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Standard Specification for Functional Additions for Use in Hydraulic Cements¹

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1. Scope*

1.1 This specification covers methods to investigate the effectiveness of a material to beneficially change the properties of hydraulic cements when the material is incorporated during manufacture of the cement.

1.2 The values stated in SI units are to be regarded as standard. No other units of measurement are included in this standard.

1.3 The effect of additions in cement may markedly change properties other than those they are intended to modify. This specification is designed to test for such changes. **Table 1** sets forth values for those properties of cement pastes and mortars that would permit a judgment of the changes effected by an addition. Likewise, **Table 2** sets forth similar criteria for concrete. Certain additions may be found effective for more than one purpose as indicated in **3.1.4** and **3.1.5**.

1.4 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 ASTM Standards:²

- C10/C10M Specification for Natural Cement
- C39/C39M Test Method for Compressive Strength of Cylindrical Concrete Specimens
- C78 Test Method for Flexural Strength of Concrete (Using Simple Beam with Third-Point Loading)
- C109/C109M Test Method for Compressive Strength of Hydraulic Cement Mortars (Using 2-in. or [50 mm] Cube Specimens)

¹ This specification is under the jurisdiction of ASTM Committee C01 on Cement and is the direct responsibility of Subcommittee C01.20 on Additions.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

- C143/C143M Test Method for Slump of Hydraulic-Cement Concrete
- C150 Specification for Portland Cement
- C151 Test Method for Autoclave Expansion of Hydraulic Cement
- C157/C157M Test Method for Length Change of Hardened Hydraulic-Cement Mortar and Concrete
- C187 Test Method for Amount of Water Required for Normal Consistency of Hydraulic Cement Paste
- C219 Terminology Relating to Hydraulic and Other Inorganic Cements
- C226 Specification for Air-Entraining Additions for Use in the Manufacture of Air-Entraining Hydraulic Cement
- C232 Test Method for Bleeding of Concrete
- C234 Test Method for Comparing Concretes on the Basis of the Bond Developed with Reinforcing Steel (Withdrawn 2000)³
- C266 Test Method for Time of Setting of Hydraulic-Cement Paste by Gillmore Needles
- C403/C403M Test Method for Time of Setting of Concrete Mixtures by Penetration Resistance
- C451 Test Method for Early Stiffening of Hydraulic Cement (Paste Method)
- C465 Specification for Processing Additions for Use in the Manufacture of Hydraulic Cements
- C595 Specification for Blended Hydraulic Cements
- C596 Test Method for Drying Shrinkage of Mortar Containing Hydraulic Cement
- C666/C666M Test Method for Resistance of Concrete to Rapid Freezing and Thawing
- C845 Specification for Expansive Hydraulic Cement
- C1157 Performance Specification for Hydraulic Cement

3. Terminology

3.1 Definitions:

3.1.1 *accelerating addition*—a functional addition that accelerates the setting or early strength, or both, of concrete and mortar.

3.1.2 *retarding addition*—a functional addition that retards the setting of concrete and mortar.

³ The last approved version of this historical standard is referenced on www.astm.org.

*A Summary of Changes section appears at the end of this standard

TABLE 1 Criteria for Evaluating Neat Cement and Mortar Containing Functional Cement Additions

