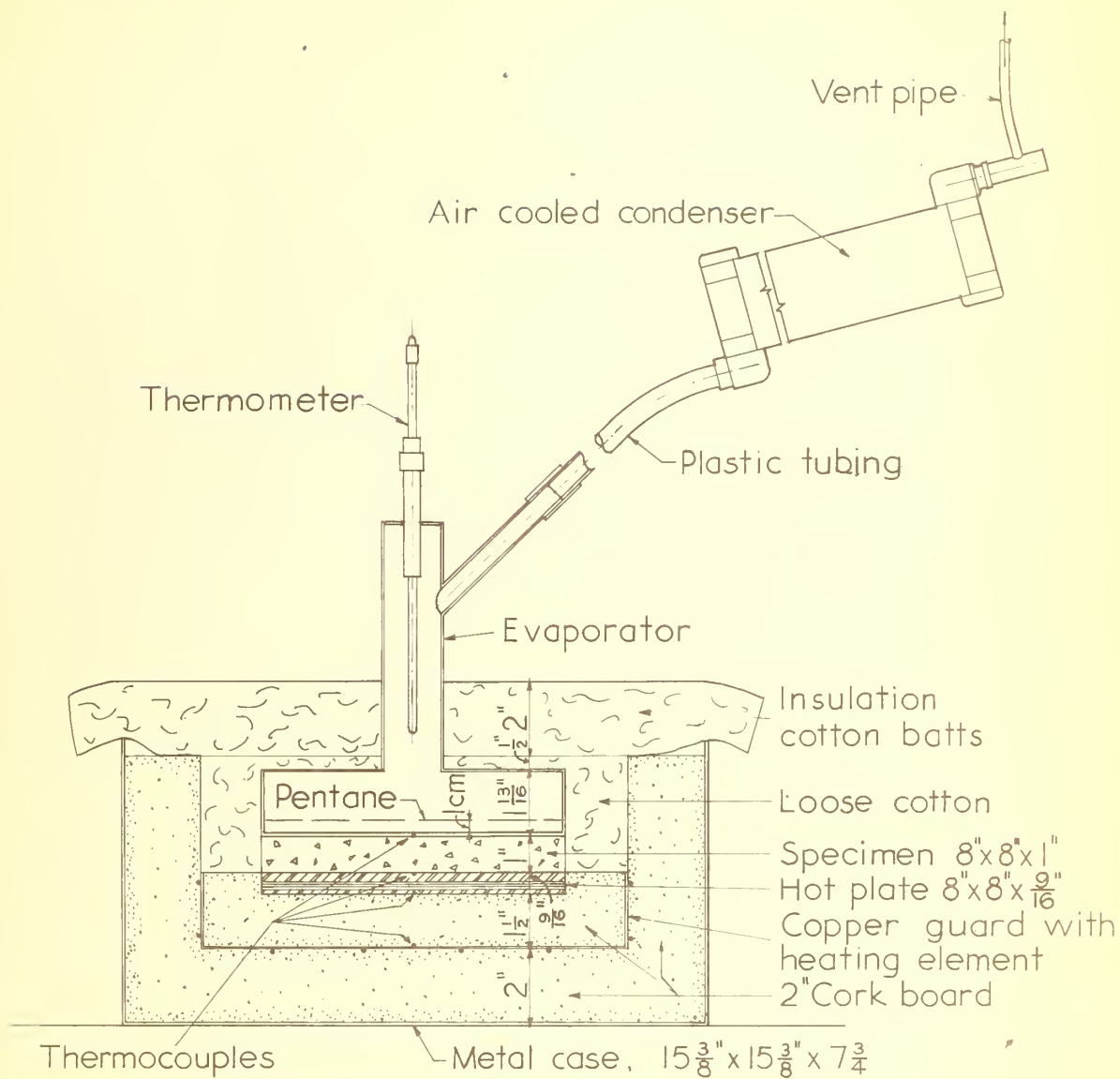


FIG.1 - Hot plate thermal conductivity tester

The pentane vapor was condensed in an air-cooled condenser arranged so that the condensate returned to the cold plate.

The test specimen, 8 inches square and approximately one inch thick, was placed between the hot and cold plates. The contacting surfaces of the plates and of the specimens were ground flat to assure good thermal contact between them. Copper-constantan thermocouples were set in the surfaces of the hot and cold plates to measure their temperatures. Heat flow downward and outward from the edges of the hot-plate was made substantially zero by means of an electrically-heated copper guard pan placed under and around the hot-plate with insulation between them, by adjusting the guard to the same temperature as the underside of the hot-plate, as indicated by the thermocouples attached thereon.

The tests were conducted with the hot-plate at about 140°F and the cold plate at about 98°F. When steady temperatures were attained with the guard properly adjusted, the electrical power input to the hot-plate and the temperatures of the hot and cold plate surfaces in contact with the specimen were measured. The thermal conductivity (k) of the specimen, expressed in Btu per hour per square foot per degree F per inch temperature gradient, was calculated from these data combined with measurements of the area and thickness of the specimen.

The test apparatus was checked by a series of comparison tests made in the Bureau's guarded hot-plate conductivity apparatus, conforming to ASTM C-177, on a specimen having a conductivity of 0.8. Agreement between the tests in the two sets of apparatus was within 1.1 percent.

The cast specimens were prepared with flat and parallel faces by grinding, and were dried in a ventilated oven at 220°F for 72 hours prior to test. The duration of a test was from 7 to 24 hours, depending upon the time necessary to attain steady temperature conditions. The specimen was weighed immediately before and after test.

The resistance of the concretes to abrasion was determined using the apparatus designed by Schuman and Tucker.^{4/}

The compressive strength of the concretes was determined in accordance with ASTM Method Designation C39-44.^{5/}

Young's modulus of elasticity was determined in accordance with the method described by Gerald Pickett.^{6/}

Other properties and pertinent data relating to the concretes were determined as follows: The proportion, by weight, of cement to coarse to fine aggregate was arrived at using available information on concretes designed with similar aggregates. The same procedure was followed in determining the amount of vinsol resin to be added.

The cement content, air content, and weight of fresh concrete was determined according to ASTM Designation C138-44.^{5/}

The water content was calculated by the following formula:

$$\text{Water content} = \frac{\text{Mixing water in gallons}}{\text{Volume of concrete yielded in cubic yards}}$$

The slump of the fresh concrete was determined according to ASTM Designation C143-39.^{5/}

The weight per cubic foot of concrete after curing or after heat-treatment was calculated by the formula:

$$\text{Weight per cubic foot} = \frac{\text{Weight in pounds}}{\text{Volume in cubic feet}}$$

The strength-weight ratio was calculated using the formula:

$$\text{Strength-weight ratio} = \frac{\text{Compressive strength (lb/in}^2\text{)}}{\text{Weight lb/ft}^3}$$

The linear shrinkage, based on the inner dimension of the mold, was calculated using the formula:

$$\text{Linear shrinkage} = \frac{l_o - l_f}{l_o} \times 100$$

where:

l_o = original length

l_f = final length

IV. RESULTS AND DISCUSSION

A. Refractoriness or Pyrometric Cone Equivalent.

Table 1 gives the pyrometric cone equivalent (PCE) of the cements, aggregates, and concretes. Although portland cement is appreciably more refractory than the high-alumina cement, PCE of 18 versus 14, nevertheless, it is not considered satisfactory for use in heat-resistant concrete. The reason for this fact is that portland

cement, after dehydration and heating may form beta-dicalcium silicate which in turn will convert to gamma-dicalcium silicate. Such an inversion is attended by a marked volume change causing the product to "dust," which in turn results in a marked loss in bonding strength. Inasmuch as silica is a minor constituent of Lumnite there is an insignificant amount (if any) of dicalcium silicate formed and consequently in this cement no "dusting" occurs. The tests indicate a wide range of refractoriness in aggregates, namely, Cone 2 for pumice and Rocklite to Cone 31 for flint clay. The results of the PCE determination of the concretes indicate that the substitution of Lumnite cement for either portland or portland pozzolan increased the refractoriness of all concretes except that containing Waylite. The concretes designed using pumice as an aggregate showed definite indication of fusion at 1000°C. However, when Rocklite, the other aggregate with a low PCE was used, there was no indication of fusion at 1000°C.

