



Designation: **C311/C311M – 22 C311/C311M – 24**

Standard Test Methods for Sampling and Testing Fly Coal Ash or Natural Pozzolans for Use in Portland-Cement Concrete¹

This standard is issued under the fixed designation C311/C311M; 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.

This standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope*

1.1 These test methods cover procedures for sampling and testing fly coal ash and raw or calcined pozzolans for use in portland-cement concrete.

1.2 The procedures appear in the following order:

Sampling	Sections 7
CHEMICAL ANALYSIS	
Reagents and apparatus	10
Moisture content	11 and 12
Loss on ignition	13 and 14
Silicon dioxide, aluminum oxide, iron oxide, calcium oxide, magnesium oxide, sulfur trioxide, sodium oxide and potassium oxide	15
Available alkali	16 and 17
Ammonia	18
PHYSICAL TESTS	
Density	19
Fineness	20
Increase of drying shrinkage of mortar bars	21 – 23
Soundness	24

¹ These test methods are under the jurisdiction of ASTM Committee C09 on Concrete and Concrete Aggregates and are the direct responsibility of Subcommittee C09.24 on Supplementary Cementitious Materials.

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

Air-entrainment of mortar	25 and 26
Strength activity index with portland cement	27—30
<u>Strength activity index</u>	<u>27 – 30</u>
Water requirement	31
Effectiveness of Fly Ash or Natural Pozzolan in Controlling Alkali-Silica Reactions	32
<u>Effectiveness of Coal Ash or Natural Pozzolan in Controlling Alkali-Silica Reactions</u>	<u>32</u>
Effectiveness of Fly Ash or Natural Pozzolan in Contributing to Sulfate Resistance	34
<u>Effectiveness of Coal Ash or Natural Pozzolan in Contributing to Sulfate Resistance</u>	<u>34</u>

1.3 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system are not necessarily exact equivalents; therefore, to ensure conformance with the standard, each system shall be used independently of the other, and values from the two systems shall not be combined.

NOTE 1—Sieve size is identified by its standard designation in Specification E11. The alternative designation given in parentheses is for information only and does not represent a different standard sieve size.

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 The text of this standard references notes and footnotes that provide explanatory information. These notes and footnotes (excluding those in tables) shall not be considered as requirements of this standard.

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

- C109/C109M Test Method for Compressive Strength of Hydraulic Cement Mortars (Using 50 mm [2 in.] Cube Specimens)
- C114 Test Methods for Chemical Analysis of Hydraulic Cement
- C125 Terminology Relating to Concrete and Concrete Aggregates
- C150/C150M Specification for Portland Cement
- C151/C151M Test Method for Autoclave Expansion of Hydraulic Cement
- C157/C157M Test Method for Length Change of Hardened Hydraulic-Cement Mortar and Concrete
- C185 Test Method for Air Content of Hydraulic Cement Mortar
- C188 Test Method for Density of Hydraulic Cement
- C204 Test Methods for Fineness of Hydraulic Cement by Air-Permeability Apparatus
- 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
- C227 Test Method for Potential Alkali Reactivity of Cement-Aggregate Combinations (Mortar-Bar Method) (Withdrawn 2018)³
- C430 Test Method for Fineness of Hydraulic Cement by the 45- μm (No. 325) Sieve
- C441/C441M Test Method for Effectiveness of Pozzolans or Ground Blast-Furnace Slag in Preventing Excessive Expansion of Concrete Due to the Alkali-Silica Reaction
- C595/C595M Specification for Blended Hydraulic Cements
- C604 Test Method for True Specific Gravity of Refractory Materials by Gas-Comparison Pycnometer
- C618 Specification for Coal Ash and Raw or Calcined Natural Pozzolan for Use in Concrete
- C670 Practice for Preparing Precision and Bias Statements for Test Methods for Construction Materials

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.

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

C778 Specification for Standard Sand

C1012/C1012M Test Method for Length Change of Hydraulic-Cement Mortars Exposed to a Sulfate Solution

C1437 Test Method for Flow of Hydraulic Cement Mortar

C1697 Specification for Blended Supplementary Cementitious Materials

D1426 Test Methods for Ammonia Nitrogen In Water

D4326 Test Method for Major and Minor Elements in Coal Ash By X-Ray Fluorescence

E11 Specification for Woven Wire Test Sieve Cloth and Test Sieves

2.2 ACI Document:⁴

ACI 201.2R Guide to Durable Concrete

3. Terminology

3.1 Definitions:

3.1.1 For definitions of terms used in this test method, refer to Terminology C125 and Terminology C219.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *bottom ash, n*—ash that results from the process of combustion of ground or powdered coal that is not transported by 24 flue gases.

3.2.1.1 Discussion—

This definition of bottom ash does not include the residue resulting from: (1) fluidized bed combustion, (2) the burning of municipal solid waste or any other refuse with coal, or (3) the burning of industrial or municipal solid waste in incinerators.

3.2.2 *coal ash, n*—fly ash and bottom ash resulting from the process of combustion of ground or powdered coal obtained either from current power plant production or harvested from landfills or impoundments.

