## NATIONAL BUREAU OF STANDARDS REPORT

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

3855

QUARTERLY REPORT

EVALUATION OF REFRACTORY QUALITIES OF CONCRETES FOR JET AIRCRAFT WARM-UP, POWER CHECK, AND MAINTENANCE APRONS

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bу

W. L. Pendergast, Edward C. Tuma, R. A. Clevenger



U. S. DEPARTMENT OF COMMERCE NATIONAL BUREAU OF STANDARDS

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#### NATIONAL BUREAU OF STANDARDS REPORT

NBS PROJECT

**NBS REPORT** 

0903-21-4428

December 31, 1954

3855

QUARTERLY REPORT

ON

EVALUATION OF REFRACTORY QUALITIES OF CONCRETES FOR JET AIRCRAFT WARM-UP, POWER CHECK, AND MAINTENANCE APRONS

by

W. L. Pendergast, Edward C. Tuma, R. A. Clevenger Refractories Section Mineral Products Division

> Sponsored by Department of the Navy Bureau of Yards and Docks Washington, D. C.

Reference: NT4-59/NY 420 008-1 Project No. 61717 NBS File No. 9.3/1134-C

Approved:



R. A. Heindl, Chief Refractories Section

# U. S. DEPARTMENT OF COMMERCE NATIONAL BUREAU OF STANDARDS

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# QUARTERLY REPORT

EVALUATION OF REFRACTORY QUALITIES OF CONCRETES
FOR JET AIRCRAFT WARM-UP, POWER CHECK,
AND MAINTENANCE APRONS

#### TECHNICAL REQUIREMENTS

The technical requirements for the concretes designed with dense aggregates are the same as those given in NBS Report 3012, dated December 31, 1953.

The technical requirement for the concretes designed with lightweight aggregates are: (1) they must develop a flexural strength of 650 psi after curing for 28 days in the fog-room; (2) the maximum sement content shall not exceed nine sacks per cubic yard.

#### 1. INTRODUCTION

The objective of the investigation is the determination of the physical properties of concretes that will evaluate their suitability for use in jet aircraft warm-up, power check, and maintenance aprons.

#### 2. MATERIALS: PREPARATION AND TESTING

#### 2.1 Cements

The thermal length changes from room temperature to approximately 1200°C were measured on specimens of the three types of cements. The neat cement specimens for that purpose were cured for 28 days in the fog-room and oven dried at 105°C for 18 hours before testing.

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#### 2.2 Aggregates

A second shipment, totaling ten tons of sintered slag was crushed and screened to required sizes.

The following properties of both the sintered slag and a coated expanded shale, "Rocklite", were determined: (1) wear in the Los Angeles Abrasion Test; (2) the bulk specific gravity; (3) the absorption; (4) the unit weight in pounds per cubic foot.

The thermal length changes, of one of the dense aggregates namely, crushed building brick, were observed from room temperature to approximately 1200°C.

#### 2.3 Concretes

During this reporting period 27 one-cubic foot trial batches of concrete and one 15 cu. ft. final batch, were designed, mixed, specimens fabricated, cured, and tested if the curing period was completed.

Fifteen of the trial batches were designed with a light-weight aggregate "Kenlite", which is an expanded shale, crushed. Eleven of these contained the portland cement as the bond, two the portland pozzolan, and two the high-alumina hydraulic cement.

Six trial batches were designed with the second light-weight aggregate, "Rocklite". Five of these contained the portland cement, and one the portland pozzolan.

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 Six trial batches were designed with sintered slag

(second shipment) as the aggregate. Two of each of these

trial batches were designed with portland, portland pozzolan,

and high-alumina hydraulic cements respectively. Using the

information obtained from tests on the trial batches, one

final fifteen cubic feet, batch of concrete was designed

with the high-alumina hydraulic cement as the bond. This

concrete has been mixed and test specimens fabricated. One

set of specimens is being cured in fog-room for 28 days.

Four sets have completed the seven-day fog-room curing and

are stored in the laboratory at ordinary temperatures and

humidity. These specimens will be tested after two different

curing periods and three heat exposures.

