



Designation: C980 – 23

Standard Specification for Industrial Chimney Lining Brick¹

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1. Scope*

1.1 This specification covers solid kiln fired brick made from clay, shale, or mixtures thereof suitable for use in masonry construction in contact with the chemicals present in flue gases found in industrial chimneys.

1.2 The brick and tile covered herein are intended for use in harsh chemical environments where resistance to thermal shock may be a consideration. These brick are normally used with chemical-resistant mortars.

1.3 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.4 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.5 *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

[C20 Test Methods for Apparent Porosity, Water Absorption, Apparent Specific Gravity, and Bulk Density of Burned Refractory Brick and Shapes by Boiling Water](#)

[C67/C67M Test Methods for Sampling and Testing Brick and Structural Clay Tile](#)

[C1232 Terminology for Masonry](#)

¹ This specification is under the jurisdiction of ASTM Committee C15 on Manufactured Masonry Units and is the direct responsibility of Subcommittee C15.02 on Brick and Structural Clay Tile.

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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.

[E11 Specification for Woven Wire Test Sieve Cloth and Test Sieves](#)

3. Terminology

3.1 *Definitions*—For definitions relating to industrial chimney lining brick, refer to Terminology [C1232](#).

4. Classification

4.1 The physical and chemical properties of chimney lining brick differ from supplier to supplier mainly because their composition is determined by the source of raw materials. Chimney lining brick, regardless of these differences, are considered to be of three types noted as follows:

4.1.1 *Type I*—For use where low absorption and high acid resistance are not major factors.

4.1.2 *Type II*—For use where lower absorption and higher acid resistance are required.

4.1.3 *Type III*—For use where lowest absorption and highest acid resistance are required.

NOTE 1—Types I, II, and III may not differ significantly in their resistance to thermal shock, and selection of brick type should be based upon their absorption and acid-resistant service requirements.

5. Physical Properties and Chemical Resistance Requirements

5.1 *Compressive Strength*—When tested in accordance with Test Methods [C67/C67M](#), Section 6 (Compressive Strength), the brick shall conform to the requirements for “Minimum Compressive Strength” as shown in [Table 1](#).

5.2 *Water Absorption*—When tested in accordance with Test Methods [C20](#), the brick shall conform to the requirements for “Maximum Water Absorption by 2-h Boiling” as shown in [Table 1](#).

5.3 *Sulfuric Acid Boil Test*—When tested in accordance with Section [8](#), the brick shall conform to the requirements for “Maximum Average Weight Loss by H₂SO₄ Boil Test” as shown in [Table 1](#).

6. Dimensions, Mass, and Permissible Variations

6.1 *Sizes*—The sizes of brick shall be as specified by the purchaser. When tested in accordance with Test Methods [C67/C67M](#), Section 11 (Measurement of Size), the brick shall conform to the requirements for “Permissible Variations in Dimensions” as shown in [Table 2](#).

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

TABLE 1 Physical Properties and Chemical Resistance Requirements^A

Designation	Minimum Compressive Strength, Gross Area, psi (MPa)		Maximum Water Absorption by 2-h Boiling, %		Maximum Average Weight Loss by H ₂ SO ₄ Boil Test, %
	Average of 10	Individual	Average of 10	Individual	
Type I	8 500 (58.6)	8 000 (55.2)	6.0	7.0	20
Type II	10 000 (69.0)	9 000 (62.2)	4.0	5.0	12
Type III	12 000 (82.8)	10 000 (69.0)	1.0	1.5	8

^A One complete set of tests for each of the above requirements shall be performed from brick randomly selected from every 100 000 bricks.

TABLE 2 Permissible Variations in Dimensions and Warpage^A

Dimensions	Dimensions		
	Maximum Permissible Variations in Dimensions Between Largest and Smallest Brick in a Random Sampling of 10 Brick, %	Warpage Maximum Face and Diagonal Dimensions, in. (mm)	Maximum Permissible Deviation, in. (mm)
Height	3	up to 9 ½ (241) incl	¼ (3.0)
Length	5
Width	5

^AOne complete set of tests for each of the above requirements shall be performed from brick randomly selected from every 100 000 bricks.

