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A STUDY ON WORKABILITY AND STRENGTH PROPERTIES OF FLYASH BASED SELF COMPACTING CONCRETE OF GRADE M20

¹B.Harsha Vardan Reddy,²S.Haneef

¹²Assistant Professor Department Of Civil Engineering

CVRT Engineering college, Tadipatri

ABSTRACT: - The Main use of mineral and chemical admixtures in concrete is a solution to achieve full compaction particularly where reinforcement congestion and shortage of skilled workers. The past researchers have been underscored the use of mineral and chemical admixtures imparts the desirable properties to concrete in both fresh and hardened state. This paper has been made an attempt to study the performance of Self-Compacting Concrete containing0%,5%, 10%,15% & 20% fly ash of cement content. The experimental tests for fresh and hardened properties of Self-Compacting Concrete for five mixes of M20 grade are studied and the results are compared with normal vibrated concrete. The tests considered for study are, slump test, compaction factor test, unit weight and compressive strength test The results show that for the constant water cement ratio, increase of superplasticizer dose in Self-Compacting Concrete leads to gain of good self compaction ability in addition to marginal reduction in unit weight. Moreover, there is also slightly increase in compressive strength than that of normal concrete mix.

Keywords: - Compressive strength, Fly ash, Normal concrete, Self-Compacting Concrete, Superplasticizer, Unit weight, Workability.

I. INTRODUCTION

1.1 General:

Self-consolidating concrete (SCC) or Self Compacting concrete, as it's sometimes known, arrived as a revolution in the field of concrete technology. Even if there is still no official definition of SCC, the concept could be defined as follows:

A self-consolidating concrete must:

Have a fluidity that allows self-consolidation without external energy

- · Remain homogeneous in a form during and after the placing process, and
- Flow easily through reinforcement.

Self Compacting concrete (SCC) is an innovative concrete that does not require vibration for placing and compaction. It is able to flow under its own weight, completely filling formwork and achieving full compaction, even in the presence of congested reinforcement. The hardened concrete is dense, homogeneous and has the same engineering properties and durability as traditional vibrated concrete.

Self Compacting concrete was developed at that time to improve the durability of concrete structures. Since then, various investigations have been carried out and SCC has been used in practical structures in Japan, mainly by large construction companies. Investigations for establishing a rational mix-design method and self compact ability testing methods have been carried out from the viewpoint of making it a standard concrete. Self Compacting concrete is cast so that no additional inner or outer vibration is necessary for the compaction. It flows like "honey" and has a very smooth surface level after placing. With regard to its composition, Self Compacting concrete consists of the same components as conventionally vibrated concrete, which are cement, aggregates, and water, with the addition of chemical and mineral admixtures in different proportions.

1.2 Historical Development of Self Compacting Concrete:

Self Compacting concrete, in principle, is not new. Special applications such as underwater concreting have always required concrete, which could be placed without the need for compaction. In such circumstances vibration was simply impossible. Early Self Compacting concretes relied on very high contents of cement paste and, once super plasticizers became available, they were added in the concrete mixes. The mixes required specialized and well-controlled placing methods in order to avoid segregation, and the high contents of cement paste made them prone to shrinkage. The overall costs were very high and applications remained very limited.

1.3 Motive for Development of Self Compacting Concrete:

For several years beginning in 1983, the problem of the durability of concrete structures was a major topic of interest in Japan. To make durable concrete structures, sufficient compaction by skilled workers is required. However, the gradual reduction in the number of skilled workers in Japan's



2.1 General

Present-day self Compacting concrete can be classified as an advanced construction material. As the name suggests, it does not require to be vibrated to achieve full compaction. This offers many benefits and advantages over conventional concrete. These include an improved quality of concrete and reduction of on-site repairs, faster construction times, lower overall costs, facilitation of introduction of automation into concrete construction. An important improvement of health and safety is also achieved through elimination of handling of vibrators and a substantial reduction of environmental noise loading on and around a site. The composition of SCC mixes includes substantial proportions of fine-grained inorganic materials and this gives possibilities for utilization of mineral admixtures, which are currently waste products with no practical applications and are costly to dispose of (St John, 1998).