Table 1
Pyrometric Cone Equivalents (PCE)
of
Cements, Aggregates, and Concretes

Cement		Aggregate	Cement Aggregate ratio by weight	PCE	Equivalent approximate temperature (°C)
Portland		---	---	18	1490
Portland pozzolan		---	---	14	1400
Lumnite		---	---	14-15	1420
---		Pumice	---	2	1165
---		Rocklite	---	2	1165
---		Haydite	---	6	1230
---		Lelite	---	10	1305
---		Waylite	---	13	1350
---		Common building brick	---	15-16	1450
---		Flint clay calcined	---	31	1680
Portland	and	Pumice	1 : 1.5	5	1205
do	do	Rocklite	1 : 3.9	4	1190
do	do	Haydite	1 : 3.6	4	1190
do	do	Waylite	1 : 2.4	14-15	1420
Portland pozzolan	and	Pumice	1 : 1.5	4	1190
do	do	Rocklite	1 : 3.9	4	1190
do	do	Haydite	1 : 3.6	3 - 4	1180
do	do	Waylite	1 : 2.4	14	1400
Lumnite	and	Pumice	1 : 1.5	7 - 8	1255
do	do	Rocklite	1 : 3.9	5 - 6	1220
do	do	Haydite	1 : 3.6	9	1285
do	do	Waylite	1 : 2.4	12	1335

1. Cements. The results of the physical tests and chemical analyses are given in tables 2 and 3.

Table 2. Results of Physical Tests of Cements

Cement	Time of set		Surface Blaine a/ apparatus	Compressive Strength			Air Con- tent	Autoclave Expansion
	<u>Initial</u>	<u>Final</u>		3-day	7-day	28-day		
	Hr. Min.	Hr. Min.	cm ² g	lb/in ²	lb/in ²	lb/in. ²	%	%
Portland	4 : 40	7 : 00	3340	1040	2040	3820	8.0	0.10
Portland pozzolan	4 : 45	7 : 05	3770	1170	1780	3370	13.2	0.02
High - alumina	11 : 30	13 : 15	--	4280	4360	5200	5.4	0.02

Table 3. Chemical Analysis of Cements

Cement	Ignition Loss	Insol. Residue	SO ₃	SiO ₂	Al ₂ O ₃	Fe ₂ O ₃	CaO	MgO	Total alkali as Na ₂ O	K ₂ O	FeO
	%	%	%	%	%	%	%	%	%	%	%
Portland	1.9	0.2	1.7	21.6	5.7	2.6	62.4	3.1	0.30	0.84	
Portland pozzolan	0.0	0.3	1.7	24.7	7.7	2.2	59.4	1.8	0.05	0.44	2.0
High- alumina	-0.1 <u>b/</u>	1.7	0.3	8.6	42.7	4.3	36.8	0.8	--	--	6.2

a/ Tentative method of Test for Fineness of Portland Cement by Air Permeability Apparatus A.S.T.M. Designation: C204-46T, 1946

b/ Gain

The portland cement complied with the technical requirements of Federal Specification SS-C-191. The portland pozzolan, however, failed to comply with the required compressive strength (1800 psi) after seven-day aging.

The outstanding difference in the chemical compositions of the three cements is that Lumnite contains a much higher percentage of alumina and considerably less calcium oxide and silica.

The setting of portland cement is due to the formation of hydrated calcium silicate. Because Lumnite contains only small amounts, if any, of the silicates its setting is the result of the formation of hydrated calcium aluminates and hydrated alumina. Since the aluminates hydrate more rapidly than the silicates, a high-alumina cement, such as Lumnite, develops a high early strength as indicated in table 2.

2. Aggregates. Table 4 gives the screen analysis and some properties of the aggregates. This information aided in the designing of the concretes. Two general sizings of aggregates were used in each concrete. One of these sizings designated as "coarse" consisted primarily of material retained on a No. 4 and passing a one inch screen. The other designated as "fines" consisted of material passing a 3/8 inch screen.

Specific Gravity % Dry (c)	Water Absorption Percent by weight	Crushing strength lbs/in ² (d)		
		Compaction, inches		
		1	2	3
74 64	0.24 1.06	(f)	—	—
66 08	11.28 8.61	1,535	13,863	41,062 ^(f)
65 09	8.42 5.50	561	3,244	39,824 ^(f)
68 38	17.10 2.61	264	943	8,450
26 43	39.00 44.80	396	1,563	6,465
32 65 81 97	10.54 10.22 17.80 17.10	2,780 ^(e)	28,299 ^(e)	41,026 ^(e)
26 27 37	8.93 9.60 6.10	— — —	— — —	— — —
65 65	0.90 0.80	3,930	41,030 ^(f)	—
52 50 97	4.76 5.03 3.20	778 —	13,074 —	40,682 ^(f) —

Table 4. Properties of Aggregates

Materials		Sieve Analysis											Fineness Modulus ^(a)	Unit Weight lbs/ft ³		Bulk Specific Gravity S.S. Dry ^(c)	Water Absorption Percent by weight	Crushing strength lbs/in ² (d)		
Identifica- tion	Size	Amount passing U. S. Standard Sieve, percent by weight												Loose	Jigged ^(b)			Compaction, inches		
		1"	3/4"	1/2"	3/8"	Nos.												1	2	3
						4	8	16	30	50	100	200								
Bluestone	Coarse	100.0	99.1	71.6	22.7	3.1	2.0	--	--	--	--	--	6.73	83.6	98.0	2.74	0.24	(f)	--	--
	Fine	--	--	--	100.0	99.3	79.6	50.7	26.7	11.5	3.7	11.3	3.28	99.8	113.0	2.64	1.06			
Haydite	Coarse	--	100.0	95.3	71.1	11.1	1.8	--	--	--	--	--	6.16	53.8	62.1	1.66	11.28	1,535	13,863	41,062 ^(f)
	Fine	--	--	--	100.0	99.8	95.3	70.7	43.5	27.4	18.3	12.6	2.45	68.1	97.5	2.08	8.61			
Lelite	Coarse	99.9	97.9	75.5	40.3	8.5	6.8	--	--	--	--	--	6.46	42.4	47.9	1.65	8.42	561	3,244	39,824 ^(f)
	Fine	--	--	--	--	100.0	97.3	68.0	42.7	26.6	16.8	10.8	2.48	63.9	73.1	2.09	5.50			
Waylite	Coarse	--	--	100.0	94.2	16.8	8.8	--	--	--	--	--	5.80	33.2	39.4	1.68	17.10	264	943	8,450
	Fine	--	--	--	100.0	99.9	97.3	84.6	54.9	32.0	15.2	5.9	2.16	60.4	72.2	2.38	2.61			
Pumice	Coarse	100.0	98.7	82.5	51.0	16.8	15.4	--	--	--	--	--	6.18	29.2	32.1	1.26	39.00	396	1,563	6,465
	Fine	--	--	--	100.0	76.3	46.2	32.8	21.8	14.3	8.1	13.5	4.01	38.6	43.9	1.43	44.80			
Rocklite	Coarse	100.0	78.9	--	--	--	--	--	--	--	--	--	7.21	47.7	52.0	1.32	10.54	2,780 ^(e)	28,299 ^(e)	41,026 ^(e)
	Thru 9/16	--	100.0	98.9	59.9	0.7	--	--	--	--	--	--	6.39	51.3	57.0	1.65	10.22			
	Thru 5/16	--	--	--	100.0	44.5	1.3	--	--	--	--	--	5.54	55.3	61.9	1.81	17.80			
	Fine	--	--	--	100.0	99.8	78.7	40.0	20.6	9.5	3.9	--	3.48	66.3	73.3	1.97	17.10			
Building Brick	Coarse	100.0	99.1	66.8	15.2	4.4	3.9	--	--	--	--	--	6.77	61.4	71.9	2.26	8.93	--	--	--
	Medium	--	--	100.0	98.3	16.5	5.4	4.3	--	--	--	--	5.75	60.5	70.3	2.27	9.60			
	Fine	--	--	--	100.0	99.9	70.9	50.5	36.0	23.5	11.0	7.5	3.08	80.1	91.9	2.37	6.10			
Flint-clay Calcined	Coarse	100.0	99.6	85.3	70.4	44.2	24.9	--	--	--	--	--	5.60	87.7	101.7	2.65	0.90	3,930	41,030 ^(f)	--
	Fine	--	--	--	100.0	75.1	38.0	20.2	10.6	5.2	1.8	0.9	4.49	89.4	101.3	2.65	0.80			
Flint-clay Raw	Coarse	100.0	99.8	83.2	69.8	45.5	29.3	--	--	--	--	--	5.55	86.0	101.5	2.52	4.76	778	13,074	40,682 ^(f)
	Fine	--	--	--	100.0	76.3	37.3	20.1	10.2	4.6	1.5	1.9	4.50	80.9	95.0	2.50	5.03			
Olivine	Coarse	--	100.0	85.3	70.9	54.3	45.6	--	--	--	--	--	5.29	124.8	146.7	2.97	3.20	--	--	--
	Fine	--	--	--	100.0	99.9	99.3	82.0	65.5	35.2	10.3	4.0	2.08	114.4	130.5	3.09	1.00			
White Marsh Gravel Sand	Coarse	89.9	76.2	54.1	31.9	3.3	--	--	--	--	--	--	6.88	101.1	110.9	2.64	0.30	--	--	--
	Fine	--	--	--	100.0	97.9	8.00	64.9	49.5	22.0	4.1	1.2	2.82	100.4	112.0	2.63	0.30			

