

13. Conference and Workshop "Rheological Measurement of Building Materials" FH Regensburg, Germany, March 10th / 11th 2004

Dipl. Ing. Markus Greim, Schleibinger Geräte, Buchbach, Germany

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The 13th "Rheology of Building Materials" Workshop has been held at the University of Applied Science Regensburg, Prof. Kusterle, mid of March 2003. Started with a small German 20 persons meeting in 1991, and has grown to an international conference with nearly 100 participants from the European research community as well as the application engineers from the construction materials and building industries.

Beneath the strength and durability the workability is an important property of mineral based materials like concrete, mortar, plaster etc. Up to now this properties are often still estimated or determined in a very heuristic way with spread tables, slump cones etc. In the last years the development of new additives like stabilizer and superplastizisers leads to new construction materials like self leveling screed, and self compacting concrete. This new materials are interesting in two ways. They need no kind of vibration at the building site, so they avoid noise and save a lot of manpower. They also give the architect new kinds of freedom in the building design. On the other hand this new materials a need a design regarding the rheological properties not only in a heuristic way, but with scientific methods of rheometry. Also for standard materials this methods are coming more convenient.

This development is shown in the topics of the presented papers 2004 in Regensburg. They can coarsely divided in three groups: General lessons regarding the rheology of building materials, the effects of additives and admixtures and the self compacting concrete (SCC).

Building materials like cement paste, mortar, or a lime putty are unfortunately not only non-Newton but also dependent in time and shear-history.

A.Eberhard, from the Finger-Institute, University Weimar, Germany, presented in his paper the influence of the hydration of C_3A , the several sulfate forms and the kiln-fines to the stiffening of Portland-cement. Parallel to the characterization of the hydration process with several methods like microscopy (ESEM-FEG), DSC, X-ray analysis, the stiffening of the cement paste was tested with a constant shear rate. It can be shown that there is a strong correspondence between the hydration and shear resistance measured by the rheometer. After the first phase initial reactions the stiffening can be divided in two other phases. First during the hydration of aluminate the water needed for the hydration is no longer available for the flow process. Therefore all effects pushing the aluminate-reaction like more fines or more calcium-sulfate will cause a stiffening. Later there is a stiffening due to structural changes. If there is less sulfate there are growing, beneath ettringite, monosulfoaluminate (Afm) phases which are supporting the agglomeration of the cement paste. If there is to much sulfate beneath ettringite gypsum is growing also causing a stiffening of the cement paste. In the conclusion it can be shown that the rheological properties of the cement paste can be optimized by the fines as well as a reducing of the aluminate-hydration by an sulfate optimized cement.

Mrs. Vavorva from the Department of chemical technology of monuments conservation, ITC Praha Czech Republic, did her research on the rheological properties of lime putty. Calcium oxide CaO , also called quick lime, is slacked with water to calcium hydroxide $Ca(OH)_2$. After this process there is a curing period necessary from three weeks up to several years. This curing may be accelerated by a mechanical ac-

tivation. It can be shown that the freshly prepared lime putty has a viscosity two levels below the matured lime putty. A mechanical activation of fresh lime putty by mixing it 15 minutes rises the viscosity nearly to the same level than the matured one. Also inorganic salts have an influence on the viscosity of the lime putty, but not so strong than the mixing effects. So controlling the rheological parameters prior to application can avoid using inadequate materials on historical buildings and monuments.

E.Schneider, SAFA Baden-Baden, Germany, demonstrates a concept for a concrete design process based on the rheological properties of cement-paste and mortar to predict the workability (spread table value) of fresh concrete. This development is based on the work of J.Teubert [1] in 1981. A cement paste with a fix water-cement ratio and no segregation effects is designed, which is as fluid as possible. If necessary additives like fly ash or plasticizers are used to get an optimal paste. In the next step the mortar is filled with the fine aggregates up to two millimeters. The consistence of this mortar is determined by a mortar rheometer. With the equation of Teubert you can now calculate the spread table value at a fix amount of mortar, or you can determine the volume of mortar you need to get a certain spread table value. Schneider validates this equation, with some modification for modern superplasticizer. Also the influence of other admixtures can be integrated in this design concept.