2.2 Previous Research Work on Self Compacting Concrete:

Self Compacting concrete extends the possibility of use of various mineral by-products in its manufacturing and with the densification of the matrix, mechanical behavior, as measured by compressive, tensile and shear strength, is increased. On the other hand, the use super plasticizers or high range water reducers, improves the stiffening, unwanted air entrainment, and flowing ability of the concrete. Practically, all types of structural constructions are possible with this concrete. The use of SCC not only shortens the construction period but also ensures quality and durability of concrete. This non-vibrated concrete allows faster placement and less finishing time, leading to improved productivity.

In the following, a summary of the articles and papers found in the literature, about the self Compacting concrete and some of the projects carried out with this type of concrete, is presented.

Hajime Okamura: A new type of concrete, which can be compacted into every corner of a formwork purely by means of its own weight, was proposed by Okamura (1997). In 1986, he started a research project on the flowing ability and workability of this special type of concrete, later called self-compacting concrete. The self-compactability of this concrete can be largely affected by the characteristics of materials and the mix proportions. In his study, Okamura (1997) has fixed the coarse aggregate content to 50% of the solid volume and the fine aggregate content to 40% of the mortar volume, so that self-compactability could be achieved easily by adjusting the water to cement ratio and super plasticizers dosage only.

A model formwork, comprised of two vertical sections (towers) at each end of a horizontal trough, was used by professor Okamura to observe how well self compacting concrete could flow through obstacles. Figure 2.1 shows the ends of small pipes mounted across the horizontal trough and used as obstacles. The concrete was placed into a right-hand tower, flowed through the obstacles, and rose in the left-hand tower.



Fig 2.Small pipes used as obstacles in formwork (Okamura, 1997).

The obstacles were chosen to simulate the confined zones of an actual structure. The concrete in the left-hand tower rose to almost the same level as in the right-hand tower. Similar experiments of this type were carried out over a period of about one year and the applicability of Self Compacting concrete for practical structures was verified. This research was started at the suggestion of professor Kokubu (Okamura, 1997) from Kobe University, Japan, one of the advisors of Hajime Okamura. They thought that it would be easy to create this new concrete because anti washout underwater concrete was already in practical use. Anti washout underwater concrete is cast underwater and segregation is strictly inhibited by adding a large amount of a viscous agent (anti washout admixture), which prevents the cement particles from dispersing in the surrounding water. With a super plasticizer, the paste can be made more flow able with little concomitant decrease in viscosity, compared to the drastic effect of the water, when the cohesion between the aggregate and the paste is weakened (Figure 2.2).



Fig 3. Effect of super plasticizer on viscosity (Okamura, 1997)

The water-cement ratio was taken between 0.4 and 0.6 depending on the properties of the cement. The super plasticizer dosage and the final water-cement ratio were determined so, as to ensure the selfcompactability, evaluated subsequently by using the U-type test (Ouchi and Hibino, 2000) described in the previous chapter.

COMPOSITION MIX DESIGN AND TESTING PROCEDURES OF SELF COMPACTING III. **CONCRETE**

3.1 Materials used for Self-Compacting Concrete:

The materials used in Self-Compacting concrete are:

- 1. Portland Cement
- 2. Aggregates
 - Coarse aggregate
 - Fine aggregate
- 3. Mineral admixtures
- Fly Ash 4. Chemical admixtures
 - Super-plasticizers

5. Water

Portland Cement: In principle, the manufacture of Portland cement is very simple and relies on the use of abundant raw

materials. An intimate mixture, usually of limestone and clay, is heated in a kiln to 1400 to 1600°C (2550 to 2900°F), which is the temperature range in which the two materials interact chemically to form the calcium silicates. High-quality cements require raw materials of adequate purity and uniform composition.

A typical chemical composition of an ordinary Portland cement is given in Table 3.1. It can be noted that the quantities do not add up to 100%, the missing percentages being accounted for by impurities.