(a) Indicates distribution of sizes of aggregate as determined by ASTM method C125-43 "Standard Definitions of Terms Relating to Concrete and Concrete Aggregates", ASTM Standards on Mineral Aggregates, Concrete, and Nonbituminous Highway Materials, Sept. 1948, page 70.

(b) Indicates bulking or fitting together of various sizes of aggregates.

(c) "S.S." Saturated aggregate - Surface Dry.

(d) Grading - 50% through 3/8" retained on No. 4; 30% through No. 4 retained on No. 8; 20% through No. 8 retained on No. 16.

(e) Rocklite - 60% through No. 4 retained on No. 8; 40% through No. 8 retained on No. 16.

(f) Bluestone beyond capacity of apparatus at 1" compaction;
 Flint clay (calcined) maximum compaction possible with apparatus 1 13/16"
 Haydite " " " " " 2 21/64"
 Lelite " " " " " 2 23/64"
 Flint Clay (Raw) " " " " " 2 9/16"

The screen analyses were necessary to determine the distribution of the particle sizes. From these analyses the fineness moduli of both the "fines" and the coarse were calculated. The modulus of the "fines" should not exceed a value of approximately 3.2. The fineness modulus of the combined mixture of fine and coarse aggregate is calculated in accordance with the respective proportions of each used in the concrete mix. It is not considered desirable that this value exceed approximately 5.2. Two of the fineness moduli of the "fines" as given in table 4, were above the limit of 3.2 and the combined fineness moduli of the same two aggregates were slightly above 5.2. This data refers only to the five light-weight aggregates reported. Values outside these limits tend to develop a harsh concrete with a high percentage of voids, resulting in a loss of strength.

It must be recognized that the fineness modulus does not apply perfectly to light-weight aggregates since it was founded on data using normal aggregates. The bulk specific gravity factor adjusts the mix to the proper proportion, by weight, as compared to volume. The water absorption of the aggregate determines the amount of excess mixing water to add to the cement-water ratio. The crushing strength in compaction indicates the maximum strength obtainable with that aggregate. The strength of the resulting concrete, however, also depends on the shape and condition of the surface of the aggregate.

Modulus of Elasticity E_c Longitudinal After heating	Linear Shrinkage d		Abrasion Loss
	Before heating	After heating	
$\times 10^6$	%	%	gms
---	---	---	---
---	---	---	---
---	---	---	---
---	0.000	0.766	---
---	0.050	4.990	---
---	---	---	---
---	---	0.650	---
---	---	---	---
---	0.067	0.916	---
---	0.130	2.210	---
---	0.116	---	---
---	---	---	---
---	---	---	---
---	0.083	---	---
---	0.170	---	---
---	---	---	---
1.373	0.083	0.216	---
1.360	0.110	0.180	44.3
0.560	0.000	0.450	625.5
0.527	0.217	-0.166	---
---	0.100	---	---
---	---	---	---
1.160	0.166	0.216	---
0.922	0.060	0.190	50.0
0.594	0.100	0.430	338.4
0.434	0.317	-0.183	---