6.2 *Warpage*—When tested in accordance with Test Methods C67/C67M, Section 12 (Measurement of Warpage), the tolerance on warpage of the brick shall be as indicated in Table 2.

7. Finish and Appearance

7.1 *Black Heart*—Brick when broken may have a dark area that has a steely appearance and is sharply delineated from the surrounding normal color of the brick it is known as black heart or black core. Black heart is generally the result of the reduction of iron minerals during the firing process. Its presence, regardless of size in brick that otherwise meet the physical and chemical requirements of this specification, shall not be cause for rejection.

7.2 *Texture*—Scoring or matte texturing, or both, of the brick is recommended. However, no flutes or scores shall exceed ⅛ in. (3.0 mm) in height of protrusion or in depth.

7.3 *Surface Defects*—The brick and tile shall be free of open surface laminations or cracks which would impair the performance of the construction.

NOTE 2—Open laminations or cracks within the brick or tile observed in the brick or tile cut or broken during testing, should be noted with their size and number indicated as part of the test report. If internal open laminations or cracks, or both, are reported, the purchaser shall determine the suitability of such brick or tile for his application.

8. Sulfuric Acid Solubility Test

8.1 *Significance and Use*—This test with sulphuric acid represents an extremely severe one and may not be significant for chemical-resistant brick in less demanding applications. It can be assumed that sulphuric acid in this test concentration will be more corrosive than most other acids excluding those containing flourine. A similar test procedure using other chemicals may be more suitable for specific purposes. The

performance of these other tests and appropriate qualifying data should be resolved between the purchaser and the seller.

8.2 Apparatus:

8.2.1 *Crusher*, jaw-type.

8.2.2 *Sieves*, ¼-in. (6.3-mm) and No. 4 (4.75-mm), (equivalent to 3-mesh and 4-mesh sieves, respectively, in the Tyler series), conforming to Specification E11.

8.2.3 *Mechanical Shaking Device*, producing a lateral and vertical motion of the sieve, accompanied by a jarring action so as to keep the sample moving continuously over the surface of the sieve.

8.2.4 *Drying Oven*.

8.2.5 *Analytical Balance and Weights*, 0.01-g sensitivity.

8.2.6 *Desiccator*.

8.2.7 *Erlenmeyer Flask*, 750-mL, of heat-resistant and chemically resistant glass.

8.2.8 *Water-Cooled Condenser*.

8.2.9 *Hot Plate*.

8.2.10 *Fritted-Glass Funnel*, fine porosity.

8.2.11 *Suction Pump*.

8.3 *Preparation of Sample*—Prepare the sample from at least five masonry units selected in accordance with Test Methods C67/C67M. Remove the skin surface from a quarter of each unit selected, and crush the remaining pieces in a jaw-type crusher, with the jaws set so that the grain size of the product ranges from material retained on a ¼-in. (6.3-mm) sieve to material passing a No. 4 (4.75-mm) sieve. Reduce this material either by mixing and quartering or by a mechanical splitter to approximately a 1000-g sample, and screen in a mechanical shaking device for 15 min, using the No. 3 and No. 4 sieves. Thoroughly mix the portion of the material passing the No. 3 sieve and remaining on the No. 4 sieves (Note 3), and then quarter down to obtain two 50-g samples. Dry these samples in a drying oven at 221 to 239°F (105 to 115°C) for at least 16 h, and then cool in a desiccator.

NOTE 3—Although it is recognized that some types of material tend to break down in a manner yielding various-shaped particles, no attempt shall be made at hand selection.

8.4 *Procedure*—Transfer each of the 50-g samples, weighed to the nearest 0.01 g, and 250 mL of sulfuric acid (sp gr 1.706) or 60° Baumé (78 weight %) into separate 750-mL Erlenmeyer flasks. Insert water-cooled condensers and boil on hot plates for 48 h (Note 4). Cool the flasks and contents sufficiently to permit handling, and decant the solutions through fritted-glass funnels with the aid of suction, retaining the samples in the flasks. Add about 250 mL of water to the flasks, boil for 10 min, and decant with the aid of suction through the same funnels as used previously. Repeat this washing procedure three times. On the fourth decantation of wash water, transfer