Chemical Name	Chemic al	Sho rth	Weig ht
	Formul	and	Perce
	a	Not	ntage
		atio	
		n	
Tricalcium	3CaO-	C3	55
Silicate	SiO2	S	
Dicalcium	2CaO-	C2	18
Silicate	SiO2	S	
Tricalcium	3CaO-	C3	10
aluminate	Al2O3	A	
Tetracalciu	4CaO-	C3	08
m	Al2O3.	AF	
aluminoferri	Fe2O3		
te			
Calcium	CaSO4.	CS	06
Sulfate	2H2O	H2	
dehydrate			
(Gypsum)			

Table .1 Typical composition of ordinary Portland cement.

Super plasticizers:

Ozkul and Dogan (1999) studied the effect of an N-vinyl copolymer super plasticizer on the properties of fresh and hardened concretes. Workability of concrete was measured by slump flow test and in situ tests were undertaken to find out the pumping ability of super plasticized concrete. The coarse aggregate was crushed stone with the maximum size of 25 mm. By using this chemical admixture, which was a little bit different from the conventional ones, the ability of water reduction was increased along with the retention of high workability for a longer time.



Fig 4. Effect of super plasticizer on cement: (a) Cement and water; (b) Cement, water, and super plasticizer



Fig 5. Dispersing action of water-reducing admixtures: (a) flocculated paste; (b) dispersed paste (Mindess et al., 2003).

Some high-range water-reducing admixtures can retard final set by one to almost four hours and if prolonged setting times are not convenient, the admixture can be combined with an accelerating admixture to counteract the retarding tendencies or even to provide some net acceleration of setting. When water-reducing admixtures are used in concrete mixtures, some increases in compressive strength can be anticipated and these increases can be observed in as early as one day if excessive retardation does not occur.

3.2 Mix Design of Self-Compacting Concrete:

Till now there is no specified method for the proportioning of Self-Compacting Concrete. Different people followed different methods. Some of the methods are discussed here.

The European Guidelines for Mix design of Self-Compacting Concrete

Mix design principles

To achieve the required combination of properties in fresh SCC mixes:

• The fluidity and viscosity of the paste is adjusted and balanced by careful selection and proportioning of the cement and additions, by limiting the water/powder ratio and then by adding a superplasticiser and (optionally) a viscosity modifying admixture. Correctly controlling these components of SCC, their compatibility and interaction is the key to achieving good filling ability, passing ability and resistance to segregation.

• In order to control temperature rise and thermal shrinkage cracking as well as strength, the fine powder content may contain a significant proportion of type l or ll additions to keep the cement content at an acceptable level.

• The paste is the vehicle for the transport of the aggregate; therefore the volume of the paste must be greater than the void volume in the aggregate so that all individual aggregate particles are fully coated and lubricated by a layer of paste. This increases fluidity and reduces aggregate friction.

• The coarse to fine aggregate ratio in the mix is reduced so that individual coarse aggregate particles are fully surrounded by a layer of mortar. This reduces aggregate interlock and bridging when the concrete passes through narrow openings or gaps between reinforcement and increases the passing ability of the SCC.

These mix design principles result in concrete that, compared to traditional vibrated concrete, normally contains: • Lower coarse aggregate content

- Increased paste content
- Low water/powder ratio
- Increased superplasticiser
- Sometimes a viscosity modifying admixture.

Test methods

A wide range of test methods have been developed to measure and assess the fresh properties of SCC. Table 3.3 lists the most common tests grouped according to the property assessed.

Characterist ic	Test method	Measured value
Flowability/	Slump-flow	total spread
filling ability	Kajima box	visual filling
	T ₅₀₀	flow time
Viscosity/	V-funnel	flow time
flowability	O-funnel	flow time
	Orimet	flow time
	L-box	passing ratio
D .	U-box	height difference
ability	J-ring	step height, total flow
	Kajima box	visual passing ability
	penetration	depth
Segregation	sieve	percent
resistance	segregation	laitance
resistance	settlement	segregation
	column	ratio

Table .2 Testing methods according to the property assessed 3.3 EFNARC guide lines for Mix design of Self-Compacting Concrete

Requirements of S.C.C.