Concrete mixes of the
will show any

Table 5. Properties of Heat-Resisting Concretes

Laboratory Identifi- cation ^a	Proportions by weight Cement to coarse and to fine aggregate	Cement Content		Vinsol resin by weight of cement	Water Content		Air Content	Slump on fresh concrete	Weight of fresh concrete	Weight of Concrete after		Compressive Strength 6 x 12 in. cylinder	Strength weight ratio	Young's modulus of elasticity ^c /		Linear Shrinkage ^d /		Abrasion Loss		
		Bags/yd ³ of concrete	%		Gal/yd ³ of concrete	%				inches	lbs/ft ³			lbs/ft ³	lbs/in ²	lb/in ² x 10 ⁶	%		%	gms
P-P-1 ^{28 days}	1:1:0.4	7.1	0.02		72	14.5		3.00	81	74	—	1470	19.9	0.852	—	—	—	—		
P-P-2 ^{28 days}	1:1:0.5	6.8	do		72	16.2		2.25	80	—	—	1610	—	—	—	—	—	—		
P-P-3	do	6.4	do		72	18.7		5.75	76	—	59	1150	19.5	—	—	—	—	—		
P-P-4	do	6.6	do		74	13.9		0.00	79	73	57	455	8.0	—	—	0.000	0.766	—		
P-P-5	do	6.6	do		72	15.7		5.50	79	70	—	85 ^g /	—	0.714	—	0.050	4.990	—		
Z-P-1	do	6.4	do		71	17.1		5.25	77	70	—	1255	17.9	0.731	—	—	—	—		
Z-P-2	do	7.1	do		78	9.6		2.25	85	—	62	1500	24.4	—	—	—	0.650	—		
Z-P-3	do	5.7	do		65	25.5		7.50	68	—	61	665	10.9	—	—	—	—	—		
Z-P-4	do	6.6	do		79	12.1		5.25	80	71	57	385	6.8	—	—	0.067	0.916	—		
Z-P-5	do	6.6	do		71	15.8		4.75	78	68	—	95 ^g /	—	0.749	—	0.130	2.210	—		
L-P-1	do	6.9	do		83	7.2		6.75	85	68	—	560	8.2	0.535	—	0.116	—	—		
L-P-2	do	7.1	do		86	12.5		0.25	88	—	—	415	—	—	—	—	—	—		
L-P-3	do	6.0	do		74	18.7		7.50	74	—	61	—	—	—	—	—	—	—		
L-P-4	do	6.8	do		81	9.5		5.00	83	73	—	—	—	—	—	0.083	—	—		
L-P-5	do	6.5	do		75	14.1		6.00	79	71	—	—	—	0.743	—	0.170	—	—		
P-H-1	1:1.7:1.9	5.2	do		57	11.4		6.75	101	97	—	1750	18.1	1.930	—	—	—	—		
P-H-2	do	5.3	do		54	11.2		3.63	101	99	91	2200	24.2	2.128	1.373	0.083	0.216	—		
P-H-3	do	5.7	do		58	5.2		2.25	109	104	94	1670	17.3	2.455	1.360	0.110	0.180	44.3		
P-H-4	do	5.1	do		56	11.5		2.75	101	102	92	580	6.3	2.313	0.560	0.000	0.450	625.5		
P-H-5	do	5.6	do		57	6.6		2.75	107	102	90	290	3.2	2.340	0.527	0.217	-0.166	—		
P-H-1	do	5.3	do		54	11.5		5.25	102	99	—	2070	20.1	2.032	—	0.100	—	—		
Z-H-1	do	—	do		—	—		—	—	—	—	—	—	—	—	—	—	—		
Z-H-2	do	5.1	do		54	13.3		6.63	99	97	89	2000	22.5	1.788	1.160	0.166	0.216	—		
Z-H-3	do	5.3	do		54	12.4		5.75	100	98	90	1445	16.0	2.089	0.922	0.060	0.190	50.0		
Z-H-4	do	5.2	do		55	13.2		4.50	99	99	90	595	6.5	2.054	0.594	0.100	0.430	338.4		
Z-H-5	do	5.4	do		55	10.1		6.00	103	98	88	240	2.7	2.080	0.434	0.317	-0.183	—		
L-H-1	do	5.5	do		60	6.8		2.75	106	100	—	2145	21.5	2.011	—	0.200	—	—		
L-H-2	do	5.5	do		59	6.4		3.50	106	101	94	890	9.5	1.993	0.899	0.100	0.316	—		
L-H-3	do	5.5	do		58	8.4		3.25	105	101	92	705	7.6	2.020	0.596	0.130	0.110	342.5		
L-H-4	do	5.2	do		58	11.5		4.50	100	99	90	540	6.0	1.928	0.473	0.210	0.230	2266.0		
L-H-5	do	5.6	do		60	5.2		5.50	107	101	89	310	3.5	2.090	0.509	0.316	-0.183	—		
P-W-1	1:0.9:1.5	7.0	0.01		69	11.4		0.00	103	98	—	1535	15.6	1.880	—	0.260	—	140.8		
P-W-2	do	6.7	do		67	14.6		1.75	99	95	89	1295	14.6	1.740	1.030	0.100	0.280	169.2		
P-W-3	do	6.8	do		67	13.4		1.50	101	—	85	1150	13.5	—	0.719	—	0.350	—		
P-W-4	do	6.7	do		66	15.0		2.50	99	94	81	—	—	1.684	—	0.300	-0.080	—		
P-W-5	do	6.4	do		69	15.6		5.50	97	92	78	68	—	1.542	—	0.130	-0.650	—		
Z-W-1	do	6.7	do		66	14.8		2.75	95	91	—	1420	15.6	1.410	—	0.000	—	67.2		
Z-W-2	do	6.6	do		67	15.3		1.50	98	92	89	1135	12.7	1.577	0.856	0.000	0.130	173.8		
Z-W-3	do	6.6	do		62	18.0		2.20	96	—	82	965	11.8	—	0.629	—	0.330	—		
Z-W-4	do	6.6	do		63	17.3		2.50	96	90	81	415	5.1	1.513	0.451	0.060	0.400	—		
Z-W-5	do	6.4	do		70	15.7		3.00	97	89	78	122	1.5	1.399	—	0.120	-0.420	—		
L-W-1	do	6.8	do		68	13.0		0.13	101	96	—	1660	17.5	1.723	—	0.130	—	203.6		
L-W-2	do	6.4	do		68	16.4		2.50	96	93	86	565	6.6	1.565	0.618	0.300	0.360	299.2		
L-W-3	do	7.0	do		70	10.0		0.00	104	—	85	520	6.1	—	0.336	—	0.900	—		
L-W-4	do	6.7	do		70	13.3		2.00	100	93	83	543	6.5	1.607	0.445	0.160	0.200	—		
L-W-5	do	6.6	do		70	13.6		1.25	99	93	82	303	3.7	1.663	—	0.200	-0.650	—		
P-R-1 ^z	1:0:0.4:0.8:0.8:1.9	4.6	0.02		50	17.3		6.75	94	93	—	2110	22.7	1.865	—	0.180	—	100.3		
P-R-2	do	4.7	do		51	15.0		2.00	96	92	84	2205	26.2	1.946	1.452	0.150	0.110	29.8		
P-R-3	do	4.2	do		51	16.3		7.00	94	91	—	—	—	1.777	—	0.100	—	—		
P-R-4	do	4.8	do		55	12.4		2.00	98	91	82	576	7.0	1.936	0.997	0.000	0.100	—		
P-R-5	do	4.9	do		54	11.4		1.00	100	96	86	445	4.5	2.109	0.707	0.100	0.470	448.8		
Z-R-1	do	4.5	do		50	18.7		5.25	92	91	—	2770	30.4	1.855	—	0.130	—	51.4		
Z-R-2	do	4.9	do		53	12.5		1.25	99	93	86	2755	32.0	1.943	1.447	0.040	0.080	34.1		
Z-R-3	do	4.2	do		52	18.5		7.00	91	88	—	—	—	1.719	—	0.000	—	—		
Z-R-4	do	4.8	do		54	12.2		1.25	99	92	84	960	11.4	2.029	0.929	0.090	0.330	—		
Z-R-5	do	4.9	do		54	11.3		0.00	101	92	84	515	6.1	1.877	0.755	0.300	0.540	583.0		
L-R-1	do	5.0	do		55	9.8		0.50	102	97	—	2350	24.3	1.794	—	0.080	—	110.6		
L-R-2	do	4.5	do		53	16.5		6.75	93	90	82	445	5.4	1.615	0.692	0.170	0.180	785.0		
L-R-3	do	4.5	do		55	12.8		1.25	98	91	—	—	—	1.723	—	0.110	—	—		
L-R-4	do	4.7	do		55	14.1		4.00	96	92	84	470	5.6	1.828	0.551	0.190	0.250	—		
L-R-5	do	4.9	do		57	9.4		0.50	102	95	86	515	6.0	1.839	0.619	0.090	0.400	522.3		

^a/ The first letter indicates the type of cement, namely: P=Portland, Z=Portland Pozzolan, L=Lumnite
The second letter indicates the type of aggregate: P=Pumice, H=Haydite, R=Rocklite
The numerals indicate: 1=cured for 28 days only; 2,3,4 and 5 =cured for 28 days and heat treated at 250°C, 500°C, 750°C, 1000°C, respectively.

^b/ Specimens were heated at an approximate rate of 50°C per hour to maximum temperature. After equilibrium was reached they were held at this temperature for 5 hours.

^c/ See foot notes a and b for details of heat treatment.

^d/ The modulus of elasticity and the linear shrinkage were determined on each cylinder of each mix after the 28-day curing. These determinations were made to compare concrete mixes of the same design (See column "Laboratory Identification") but made on different days. The results, when compared with those obtained after the several heat treatments, will show any changes in structure of the cylinder that these properties may indicate.

^e/ Inaccurate due to strength of cap.

^z/ Cement : coarse : thru 9/16 : thru 5/16 : fine.