Tests	Type of Addition					
	Water Reducing	Retarding	Accelerating	Water-Reducing and Retarding	Water-Reducing and Accelerating	Set-Control
Normal consistency, deviation from control, percentage points ^A	-1.0 min	+1.0 max	+1.0 max	-1.0 min	-1.0 mm	±1.0 max
Standard consistency (flow) deviation from control, percentage points ^A	-4.0 min	+2.0 max	+2.0 max	-4.0 min	-4.0 min	±2.0 max
Setting time, (Gillmore) deviation from control, h:min						
Initial						
At least	...	1:00 later ^B		1:00 later ^B		...
Not more than	1:00 earlier nor 1:30 later	3:30 later	1:30 earlier nor 1:30 later	3:30 later	1:30 earlier nor 1:30 later	1:00 earlier nor 1:30 later
Setting time, Vicat Initial ^C						
At least	...	0:50 later ^B
Not more than	0:50 earlier nor 1:15 later	2:50 later	1:15 earlier nor 1:15 later	0:50 later ^B	1:15 earlier nor 1:15 later	0:50 earlier nor 1:15 later
Final						
Not more than	1:00 earlier nor 1:30 later	3:30 later	1:00 earlier nor 1:30 later	3:30 later	1:00 earlier nor 1:30 later	1:00 earlier nor 1:30 later
Compressive strength, min, percent of control: ^D						
1 day in moist air	110	90	125 ^E	90	125	^F
1 day in moist air, 2 days in water	110	90	125 ^E	100	125	
1 day in moist air, 6 days in water	110	90	100	110	110	
1 day in moist air, 27 days in water	110	95	95	110	110	
Autoclave Expansion						
max increase in % change in length compared to control	0.10	0.10	0.10	0.10	0.10	0.10
Drying Shrinkage of Mortar						
max % change in length compared to control	0.020	0.020	0.030	0.020	0.020	0.020

^A The minus sign indicates that the percentage of water required shall be less than that of the control cement by at least the indicated percentage points.

^B Or 50 % later, whichever is the lesser.

^C Either Vicat or the Gillmore time of setting method shall be used at the choice of the manufacturer.

^D The compressive strength of mortar containing the test cement shall be not less than 95 % of that attained at any previous test age. The objective of this limit is to require that the strength of mortar containing the addition under test shall not decrease with age.

^E In cases where the accelerated set time only is required, the strength can be reduced to 100 % of the control.

^F The grand average of the 1, 3, 7, and 28-day strengths shall be not less than 95 % of the grand average for the corresponding control cement.

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5. Materials

3.1.3 *set-control addition*—a functional addition composed essentially of calcium sulfate in any hydration state from CaSO₄ to CaSO₄·2H₂O.

3.1.4 *water-reducing addition*—a functional addition used to reduce the quantity of mixing water required to produce concrete and mortar of a given consistency.

3.1.5 *water-reducing and accelerating addition*—a functional addition that reduces the quantity of mixing water required to produce concrete of a given consistency and that accelerates the setting or early strength development, or both, of concrete and mortar.

3.1.6 *water-reducing and retarding addition*—a functional addition that reduces the quantity of mixing water required to produce concrete and mortar of a given consistency and simultaneously retards the setting of concrete and mortar.

NOTE 1—This section is intended to provide a specification that may be applied to calcium sulfates as defined in Terminology C219.

NOTE 2—It should be realized that some calcium sulfates, particularly some byproduct calcium sulfates, have produced cements with undesired set behavior after storage.

4. Ordering Information

4.1 The purchaser shall specify the type of functional addition desired.

5.1 *Cements*—The cements used in the evaluation of the addition shall be as described in Section 3.1, Cements, of Specification C465 with the following exceptions:

5.1.1 At least one of the Type I cements shall contain not less than 9 percent tricalcium aluminate (C₃A).

5.1.2 Disregard the last sentence of Section 3.1.6 of Specification C465 and substitute the following: “ Each control cement shall comply with all the requirements in the specification (C10/C10M, C150, C595, C845, and C1157) applicable to that type of cement. The method shall be adequate for the qualitative and quantitative determination of the addition in the finished cement, and shall be fully described in the report of the tests on the addition.”

5.2 *Aggregates*—The aggregates used in the evaluation of the addition shall be in accordance with the Aggregates portion of the Materials section of Specification C465, using proportions specified in Concrete Mixtures section of that specification.