SCC can be designed to fulfill the requirements of EN 206 regarding density, strength development, final strength and durability. Due to the high content of powder, SCC may show more plastic shrinkage or creep than ordinary concrete mixes. These aspects should therefore be considered during designing and specifying SCC. Current knowledge of these aspects is limited and this is an area requiring further research. Special care should also be taken to begin curing the concrete as early as possible. The workability of SCC is higher than the highest class of consistence described within EN 206 and can be characterized by the following properties:

- Filling ability
- Passing ability
- Segregation resistance

A concrete mix can only be classified as Self-compacting Concrete if the requirements for all three characteristics are fulfilled.

Test methods

Many different test methods have been developed in attempts to characterize the properties of SCC. So far no single method or combination of methods has achieved universal approval and most of them have their adherents. Similarly no single method has been found which characterizes all the relevant workability aspects so each mix design should be tested by more than one test method for the different workability parameters.

Method	Property
1 Slump-flow by Abrams cone	Filling ability
2 T50cmslumpflow	Filling ability
3 J-ring	Passing ability
4 V-funnel	Filling ability
5 V-funnel at T5minutes	Segregation resistance
6 L-box	Passing ability
7 U-box	Passing ability
8 Fill-box	Passing ability
9 GTM screen stability test	Segregation resistance
10 Orimet	Filling

Table 3. List of test methods for workability properties of SCC

Adjustment of the mix

Laboratory trials should be used to verify properties of the initial mix composition. If necessary, adjustments to the mix composition should then be made. Once all requirements are fulfilled, the mix should be tested at full scale at the concrete plant or at site. In the event that satisfactory performance cannot be obtained, then consideration should be given to fundamental redesign of the mix. Depending on the apparent problem, the following courses of action might be appropriate:

- Using additional or different types of filler, (if available);
- Modifying the proportions of the sand or the coarse aggregate;
- Adjusting the dosage of the superplasticiser;
- Using alternative types of superplasticiser(and/or VMA),more compatible with local materials;
- Adjusting the dosage of admixture to modify the water content, and hence the water/powder ratio.



Slump flow test:

V- Funnel test:

The slump flow is used to assess the horizontal free flow of SCC in the absence of obstructions. The slump cone, filled with concrete is lifted and concrete flows; the horizontal diameter of the flowed material is measured, as shown in Fig 3.4. The average diameter of concrete circle is a measure for the filling ability for the concrete. The time T50 is a secondary indication of flow. It measures the time taken in seconds from the instant the cone is lifted to the instant when horizontal flow diameter reaches 500mm. According to Khayat and Manail, a slump flow ranging from 500mm to 700mm is necessary tor a concrete to be self compacted. At more than 700mm the concrete might segregate and at less than 500mm the concrete may not have sufficient flow to pass through highly congested reinforcement. This is simple, rapid test procedure, though two people are needed if T50 time is to *be* measured, it can be used on site, though the size of the plate is somewhat unwieldy and a level ground is essential.



Fig 8. Slump-flow test.

The ability of flow of fresh concrete can be tested with V-funnel test, where by the flow time is measured. The funnel is filled with about 12 liters of concrete and the time taken for it to flow through the apparatus is measured. Further, $T_{5minutes}$, is, also measured with V-funnel, which indicates the tendency for segregation, wherein the funnel can be refilled with concrete and left for 5 minutes to settle. If the concrete shows segregation, the flow time will increase significantly. According to Khayat and Manai, a funnel test flow time less than 6s is recommended for a concrete to qualify for a sec.



L-Box test:

The passing ability is determined using L-Box test, Fig 2.11. The vertical section of L.box is filled with concrete, the gate lifted to let the concrete flow into the horizontal section. The height of the concrete at the end of horizontal section is expressed as a proportion that remained in the vertical section (H2/HI). This is an indication of passing ability. The T20 and T40 are the times taken for concrete to reach the 20cm and 40cm

Fig 9. V-Funnel

marks of horizontal section of L-Box. These are indications of the ease of flow of concrete. The specified requisites are the time needed to flow up to $20 \text{cm} (\text{T}20) = 1 \pm 0.5$ see, the time needed to flow up to $40 \text{cm}(\text{T}40) = 2 \pm 0.5$ see, the time needed to flow up to $40 \text{cm}(\text{T}40) = 2 \pm 0.5$ see, and a ratio between the height of the concrete at each end (or) blocking ratio less than 0.80.