3. Concretes.

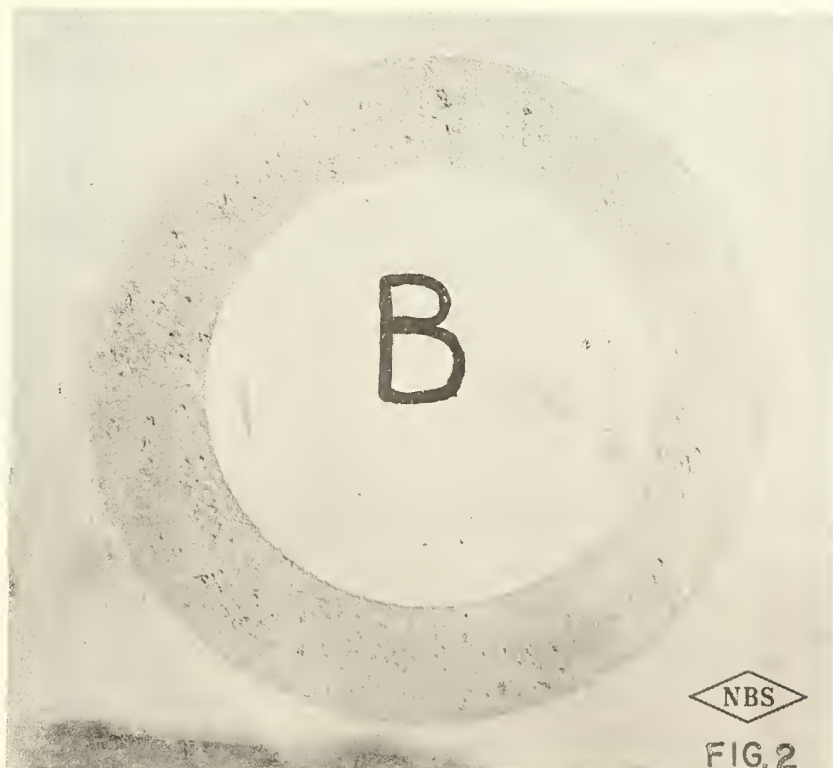
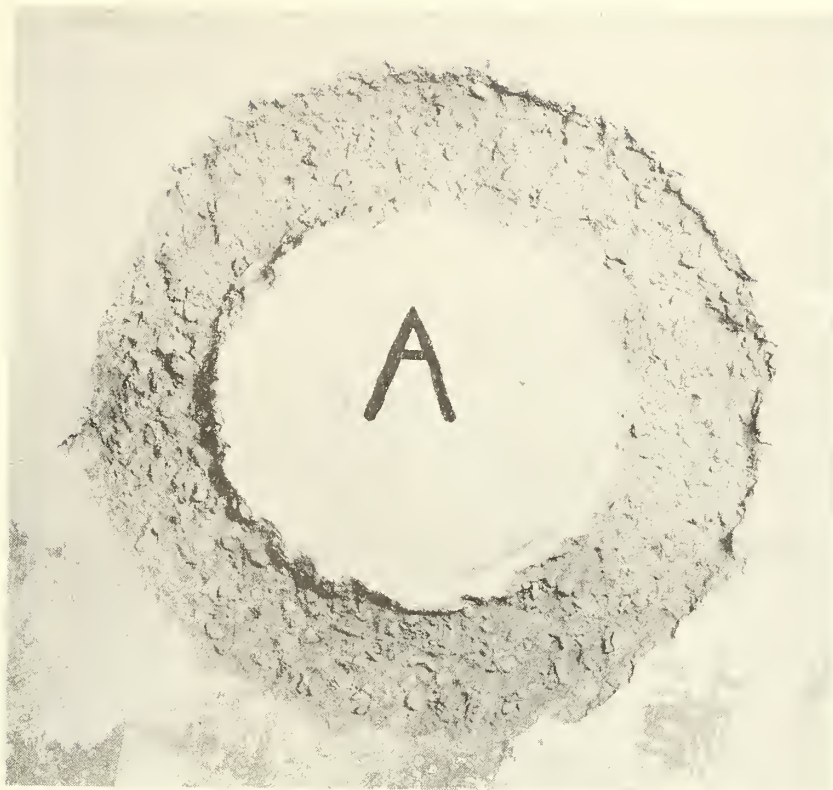
Resistance to abrasion

Test slabs of twelve concretes designed, using each of the three cements, with each of the four aggregates, respectively, were tested for abrasion and the results are given in table 5. The amount of concrete, by weight, abraided from the specimen is considered a measure of its wear in actual service. The loss due to abrasion of the tested specimens ranged from 30 to 2300 grams. In general, the concretes, designed using Lumnite cement, when tested at the age of 28-days, had the least resistance to this type of abrasion. The resistance to abrasion of all concretes irrespective of the aggregates or cements used decreased as the temperature of the heat treatments was increased above 250°C and ranging up to 1000°C.

Figure 2 shows the difference in abrasion resistance of two concretes. Specimen A contained the high-alumina cement and the Haydite aggregate, and had been heated at 750°C. The loss of 2266 grams indicated a comparatively low resistance to abrasion. Specimen B contained the portland pozzolan cement and Waylite aggregate and had been heated at 250°C. It lost 174 grams indicating this concrete had a high resistance to abrasion.

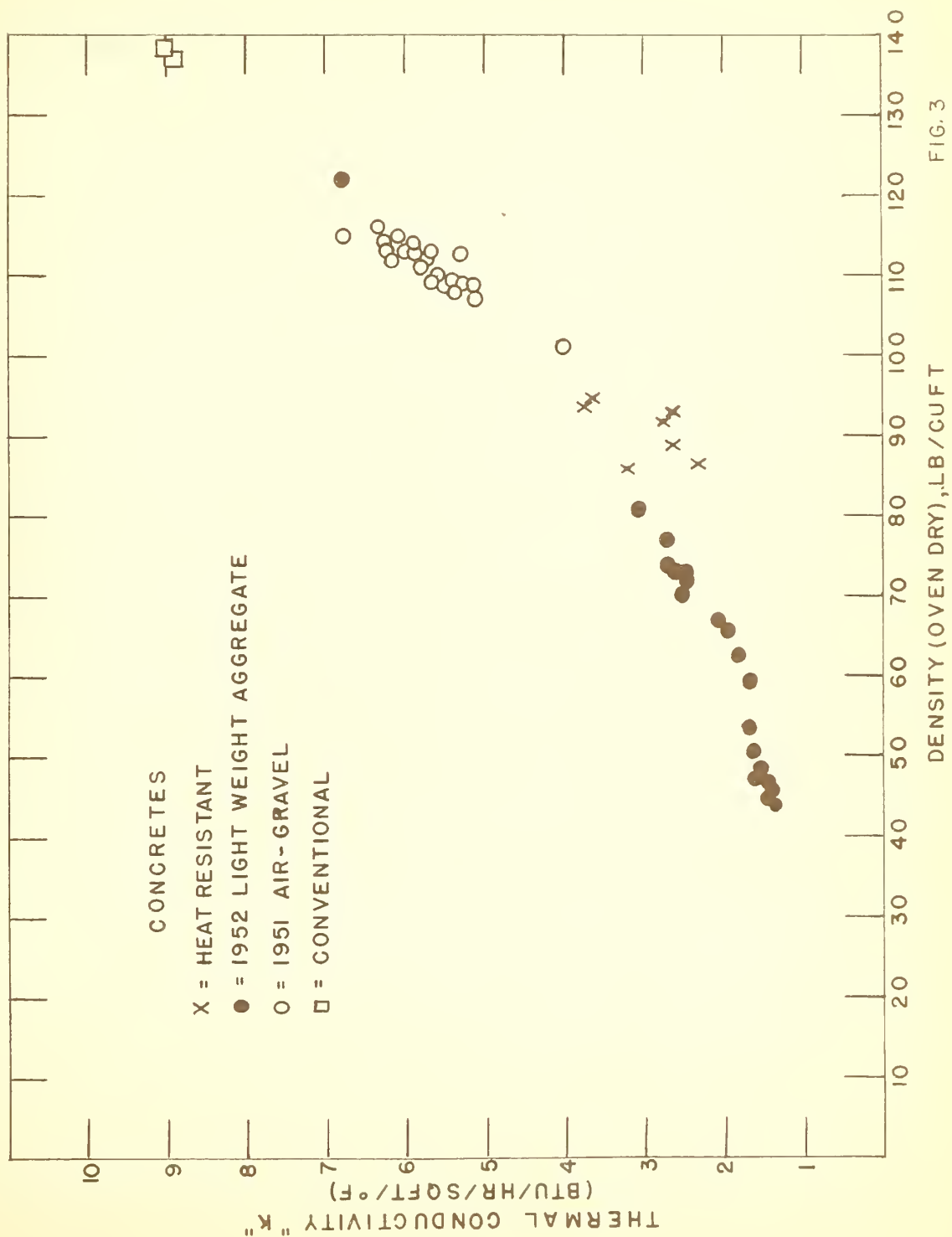
Thermal Conductivity

Figure 3 shows the thermal conductivity of seven lightweight heat-resistant concretes measured at a mean



NBS

FIG. 2



temperature of approximately 115°F. The figure not only shows the "k" values for the light-weight heat-resistant concretes included in this investigation but also the "k" values for no fines concretes reported by Valore and Green,^{8/} as well as unpublished values obtained in an active investigation "High Air-Content Light-Weight Aggregate Concrete."* In addition two "k" values are shown for conventional concrete. The corresponding weight or density (oven dry) in pounds per cubic foot are plotted against these ("k") values. All these results are shown in order that the location of the heat-resistant concretes may be seen with respect to the other types of concretes. The heat-resistant concretes range in density from 85 to 95 pounds per cubic foot and "k" from 2.6 to 3.8. The "k" values in the resulting plotted curve for all concretes have an overall range from 1 to 9 and densities from 40 to 140 pounds per cubic foot so that the heat-resistant concretes fall approximately in the central portion.

