Contents

Preface to the Fifth Edition xv
Preface xvii
Acknowledgements xx

1 Portland cement **1**

Historical note 1
Manufacture of Portland cement 2
Chemical composition of Portland cement 8
Hydration of cement 13
  Calcium silicate hydrates 14
  Tricalcium aluminate hydrate and the action of gypsum 17
Setting 19
  False set 20
Fineness of cement 20
Structure of hydrated cement 25
Volume of products of hydration 26
  Capillary pores 31
  Gel pores 32
Mechanical strength of cement gel 34
Water held in hydrated cement paste 35
Heat of hydration of cement 37
Influence of the compound composition on properties of cement 41
  Effects of alkalis 46
  Effects of glass in clinker 48
Tests on properties of cement 49
  Consistency of standard paste 49
  Setting time 49
  Soundness 51
  Strength of cement 53
References 56

2 Cementitious materials of different types **62**

Categorization of cementitious materials 62
Different cements 65
Ordinary Portland cement 69

	Rapid-hardening Portland cement	71
	Special very rapid-hardening Portland cements	72
	Low heat Portland cement	75
	Sulfate-resisting cement	76
	White cement and pigments	77
	Portland blastfurnace cement	79
	Supersulfated cement	81
	Pozzolanas	83
	Fly ash	84
	Pozzolanic cements	86
	Silica fume	86
	Fillers	88
	Other cements	88
	Which cement to use	90
	High-alumina cement	91
	Manufacture	91
	Composition and hydration	92
	Resistance to chemical attack	92
	Physical properties of high-alumina cement	93
	Conversion of high-alumina cement	95
	Refractory properties of high-alumina cement	102
	References	103
3	**Properties of aggregate**	**108**
	General classification of aggregates	108
	Classification of natural aggregates	109
	Sampling	111
	Particle shape and texture	112
	Bond of aggregate	118
	Strength of aggregate	119
	Other mechanical properties of aggregate	123
	Specific gravity	125
	Bulk density	127
	Porosity and absorption of aggregate	128
	Moisture content of aggregate	132
	Bulking of fine aggregate	134
	Deleterious substances in aggregate	136
	Organic impurities	136
	Clay and other fine material	137
	Salt contamination	139
	Unsound particles	140
	Soundness of aggregate	142
	Alkali–silica reaction	144
	Tests for aggregate reactivity	145
	Alkali–carbonate reaction	147
	Thermal properties of aggregate	148

Sieve analysis 149
Grading curves 154
Fineness modulus 154
Grading requirements 155
Practical gradings 163
Grading of fine and coarse aggregates 166
Oversize and undersize 170
Gap-graded aggregate 171
Maximum aggregate size 174
Use of 'plums' 175
Handling of aggregate 175
Special aggregates 176
Recycled concrete aggregate 176
References 178

4 Fresh concrete 183

Quality of mixing water 183
Density of fresh concrete 186
Definition of workability 186
The need for sufficient workability 187
Factors affecting workability 188
Measurement of workability 191
Slump test 191
Compacting factor test 193
ASTM flow test 194
Remoulding test 195
Vebe test 196
Flow table test 197
Ball penetration test and compactability test 197
Nasser's K-tester 199
Two-point test 199
Comparison of tests 200
Stiffening time of concrete 203
Effect of time and temperature on workability 203
Segregation 205
Bleeding 207
The mixing of concrete 209
Concrete mixers 209
Uniformity of mixing 211
Mixing time 213
Hand mixing 216
Ready-mixed concrete 216
Retempering 217
Pumped concrete 219
Concrete pumps 219
Use of pumping 220

Requirements for pumped concrete 221
Pumping lightweight aggregate concrete 225
Shotcrete 225
Underwater concrete 228
Preplaced aggregate concrete 228
Vibration of concrete 230
Internal vibrators 230
External vibrators 231
Vibrating tables 232
Other vibrators 233
Revibration 233
Vacuum-dewatered concrete 234
Permeable formwork 236
Analysis of fresh concrete 236
Self-compacting (self-consolidating) concrete 238
References 238

5 Admixtures 245

Benefits of admixtures 245
Types of admixtures 245
Accelerating admixtures 247
Retarding admixtures 251
Water-reducing admixtures 254
Superplasticizers 257
Nature of superplasticizers 258
Effects of superplasticizers 258
Dosage of superplasticizers 261
Loss of workability 261
Superplasticizer–cement compatibility 263
Use of superplasticizers 264
Special admixtures 265
Waterproofing admixtures 265
Anti-bacterial and similar admixtures 266
Remarks about the use of admixtures 267
References 267