IV. MATERIALS USED IN THIS INVESTIGATION

4.1 Scope of Investigation:

The proposed study is being carried out to develop Self Compacting concrete of different grades with Fly ash as admixture for use in the Indian conditions satisfying European Standards for rheological properties of concrete in fresh state.

4.2 Materials Used:

The different materials used in this investigation are

- 53 grade Ordinary Portland Cement
- Coarse Aggregate
- Fine Aggregate
- Fly Ash
- Superplasticizer
- Water

4.2.1 Cement:

The cement used in all mixtures was commercially available Ordinary Portland cement (OPC) of 53 grade manufactured by Ultratech Company confirming to IS: 12269-1987.

	S. No	Property	Experimental Values	Suggested value as per IS: 12269-1987 code
	1.	Specific gravity	3.15	3.00 to 3.20
ĺ	2.	Normal Consistency	34%	
	3.	Initial Setting Time	121min	Min 30 minutes
	4.	Final Setting Time	320min	Max 10 Hours

Table 3. Physical properties of cement

4.2.2 Coarse Aggregates: The coarse aggregate from a

The coarse aggregate from a local crushing unit having 20mm normal size well-graded aggregate according to IS-383 is used in this investigation. The coarse aggregate procured from quarry was sieved through 20mm, 16mm, 12.5mm, 10mm and 4.75mm sieves. The material retained on 12.5mm, 10mm and 4.75mm sieves was filled in bags and stacked separately and used in the production of Self Compacting Concrete.

S. No	Property	Value
1.	Specific gravity	2.70
2.	Bulk density	1479 Kg/m3
3.	Water Absorption	0.1%
4.	Fineness modulus	7.01

Table 4. Physical properties of coarse aggregate

4.2.3 Fine Aggregates:

The fine aggregate that falls in zone-II was obtained from a nearby river course. The sand obtained was sieved through all the sieves (i.e.4.75mm, 2.36mm, 1.18mm, 600 μ , 300 μ , 150 μ). To obtain zone-II sand correctly, sand retained on each sieve is mixed in appropriate proportion.

S. No	Property	Value
1.	Specific gravity	2.63

2.	Fineness modulus	2.53	
3.	Bulk Density	1551 Kg/m3	
4.	Grading	Zone-II	

Table 5. Physical properties of fine aggregate:

Sieve Size	re Weight e retained % weight retained (%) w	Cumulative (%) weight	Cumulative % weight	Specification as per IS 383	
(mm)	(gms)		Retained(F)	passing	Zone II
4.75	27	2.7	2.7	97.30	90-100
2.36	38	3.8	6.50	93.50	75-100
1.18	132	13.2	19.70	80.3	55-90
600	260	26.0	45.70	54.30	35-59
300	420	42.0	87.70	12.30	8-30
150	105	10.5	98.20	1.80	0-10
75	10	1.00	99.20	0.80	

Table 6. Sieve analysis of fine aggregate:

As with all chemical products, care should be taken during use and storage to avoid contact with eyes, mouth, skin and foodstuffs (which can also be tainted with vapour until product fully cured or dried). Treat splashes to eyes and skin immediately. If accidentally ingested, seek immediate medical attention. Keep away from children and animals. Reseal containers after use. Do not reuse containers for storage of consumable item.



FIG.11 Chemical admixtures Used in the Present Investigation EXPERIMENTAL INVESTIGATIONS

5.1 General

V.

Safety precautions:

This experimental program has been carried out for designing S.C.C. mixes by partly replacing cement with Fly ash (Percentages of replacement are 0, 5, 10,15 and 20%).