#### 3. RESULTS AND DISCUSSION

#### 3.1 Cements

Preliminary observations of the thermal length changes of the three neat cements were made up to that temperature at which either softening or rapid shrinkage occurred.

When all tests are completed curves showing the length changes

The results of the tests of trial batches of concretes using sintered slag and given in NBS Report 3705, Table 3, indicated that a concrete could be designed that would meet the specified technical requirements. However, because the properties of the second shipment of slag differed considerably from the first; additional trial batches of concretes were prepared and tested.

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during actual heating will be given in a future report and discussed in detail. For the present it can be pointed out that the portland cement had a total shrinkage of 7.66% up to 1180°C, which was more than double that of either the portland pozzolan or the high alumina cements.

### 3.2 Aggregates

Some properties of two of the aggregates are given in Table 1.

Table 1. Properties of Lightweight Aggregates.

Aggregate	Size	Bulk Specific Gravity <u>a</u> / <u>b</u> / S-SD	Water Absorption in Percent by Weightb	Wear in Los Angeles Abrasion Test percent
Rocklite	Coarse Fine	1.24 1.50	6.45 11.45	25.1
Sintered Slage	Coarse Fine	1.83 2.72	9.20 0.80	67.5
Sintered Slagd	Coarse Fine	2.16 2.49	3.86 3.18	45•3

a/ Saturated surface-dry basis.

b/ The gradation of the aggregate was the same as that used in designing the concretes.

c/ First shipment of slag sintered at Armour Institute

d/ Second shipment of slag sintered on contract by Armour Institute.

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While the bulk specific gravity of the coarse aggregate of Rocklite, (-1 1/2" to +4) was 1.24, some of the larger size particles are lighter than water. In mixing concrete designed with this aggregate the slump must be kept between two and three inches to prevent the segregation of the larger particles. The 25 percent wear loss in the abrasion test is not a true measure of the strength of this aggregate. The volume of the charge due to its lightweight reduces the impact during the testing and very few of the pieces actually fractured. The indicated loss was a result of wear on the coating.

A comparison of the results of tests of the slags received in the first and second shipments indicates that if the slag was from the same source the method and/or temperature of sintering must have differed.

The thermal length changes for specimens cut from building brick, were characterized by a rapid expansion approximating 5.0 percent caused by bloating, within the range from 1000°C to 1175°C. The total amount of expansion from 25° to 1000°C was 0.72 percent. Graphs showing in detail the length changes are being prepared and will appear in the next report.

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#### 3.3 Concretes

Table 2 gives the composition, some properties of the fresh concretes, together with the flexural strengths, of trial batches of mixes designed with the lightweight aggregate "Rocklite". The few mixes designed and tested have not developed the required flexural strength of 650 psi even with a cement content of slightly more than the maximum of nine sacks per cubic yard. This aggregate, when used in concrete, fractures exposing numerous and sizeable air voids. It is, however, probable that a systematic increase in the ratio of coarse-to-fine aggregate may result in a concrete with the required strength. An examination of the fractured beams fabricated from these concretes shows a deficiency in the intermediate sizes of the coarse (-3/4 +3/8). This deficiency may be overcome by the increase in the ratio of coarse-to-fine aggregate, otherwise a change in the fineness modulus of the coarse aggregate will be necessary. The spherical shape of the aggregate will permit the increase in coarse fractions without materially effecting the workability of the concrete.

Table 3 gives information similar to that given in Table 2, but governs mixes designed with the lightweight aggregate, "Kenlite". Of the 14 concretes tested only two, namely, Z-K-C<sup>1</sup> and P-K-E<sup>1</sup> developed the required 650 psi. In both of these the cement content, as calculated, was over the nine-sack maximum permitted.

