



Designation: E1512 – 01 (Reapproved 2023)

Standard Test Methods for Testing Bond Performance of Bonded Anchors¹

This standard is issued under the fixed designation E1512; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 These test methods cover instructions for making a variety of tests for the strength of the adhesive bond developed between a steel anchor and the surface of a hole in concrete or masonry (including masonry units and mortar joints) and for assessing the effects on such bond of a variety of factors including elevated temperature, fire, moisture, and freezing and thawing action. The specifier or manufacturer shall select those tests that are appropriate for the given anchoring system and intended application.

1.2 The adhesive-bonded anchor system refers to a smooth or deformed steel bar or threaded rod, set in a predrilled hole containing chemical bonding compounds. Loads are transferred mainly by the bond of the adhesive both to the anchor and the surrounding elements along the sides of the hole. For anchoring systems made of significantly different materials, these test methods shall be taken as a guideline.

1.3 These test methods apply to all adhesives used to bond steel anchors or steel reinforcement bars (rebar) to concrete or masonry. These test methods apply to anchorages used in uncracked concrete or masonry. They do not apply to the use of the anchor in the concrete tension zone. The usual forces applied during the tests are in tension, shear, and under a combination of both tension and shear.

1.4 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.

1.5 *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.*

1.6 *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

C666/C666M Test Method for Resistance of Concrete to Rapid Freezing and Thawing

E119 Test Methods for Fire Tests of Building Construction and Materials

E488/E488M Test Methods for Strength of Anchors in Concrete Elements

E575 Practice for Reporting Data from Structural Tests of Building Constructions, Elements, Connections, and Assemblies

3. Terminology

3.1 *Definitions of Terms Specific to This Standard:*

3.1.1 *baseline test*—restrained test conducted on anchors installed in the same test member and under the same installation method as a required environmental test for comparison purposes.

3.1.2 *bonded anchor*—a fastener placed in hardened concrete or masonry that derives its holding strength from a chemical compound placed between the wall of the hole and the embedded portion of the anchor.

4. Significance and Use

4.1 These test methods are intended to provide information from which applicable design data and specifications are derived for a given anchorage device and for qualifying anchors or anchorage devices.

4.2 These test methods shall be followed to ensure reproducibility of the test data.

5. General Requirements

5.1 The adhesive bonded anchors to be tested shall be representative of the product made available for typical field

¹ These test methods are under the jurisdiction of ASTM Committee E06 on Performance of Buildings and are the direct responsibility of Subcommittee E06.13 on Structural Performance of Connections in Building Construction.

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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.

installations. The manufacturer shall provide information on physical, mechanical, and chemical properties of the anchor system. If required by a customer or approval agency, the testing laboratory shall verify, or have a specialized laboratory verify, the physical, mechanical, and chemical properties of the adhesive.

5.2 The installation equipment, instructions, and procedures shall be as specified by the manufacturer. If there are any deviations from the manufacturer's instructions when testing commercial anchors, they shall be described in the report.

5.3 The structural members shall be as described in Test Methods [E488/E488M](#).

5.4 The test and measuring equipment for performing static tension and shear tests, as well as dynamic tests, are described in Test Methods [E488/E488M](#). For performing long-term creep tests, equipment that will sustain the required loads without distress shall be used.

6. Materials and Manufacture

6.1 The adhesive-bonded anchors shall be installed for use in accordance with written instructions of the manufacturer. An inert filler that does not affect the performance of the components, if specified by the manufacturer, shall be uniformly incorporated in one or both bonding components.

7. Procedure

7.1 This section presents the specific tests that shall be performed as required to evaluate the bonded anchor system. When evaluating bonded anchors in concrete, the concrete strength shall be 3000 psi \pm 500 psi (20 MPa \pm 3 MPa) compressive strength, unless otherwise specified, using aggregate of river gravel or crushed rock. Cure the concrete for a minimum of 28 days. Condition the test member to 75 °F \pm 10 °F (24 °C \pm 5 °C) prior to anchor installations, unless otherwise specified. Masonry shall be permitted to be used as the test member.