3.2.3 *composite sample, n*—a sample that is constructed by combining equal portions of grab or regular samples.

3.2.4 *established source, n*—a source for which at least six months of continuous production quality assurance records from a test frequency required for a new source are available, sampled at the source.

3.2.5 *grab sample, n*—a sample that is taken in a single operation from a conveyor delivering to bulk storage, from bags, or from a bulk shipment.

3.2.5.1 Discussion—

A grab sample may or may not reflect the composition or physical properties of a single lot of flycoal ash or natural pozzolan. This type of sample can be used to characterize small amounts of material.

3.2.6 *new source, n*—a source for which less than six months of production records are available, sampled at the source.

3.2.7 *regular sample, n*—a sample that is constructed by combining equal portions of grab samples that were taken at predetermined times or locations from any single lot of material.

4. Significance and Use

4.1 These test methods are used to develop data for comparison with the requirements of Specification C618 or Specification C1697. These test methods are based on standardized testing in the laboratory and are not intended to simulate job conditions.

4.1.1 *Strength Activity Index*—The test for strength activity index is used to determine whether flycoal ash or natural pozzolan results in an acceptable level of strength development when used with hydraulic cement in concrete. Since the test is performed with mortar, the results may not provide a direct correlation of how the flycoal ash or natural pozzolan will contribute to strength in concrete.

4.1.2 *Chemical Tests*—The chemical component determinations and the limits placed on each do not predict the performance of a flycoal ash or natural pozzolan with hydraulic cement in concrete, but collectively help describe composition and uniformity of the material.

⁴ Available from American Concrete Institute (ACI), P.O. Box 9094, Farmington Hills, MI 48333-9094, <http://www.aci-int.org>.

5. Materials

5.1 *Graded Standard Sand*—The sand used for making test specimens for the activity index ~~with lime or portland cement~~ shall be natural silica sand conforming to the requirements for graded standard sand in Specification **C778**.

NOTE 2—*Segregation of Graded Sand*—The graded standard sand should be handled in such a manner as to prevent segregation, since variations in the grading of the sand cause variations in the consistency of the mortar. In emptying bins or sacks, care should be exercised to prevent the formation of mounds of sand or craters in the sand, down the slopes of which the coarser particles will roll. Bins should be of sufficient size to permit these precautions. Devices for drawing the sand from bins by gravity should not be used.

5.2 *Hydrated Lime*—The hydrated lime used in the tests shall be reagent-grade calcium hydroxide, 95 % minimum calculated as $\text{Ca}(\text{OH})_2$ (Note 3), and have a minimum fineness of 2500 m^2/kg as determined in accordance with Test Method **C204**.

NOTE 3—The calcium hydroxide should be protected from exposure to carbon dioxide. Material remaining in an opened container after a test should not be used for subsequent tests.

5.3 *Portland Cement*—~~The portland cement used in the Strength Activity Index with Portland Cement test~~ cement used for all tests shall comply with the requirements of Specification **C150/C150M** Type I or II or the requirements for Specification **C595/C595M** Type **II** and have a minimum compressive strength of 35 MPa (5000 psi) at 28 days and total equivalent alkalis ($\text{Na}_2\text{O} + 0.658 \text{K}_2\text{O}$) not less than 0.50 % nor more than 0.80 %. The specification, type, producer, and source of the cement shall be included with the results of tests that involve cement.

NOTE 4—The results from test methods that involve the use of cement may vary depending on the type, producer, or source of the cement used. This potential variation should be considered if comparing with previous test results obtained using a different cement.

5.3.1 The use of a locally available ~~portland cement~~ in the Strength Activity Index or a project cement that does not meet the requirements of the section on Materials is permitted when the variations from the requirements of the section on Materials are reported and when the use of such portland cement is requested. The specification, type, producer, and source of the cement shall be included with the results of tests that involve cement.

6. Sample Type and Size

6.1 Grab samples and regular samples shall have a mass of at least 2 kg (4 lb).

6.2 Grab samples or regular samples taken at prescribed intervals over a period of time (see **Table 1**), may be combined to form a composite sample representative of the flycoal ash or natural pozzolan produced during that period of time.

6.3 Composite samples shall have a mass of at least 4 kg (8 lb).

6.4 The sampling shall be done by, or under the direction of, a responsible representative of the purchaser.

TABLE 1 Minimum Sampling and Testing Frequency^A

Test	Sample Type	Jobsite or New Source ^B	Established Source ^B
Moisture content	Regular	Daily or each	Daily or each
Loss on ignition		90 Mg ^C	360 Mg ^C
Fineness		(100 Tons)	(400 Tons)
Density and the other tests in Specification C618 , Tables 1 and 2	Composite	Monthly or each 1 800 Mg ^C (2 000 Tons)	Monthly or each 2 900 Mg ^C (3 200 Tons)

^A It should be noted that the minimum test frequency given in **Table 1** is not necessarily the frequency needed for quality control programs on some flycoal ash or natural pozzolans.

^B For definitions, refer to the Terminology section.

^C Whichever comes first.

