Index

Α

"A plus" ordering option, 45 accelerating admixtures (Type C), 35-36 acceptance criteria, strength testing, 171-178 accuracy meter, 114 scale, 84-88, 89-90 ACI 211.1, 6 (table), 43, 45, 48, 74 ACI 211.2, 6 (table), 48 ACI 214R-11, 151 ACI 225R-99, 19 ACI 228.1R-03, 155 ACI 301, 2, 6 (table), 47, 77, 156. See also ACI 301-10 ACI 301-10, 2, 28, 50, 53, 145. See also ACI 301 ACI 305R, 6 (table) ACI 306R, 6 (table), 115 ACI 318 Building Code, 154, 155, 157, 171 ACI 318, 6 (table), 49, 54, 77, 132. See also ACI 318-11 ACI 318-11, 2, 44, 145, 146, 152, 154, 155, 156, 157, 171, 174. See also ACI 318 ACI 350, 53. See also ACI 350-06 ACI 350-06, 44, 145. See also ACI 350 ACI Concrete Laboratory Testing Technician-Grade I, 150 added water, 88, 125. See also water admixture dispenser on weight basis, 79 (figure) admixtures, 24, 35-37 air-entrained, 25, 34-35, 104, 167 chemical, 35-37, 43, 74, 76-78 fiber, 76 liquid, 77-78 mineral, 24, 69, 126-127 purchaser specifications, 51-52 See also specific admixtures aggregate feed system, 82-83 aggregates, 27-29 alkali-reactive, 19, 28 batch tickets and, 127-128 in cold weather, 116

mass, 72, 82-83 measurement and, 72-73 proportioning, 45 reactivity evaluation, 28 storage, 81-84 See also course aggregates; lightweight aggregates agitators, 91, 93, 94-95, 97-99 air content, 11 check test, 147-148 losses, 64-65 point of discharge and, 44 (table) test methods and, 133-135 test reports and, 50 tests, 61-62, 64-65, 67 tolerance and, 63-67 uniformity tests and, 167 values, 62-63 air content tests, 61-62, 64-65, 67, 147-148 air detrainer, 37 air entrainment, 23. See also air-entrained admixtures (AEA); air-entrained concrete air-dry mass, 47 air-entrained admixtures (AEA), 34-35 fly ash and, 25 mixing time, 104 uniformity tests and, 167 air-entrained concrete, 43-45, 61-67, 175 air-entrained portland cement, 21 air-free mortar, 168-169 air proportions, 18 (figure) alkali oxide, 19 alkali-reactive aggregate, 19 alkali-silica reactivity (ASR) requirements, 2 alumina (Al₂O₂), 18 American Association of State Highway and Transportation Officials (AASHTO), 19 Annex A1, 122, 165-170 anti-washout admixtures, 37

arbitration, low strength test and, 159-161 architect/engineer (A/E) firms, 53, 63. See also purchaser architectural concrete, 43 asphalt production, 81 ASTM C29/C29M, 12, 13 ASTM C31/C31M, 5 (table), 48, 131, 149, 152 ASTM C33/C33M, 2, 5 (table), 19, 27, 29, 50 ASTM C39/C39M, 5 (table), 132, 151, 154 ASTM C42/C42M, 155 ASTM C70, 127 ASTM C78/C78M, 153 ASTM C88, 28 ASTM C125, 5 (table) ASTM C138/C138M, 5 (table), 11, 12, 13, 15, 46, 47, 66, 132-134, 149, 167, 611 ASTM C143/C143M, 5 (table), 55, 56, 135, 149 ASTM C150/C150M, 5 (table), 17, 19-21, 50, 51, 69, 71-72 ASTM C172/C172M, 5 (table), 12-13, 64, 108, 136-137, 143-144, 146, 149, 167 ASTM C173/C173M, 5 (table), 61, 149 ASTM C219, 18 ASTM C231/C231M, 5 (table), 12, 13, 61, 65, 133-134, 135 (figure), 149 ASTM C260/C260M, 5 (table), 34-35, 50, 52 ASTM C293/C293M, 153 ASTM C330/C330M, 5 (table), 50 ASTM C457/457M, 65 ASTM C494/C494M, 5 (table), 50, 52 ASTM C566, 127 ASTM C567/C567M, 6 (table), 45-47 ASTM C595/C595M, 6 (table), 20, 21-23, 24, 26, 50, 69 ASTM C617/C617M, 132 ASTM C618, 6 (table), 24-26, 50, 69, 126 ASTM C637, 29 ASTM C637, 6 (table) ASTM C666/C666M, 28, 64-65 ASTM C685/685M, 15, 69, 81 ASTM C917, 50 ASTM C989/C989M, 6 (table), 26, 50, 69, 126 ASTM C1017/C1017M, 6 (table), 50, 52 ASTM C1064/C1064M, 6 (table), 137, 149 ASTM C1074, 132 ASTM C1077, 6 (table), 137-138, 142 ASTM C1157/C1157M, 2, 6 (table), 20, 21, 23, 24, 26, 50, 69 ASTM C1231/C1231M, 132 ASTM C1240, 6 (table), 27, 50, 69, 126 ASTM C1260, 28 ASTM C1293, 28 ASTM C1602/C1602M, 6 (table), 29-34, 47, 74 ASTM C1603, 32 ASTM C1610/C1610M, 42, 43