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TABLE 2. PROPERTIES OF FRESH CONCRETES<sup>8</sup>/

		п						
Rema nice	Cured Congrete		few pull-outs; mostly fractured aggregate	few pull-outs; mostly fractured aggregate	few pull-outs; large aggregate fracturee	few pull—outs; large aggregate fractures	1	1
	Flexural	pet	615	575	535	965	ı	ı
Rema riks	Fresh Concrete		easily placed	placed well; sticky	easily placed	easily placed	harsh but placeable	sticky but placeable
Water	Cement Ratio		0.38	0.37	0.37	0.35	0.34	07.0
Weight	Fresh Concrete	1bs/ft <sup>3</sup>	06*96	102.50	071.66	09°101	02.66	047.66
	Slump	inchee	00.9	3.00	0°.9	2,50	1.75	2,25
Air Content	Gravimetric	percent	6.78	2,25	4.25	3.19	2.82	2.46
	Water Content	gals/yd3 of congrete	39.1	5.07	38.2	36.9	34.3	39.4
Vinsol	Weight of Cement	percent	0.005	0.005	0.005	0.005	0.005	none
	Cement Content	sacks/yd3 of concrete	9.15	9.75	9.16	9.38	8.97	83.88
Proportions	Identification to Coarse and to Fine Aggregate		1:0.84:0.69	1:0.84:0.69	1:0.88:0.72	1:0.89:0.73	1:1.03:0.68	1:1.04:0.70
/4	Identification	,	P-R-A-	P-R-A <sup>2</sup>	P-R-B <sup>1</sup>	P-R-B <sup>2</sup>	$P-R-C^{\perp}$	2-R-C <sup>2</sup>

 $\underline{\mathbb{A}}$  The flexural strength after curing for 28 days in fog-room is included.

\(\text{D}\) The first letters: P = portland eement;
\(\text{D}\) The first letters: R = Rocklite aggregate.
The second letter: R = Rocklite aggregate.
The third letters: = Batch identification, with superscript indicating that the aggregate was creemed and recombined using the gradation that was used throughout this project, MBS Report 3012, Figure 1.

2/ Mixes charged with saturated aggregats. Coarss and fine aggregate was immersed in water 18 hours and allowed to drain 18 hours before mixing.



Remarks Cured Concrete	pratorio ramo		all large aggregate fractured; air voids	90% fracture; air voide	practically all large aggregate fractured	practically all large aggregate fractured	few large air voids; all large aggregate fractured	few large air voide; all large aggregate fractured	all large aggregate fractured; few large air woids	all large aggregate fractured; few air voide	2 or 3 pull-outs; all other fractures	few pull-oute	very few pull-oute mostly aggregate fracture	for pull-oute numerous air voide	few pull-oute numerous air voids	mostly aggregate fracture	
Flexural Strength		pet	250	550	029	970	929	2112	605	585	615	575	625	585	970	069	
Remarkos Fresh Congrete			bleede; aggregate eegregation	very good; elightly plastic	slightly harsh	good	slightly hareh and dry	slightly harsh	slightly harsh; bleede some	very good	slightly harsh	eaeily placed too wet	very good	placed well	very hareh	harsh but placeable	very good
Water Cement Ratio			0.54	0.39	0.3	0.50	07.0	47.0	0.38	۲۴۰۰	0.34	0.39	0.37	0.32	0.29	0.37	0.39
Weight of Fresh	Concrete	lbs/ft3	95.00	97.50	00.101	09.101	104.80	93.70	98.80	100.60	100,30	07.86	102.80	100.30	98.70	01.601	100.00
Slump		inchee	too thin	2.50	1,25	3.50	1.50	8.8	7.50	00**	1.00	0.9	1,50	2*00	0.50	1.00	2,25
Air Content Gravimetrio		percent	7.00	7.05	7.4	1.50	0.85	3.15	5.32	2.86	3.97	12.4	70.4	8.05	41.6	3.40	5.50
Water Contents/		gals/yd3 of concrete	44.5	34.6	30°0	6*17	17.8	43.4	38.2	1.2.7	35.0	39.0	39.7	33.9	30.0	38.9	37.8
Vineol Resin by Weight of	Cement	percent	0.010	0.010	0.005	0.005	euou	ecou	0.005	none	0.005	0.005	0.005	900.0	0.005	0.005	0.005
Cement Content		sacks/yd3 of concrete	7.32	7.82	9.06	8.58	74.6	8.8 B.	8.88	70°6	9.15	8.82	9.35	07.6	9.%	6.43	8.71
Proportions by Weight: Cement to Coarse and to Fine Agreement	rine Aggregate		1:0.88:1,10	1:0.88:1,10	1:0.95:0.78	1:0.95:0.78	1:0.74:0.88	1:0.94:0.71	1:0.89:0.74	1:0.91:0.69	1:0.98:0.65	1:0.99:0.66	1:0.99:0.66	1:0.92:0.69	1:0.99:0.66	1:0.99:0.66	1:1.06:0.70
Identification b/		r	P-K-A	P-K-A <sup>2</sup>	P-K-B	P-K-B <sup>2</sup>	Z-K-C <sup>+</sup>	Z-K-G <sup>2</sup>	P-K-C <sup>1</sup>	Z-K-D <sup>2</sup>	P-K-D <sup>+</sup>	P-K-D <sup>2</sup>	P-K-E	L-K-A	L-K-A	P-K-E	P-K-₽¹