The test program consists of

- 1. Preparing Self Compacting Concrete mixes with various percentages of super Plasticizer, and water/Powder ratio for each percentage replacement of cement with Fly ash (0%, 5%, 10%, 15% and 20%) and carrying out standard flow tests of SCC (Slump test, V-Funnel test, L- Box test) on these mixes.
- 2. Casting specimens and conducting Compressive strength test on cubes and split tensile strength test on cylinders, for those mixes which satisfy the requirements of SCC.
- 3. In this work a total of 5 mixes were prepared, out of which are satisfied the properties of Self compaction concrete. For the satisfied Self Compacting concrete mixes, a total of 75 specimens which consist of 45 cubes (150X150X150mm size) and 30 cylinders (150X300 size) were cast and tested.

5.2 Mix Proportioning:

To produce SCC, the major challenge is designing an appropriate mix proportion and evaluating the properties of the concrete thus obtained. In practice, SCC in its fresh state show high fluidity, self-compacting ability and segregation resistance, all of which contribute to reducing the risk of honey combing of concrete. With these good properties, the SCC produced can greatly improve the reliability and durability of the reinforced concrete structures.

S.N	Mix	Mix Details
	TR1	Plain SCC with 0% replacement of Fly ash and with
1	(SCC 1)	SP=1.8% (9.0 kg/m ³), Cementitious Material : 500Kg, W/P=0.4
	TR2	Plain SCC with 5% replacement of Fly ash and with SP= 1.80% (9.0
2	(SCC 2)	kg/m^3) and W/P = 0.40, Cementitious Material :500Kg
	TR3	Plain SCC with 10% replacement of Fly ash and with SP=2.20% (11.0
3	(SCC 3)	kg/m3) and W/P = 0.40, Cementitious Material :500Kg
	TR4	Plain SCC with 15% replacement of Fly ash and with SP= 2.40% (12.0
4	(SCC 4)	kg/m3) and W/P = 0.40, $$ Cementitious Material :500Kg $$
-	TR5	Plain SCC with 20% replacement of Fly ash and with SP= 2.60% (13.0
3	(SCC5)	kg/m3) and W/P = 0.45, Cementitious Material :500Kg

Table-7: Nomenclature of Fly ash based SCC mixes

Tr.no	Mix	% Replace ment of PG	Cem ent (Kg)	PG (Kg)	FA (Kg)	CA (Kg)	w/p	Water (Li)	SP (Kg)
1	TR1	0	500	0	642	659	0.4	200	9
2	TR2	5	475	25	642	659	0.4	200	9
3	TR3	10	450	50	642	659	0.4	200	11
4	TR4	15	425	75	642	659	0.4	200	12
5	TR5	20	400	100	642	659	0.4	200	13

Table 8- Details of mix proportions for Self Compacting Concrete

For each grade mix FS=Fly ash, FA=Fine aggregate, CA=coarse aggregate, SP= Super Plasticizer (GleniumB233),

Fresh Properties of SCC:

Slump flow test and t_{50cm} test:

The slump flow is used to assess the horizontal free flow of SCC in the absence of obstructions. It was first developed in Japan for use in assessment of underwater concrete. The test method is based on the test method for determining the slump. The diameter of the concrete circle is a measure for the filling ability of the concrete. The test also indicates the resistance to segregation.

Equipment:

Mould in the shape of a truncated cone with the internal dimensions 200mm diameter at the base, 100mm diameter at the top and a height of 300mm.

- Base plate of a stiff non-absorbing material, at least 1000mm square, marked with a circle marking the central location for the slump cone, and a further concentric circle of 500mm diameter.
- Trowel
- Scoop
- Ruler
- Stopwatch



Fig 12 Slump Diameter measurement

L - Box test method:

This test is based on a Japanese design for underwater concrete, has been described by Peterson the test assesses the flow of the concrete, and also the extent to which it is subjected to blocking by reinforcement. The apparatus is shown in the Fig. 4.1 below.

- Equipment:
 - L-Box
 - Bucket
 - Trowel
 - Scoop
 - Stopwatch



Fig 13. L-Box

V– Funnel test and V-Funnel test at 5 minutes:

The test was developed in Japan and used by Ozawa et al. The equipment consists of a V-shaped funnel. The described V-funnel, test is used to determine the filling ability (Flow ability) of the concrete with maximum aggregate size of 20mm. The funnel is filled with about 12 liters of concrete and the time taken for it to flow through the apparatus is measured. After this the funnel can be refilled concrete and left for 5 minutes to settle. If the concrete shows segregation then the flow time will increase significantly. **Assessment of test:**

Though the test is designed to measure Flowability; the result is affected by concrete properties other than flow. The inverted cone shape will cause any liability of the concrete to block to be reflected in the result 0 if, for example there is too much coarse aggregate. High flow time can also be associated with low deformability due to a high paste viscosity, and with high inter-particle friction.