6 Strength of concrete 271

Water/cement ratio 271
Effective water in the mix 275
Gel/space ratio 276
Porosity 279
Cement compacts 286
Influence of properties of coarse aggregate on strength 286
Influence of aggregate/cement ratio on strength 289
Nature of strength of concrete 291

Strength in tension 291
Cracking and failure in compression 293
Failure under multiaxial stress 295
Microcracking 300
Aggregate–cement paste interface 302
Effect of age on strength of concrete 304
Maturity of concrete 306
Relation between compressive and tensile strengths 310
Bond between concrete and reinforcement 313
References 313

7 Further aspects of hardened concrete 320

Curing of concrete 320
Methods of curing 325
Tests on curing compounds 328
Length of curing 329
Autogenous healing 330
Variability of strength of cement 330
Changes in the properties of cement 334
Fatigue strength of concrete 337
Impact strength 345
Electrical properties of concrete 348
Acoustic properties 353
References 355

8 Temperature effects in concrete 361

Influence of early temperature on strength of concrete 361
Steam curing at atmospheric pressure 368
High-pressure steam curing (autoclaving) 372
Other thermal curing methods 375
Thermal properties of concrete 376
Thermal conductivity 376
Thermal diffusivity 379
Specific heat 379
Coefficient of thermal expansion 379
Strength of concrete at high temperatures and resistance to fire 386
Modulus of elasticity at high temperatures 389
Behaviour of concrete in fire 389
Strength of concrete at very low temperatures 392
Mass concrete 395
Concreting in hot weather 399
Concreting in cold weather 402
Concreting operations 404
References 407

9 Elasticity, shrinkage, and creep **413**
Stress–strain relation and modulus of elasticity 413
Expressions for stress–strain curve 418
Expressions for modulus of elasticity 419
Dynamic modulus of elasticity 421
Poisson's ratio 422
Early volume changes 424
Autogenous shrinkage 426
Swelling 426
Drying shrinkage 427
Mechanism of shrinkage 427
Factors influencing shrinkage 430
Influence of curing and storage conditions 436
Prediction of shrinkage 438
Differential shrinkage 439
Shrinkage-induced cracking 442
Moisture movement 443
Carbonation shrinkage 444
Shrinkage compensation by the use of expansive cements 447
Types of expansive cements 447
Shrinkage-compensating concrete 449
Creep of concrete 450
Factors influencing creep 453
Influence of stress and strength 455
Influence of properties of cement 457
Influence of ambient relative humidity 458
Other influences 461
Relation between creep and time 466
Nature of creep 470
Effects of creep 473
References 475

10 Durability of concrete **483**
Causes of inadequate durability 483
Transport of fluids in concrete 484
Influence of the pore system 485
Flow, diffusion, and sorption 485
Coefficient of permeability 486
Diffusion 487
Diffusion coefficient 487
Diffusion through air and water 487
Absorption 488
Surface absorption tests 489
Sorptivity 490
Water permeability of concrete 491
Permeability testing 495
Water penetration test 496

Air and vapour permeability 496
Carbonation 498
Effects of carbonation 499
Rate of carbonation 500
Factors influencing carbonation 502
Carbonation of concrete containing blended cements 504
Measurement of carbonation 505
Further aspects of carbonation 506
Acid attack on concrete 507
Sulfate attack on concrete 509
Thaumasite form of sulfate attack 510
Mechanisms of attack 510
Factors mitigating the attack 512
Tests on sulfate resistance 514
Delayed ettringite formation 515
Efflorescence 515
Effects of sea water on concrete 516
Salt weathering 518
Selection of concrete for exposure to sea water 519
Disruption by alkali–silica reaction 519
Preventive measures 521
Abrasion of concrete 523
Tests for abrasion resistance 523
Factors influencing abrasion resistance 525
Erosion resistance 525
Cavitation resistance 526
Types of cracking 527
References 531

11 Effects of freezing and thawing and of chlorides 539

Action of frost 539
Behaviour of coarse aggregate particles 544
Air entrainment 546
Air-void system characteristics 548
Entrained-air requirements 550
Factors influencing air entrainment 552
Stability of entrained air 554
Air entrainment by microspheres 555
Measurement of air content 556
Tests of resistance of concrete to freezing and thawing 558
Further effects of air entrainment 560
Effects of de-icing agents 563
Chloride attack 565
Mechanism of chloride-induced corrosion 565
Chlorides in the mix 567
Ingress of chlorides 568