6. General Requirements

6.1 The cement, mortar, and concrete in which each of the additions is used shall conform to the respective requirements

TABLE 2 Criteria for Evaluating Concrete Containing Functional Cement Additions^A

Tests	Type of Addition				
	Water Reducing	Retarding	Accelerating	Water-Reducing and Retarding	Water-Reducing and Accelerating
Water content, max, percent of control	95	95	95
Time of setting, (penetration) deviation from control, h:min:					
Initial					
At least	...	1:00 later ^B		1:00 later ^B	
Not more than	1:00 earlier nor	3:30 later	3:30 earlier	3:30 later	3:30 earlier
Final	1:00 later				
Not more than	1:00 earlier nor 1:30 later	3:30 later	...	3:30 later	...
Compressive strength, min, percent of control: ^C					
1 day ^D	110	85	125 ^E	100	125
3 days	110	85	125 ^E	100	125
7 days	110	90	100	110	110
28 days	110	90	95	110	110
3 months	100	90	95	100	100
1 year	100	90	95	100	100
Flexural strength, min, percent of control: ^C					
1 day ^D	100	85	110	90	110
3 days	100	85	110	100	110
7 days	100	90	100	100	100
28 days	100	90	90	100	100
3 months	100	90	90	100	100
1 year	100	90	90	100	100
Bond strength, percent of control:					
28 days	100	90	100	100	100
Volume change, expressed as change in length, max, increase over control, percentage points:					
28 days	0.010	0.010	0.030	0.010	0.010
3 months	0.010	0.010	0.030	0.010	0.010
1 year	0.010	0.010	0.030	0.010	0.010
Durability factor, min, percent of control ^F	80	80	80	80	80

^A The values in the table are intended to allow for normal variation in test results. For example, the object of the 90 % compressive strength requirement for a retarding addition is to require a level of performance comparable to that of the reference concrete.

^B Or 50 % later, whichever is the lesser.

^C The compressive and flexural strength of the concrete containing the addition under test at any test age shall be not less than 90 % of that attained at any previous test age. The objective of this limit is to require that the compressive or flexural strength of the concrete containing the addition under test shall not decrease with age.

^D One-day strengths applicable only to Type III cement. One-year strength tests shall be made; however, the addition may be approved after completion of the 3-month strength results, at the discretion of the purchaser.

^E In cases where the accelerated set time only is required, the strength can be reduced to 100 % of the control.

^F This requirement is applicable only when the addition is to be used in air-entrained concrete.

prescribed in **Table 1** and **Table 2**, except that if the test cement fails to meet the requirements of **Table 1**, but possesses all the requirements listed in **Table 2**, then the requirements of **Table 2** shall govern approval of the addition.

6.2 The trade name, source, and character of the material shall be specified and the means for the quantitative determination of the proposed addition in the finished cement, shall be furnished by the manufacturer or seller of the addition, and the results of such pertinent quantitative analysis shall form a part of the record of tests of the addition.

6.3 At the request of the purchaser of an addition for a specific functional purpose, the manufacturer shall state in writing the content of any substance which is known to or believed to impair other desirable properties of the cement or concrete.

6.4 The additions shall be evaluated by comparing cements containing the “test addition” to cements ground from similar

clinkers from the same source. Those cements without test additions are referred to in this specification as “control cements.”

6.4.1 *Special Provisions for Set-Control Additions Conforming to 3.1.3:*

6.4.1.1 The additions shall be evaluated by comparing cements containing the “test addition” to control cements ground from similar clinkers from the same source and under the same grinding conditions with the mill temperatures being within ± 3 °C (5 °F) of the same value. The control cements shall be produced with calcium sulfate at any hydration state having a past record of satisfactory usage as an addition for portland cement.

6.4.1.2 Each test cement shall contain sufficient test addition CaSO₄ to produce a sulfur trioxide (SO₃) content that differs by no more than 0.24 percentage points from that of the control cement. The SO₃ shall be expressed as a percentage of the mass of the cement and reported to the nearest 0.01 %.