~~Designation:C260–10~~ Designation: C260/C260M – 10a

Standard Specification for Air-Entraining Admixtures for Concrete[1]

This standard is issued under the fixed designation C260/C260M; 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 Department of Defense.

1. Scope*

1.1 This specification covers materials proposed for use as air-entraining admixtures to be added to concrete mixtures in the field.

~~1.2The values stated in SI units are to be regarded as the standard. The values given in parentheses are for information only.~~

1.2 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

1.3 The text of this specification references notes and footnotes which provide explanatory material. These notes and footnotes (excluding those in tables and figures) shall not be considered as requirements of the standard.

2. Referenced Documents

2.1 *ASTM Standards:*[2]

C183 Practice for Sampling and the Amount of Testing of Hydraulic Cement

C185 Test Method for Air Content of Hydraulic Cement Mortar

C233 Test Method for Air-Entraining Admixtures for Concrete

3. Terminology

3.1 *Definitions of Terms Specific to This Standard:*

3.1.1 *air-entraining admixture*, *n—for the purpose of this specification*, a material that is used as an ingredient of concrete, added to the batch immediately before or during its mixing, for the purpose of entraining air.

4. General Requirements

4.1 At the request of the purchaser, the manufacturer shall state in writing that the air-entraining admixture supplied for use in the work is essentially identical in concentration, composition, and performance to the air-entraining admixture tested under this specification.

NOTE 1—It is recommended that, whenever practicable, tests with the air-entraining admixture be made using all of the ingredients of the concrete proposed for the specific work, because the effect produced by the air-entraining admixture may vary with the properties of the other ingredients of the concrete.

4.2 Requirements for establishing compositional or chemical equivalence of a subsequent lot relative to a previous lot that was subjected to quality tests and found to comply with the requirements of 5.1 shall be determined if agreed upon by the purchaser and the manufacturer. At the request of the purchaser, the manufacturer shall recommend appropriate test procedures, such as infrared spectrophotometry (I.R.), pH value and solids content, for establishing the equivalence of materials from different lots or different portions of the same lot.

NOTE 2—Ultraviolet light absorption (UV) of solutions and infrared spectroscopy of dried residues have been found to be valuable for these purposes. The specific procedures to be employed and the criteria to establish equivalence should be stipulated with due regard to the composition and properties of the sample.

4.3 At the request of the purchaser, the manufacturer shall state in writing the chloride content of the air-entraining admixture and whether or not chloride was added during its manufacture.

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[1] This specification is under the jurisdiction of ASTM Committee C09 on Concrete and Concrete Aggregates and is the direct responsibility of Subcommittee C09.23 on Chemical Admixtures.

Current edition approved Dec. 15, 2010. Published January 2011. Originally approved in 1950. Last previous edition approved in 2006 as ~~C260–06.~~C260–10. DOI: 10.1520/C0260_C0260M-10a.

[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.

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

NOTE 3—Admixtures that contain chlorides may accelerate corrosion of embedded metals.

5. Optional Uniformity Requirements

5.1 A series of two or more samples from a manufacturing lot will be considered sufficiently uniform to be properly composited into a single sample for quality testing provided they do not differ more than the amounts indicated in 5.4.

5.2 A subsequent sample or composite sample shall be considered in compliance with these requirements, so long as they differ from the reference sample by no more than the amounts listed in 5.4. The reference sample is the original sample tested to meet the requirements of 6.1. Any additional optional, appropriate tests, such as infrared spectroscopy and ultraviolet light absorption, referred to in 4.2, also shall meet pre-agreed requirements.

5.3 Determinations of uniformity shall be made in accordance with the procedures given in the sections "Check Tests for Uniformity" and "Procedure for Residue by Oven Drying" of Test Method C233.

5.4 Allowable differences in results of uniformity determinations shall not exceed the following amounts:

5.4.1 The manufacturer shall provide an acceptable range of pH that does not exceed 3.0 pH units. The pH of samples tested shall fall within this range.

5.4.2 The air content in percent of Test Method C185 mortars prepared from successive lots shall not differ by more than 2.0 from that for the acceptance sample.

5.4.3 The manufacturer shall provide acceptable limits of residue content not to exceed ±12 % of the midpoint of the limits. The residue content of samples tested shall fall within these limits (Note 4).

NOTE 4—As an example, an admixture may commonly be produced with residue content ranging from 5.0 to 6.5 %. The manufacturer would provide acceptable limits of 5.06 to 6.44 %, representing ±12 % of the midpoint of the limits which is 5.75 %.

6. Performance Requirements

6.1 The air-entraining admixture shall conform to the requirements in Table 1.

6.1.1 *Resistance to Freezing and Thawing*—The relative durability factor of concrete containing the admixture under test shall be not less than 80. The relative durability factor shall be calculated as follows:

$$DF \text{ (or } DF_1) = PN/300 \tag{1}$$

$$RDF = (DF/DF_1) \times 100$$

TABLE 1 Physical Requirements[A]

	Air-Entraining Admixtures
Time of setting, allowable deviation from control, h:min:	
Initial: not more than	1:15 earlier nor 1:15 later
Final: not more than	1:15 earlier nor 1:15 later
Compressive strength, min, % of control:	
3 days	90
7 days	90
28 days	90
Flexural strength, min, % of control:[B]	
3 days	90
7 days	90
28 days	90
Length change, max shrinkage (alternative requirements):[B,C]	
Percent of control	120
Increase over control, percentage points[D]	0.006
Relative durability factor, min	80
Bleeding of the net amount of mixing water, max percent over control[E]	2

[A] The values in the table include allowance for normal variation in test results. The object of the 90 % compressive strength requirement for air entraining admixtures is to require a level of performance comparable to that of the reference concrete.

[B] Applicable only when required by the purchaser.

[C] Alternative requirements, see 6.1.2, "percent of control" limit applies when the length change of the control is 0.030 % or greater, "increase over control" limit applies when the length change of the control is less than 0.030 %.

[D] Applicable when shrinkage of control concrete is less than 0.030 %.

[E] Bleeding is computed as a percentage of the net amount of mixing water in each concrete. The net mixing water is the water in excess of that present as absorbed water in the aggregates. For example, a test concrete mixture that contains 4.65 kg of net mix water and produces 0.29 kg of bleed water would have 6.24 % bleed water by mass of net mixing water. If a control mixture produces 7.05 % bleed water, the change in bleeding between the test and control concrete mixtures would be – 0.81 percentage points.