Table 5 gives information relevant to the mixed concretes and some of their properties. A good portion of this data is given as a matter of interest to illustrate the wide ranges that exist in such data.

The results given indicate that most of the water loss occurred between the 28-day aging period and 250°C heat treatment. The loss of water continued with successive

* Building Technology Division, Structural Engineering Section, National Bureau of Standards.

heat treatments to 1,000°C but at a considerably reduced rate. The compressive strengths given in table 5 indicate that only one of the 15 concretes tested met the specified technical requirement of 2600 psi. The one concrete that complied with this requirement contained portland pozzolan cement and the Rocklite aggregate with a 1:1.39 cement-aggregate ratio. It is quite possible that the required strength of 2600 psi might be developed if in one or more of the concretes the cement content were increased. Four of the 12 concretes increased slightly in strength between the 28-day curing period and after the 250°C heat treatment. In all four concretes portland or portland pozzolan cement was used. The strength of the concretes decreases rapidly after heating at 500°C, especially when portland or portland pozzolan cement was used. The concretes containing Lumnite have a tendency to decrease in strength at a slower rate after the 500°, 750° or 1,000°C heating than those containing either of the other two cements.

Modulus of Elasticity

The maximum modulus of elasticity of the concretes, as given in table 5, is approximately 2,000,000 pounds per square inch. Young's modulus for concretes containing pumice, when specimens remained intact so that this property could be determined, was in some instances about one-third that of the concretes made with the other four aggregates.

Heat treating the concretes made with pumice aggregate caused cracking and at some temperatures complete disintegration. The fundamental frequency could not be determined on cracked specimens. In all concretes the modulus decreased rapidly with increasing heat treatments, but when Lumnite cement was used this decrease was less pronounced and tended to level off after heating at 500°C and above.