- Equipment:
 - V-funnel
 - Bucket
 - Trowel
 - Scoop
 - Stopwatch



Fig 14. V-Funnel



Fig 15.V-Funnel with SCC

Procedure flow time at T₅ minutes:

- Do not clean or moisten the inside surfaces of the funnel again.
- Close the trap door and refill the V-funnel immediately after measuring the flow time.
- Place a bucket underneath.
- Fill the apparatus completely with concrete without compacting or tapping, simply strike off the concrete level at the top with trowel.
- Open the trap door 5 minutes after the second fill of the funnel and allow the concrete to flow out under gravity.

• Simultaneously start the stopwatch when the trap door is opened, and record the time for discharge to complete (flow times at T₅ minutes). This is taken to be when the Light is seen from above through the funnel.

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Testing of Specimens:
Compressive strength test on cubes:
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Fig. 16. Testing of Cubes for Compressive strength

The specimens were loaded gradually to the possible extent up to failure and the ultimate load was noted. After switching off the machine the pressure valve was released. The plates were cleaned. The procedure was repeated for testing all the cubes specimens and results are presented in Table 5.4.

Cube compressive strength $fck = P/A N/mm^2$

Where P= Ultimate load in N.

A= Area of cube specimen under loading.



Fig 17.Compressive strength test on cubes



5.5.2 Split tensile strength test on cylinders:



Fig.18. Testing of Cylinders for Split Tensile strength



Fig 19. Split tensile strength test on cylinders



Fig 20. Specimens after Split tensile strength test TEST RESULTS AND DISCUSSIONS

6.1 General:

VI.

This chapter presents the results of the tests conducted for ascertaining Self Compacting concrete properties such as workability, passing ability, filling ability for different mix proportions and also presents the results of compressive strength, split tensile strength and flexural strength tests.

6.2 Self Compactability Tests:

The results of workability tests conducted to achieve self compaction concrete are presented. The trials started at 50% volume of total concrete as content of coarse aggregate and 50% by the volume of mortar in concrete as content of fine aggregate and variation in cement, Fly Ash, water powder ratio, Superplasticizer and viscosity modifying agent were carried out to achieve the Self Compacting concrete mixes. Similarly different trials were carried out for different mix proportions until all properties of Self Compacting concrete obtained. The results of these tests are represented in table 6.2 and the graphs are drawn for these tests comparing for different mixes. The properties of Self Compacting Concrete as recommended by EFNARC are presented in Table 6.1.

S.No.	Test Method	Property	Unit	Min	Max
1	Slump flow	Filling ability / Flow ability	mm	650	800
2	Slump flow at T ₅₀ cm	Flow ability	Sec	2	5
3	V-Funnel	Filling ability / flow ability	Sec	6	12
4	Time increase, V- funnel at T5minutes	Segregation	Sec	0	+3
5 L-Box		Passing ability	Ratio	0.8	1.0

S N O	Mix	Slum p Dia (mm)	V- Funn el (sec)	V- Funne l at T5 min(se c)	L- Box (h2/h 1)
1	TR1 (SCC 1)	690	7.0		.85
2	TR2 (SCC 2)	750	8.0		.90

Table-9: Properties of SCC as per EFNARC guidelines:

1	Λ	\mathbf{O}
т	Ŧ	4

3	TR3 (SCC 3)	730	8.0	 .95
4	TR4 (SCC 4)	760	9.0	 .90
5	TR5 (SCC 5)	670	11.0	 0.85

Table – 10. Fresh Concrete Properties of SCC Fig 21. Trial No V/S Slump in Dia (mm)



Fig 22 Trial No V/S V Funnel Time in Sec



Fig 23 Trial No V/S h2/h1 Ratio

As per filling ability of the mixes was concerned the test results of V-funnel test satisfied the standard requirements.