7.2 Static Tests:

7.2.1 Perform tension and shear tests in accordance with Test Methods [E488/E488M](#). All sizes are to be tested at both minimum and maximum embedments expected. Shear tests at the maximum embedment shall be permitted to be excluded if shear tests at a shallower embedment result in a steel failure. If there is a difference greater than nine anchor diameters between these embedments additional intermediate embedments shall be tested. Clean holes and install anchors as specified by the manufacturer. Measure and record hole diameters and/or drill bit diameters. Install and cure anchors at 75 °F \pm 10 °F (24 °C \pm 5 °C).

7.3 Dynamic Tests:

7.3.1 *Fatigue Tests*—Perform fatigue tests in accordance with Test Methods [E488/E488M](#).

7.3.2 *Seismic Tests*—Perform seismic tests in accordance with Test Methods [E488/E488M](#).

7.4 Environmental Tests:

7.4.1 The tests given in [7.4.3 – 7.4.8](#) are designed to determine the effect of loading and environmental influences

on the bond strength of the adhesive. To ensure bond failure, use steel of sufficiently high strength to prevent steel failure of the anchor. To provide comparative standardized data, anchors shall be ½ in.–13 UNC Threaded Rod, unless otherwise specified (12 mm), and be embedded 4.5 in. \pm 0.1 in. (115 mm \pm 2.5 mm). Test anchors of other diameters when specified by the purchaser or manufacturer. Install and cure all anchors at 75 °F \pm 10 °F (24 °C \pm 5 °C), unless specified otherwise. Install and cure anchors according to the manufacturer's instructions, unless directed otherwise.

7.4.2 The tests given in [7.4.3 – 7.4.8](#) shall be conducted as restrained tests or unrestrained tests, unless the section in question requires a specific test. A restrained test is defined as a test conducted in accordance with Test Methods [E488/E488M](#) except that the test equipment support clearance requirements of Test Methods [E488/E488M](#) do not apply. The reaction base shall be approximately equal to the drilled hole diameter for the anchor to preclude concrete or masonry failure, but allow bond failure. An unrestrained test is defined as a test conducted in accordance with Test Methods [E488/E488M](#). If the environmental tests are conducted as restrained tests, baseline tests are required for comparison purposes. Baseline tests are defined as restrained tests conducted on three ½ in. (12 mm) anchors embedded 4.5 in. \pm 0.1 in. (115 mm \pm 2.5 mm) in the same base material using the same installation method as the required environmental test. If the environmental tests are conducted as unrestrained test, baseline tests are not required.

7.4.3 *Test on Short-term Effect of Fire*—The purpose of this test is to determine anchor performance when subjected to the temperatures and times given in the fire-temperature curve in Test Methods [E119](#). This test shall be conducted in the unrestrained mode. Install and test a minimum of three anchors. Use a test member that is sufficiently large (36 in.² (1 m²)) to give realistic concrete or masonry response to the fire temperature exposure in the vicinity of the test anchor. Condition the test member in accordance with Test Methods [E119](#) under the “Protection and Conditioning of Test Specimen” section. A typical set-up is shown in [Fig. 1](#). During testing, subject the anchors to a constant tension load. This load shall be the allowable load for the anchor as determined in [7.2](#), or other load as specified by the manufacturer. Maintain the load as the fire temperature is increased in accordance with the Test Methods [E119](#) time-temperature curve. Record temperature and displacement readings at 1-min increments until failure occurs.

7.4.4 *Radiation Test*—Perform these tests where the radiation resistance of the adhesive is required. The tests shall be conducted as restrained tests, or unrestrained tests. If testing is conducted in the restrained mode, baseline tests are required. Install and test a minimum of three anchors. Expose the test specimens to a minimum gamma radiation level of 2 \times 10⁷ rads. Conduct tension tests and compare the irradiated anchor results to the baseline test results if the radiation tests were conducted in the restrained mode. Compare the irradiated anchor results to the results determined in [7.2](#) for the same size anchor if the radiation tests were conducted in the unrestrained mode. Upon completion of the tests, the testing agency shall be