a/ The flantal strength after curing for 28 days in fog-room is included.
b/ The first letters: P = portland coment; Z = portland pozzolan ecment; L = high-alumina hydraulic coment.
The second latter: K = Kenlite aggregate.
The second latter = batch identification, with supercoript indicating that the aggregate was used in the same proportion as received;
The third latter = batch identification, with supercoript indicating that the aggregate was soreened and recombined using the gradation that was used throughout this project, NBS Report 2012, Figure 1.

2/ Mixer charged with saturated aggregate. Coarse and fine aggregate wae immersed in water 18 hours and allowed to drain 18 hours before mixing.



An increase in cement content, systematic changes in the ratio of coarse-to-fine aggregate, and a reduction in air and water content have failed to yield a concrete of satisfactory strength. This aggregate is marketed in a top size of +1/2 inch. The ratio of coarse-to-fine aggregate has been increased until the concrete is difficult to place (too harsh). The manufacturer has been contacted for the purpose of obtaining a larger top size aggregate. The introduction of a larger size, but in the same amount, may yield a concrete with good placeability and sufficient flexural strength.

Table 4 gives information similar to that in Tables 2 and 3 but covering trial batches of mixes designed with sintered slag from the second shipment. The results of tests of these trial batches indicate that sufficient strength will develop in concretes with a much lower cement content than first indicated when the slag originally furnished was used. Table 4 also gives the composition and the properties of the fresh concrete of a final, 15 cubic foot batch, of concrete designed with the high-alumina hydraulic cement and using sintered slag from the second shipment as the aggregate. Due to the limited capacity of our mixer, namely five cubic foot, it was necessary to make three separate batches (L-SS-1,2,3) identical in composition,

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TABLE 4. PROPERTIES OF FRESH CONCRETES<sup>B</sup>

