



Designation: C31/C31M – 15a

Standard Practice for Making and Curing Concrete Test Specimens in the Field¹

This standard is issued under the fixed designation C31/C31M; 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 This practice covers procedures for making and curing cylinder and beam specimens from representative samples of fresh concrete for a construction project.

1.2 The concrete used to make the molded specimens shall be sampled after all on-site adjustments have been made to the mixture proportions, including the addition of mix water and admixtures. This practice is not satisfactory for making specimens from concrete not having measurable slump or requiring other sizes or shapes of specimens.

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 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.

1.4 *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 and health practices and determine the applicability of regulatory limitations prior to use. (Warning—Fresh hydraulic cementitious mixtures are caustic and may cause chemical burns to exposed skin and tissue upon prolonged exposure.²)*

1.5 The text of this standard references notes which provide explanatory material. These notes shall not be considered as requirements of the standard.

2. Referenced Documents

2.1 ASTM Standards:³

¹ This practice is under the jurisdiction of ASTM Committee C09 on Concrete and Concrete Aggregates and is the direct responsibility of Subcommittee C09.61 on Testing for Strength.

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² See Section on Safety Precautions, Manual of Aggregate and Concrete Testing, *Annual Book of ASTM Standards*, Vol. 04.02.

³ 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.

C125 Terminology Relating to Concrete and Concrete Aggregates

C138/C138M Test Method for Density (Unit Weight), Yield, and Air Content (Gravimetric) of Concrete

C143/C143M Test Method for Slump of Hydraulic-Cement Concrete

C172/C172M Practice for Sampling Freshly Mixed Concrete

C173/C173M Test Method for Air Content of Freshly Mixed Concrete by the Volumetric Method

C231/C231M Test Method for Air Content of Freshly Mixed Concrete by the Pressure Method

C330/C330M Specification for Lightweight Aggregates for Structural Concrete

C403/C403M Test Method for Time of Setting of Concrete Mixtures by Penetration Resistance

C470/C470M Specification for Molds for Forming Concrete Test Cylinders Vertically

C511 Specification for Mixing Rooms, Moist Cabinets, Moist Rooms, and Water Storage Tanks Used in the Testing of Hydraulic Cements and Concretes

C617/C617M Practice for Capping Cylindrical Concrete Specimens

C1064/C1064M Test Method for Temperature of Freshly Mixed Hydraulic-Cement Concrete

C1077 Practice for Agencies Testing Concrete and Concrete Aggregates for Use in Construction and Criteria for Testing Agency Evaluation

2.2 *American Concrete Institute Publication:*⁴

309R Guide for Consolidation of Concrete

3. Terminology

3.1 For definitions of terms used in this practice, refer to Terminology C125.

4. Significance and Use

4.1 This practice provides standardized requirements for making, curing, protecting, and transporting concrete test specimens under field conditions.

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

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

4.2 If the specimens are made and standard cured, as stipulated herein, the resulting strength test data when the specimens are tested are able to be used for the following purposes:

- 4.2.1 Acceptance testing for specified strength,
- 4.2.2 Checking adequacy of mixture proportions for strength, and
- 4.2.3 Quality control.

4.3 If the specimens are made and field cured, as stipulated herein, the resulting strength test data when the specimens are tested are able to be used for the following purposes:

- 4.3.1 Determination of whether a structure is capable of being put in service,
- 4.3.2 Comparison with test results of standard cured specimens or with test results from various in-place test methods,
- 4.3.3 Adequacy of curing and protection of concrete in the structure, or
- 4.3.4 Form or shoring removal time requirements.

5. Apparatus

5.1 *Molds, General*—Molds for specimens or fastenings thereto in contact with the concrete shall be made of steel, cast iron, or other nonabsorbent material, nonreactive with concrete containing portland or other hydraulic cements. Molds shall hold their dimensions and shape under all conditions of use. Molds shall be watertight during use as judged by their ability to hold water poured into them. Provisions for tests of water leakage are given in the Test Methods for Elongation, Absorption, and Water Leakage section of Specification **C470/C470M**. A suitable sealant, such as heavy grease, modeling clay, or microcrystalline wax shall be used where necessary to prevent leakage through the joints. Positive means shall be provided to hold base plates firmly to the molds. Reusable molds shall be lightly coated with mineral oil or a suitable nonreactive form release material before use.

5.2 *Cylinder Molds*—Molds for casting concrete test specimens shall conform to the requirements of Specification **C470/C470M**.

5.3 *Beam Molds*—Beam molds shall be of the shape and dimensions required to produce the specimens stipulated in **6.2**. The inside surfaces of the molds shall be smooth. The sides, bottom, and ends shall be at right angles to each other and shall be straight and true and free of warpage. Maximum variation from the nominal cross section shall not exceed 3 mm [$\frac{1}{8}$ in.] for molds with depth or breadth of 150 mm [6 in.] or more. Molds shall produce specimens at least as long but not more than 2 mm [$\frac{1}{16}$ in.] shorter than the required length in **6.2**.

5.4 *Tamping Rod*—A round, smooth, straight, steel rod with a diameter conforming to the requirements in **Table 1**. The length of the tamping rod shall be at least 100 mm [4 in.]

greater than the depth of the mold in which rodding is being performed, but not greater than 600 mm [24 in.] in overall length (see **Note 1**). The rod shall have the tamping end or both ends rounded to a hemispherical tip of the same diameter as the rod.