ASTM C1611/C1611M, 6 (table), 42, 43, 56, 135–136 ASTM C1621/C1621M, 43 ASTM C1697, 27 ASTM D75/D75M, 28 ASTM Subcommittee C09.40, 112, 160–161 Automated Slump Adjustment System (ASAS), 111–115 automated slump flow monitoring, 113–115 automated water measurement, 125

В

bacteriocidal admixtures, 37 bags, chemical admixture, 76 bags, as measurement, 71–72 basis of purchase, 11-15 batch characteristics, 167 batch persons, 84 batch plant, 82 certification, 165 processes of, 82-83, 83 (figure) refinements, 8 (table) scale accuracy and, 84-88, 89-90 water and, 88-89 batch tickets, 123-128, 124 (figure) strength tests and, 152-153 See also delivery ticket batching, 73 accuracy limit, 72 process, 81 82 (figure) instruments, 82-83 sequence, 98 silica fume and, 27 tolerance, 11, 70, 76 water and, 30-31 See also scale; specific considerations; specific hoppers beam and poise weighing system, 87 (figure) beams, 150, 151 bench scales, 77 (figure) bicalcium aluminate (C_2A), 18 bin, 81 bituminous coal, 25 blade wear, 97-98, 99 blades, 92-93, 95, 97, 98 (figure) blended hydraulic cements, 21-23 brand names, 126 build-up, drum, 97-98, 99 burden on the purchaser, 115-116 burns, 3-4

С

calcinated clay, 26 calcinating, 23

calcium-aluminate cements, 37 calcium carbonate, 37 calcium chloride (CaCl₂), 37, 118. See also flaked calcium chloride (CaCl₂) calcium oxide (CaO), 18 calcium silicate hydrate, 24 calcium sulfate (CaSO₄), 18 calculation of yield, 12, 13 calibrated volumetric tanks, 89 cellulose fibers, 37 cement, 19-24, 51, 52. See also specific types cement balls, 98 central-mix plant, 92, 94, 95, 104. See also stationary mixer central-mixed concrete, 7 certification requirement, strength, 149 certification tests, 49-50 charging hopper, 98 chemical admixtures, 35-37 measurement, 76-78 mixing water in, 74 in self-consolidating concrete (SCC), 43 chert limitations, 28 chlorine limits, 32 clinker grinding process, 18-19 coal, 25. See also fly ash code requirements, 1. See also specific requirements coefficient of variation, strength testing, 156 cold weather conditions, 9 (figure), 115-116, 118, 138 coloring admixtures, 37 combined water, 30 communication with dispatch, 53-54 compartment, 81 completion of discharge, 111 composition, typical, 18 (figure) comprehensive strength tests, 149, 151, 169, 171-174, 175 (table), 176 (table). See also strength tests compression tests, 131-132 compressive strength tests, 50 computerized batch tickets, 110 computerized batching control system, 83, 156-157 concrete manufacturing facility. See batch plant Concrete Plant Manufacturers Bureau (CPMB), 70, 72, 89-90,92 Concrete Strength Testing Technician Certification, 150 concrete. See aggregates; admixtures; specific components; specific practices tests; specific types; water concrete, central-mixed, 7 concrete, ready-mixed, 7 concrete, shrink-mixed, 7-8, 106 concrete strength. See strength