Dr. J.Golaszewski, University Gliwice, Poland, shows the influence of air entraining agents on the rheological properties of superplasticized mortars. Air bubbles in the concrete are important for the durability of concrete against a frost thaw attack. From the rheological point of view air entraining agents (AE) lowers the viscosity as well as the yield stress of a mortar. Superplasticizers (SP) generally lowers the plastic viscosity. In detail this trends depends on the (chemical) compatibility of the used cement, SP and the AE. It is known that reducing the amount of water in the mortar rises the viscosity and the yield stress of the mortar. This effect, working in the opposite to the AEs may be used to compensate the rheological effects of the AEs.

Dr. O.Wallevik, IBRI Reykjavik, Island presented a rheological study on interaction between different types of cements and dispersing admixtures.

The second part of the colloquium was concerned with

self compacting concrete (SCC).

S. Uebachs, University Aachen, ibac, Germany, was discussing the influence of several SPs varying the temperature in the rheological behavior of superplasticized mortars. Figure 1 shows the differences between several SPs using the same cement. The shear value at constant shear rate for several SPs and the same cement. It was also pointed out that mortars used for SCC are more according to the Bulky-Herschel than to the Bingham-model.

H.Eckhardt, Readymix Institut, Ratingen, Germany, shows in his lesson "rheometry and praxis" the application of rheological methods for the design and quality testing during a big building project for (BMW, Leipzig, Germany) for more than 4000m³ of SCC. Also in this study the influence of the temperature in the power of modern SPs was shown. The workability of standard concretes is mostly influenced by the yield stress whereas the plastic viscosity is quite low. In the opposite the workability of SCC is mostly influenced by the viscosity.

S. Kordts, VDZ Düsseldorf, Germany presented a simple piece of test equipment, the so-called "flow cone". It was developed in order to simplify the amount of testing when SCC is delivered as ready-mixed concrete. That is suitable for site conditions, with which the two decisive test slump flow and V-funnel flow time for describing the required fresh concrete properties of an SCC can be determined reliably in a single test. The flow cone is a normal commercial slump cone mounted on an appropriate supporting stand and closed off at the bottom by a slide. A flow nozzle with an outlet diameter of 63.5 mm exhibiting the same slope of the slump cone was attached to the underside of the support. After the SCC was poured into the flow cone and the slide was removed the time was measured the SCC needed to flow out of the flow cone. With the SCC investigated here the same flow times were measured as those obtained using the V-funnel with low-viscosity and higher-viscosity SCC, respectively. The slump flow measured at the same time was not affected by the tapered shape when compared with the conventional slump cone test. The flow cone therefore represents an alternative way of determining the viscosity of SCC that can be used particularly advantageously for acceptance testing on site.

M. Greim, Schleibinger Geräte, Buchbach, Germany, answered some frequently asked questions, regarding

the rheometry of building materials. It was shown that the measuring a Bingham fluids like mortar at low shear rates with a standard geometry like cylinder-cylinder will not shear the material completely. In the gap between sheared and non sheared material the fluid phase will be separated from the coarse. This effect, often called wall slip, is independent from the roughness of the cylinder-material. At higher shear rates the complete material is sheared, but centripetal forces will cause segregation. Gravity will cause also sedimentation. This effects can be avoided by mixing the mortar and removing the mortar by a scraper from the specimen container during the measurement. A so designed measuring-mixer like the Viskomat NT has no well defined geometry. A calibration can be done for Newton fluids. Unfortunately for mortar this is quite useless because most mortars are non-Newton fluids.

After the colloquium at March, 10th things are furthermore discussed at the evening in a typical restaurant located the historical city of Regensburg. On March, 11th at a laboratory workshop some basic principles of rheology of building materials were demonstrated in a quite practical way. Tests with a mortar (rheometer Viskomat NT), and furthermore with a concrete based on this mortar (rheometer BT2) showed the participants how to transfer results between the laboratory to the building site.

The next Regensburg colloquium and workshop will take place mid of March 2005 at the FH Regensburg.

[1] Teubert, J.: Die Messung der Konsistenz von Betonmörtel und ihre Bedeutung für die Verarbeitungseigenschaften des Frischbetons, BETONWERK+FERTIGTEIL-TECHNIK, 4 (1981) 217-222.

Most of the papers are completely presented at <http://www.schleibinger.com/k2004/regen04US.html>

M. Greim
Schleibinger Geräte GmbH
Gewerbestraße 4
84428 Buchbach Germany
e-mail: greim@schleibinger.com

Prof. Dr. W. Kusterle
Fachhochschule Regensburg, FB Bauingenieurwesen
Prüfener Str. 58
93049 Regensburg, Germany
e-mail: wolfgang.kusterle@bau.fh-regensburg.de