3 trial no

h2/h1 ratio

In the total investigation, 5 trails (TR1 to TR5) were done to satisfy the Self compaction concrete characteristics. These trail mix proportions satisfy all the properties of self compaction concrete. For these mix proportions, specimens were prepared and tested to know compressive strength and split tensile strength. The results of these tests are shown in tables and the graphs are drawn for different replacement percentages of Fly ash.

olo: Hui dened concrete proper des					
S.NO	MIX	% OF	COMPRESSIVE		
		FLYASH	STRE	STRENGTH N/mm ²	
			7	14	28
			DAYS	DAYS	DAYS
1.	M-1	0	17	22.59	25.09

6.3. Hardened concrete properties

2.	M-2	5	18.74	24.81	27.57
3.	M-3	10	19.85	25.55	28.39
4.	M-4	15	19.25	24.66	27.8
5.	M-5	20	16.54	21.23	24.38

 Table -11: Average Compressive strengths of cubes



Fig. 24. Compressive Strength in N/mm V/S % of Fly Ash

S NO	MIX	% of Fly ash	Split tensile strength in N/mm2 for 28 days
1	SCC1	0	3.20
2	SCC2	5	3.51
3	SCC3	10	3.95
4	SCC4	15	3.68
5.	SCC5	20	3.12

Table – 12. Average Split Tensile Strength in N/mm2



Fig.24. Split Tensile Strength V/S % of Fly Ash

VII. CONCLUSIONS

Based on the results obtained from this study, the following Conclusions seems to be valid.

- The increase in Percentage replacement of cement with Fly ash from 0% to 10% causes increase in the compressive strength of concrete from 17.00 MPa to 19.85MPa and from 22.59 MPa to 25.55 and from 25.09MPa to 28.39MPa for 7 days, 14 days and 28 days curing respectively. Further increase in percentage replacement of cement with Fly ash from 10% to 20% causes decrease in the compressive strength of concrete from 19.85 MPa to 16.54MPa and from 25.55 MPa to 21.23 MPa and from 28.39MPa to 24.38MPa for 7 days, 14 days curing respectively.
- 2) The increase in Percentage replacement of cement with Fly ash from 0% to 10% causes increase in the Split Tensile strength of concrete from 2.08 MPa to 2.57 MPa and from 3.20 MPa to 3.95 MPa for 7 days and 28 days curing respectively. Further increase in percentage replacement of cement with Fly ash from 10% to 20% causes decrease in the Split Tensile strength of concrete from 2.57 MPa to 2.2.03 MPa and from 3.95 MPa to 3.12 MPa for 7 days and 28 days curing respectively.
- 3) SCC mix requires high powder content, lesser quantity of coarse aggregate, high range Superplasticizer to give stability and fluidity to the concrete mix.
- 4) SCC can be obtained for widely differing Fly ash contents or cement contents as long as the paste volume constituted by the water cement ratio is kept constant.
- 5) The workability of SCC is equilibrium of fluidity, deformability, filling ability and resistance to segregation. This equilibrium has to be maintained for a sufficient time period to allow for transportation, placing and finishing.
- 6) An industrial waste like fly ash iM Pairs the strength development of calcined products and hence it can be used in construction industry for preparation of concrete replacing some quantity of cement, which is a valuable ingredient of concrete to achieve economy.
- 7) With 10% replacement of cement with fly ash not only the compressive strength increased significantly with age but also the split tensile strength at 28th days increased. However, further replacement of cement with fly ash lead to drastic reduction in compressive strength.
- 8) The Mix proportions for different grades of Self Compacting Concrete are recommended as follows.

Suggestions for future work

- 1. Experiments can be conducted for producing Fibre Reinforced Self Compacting Concrete with Fly ash as admixture.
- 2. Experiments can be conducted for producing Glass Fibre Reinforced Self Compacting Concrete with Fly ash as admixture.
- 3. Durability tests such as Permeability test, Resistance to acid attack test, High temperature resistance to fire attack test etc., can be conducted on Fly ash based Self Compacting Concrete.

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