concrete, truck-mixed, 8, 106-109 constructability, 48, 56 construction cement, general, 19 continuous mixing, 81 contractor, 3 contractor requirements, 141-142 core strength, 154-155 corrosion-inhibiting admixtures, 37 corrosion, reinforced steel, 32 cost. See price course aggregate, 27–28 content, 166-67, 168, 168 (figure) size, 41 in transit water addition, 57 cumulative aggregate batches, 73 curing, 48, 131-132, 138, 152 cylinders, 132, 149-150, 151 test reports and, 50 weather conditions and, 138

D

decumulative batcher, 83 delivery ticket, 52-54. See also batch ticket density (unit weight), 12 (figure), 12-13, 14, 15, 45-47 air content and, 66 relative, 52 test methods and, 132-133 uniformity tests and, 167, 168 See also density tests density tests, 47 (table) dial-head scale indicator, 83 discharge air content and, 44 (table), 63 completion of, 111 testing, 141 uniformity, 96-97 water addition and, 57, 58-59 discrepancies in yield, 11 division of responsibility, 45 documentation mixture proportions, 49, 53-54 nonmandatory, 174 See also batch ticket; delivery ticket dosages, admixture, 52 drum, 92-94, 94 (figure), 98 (figure), 98-99. See also blades; drum revolutions drum revolutions, 106, 111 dry mass, 49 durability, 48 air content and, 64 requirements, 41, 44, 53

Е

engineers, arbitration panel of, 159–160 entrapped air, 62. *See also* air-entrained concrete equilibrium density, 46 equipment, 91 automatic monitoring, 112–115 nonagitating, 102, 121–122 uniformity tests and, 96–97 *See also* agitators; blades; cylinders; drum; hopper; mixers; scale

F

fiber admixtures, 76 fiber reinforcement, 127 field curing, 48, 152 fine aggregate, 27 flaked calcium chloride (CaCl₂), 76–77 flexural strength tests, 149, 151, 153 flowable fill, 37 flowing concrete, 36 fluidity, 55. See also slump test fly ash, 25, 126 foaming agents, 37 freeze-thaw resistance, 43, 44. See also air-entrained concrete; freeze-thaw tests freeze thaw tests, 64 frequency, strength testing and, 152, 172 -173, 173 (figure) frequency, testing, 145-146 freshly mixed, 11 front discharge drum, 91, 92 (figure)

G

general construction, 19–20, 22–23 general construction cement, 19 general purpose cement, 19, 24 glass fibers, 37 grade of slag, 126 grading, aggregate, 52 gray water, 33, 34 (figure) ground granulated blast furnace slag (GGBFS), 26 gypsum, 18, 32

н

head pack, 98 head water, 98 high early strength cement, 20, 24 high sulfate resistant portland cement, 20–21, 24 hopper, batch, 69 hopper, charging, 98 hopper, weigh, 70, 81, 83 hot weather conditions, 10 (figure), 116–118, 138 hydration, 18, 24. *See also* mixing water; water hydration-control (stabilizer) admixtures, 37 hydraulic cement, 17–24, 69–71, 78

I

ice, 74, 75 ID designation, 125 individual batcher, 73 initial water, 98 inspection of mixers and agitators, 97–99 plant, 129–130 water addition, 110 inspector, 144. *See also* inspection International System of Units (SI), 3 in-transit water addition, 57–58

J

job waste, 11 job-site water addition, 57, 58–59, 109–112, 125

Κ

kaolinite, 18, 26 knowledgeable professional, 48–49. *See also* engineers; operator; technician

L

labcrete submittals, 50 lawyers, 160 length-diameter ratio (L/D), 155 lightweight aggregates, 28-29, 49 lightweight concrete density and, 143 mass per unit volume, 45-47, 47 (table) lignite, 25 limestone, 18, 23. See also cement limits of liability, 123 liquid admixture, 77-78 lithium-based additives, 37 load-cell scale system, 70 (figure) load-to-load variations, 57 low heat of hydration cement, 20, 24 low reactivity with alkali reactive aggregates, 24 low strength tests, 156, 159