7. Sampling Procedure

7.1 The fly~~co~~al ash or natural pozzolan may be sampled by any one of the following methods:

7.1.1 *From Bulk Storage at Point of Discharge or from Rail Cars and Road Tankers*—A sample may be taken by siphon tube during loading or by sampling tube from each loaded car or tanker. If the load is sampled at the point of discharge into the rail car or tanker, the top surface shall be removed to a depth of at least 200 mm (8 in.) before sampling. The sample shall be identified with at least the date and shipment number.

7.1.2 *From Bags in Storage*—The regular sample shall comprise increments of equal size taken by sampling tube from three bags selected at random from one lot of bagged material. The sample shall be identified with date and lot number.

7.1.3 *From Conveyor Delivering to Bulk Storage*—Take one sample of 2 kg (4 lb) or more of the material passing over the conveyor. This may be secured by taking the entire test sample in a single operation, known as the grab sample method, or by combining several equal portions taken at regular intervals, known as the regular sample method. Automatic samplers may be used to obtain samples.

7.2 Samples shall be treated as described in Section 8.

NOTE 5—Some methods of loading or delivery of fly~~co~~al ash or natural pozzolan, particularly from an airstream or conveyor belt, may create stratification or segregation in the material stream. Sampling techniques must be designed to ensure that the sample is representative of the material shipped.

8. Preparation and Storage of Samples

8.1 Prepare composite samples for the tests required in Section 9, by arranging all grab or regular samples into groups covering the period or quantity to be represented by the sample. Take equal portions from each, sufficient to produce a composite sample large enough for the tests required. Mix the composite sample thoroughly.

8.2 Samples shall be stored in clean, airtight containers identified with the source and lot or period of time represented. Untested portions of the sample shall be retained for at least one month after all test results have been reported.

9. Testing Frequency

9.1 *General*—When required, the purchaser shall specify the amount of testing for available alkalis, reactivity with cement alkalis, drying shrinkage, and air-entrainment. Make all other tests on regular or composite samples chosen as specified in Table 1.

CHEMICAL ANALYSIS

10. General

10.1 All apparatus, reagents and techniques shall comply with the requirements of Test Methods C114.

10.2 *Purity of Water*—Unless otherwise indicated, references to water shall be understood to mean distilled water or water of equal purity.

MOISTURE CONTENT

11. Procedure

11.1 Dry a weighed sample, as received, to constant mass in an oven at $110\text{ }^{\circ}\text{C} \pm 5\text{ }^{\circ}\text{C}$ [$230\text{ }^{\circ}\text{F} \pm 10\text{ }^{\circ}\text{F}$].

12. Calculation

12.1 Calculate the percentage of moisture to the nearest 0.1 %, as follows:

where:

A = mass loss during drying, and

B = mass as received.

LOSS ON IGNITION

13. Procedure

13.1 Using a representative sample of material remaining from the determination of moisture content, determine loss on ignition by the procedure described below:

13.1.1 Determine the tare mass of a clean, cool, uncovered, porcelain crucible, and record the tare mass of the crucible (A) to the nearest 0.0001 g.

NOTE 6—The tare mass of crucibles should be determined by preheating the empty crucible to constant mass at the same temperature and under the same conditions as used for the final ignition of a residue, and cooling in a desiccator for the same period of time used for the crucible containing the residue.

13.1.2 In the crucible, place an amount of material between 0.5 and 4 g and record the combined mass of the crucible and material (B) to the nearest 0.0001 g.

13.1.3 Ignite the crucible and material to constant mass in a furnace at 750 ± 50 °C. Constant mass shall be obtained by any of the following methods: 1) firing for 45 minutes, 2) successive firings until constant mass is established by measuring the loss between two successive firings. When using successive firings, the initial firing duration shall be at least 15 minutes and subsequent firings at least 5 minutes in duration. The loss after each firing is calculated using the equation given in 14.1 and the difference between two successive firings shall be less than 0.1 % for the mass to be considered constant.

13.1.4 Remove the crucible at the end of ignition and allow it to cool in a desiccator to room temperature. Measure and record the final mass of the crucible and material (C) to the nearest 0.0001 g.

14. Calculation

14.1 Calculate the percentage of loss on ignition to the nearest 0.1 %, as follows:

$$\text{Loss on ignition, \%} = \left(\frac{B - C}{B - A} \right) \times 100 \quad (2)$$

where:

A = tare mass of crucible,

B = mass of moisture-free material and crucible, and

C = mass of ignited material and crucible.

SILICON DIOXIDE, ALUMINUM OXIDE, IRON OXIDE, CALCIUM OXIDE, MAGNESIUM OXIDE, SULFUR TRIOXIDE, SODIUM OXIDE AND POTASSIUM OXIDE

15. Procedure

15.1 Determine the percentages of these oxides as required in accordance with the applicable sections of Test Methods C114 for materials having an insoluble residue greater than 1 % (Note 67). Analysts performing sodium oxide and potassium oxide determinations shall observe the precautions outlined in the applicable section of Test Methods C114. Most pozzolans dissolve completely in lithium borate fluxes.

NOTE 7—Rapid and instrumental methods may be employed similar to those in Test Methods C114 and D4326.