# "Containing Sintered Slag"

Slump	Concrete	roent inchee lbe/ft <sup>2</sup> pei	.30 2.50 129.70 0.44 fair placeability; 860 50% pull-oute 50% fractured bleeding signegate		43 none <sup>d</sup> 121.40 0.46 placed easily; 520 mostly pull-oute too thin	.11 1.50 131.30 0.43 fair; slightly 785 50% pull-oute harsh harsh aggregate	.50 2.75 132.50 0.42 very good 765 505 pull-oute 506 fractured aggregate	.13 0.75 131.90 0.37 harsh but place- 735 few pull-oute	.88 1.50 133.10 0.39 alightly haren	.36 5.50 133.80 0.39 Pery good -	.20 2.25 131.30 0.39 alightly harsh but placeable
Flexural Strength		pet							ı	'	1
Remarks Fresh Concrete	Botomo more		fair placeability; bleeding	placed well; some bleeding	placed easily; too thin	fair; slightly harsh	very good	harsh but place- able	slightly harsh but placeable	very good	slightly harsh but placeable
Water Cement Ratio			*/****O	07.0	97.0	0.43	0.42	0.37	0.39	0.39	0.39
Weight of Fresh	Concrete	1pe/ff3	129.70			131.30	132,50	131.90	133.10	133.80	131,30
Slump		inchee	2,50	2,25	pouou	1.50	2.75	0.75	1.50	5.50	2.25
Air Content Gravimetria		percent	1,30	1.54	8,43	2.11	1.50	3.13	1.88	1.36	3.20
Water Content <sup>C</sup> /		gale/yd3 of concrete	0.64	8.44	45.5	8°94	0.94	4.04	0.14	0.14	0*07
Vinsol Resin by Weight of	Cement	percent	none	00.005	0.005	none	0.005	0.005	0.005	0,005	0.005
Cement Content		sacks/yd3 of concrete	71.6	68.6	8.82	09°6	99°6	9.81	9.30	9.35	9.17
Proportions by Weight:Cement to Coarse and to Fine Agreeate	- Tic v8910844		1:1.4:1.4	1:1.11:1.26	1:1.21:1.21	1:1.15:1.25	1:1.14:1.29	1:1.2:1.2	1:1.31:1.31	1:1.31:1.31	1:1.31:1.31
Identification <sup>b</sup> /			5-88-Z	P-88-6	I-SS-I	Z-SS-H	P-SS-H	<b>7</b> -55-7	1-53-1	I-3S-2	L-SS-3

 $^{\underline{a}/}$  The flexural strength after curing for 28 days in fog-room is included.

D/ The first lettere: Z = portland pozzolan cament; P = portland cement; L = Lumnite, a high-alumina hydraulic cement. The second set of lettere; SS = sintered slag, Second Shipmant.
The shird letters = batch identification.
The third numerals 1, 2 and 3 = the three charges of the same batch.

S/ The mixer was charged with wetted aggregate. The fine portion of the aggregate was immersed in water 16 hours and not drained. The coarse aggregate was drained for one hour before placing in the mixer.

 $\underline{d}/$  Too fluid for slump measurement.



amount of water added, method of charging mixer, and time of mixing. The results indicate the variation that may be expected in handling this type of concrete.

Table 5 gives the flexural strengths of seven concretes after different curing periods. The results were obtained on prisms 3 x 4 x 16 inches therefore cannot be compared with the results for 6 x 6 x 20-inch beams fabricated from the same concretes. All concretes were designed with the lightweight aggregate "Kenlite" but with varying ratios of cement to coarse-to-fine aggregate. Some producers of lightweight aggregate recommend 35 days fog-room curing, others 42 days and some recommend additional curing or air drying. It is evident from these results that the curing, and curing and drying periods, affect the ultimate strength drastically.

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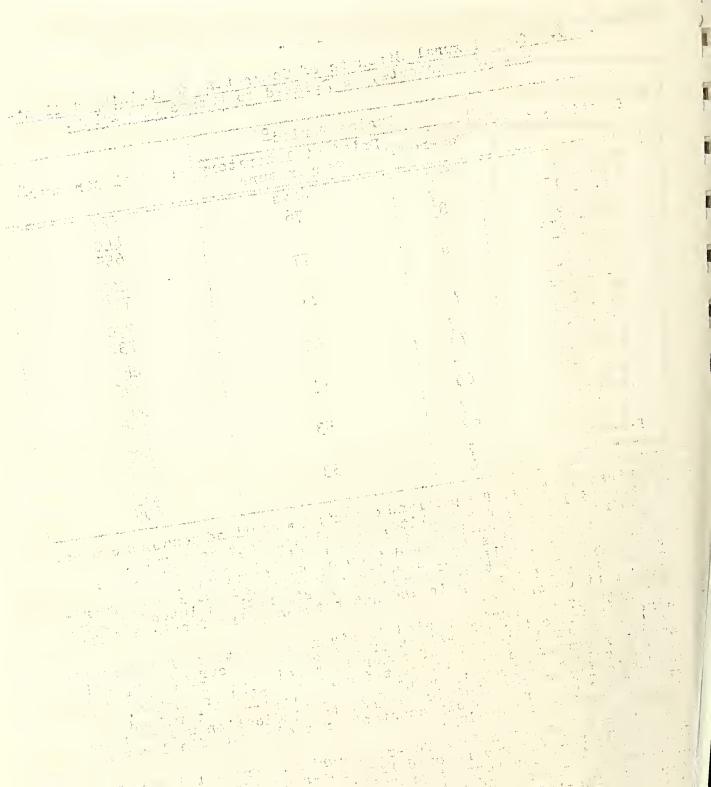
Table 5. The Flexural Strength of Concretes, Containing a Lightweight Aggregate, as Related to Method of Curing.