Μ

magnetic meters, 75 maintenance, mixer, 107 manufacturer, 3 manufacturer responsibility limitations of, 2 mixture proportions and, 47–48 plant inspection and, 129–130

proportions and, 52-53 purchaser specifications and, 52-53 quality and, 141 slump and, 59-60 mass, 11-12 aggregates and, 72, 82-83, 127-128 batching materials and, 69-70 per cubic foot, 132-134 per unit volume, 45-47, 132-134 material batching, tolerance and, 70-71, 72-73, 76 material tests, 49-50 materials aggregates, 27-29. See also aggregates air-entraining admixtures, 34-35. See also air-entraining admixtures cementious, 17, 18 (figure) chemical admixtures, 35-37 hydraulic cement, 17-24, 69-71, 78 manufacturer liberties and, 47-48 measuring, 69-79 supplementary, 24-27 water, 29-34, 31 (table), 34 (figure), 34 (table). See also water maximum aggregate size, 29 maximum allowable water content, 51 mean, strength testing, 156 measuring materials, 69-79 metakoalin, 26 metered water, 75, 127 meters, 134-135. See also specific meters mild exposure, 43 mineral admixtures, 24, 69, 126–127. See also admixtures; supplementary cementitious material (SCM) minimum cement content, 51, 52-53 minimum field standards weights and test loads, 85 (table), 87 mixer performance tests, 95-96, 104-106 mixers mass determination and, 97-99 slurry, 8 stationary, 91-92, 95-96, 167. See also stationary mixer truck, 91, 92-94, 95-96, 108-109, 112-115, 167. See also truck mixer uniformity tests and, 165-166 water and, 57-58, 75-76 mixing revolutions, 106 mixing time, 102-104, 106 mixing trucks: water and, 75-76 mixing uniformity, 95-97 Mixing uniformity tests, 165-166 mixing water, 29-31, 33, 73-76 batch tickets and, 127, 128 in-transit, 57

measurement, 88–89 See also water mixture proportions, 45 documentation, 49 manufacturer responsibility, 52–53 purchaser responsibility, 50– 51 moderate exposure, 43 moderate heat of hydration and moderate sulfate resistance cement, 20, 24 moderate sulfate resistance, 19, 24 mortar unit weight, 168

Ν

name, admixture specification, 52 National Institute of Standards and Technology (NIST), 5 National Ready Mixed Concrete Association (NRMCA), 89, 92, 96, 98 National Ready Mixed Concrete Association (NRMCA) CIP-9, 161 National Ready Mixed Concrete Association (NRMCA) CIP-10, 161 NIST Handbook 105-1, 6 (table), 86 NIST Handbook 44, 85 nominal maximum aggregate size, 29, 41-42 nominal slump, 58 nonagitating delivery, 121-122 non-potable water, 30, 31, 33, 47 normal distribution curve, strength test, 173 (figure) notes, 3 NRMCA Plant Certification, 84-85, 121, 165 NRMCA Plant Certification Checklist, 130 NRMCA Publication 133, 154 NRMCA Publication 159, 13

0

one-time water addition, 110-111, 112 open-top containers, 121 operations, 156-157 operator, 84 Option A. See ordering Option A Option B. See ordering Option B Option C. See ordering Option C optional requirements, 20-21 ordering information, 41-54, 46 (table) ordering Option A, 41, 45 ordering Option "A plus," 45 ordering Option B, 41, 45, 50 ordering Option C, 41, 45, 52-54 ordering option differences, 52, 53. See also specific ordering options oven-dry density, 46 oven-dry mass, 47

over-design, 175, 176–178 (table) over-under indicator, 87 (figure), 88 Ozyildirim, 65

