Designation: C 928 – 05

Standard Specification for Packaged, Dry, Rapid-Hardening Cementitious Materials for Concrete Repairs[1]

This standard is issued under the fixed designation C 928; 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 This specification covers packaged, dry, cementitious mortar or concrete materials for rapid repairs to hardened hydraulic-cement concrete pavements and structures. Materials that contain organic compounds, such as bitumens, epoxy resins, and polyesters, as the principal binder are not included.

1.1.1 Packaged, dry, concrete material contains aggregate of which at least 5 % by mass of the total mixture is retained on a 9.5-mm (⅜-in.) sieve.

1.1.2 Packaged, dry, mortar material contains aggregate of which less than 5 % by mass of the total mixture is retained on a 9.5-mm (⅜-in.) sieve.

1.2 Aqueous solutions, aqueous emulsions or dispersions may be included as components of the packaged materials. The manufacturer may specify that these liquids are to replace some or all of the mixing water.

1.3 Aggregates must be included as a component of the packaged materials. The manufacturer may recommend job site addition of specific amounts and types of additional aggregates to his product for some uses. However, such reformulated products are not within the scope of this specification.

1.4 The values stated in SI units are to be regarded as standard. The inch-pound units given in parentheses are for information only. Values in SI units shall be obtained by measurement in SI units or by appropriate conversion of measurements made in other units, using the Rules for Conversion and Rounding given in IEEE/ASTM SI-10.

1.5 The following safety hazards caveat pertains to the test methods portion of this specification: *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 and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 *ASTM Standards:* [2]

C 39 Test Method for Compressive Strength of Cylindrical Concrete Specimens

C 78 Test Method for Flexural Strength of Concrete (Using Simple Beam with Third-Point Loading)

C 109/C 109M Test Method for Compressive Strength of Hydraulic Cement Mortars (Using 2-in. or [50-mm] Cube Specimens)

C 143 Test Method for Slump of Hydraulic Cement Concrete

C 157 Test Method for Length Change of Hardened Hydraulic-Cement, Mortar, and Concrete

C 192/C 192M Practice for Making and Curing Concrete Test Specimens in the Laboratory

C 403/C 403M Test Method for Time of Setting of Concrete Mixtures by Penetration Resistant

C 494 Specification for Chemical Admixtures for Concrete

C 666 Test Method for Resistance of Concrete to Rapid Freezing and Thawing

C 672/C 672M Test Method for Scaling Resistance of Concrete Surfaces Exposed to Deicing Chemicals

C 702 Practice for Reducing Samples of Aggregate to Testing Size

C 882 Test Method for Bond Strength of Epoxy-Resin Systems Used With Concrete By Slant Shear

C 1012 Test Method for Length Change of Hydraulic-Cement Mortars Exposed to a Sulfate Solution

E 96 Test Methods for Water Vapor Transmission of Materials

IEEE/ASTM SI-10 Standard for Use of the International System of Units (SI): The Modern Metric System

[1] This specification is under the jurisdiction of ASTM Committee C09 on Concrete and Concrete Aggregates and is the direct responsibility of Subcommittee C09.43 on Packaged, Dry, Combined Concrete.

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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.

3. Materials and Manufacture

3.1 Three types of packaged, dry, rapid-hardening concrete and three types of packaged, dry, rapid-hardening mortar are identified in Table 1.

TABLE 1 Performance Requirements[A]

	3 hours	1 day	7 days	28 days
Compressive Strength, min, MPa (psi)				
R1 concrete or mortar	3.5 (500)	14 (2000)	28 (4000)	[B]
R2 concrete or mortar	7.0 (1000)	21 (3000)	28 (4000)	[B]
R3 concrete or mortar	21 (3000)	35 (5000)	35 (5000)	[B]
Bond strength, min, MPa (psi)				
R1, R2 and R3 concrete or mortar	. —	7 (1000)	10 (1500)	—
Length change, based on length at 3 h, max, %				
R1, R2, and R3 concrete or mortar	allowable increase after 28 days in water			+0.15
	allowable decrease after 28 days in air			–0.15
Consistency of concrete or mortar[C]			concrete slump, min, mm (in.)	Flow of mortar, min, %
R1 consistency after 15 min after addition of mixing liquid			75 (3)	100
R2 and R3 consistency at 5 min after addition of mixing liquid			75 (3)	100
Scaling resistance to deicing chemicals after 25 cycles of freezing and thawing				
Concrete, max visual rating			2.5	
Mortar, max scaled material[D]			5 kg/m^2(1 lb/ft^2)	