	_						
2/	Cı	uring Period D/					
Identification <sup>a</sup> /	Fog-room	Dried at laboratory Temperature	Flexural Strength				
	days	days	psi				
P-K-A1-1	7	76	622				
P-K-A1-2	83		770				
P-K-A <sup>2</sup> -1	7	77	265				
P-K-A <sup>2</sup> -2	84		795				
P-K-B <sup>1</sup> -1	7	69	270				
P-K-B <sup>1</sup> -2	76		730				
P-K-B <sup>2</sup> -1	7	69	<b>2</b> 45				
P-K-B <sup>2</sup> -2	76		695				
Z-K-C1-1	7	53	215				
Z-K-C1-2	60		725				
Z-K-C <sup>2</sup> -1	7	53	395				
Z-K-C <sup>2</sup> -2	60		655				
P-K-C <sup>1</sup> -1	7	53	225				
P-K-C <sup>1</sup> -2	60		695				

The first letters: P = portland cement; Z = portland pozzolan cement.
The second letter: K = Kenlite, the lightweight aggregate.
The third letter identifies the composition of the mix and the

superscript denotes the gradation of the aggregate.
The numeral identifies the specimen. Specimens 1 and 2 were fabricated from same batch. Comparison of strength is intended betwee specimens 1 and 2 of a pair and not between pairs fabricated from different concretes.

- b/The length of the curing period is given as a matter of informatio since it indicates the effect of extending the curing and drying on the flexural strength of concrete specimens. It is not neces sarily recommended as a suggested curing period or method. Base on the values of Young's modulus of elasticity, determined periodically by the dynamic method, the indication was that the strength became reasonably constant preceding the final seven days of curing and drying.
- c/All specimens had seven days fog-room curing. One set identified by the numeral (1) was removed from fog-room after seven days and stored in laboratory at prevailing temperatures and humidities. The second set identified by the numeral (2) was stored in fog-room until tested. The average flexural strength of the specimen of the seven concretes that were cured for seven days in fog-room and dried in laboratory was 295 psi. The average for those tested out of fog-room was 705 psi.



#### CONFERENCE

A conference was held at the Bureau of Yards and Docks, December 1, 1954. The names of those attending follow:

Commander Stanley Rockefeller, Bureau of Yards and Docks

- M. P. Harrington, Bureau of Yards and Docks
- P. Knoop, Bureau of Yards and Docks
- L. A. Palmer, Bureau of Yards and Docks
- P. P. Brown, Bureau of Yards and Docks
- S. E. Matullo, Bureau of Yards and Docks
- J. A. Bishop, NAVCEREIAB
- R. A. Heindl, National Bureau of Standards
- W. L. Pendergast, National Bureau of Standards

As a result of the investigative work thus far completed at the National Bureau of Standards the Department of the Navy, Bureau of Yards and Docks, instructed their laboratories at Port Hueneme, California, to place concrete aprons for field tests. The nine concretes selected and recommended for use in these field tests were those containing refractory aggregates. The recommendation was based on the evaluation of suitability tests of the 18 concretes investigated. The final nine concretes were further classified with respect to occurrence and accessitility of the aggregates and the cost of the cement.

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#### 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 (\$1.25) and its Supplement (\$0.75), available from the Superintendent of Documents, 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.



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