Ρ

parts per million (ppm), 34 performance requirements, 19 plant certification, 165 plant inspection, 129-130 Plant Inspector Guide, 130 plasticizing admixture, 36 platform scales, 77 (figure) point of discharge. See discharge polymer modifiers, 37 polypropylene fibers, 37 portland blast-furnace slag cement, 22 Portland cement, 17-18. See also hydraulic cement Portland-cement clinker, 18 portland limestone cement, 23 portland-pozzolan cement, 22-23 potable water, 30, 47 powdered admixtures, 76 pozzolan, 22, 23, 24, 25-27, 126 practice, 5 compression tests and, 131-132 performance accepting tests and, 137-138 See also specific practices precision, air content testing, 61-62 precision statement, 151 preconstruction conference, 2 preliminary sample, air content, 67 prescriptive requirements, 19 pressure air-meter measuring bowl (base), 167 price low strength test arbitration and, 160 purchaser approved changes, 117 producer, 3 pumping aids, 37 pumping process specifications, 66 purchase order requirements, 1-2 purchaser, 3. See also purchaser liberties; purchaser responsibility; purchaser specifications purchaser liberties, 2, 49 purchaser responsibility, 2, 48-49 cold weather and, 115-116 proportioning and, 50-51 slump and, 59-60 slump flow and, 58-59 test reports and, 54 water content and, 51 See also purchaser specifications

purchaser specifications, 41–47, 47–48 admixtures and, 51–52 air content and, 62–63 compressive strength and, 48 *See also* purchaser responsibility

Q

quality assurance testing, 54 quality control (QC), 28, 130 quality portion, 2 quantity, specific vs. minimum, 51

R

ready-mixed concrete, 7 rear discharge drums, 91, 92 (figure) reasonable access, 129, 141–142 reclaimer units, 33, 34 (figure) reference documents, 5–6 (table) relative density, aggregate, 52 relative yield, 13 required average strength, 174 responsibility chain, 2 responsibility groups, 45. *See also* manufacturer responsibility; purchaser responsibility retarding admixtures (Type B), 35, 36 ribbon-loading batching sequence, 98 rice-husk ash, 26 runoff water, 33–34

S

safety issues, 3-4 sampling, 133-134 air content and, 64 of fresh concrete, 136-137 stationary mixers and, 129 strength tests and, 149 techniques, 2, 142 test methods and, 136 truck mixers and, 108-109 uniformity tests and, 104-105, 108-109, 165-166 sand, 18 (figure) saturated-surface-dry mass, 49 scale, 70 (figure), 77 (figure), 83 accuracy, 83, 84-88, 89-90 test procedures, 83-87 See also scale accuracy scale lever system, 70 (figure) seasonal variations, 11. See also weather conditions segregation, 42, 121 selection, cement, 20 self-consolidating concrete (SCC) admixtures and, 36

slump and, 55, 59 slump flow and, 42-43, 135-136 settling basin, 33, 33 (figure) 7-day comprehensive strength, 169 severe exposure, 43-44 shale, 26 shrinkage-compensating expansive cements, 37 shrink-mixed concrete, 7-8, 106 silica (SiO₂), 18, 19 silica fume, 27, 126 size of course aggregate, 41-42 skin protection, 3-4 slag, 22, 23, 26, 126 slag cement, 26-27 slump cone, 135 (figure) slump flow, 42-43, 58-59, 113-115 requirements, 58-59 test methods and, 142-143 See also slump flow test; slump, tolerance slump flow test, 55-56, 144-147. See also automated slump flow monitoring slump meters, 113 slump responsibility, 60 slump tests, 55, 144-147, 167 batch uniformity and, 96-97 nonagitating delivery and, 122 test methods and, 135-136 slump tolerance. See slump: tolerance slump, 42 changes, 36 (table) losses, 57, 59, 110 measurement, 56 (figure) responsibility, 59-60 test methods and, 135-136 test reports and, 50 target, 58 tolerance, 56-57, 58-59 uniformity tests and, 167 water addition and, 109-110 See also job-site water addition. See also slump flow; slump flow test; slump test slurry mixer, 8 slurry water (high solids content), 34 sodium oxide (Na₂O₂), 19, 32 solid limits, water, 32-33 source, aggregate, 52 special admixtures (Type S), 36 specification, 1, 2, 27. See also specific types specification alteration, 2, 27 specified comprehensive strength, 48 specified minimum air content, 67 spillage, 14