Threshold content of chloride ions 571
Binding of chloride ions 571
Influence of blended cements on corrosion 573
Further factors influencing corrosion 573
Thickness of cover to reinforcement 575
Tests for penetrability of concrete to chlorides 576
Stopping corrosion 576
References 577

12 Testing of hardened concrete 583

Tests for strength in compression 583
Cube test 584
Cylinder test 585
Equivalent cube test 586
Effect of end condition of specimen and capping 586
Non-bonded caps 588
Testing of compression specimens 590
Failure of compression specimens 592
Effect of height/diameter ratio on strength of cylinders 593
Comparison of strengths of cubes and cylinders 596
Tests for strength in tension 597
Flexural strength tests 598
Splitting tension test 600
Influence on strength of moisture condition during test 602
Influence of size of specimen on strength 603
Size effects in tensile strength tests 605
Size effects in compressive strength tests 608
Specimen size and aggregate size 611
Test cores 613
Use of small cores 614
Factors influencing strength of cores 614
Relation of core strength to strength in situ 618
Cast-in-place cylinder test 619
Influence of rate of application of load on strength 620
Accelerated-curing test 621
Direct use of accelerated-curing strength 624
Non-destructive tests 625
Rebound hammer test 626
Penetration resistance test 629
Pull-out test 630
Post-installed tests 632
Ultrasonic pulse velocity test 632
Further possibilities in non-destructive testing 635
Resonant frequency method 636
Tests on the composition of hardened concrete 637

Cement content 637
Determination of the original water/cement ratio 638
Physical methods 638
Variability of test results 638
Distribution of strength 639
Standard deviation 642
References 643

13 Concretes with particular properties 651

Concretes with different cementitious materials 651
General features of use of fly ash, ggbs, and silica fume 652
Durability aspects 653
Variability of materials 654
Concrete containing fly ash 655
Influence of fly ash on properties of fresh concrete 656
Hydration of fly ash 657
Strength development of fly ash concrete 659
Durability of fly ash concrete 662
Concretes containing ground granulated blastfurnace slag (ggbs) 663
Influence of ggbs on properties of fresh concrete 664
Hydration and strength development of concrete containing ggbs 664
Durability aspects of concrete containing ggbs 667
Concrete containing silica fume 668
Influence of silica fume on properties of fresh concrete 669
Hydration and strength development of the Portland cement–silica fume system 671
Durability of concrete containing silica fume 674
High performance concrete 676
Properties of aggregate in high performance concrete 678
Aspects of high performance concrete in the fresh state 679
Compatibility of Portland cement and superplasticizer 680
Aspects of hardened high performance concrete 682
Testing of high performance concrete 686
Durability of high performance concrete 687
The future of high performance concrete 689
Lightweight concrete 690
Classification of lightweight concretes 690
Lightweight aggregates 691
Natural aggregates 691
Manufactured aggregates 694
Requirements for aggregates for structural concrete 696
Effects of water absorption by lightweight aggregate 698
Lightweight aggregate concrete 700
Aspects of the fresh state 700
Strength of lightweight aggregate concrete 701
Lightweight aggregate–matrix bond 704

Elastic properties of lightweight aggregate concrete 705
Durability of lightweight aggregate concrete 706
Thermal properties of lightweight aggregate concrete 708
Cellular concrete 710
Autoclaved aerated concrete 711
No-fines concrete 713
Nailing concrete 716
Remark about specialized concretes 717
References 717

14 Selection of concrete mix proportions (mix design) 726

Cost considerations 727
Specifications 727
The process of mix selection 729
Mean strength and 'minimum' strength 731
Variability of strength 734
Quality control 740
Factors governing the selection of mix proportions 741
Durability 741
Workability 745
Maximum size of aggregate 745
Grading and type of aggregate 746
Cement content 747
Mix proportions and quantities per batch 747
Calculation by absolute volume 749
Combining aggregates to obtain a type grading 750
American method of selection of mix proportions 754
Example 757
Mix selection for no-slump concrete 758
Mix selection for flowing concrete 758
Mix selection for high performance concrete 760
Mix selection for lightweight aggregate concrete 761
Example 762
British method of mix selection (mix design) 764
Example 769
Other methods of mix selection 770
Concluding remarks 771
References 772

Appendix I: Relevant ASTM Standards 774
Appendix II: Relevant British and European Standards 778
Name index 783
Subject index 799