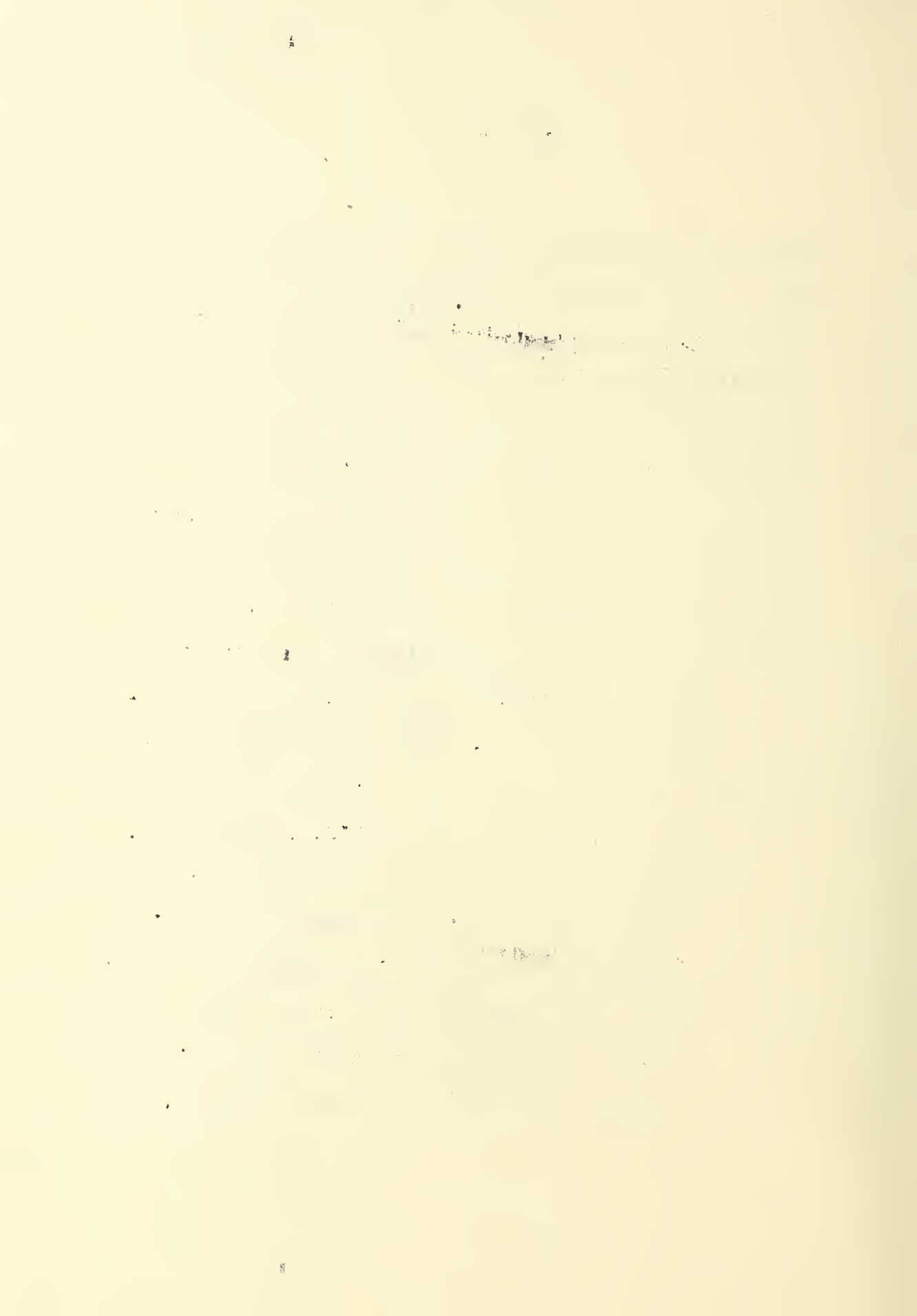
Linear Shrinkage

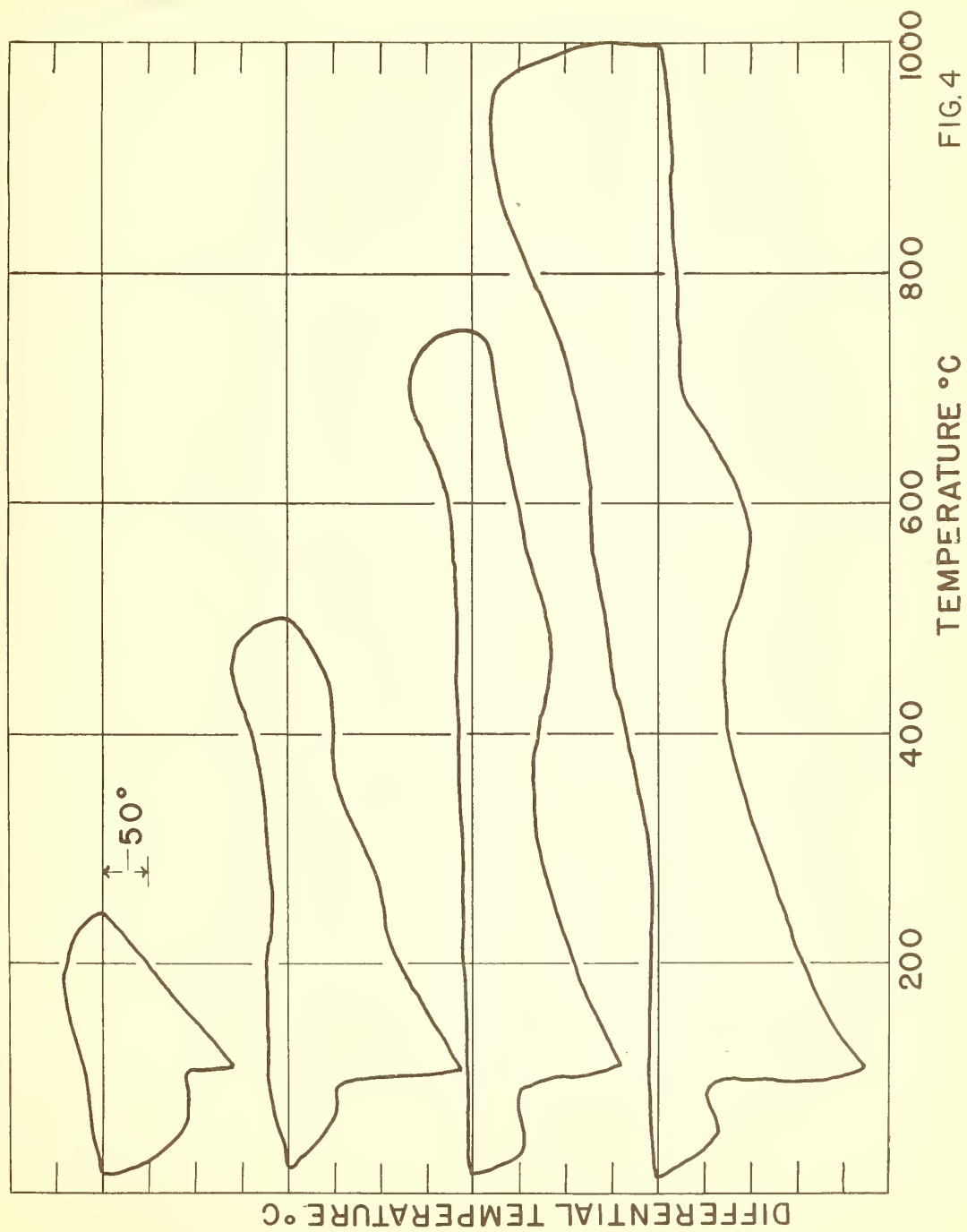
The linear shrinkage (table 5) after heating at the several temperatures was quite high for the concretes containing pumice aggregate, whereas with the concretes containing any one of the other four aggregates it was considerably less and in some instances a slight expansion occurred after heating at 1,000°C.

Differential Thermal Analysis

Specimens of the concretes were heat treated in a furnace the temperature of which was increased at the rate of 50°C per hour. In order to determine the length of time necessary to reach temperature equilibrium throughout the 12 x 6 inch cylinders a thermocouple was

placed in the center of a cylinder of each concrete and a second attached to the outside and directly opposite the first couple. From the recorded temperatures data was available for determining differential thermal analysis curves. The conventional method of making such determinations is described by Norton.^{9/} Figures 4, 5 and 6 show thermal curves for four specimens of three concretes designed using the three cements, portland, portland pozzolan, and Lumnite, respectively, with Waylite as the aggregate. All specimens were cured for twenty-eight days before heating. One of each of the four specimens of each concrete was heated at the following temperatures 250, 500, 750 and 1000°C, respectively. The thermal reactions of the three concretes are quite similar. The first inflection, between 50 and 75°C is due to temperature lag. The inverted peak at 100°C is due mostly to the evaporation of free water. The slight inflection occurring between 550 and 650°C indicates the decomposition of calcium hydroxide. This





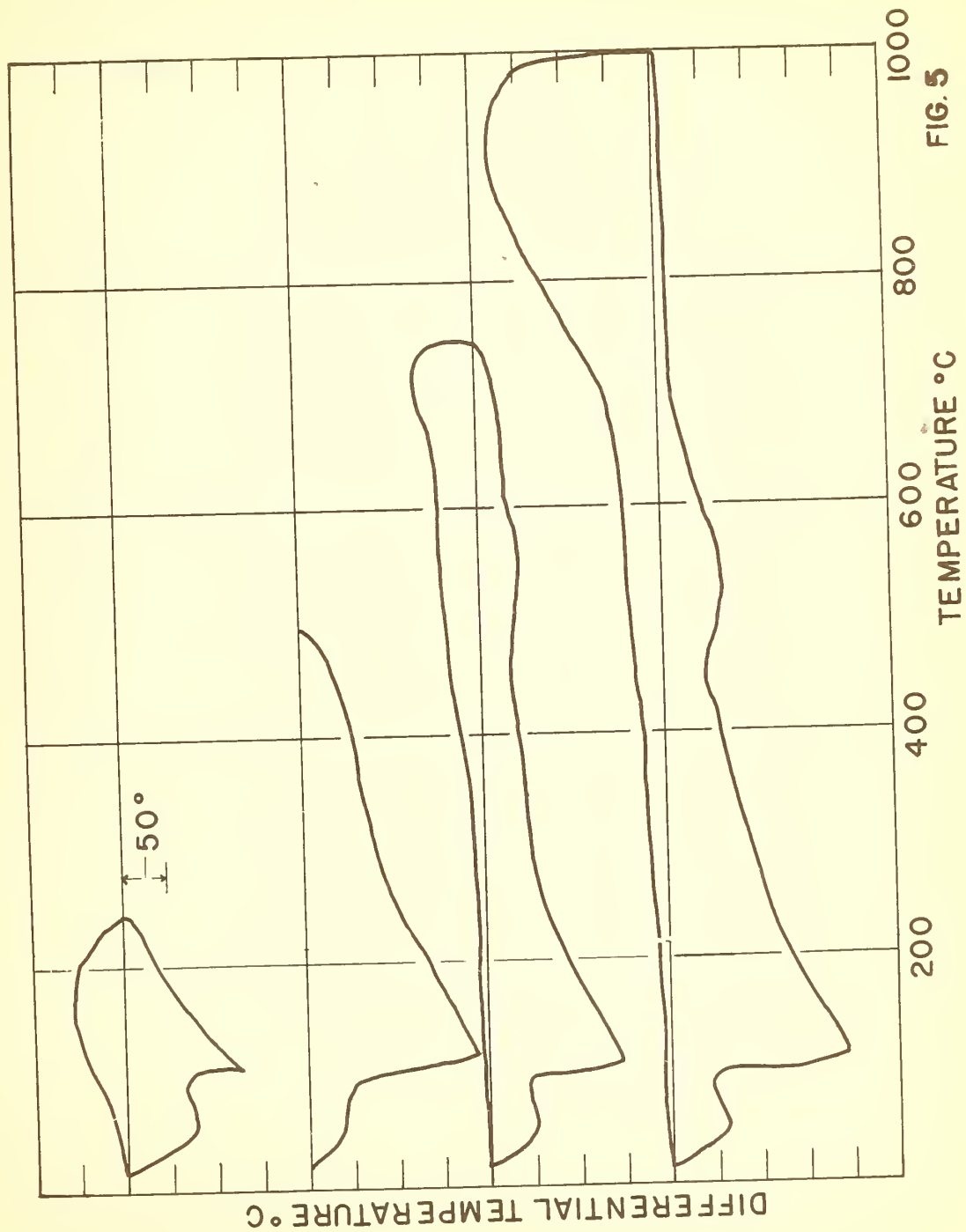
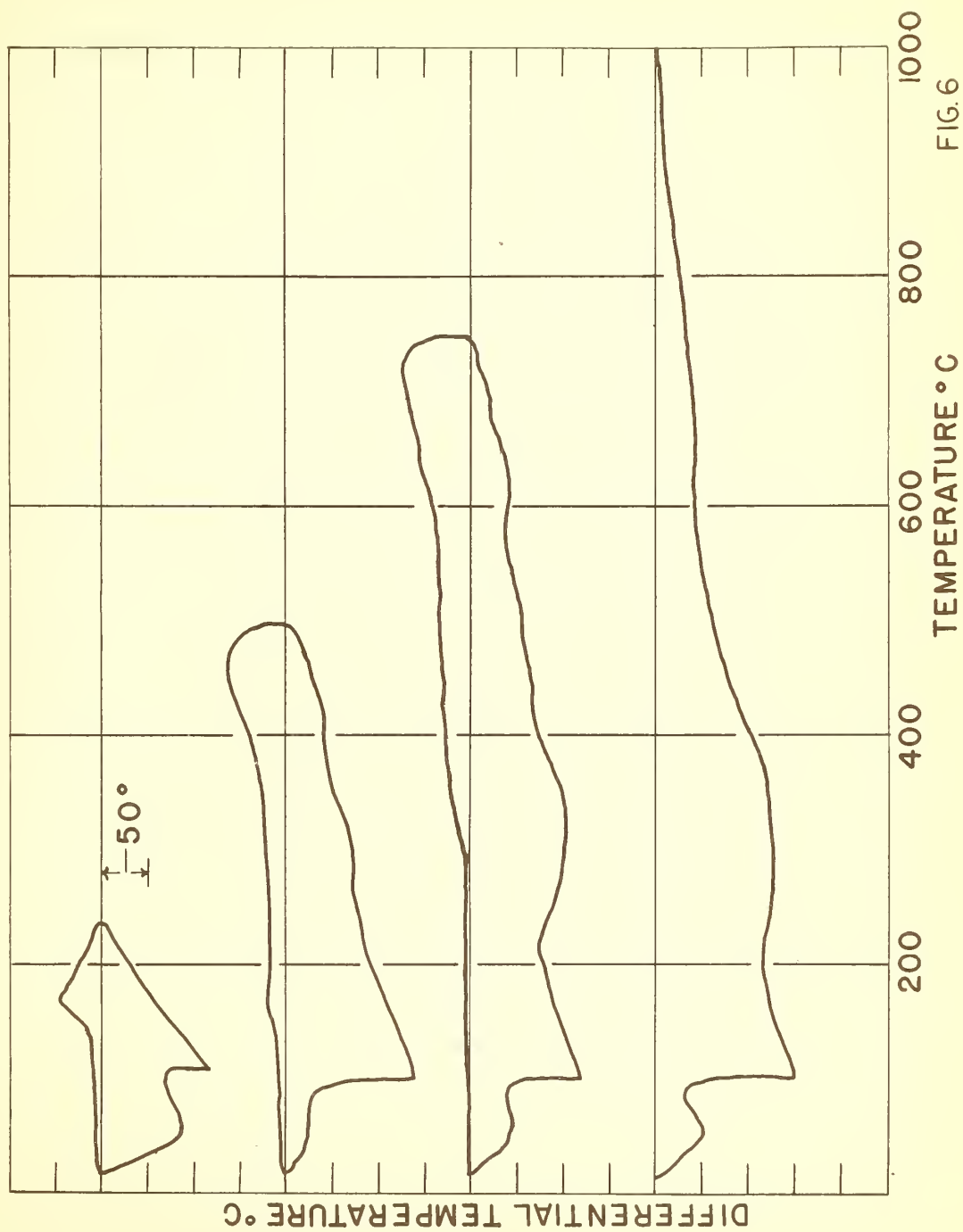