standard deviation, strength testing, 156, 172, 173-174, 174-175 standard weights, 84 stationary mixer, 91-92, 95-96, 102, 103 (table) performance tests and, 104-105, 108-109 sampling and, 129 steel fibers, 37 storm runoff water, 33 strain-load test, 86-87 strength, 55. See also strength requirements; strength tests strength requirements, 153-157 failure to meet, 159-161 required average, 174-178, 175 (table), 176 (table) strength tests, 2, 50, 149-150 acceptance criteria, 153-157, 171-178 calculations, 171, 149, 151, 169, 171-174, 175 (table), 176 (table). See also over-design comprehensive, 149, 151, 169, 171-174, 175 (table), 176 (table) evaluation of, 151-152 field-curing and, 152 frequency, 152 low, 156, 159 See also strength requirements strike-off procedure, 133 sub-bituminous coal, 25 substitution load, 86 supplementary cementitious materials (SCM), 24, 69. See also mineral admixtures surface texture requirements, 48

Т

target slump, 58 technicians, 142-143, 149, 150 temperature hydration reactions and, 59 test methods and, 137 tests, 50, 144-145 terminology, 1, 7-8 test cylinders. See cylinders test load, 86 test method, 5, 28 air content and, 133-135 density and, 132-133 reporting requirements and, 138 sampling and, 136 slump and, 135-136 temperature and, 137 See also specific test methods test reports, 54 test values, 95 testing procedures, 141-161. See also air content tests; certification tests; comprehensive strength test; density tests; materials

tests; mixer performance tests; scale; quality assurance tests; slump flow tests; slump tests; strength tests; test reports; uniformity tests time of set, 118 tolerance for aggregates and air content, 63-67 batching and, 11, 70 for chemical admixtures, 76 for mixing materials, 70-71, 72 slump, 56-57, 58-59 water meter and, 75 total mass (weight), 12 total mixing water, 88 transportation, 109. See also mixers transportation unit, 63. See also mixing trucks tricalcium aluminate (C₃A), 18 Truck Mixer Manufacturers Bureau (TMMB), 92, 93, 94 (figure), 95, 107 truck mixer wash out and settling basin, 33 (figure) truck mixer, 75-76, 91, 92-94, 95-96 automated water measurement, 112-115 batch characteristics and, 167 sampling and, 108-109 water and, 57-58, 75-76 truck time, 112 truck-mixed concrete, 8, 106-109 Type A meter, 134 Type B meter, 134-135, 135 (figure) type, admixture, 52

υ

Uniform Arbitration Act, 160 uniformity requirements, 165–170, 166 (table) uniformity tests, 95–97 mixers and, 165–166 stationary mixers and, 104–105, 108–109 *See also* uniformity requirements uniformity. *See* mixing uniformity; uniformity requirements; uniformity tests

V

variability, testing component, 172 variance, strength testing, 156 variation, with-in test coefficient, 152 vibration, effect on air content, 65 (table) Virginia Department of Transportation (VDOT), 65 viscosity, 42, 136 viscosity-modifying admixtures, 37 visual monitoring, batch, 84 Visual Stability Index (VSI), 136 volcanic tuff (ash), 25 volume loss, 14 volume purchase, 11 volumetric admixture dispenser, 79 (figure) volumetric batching, 81

W

wash water, 30, 31, 32-33, 34, 34 (table) wash water slurries, 34 washout pits, 31, 32, 33 (figure) waste, 14 water, 18 (figure), 29-34, 31 (table), 34 (figure), 34 (table), 47 added, 88, 124 additives and slump, 57-59 batching uniformity and, 96 chemical admixture and, 74 hot, 116 job-site additions, 109-112 maximum allowable content of, 51 See also ice; mixing water; specific types water-cementitious materials (w/cm) ratio, 49, 51 water content, proportional to slump, 55 water from concrete production operations, 30 water losses, 14 water measuring system, 75 water meter, 75, 114 water per cubic measurement, 49 water reducer admixtures (Type A), 36, 78 water repellant admixtures, 37 weather conditions, 8, 8 (table), 9 (figure) aggregates and, 28 air content and, 43-44 cold, 9 (figure), 115-116, 118, 138 hot, 10 (figure), 116-118, 138 weigh hopper, 70, 81, 83 weigh-on-the-belt configuration, 83 weighted water, 75, 127 wet mass, 47

Y

yield, 13, 13 (figure) calculation, 12, 13 discrepancy of, 13–14 per cubic foot, 132–134