[A] It is recognized that other characteristics of rapid-hardening concrete repair materials might need consideration. Such characteristics might be necessary in some environments and applications; however, to impose specification limits on all products is considered beyond the scope of this specification. Optional considerations with suggested methods of test may include tests for the following:

Time of setting	Test Method C 403/C 403M
Flexural strength	Test Method C 78
Freeze thaw	Test Method C 666, Procedure A
Sulfate expansion	Test Method C 1012

[B] The strength at 28 days shall be not less than the strength at 7 days.

[C] Slump or flow requirements are waived for materials intended for vertical or overhead applications.

[D] A 250-mm (10-in.) square spalled to an average depth of 3 mm (⅛ in.) for 100 % of its surface would have about 10 kg/m^2 (2.0 lb /ft^2) of scaled material.

4. *Chemical Composition* Chemical Composition

4.1 If the material contains soluble chlorides or other ingredients in sufficient quantity to cause corrosion to steel reinforcement, the package markings shall contain the following statement in letter size no smaller than the directions for use:

> This material is not recommended for use in a moist environment in contact with steel reinforcement.

4.1.1 Consider a total chloride ion content (Berman, 1972)[3,4] in the packaged repair material greater than 600 g/m^3 (1 lb/yd^3) of the hardened repair material indicative that the packaged material contains sufficient chlorides to cause corrosion to steel reinforcement when the concrete is exposed to weather, is on the ground, or is in an otherwise moist environment. A much lower chloride ion content is suggested for use in prestressed concrete. Guidance for such users is outside the scope of this specification.

4.2 If the material contains metallic iron in excess of 1 weight %, the package markings shall contain the following statement in letter size no smaller than the directions for use:

> If small or scattered spots of iron-staining are considered objectionable, do not use this material where it will be exposed.

5. Performance Requirements

5.1 The materials shall comply with the performance requirements in Table 1 for the applicable type.

6. Sampling

6.1 A lot is the quantity of packaged repair material normally placed on a pallet. In general, this quantity will weigh from 900 to 1800 kg (2000 to 4000 lb).

6.2 A unit sample is a single package of material randomly selected from the lot.

7. Specimen Preparation

7.1 *Concrete*—Mechanically mix the packaged dry concrete material with mixing liquid. Determine the properties of the unhardened mixture, and mold and cure the specimens in accordance with Practice C 192/C 192M or modifications as outlined herein.

7.1.1 The sample of packaged dry material shall be any combination of whole packages yielding not less than 20 L (⅔ ft^3) of hardened material.

7.1.2 Base the quantity of water, other liquid component, or both added to the sample on the quantity per bag stated in the directions for use.

7.1.3 Place the sample in the mixing machine and add the required amount of liquid. Start mixing immediately. Continue mixing for the length of time indicated in the directions for use.

7.1.4 When making the slump test in accordance with Test Method C 143, schedule work so the test will be completed in 5 ± ½ min after the mixing liquid is added to the R2 or R3 materials or 15 ± ½ min after mixing the liquid with the R1 materials.

7.1.5 Mold the required number of specimens using additional samples as may be necessary, mixed in accordance with 7.1.1-7.1.4. Do not use the mixtures for molding test specimens when the slump is less than that specified in Table 1.

NOTE 1—Where the nominal maximum particle size is not greater than 25 mm (1 in.), the use of cylindrical molds 100 mm (4 in.) in diameter by

[3] Berman, H. A., Determination of Chloride in Hardened Portland Cement Paste, Mortar, and Concrete, *ASTM Journal of Materials*, Vol. 7, No. 3, 1972, pp. 330–335.

[4] Clear, K. C., and Harrigan, E. T., "Sampling and Testing for Chloride Ion in Concrete," Report No. FHWA-RD77-85, Federal Highway Administration, Washington, DC, August 1977 (Available as PB 275–428/AS National Technical Information Services).