FIG. 5



bulge is more noticeable in figures 4 and 5, the curves for the portland and portland pozzolan concretes. This might be expected since these cements contain nearly twice the amount of calcium oxide present in Lumnite cement. All reactions occur at a slightly lower temperature than was reported by Kalousek, Davis and Schmertz.^{10/} A survey of the literature discloses very little published data on the thermal analysis of concretes. For this reason it is included in this report.

V. CONCLUSIONS

As yet insufficient results have been made available to justify any extended conclusions. It may be definitely stated, however, that concretes containing pumice aggregate could not be considered suitable for warm up aprons for jet planes. These concretes not only had low compressive strength after a twenty-eight day curing period but readily disintegrated on heating at elevated temperatures. Although considerable data has already been accumulated the work has not progressed to a point where a definite type of concrete can be

recommended for use in rigid pavements for general ground circulation of jet-type aircraft, for warm up, power check, or take off operations.

-
- 1/ Lightweight Aggregate Concrete, issued August 1949.
 - 2/ Standard Method of test for "Pyrometric Cone Equivalent (PCE) of Refractory Materials" ASTM Designation C24-46 Manual of ASTM Standards on Refractory Materials February 1952.
 - 3/ "Properties of Concrete made with Typical Light Weight Aggregates," Materials Laboratory Report No. C-385 June 8, 1948.
 - 4/ "A Portable Apparatus for Determining the Relative Wear Resistance of Concrete Floors", National Bureau of Standards R.P. 1252, 549.
 - 5/ "ASTM Standards on Mineral Aggregates, Concretes, and Nonbituminous Highway Materials", Sept. 1948.
Compressive Strength of Molded Concrete Cylinders, page 90.
Weight per Cubic Foot, Yield, and Air Content (Gravimetric) of Concrete, page 121.
Slump Test for Consistency of Portland Cement Concrete, page 115.
 - 6/ Proceedings of ASTM Vol. 45, 846 (1945).
 - 7/ Extending Application of the Fineness Modulus. Journal of the American Concrete Institute, Part 2, Dec. 1947 Proceedings V. 43.
 - 8/ "Air Replaces Sand in 'No-Fines' Concrete," Journal of the American Concrete Institute No. 10 (1951).
 - 9/ Critical Study of Differential Thermal Analysis Method for Identification of Clay Minerals. Journal of the American Ceramic Society Vol. 22, 1939, page 693.
 - 10/ An Investigation of Hydrating Cements and Related Hydrous Solids by Differential Thermal Analysis. Journal of the American Concrete Institute, Vol. 20, 1949, page 693.

THE NATIONAL BUREAU OF STANDARDS

Functions and Activities

The functions of the National Bureau of Standards are set forth in the Act of Congress, March 3, 1901, as amended by Congress in Public Law 619, 1950. These include the development and maintenance of the national standards of measurement and the provision of means and methods for making measurements consistent with these standards; the determination of physical constants and properties of materials; the development of methods and instruments for testing materials, devices, and structures; advisory services to Government Agencies on scientific and technical problems; invention and development of devices to serve special needs of the Government; and the development of standard practices, codes, and specifications. The work includes basic and applied research, development, engineering, instrumentation, testing, evaluation, calibration services and various consultation and information services. A major portion of the Bureau's work is performed for other Government Agencies, particularly the Department of Defense and the Atomic Energy Commission. The scope of activities is suggested by the listing of divisions and sections on the inside of the front cover.

Reports and Publications

The results of the Bureau's work take the form of either actual equipment and devices or published papers and reports. Reports are issued to the sponsoring agency of a particular project or program. Published papers appear either in the Bureau's own series of publications or in the journals of professional and scientific societies. The Bureau itself publishes three monthly periodicals, available from the Government Printing Office: The Journal of Research, which presents complete papers reporting technical investigations; the Technical News Bulletin, which presents summary and preliminary reports on work in progress; and Basic Radio Propagation Predictions, which provides data for determining the best frequencies to use for radio communications throughout the world. There are also five series of nonperiodical publications: The Applied Mathematics Series, Circulars, Handbooks, Building Materials and Structures Reports, and Miscellaneous Publications.

Information on the Bureau's publications can be found in NBS Circular 460, Publications of the National Bureau of Standards (\$1.00). Information on calibration services and fees can be found in NBS Circular 483, Testing by the National Bureau of Standards (25 cents). Both are available from the Government Printing Office. Inquiries regarding the Bureau's reports and publications should be addressed to the Office of Scientific Publications, National Bureau of Standards, Washington 25, D. C.