NOTE 1—A rod length of 400 mm [16 in.] to 600 mm [24 in.] meets the requirements of the following: Practice **C31/C31M**, Test Method **C138/C138M**, Test Method **C143/C143M**, Test Method **C173/C173M**, and Test Method **C231/C231M**.

5.5 *Vibrators*—Internal vibrators shall be used. The vibrator frequency shall be at least 150 Hz [9000 vibrations per minute] while the vibrator is operating in the concrete. The diameter of a round vibrator shall be no more than one-fourth the diameter of the cylinder mold or one-fourth the width of the beam mold. Other shaped vibrators shall have a perimeter equivalent to the circumference of an appropriate round vibrator. The combined length of the vibrator shaft and vibrating element shall exceed the depth of the section being vibrated by at least 75 mm [3 in.]. The vibrator frequency shall be checked periodically with a vibrating-reed tachometer or other suitable device.

NOTE 2—For information on size and frequency of various vibrators and a method to periodically check vibrator frequency see ACI 309R.

5.6 *Mallet*—A mallet with a rubber or rawhide head weighing 0.6 ± 0.2 kg [1.25 ± 0.50 lb] shall be used.

5.7 *Placement Tools*—of a size large enough so each amount of concrete obtained from the sampling receptacle is representative and small enough so concrete is not spilled during placement in the mold. For placing concrete in a cylinder mold, the acceptable tool is a scoop. For placing concrete in a beam mold, either a shovel or scoop is permitted.

5.8 *Finishing Tools*—a handheld float or a trowel.

5.9 *Slump Apparatus*—The apparatus for measurement of slump shall conform to the requirements of Test Method **C143/C143M**.

5.10 *Sampling Receptacle*—The receptacle shall be a suitable heavy gauge metal pan, wheelbarrow, or flat, clean nonabsorbent board of sufficient capacity to allow easy remixing of the entire sample with a shovel or trowel.

5.11 *Air Content Apparatus*—The apparatus for measuring air content shall conform to the requirements of Test Methods **C173/C173M** or **C231/C231M**.

5.12 *Temperature Measuring Devices*—The temperature measuring devices shall conform to the applicable requirements of Test Method **C1064/C1064M**.

6. Testing Requirements

6.1 *Cylindrical Specimens*—Compressive or splitting tensile strength specimens shall be cylinders cast and allowed to set in an upright position. The number and size of cylinders cast shall be as directed by the specifier of the tests. In addition, the length shall be twice the diameter and the cylinder diameter shall be at least 3 times the nominal maximum size of the coarse aggregate. When the nominal maximum size of the coarse aggregate exceeds 50 mm [2 in.], the concrete sample shall be treated by wet sieving through a 50-mm [2-in.] sieve as described in Practice **C172/C172M**. For acceptance testing

TABLE 1 Tamping Rod Diameter Requirements

Diameter of Cylinder or Width of Beam mm [in.]	Diameter of Rod mm [in.]
<150 [6]	10 ± 2 [$\frac{3}{8} \pm \frac{1}{16}$]
≥ 150 [6]	16 ± 2 [$\frac{5}{8} \pm \frac{1}{16}$]

TABLE 2 Minimum Cross-Sectional Dimension of Beams

Nominal Maximum Aggregate Size (NMAS)	Minimum Cross-Sectional Dimension
≤ 25 mm [1 in.]	100 by 100 mm [4 by 4 in.]
25 mm [1 in.] < NMAS ≤ 50 mm [2 in.]	150 by 150 mm [6 by 6 in.]

for specified compressive strength, cylinders shall be 150 by 300 mm [6 by 12 in.] or 100 by 200 mm [4 by 8 in.] (**Note 3**).

NOTE 3—When molds in SI units are required and not available, equivalent inch-pound unit size mold should be permitted.

6.2 Beam Specimens—Flexural strength specimens shall be beams of concrete cast and hardened in the horizontal position. The length shall be at least 50 mm [2 in.] greater than three times the depth as tested. The ratio of width to depth as molded shall not exceed 1.5.

6.2.1 The minimum cross-sectional dimension of the beam shall be as stated in **Table 2**. Unless otherwise specified by the specifier of tests, the standard beam shall be 6 by 150 by 150 mm [6 in.] in cross-section.

6.2.2 When the nominal maximum size of the coarse aggregate exceeds 50 mm [2 in.], the concrete sample shall be treated by wet sieving through a 50-mm [2-in.] sieve as described in Practice **C172/C172M**.

6.2.3 The specifier of tests shall specify the specimen size and the number of specimens to be tested to obtain an average test result (**Note 4** and **Note 5**). The same specimen size shall be used when comparing results and for mixture qualification and acceptance testing.

NOTE 4—The modulus of rupture can be determined using different specimen sizes. However, measured modulus of rupture generally increases as specimen size decreases.^{5,6} The strength ratio for beams of different sizes depends primarily on the maximum size of aggregate.⁷ Experimental data obtained in two different studies have shown that for maximum aggregate size between 19.0 and 25.0 mm [$\frac{3}{4}$ and 1 in.], the ratio between the modulus of rupture determined with a 150 by 150 mm [6 by 6 in.] and a 100 by 100 mm [4 by 4 in.] may vary from 0.90 to 1.07⁵ and for maximum aggregate size between 9.5 and 37.5 mm [$\frac{3}{8}$ and 1½ in.], the ratio between the modulus of rupture determined with a 150 by 150 mm [6 by 6 in.] and a 115 by 115 mm [4.5 by 4.5 in.] may vary from 0.86 to 1.00.⁶

NOTE 5—It has been shown that the variability of individual test results increases as the specimen size decreases.^{5,6}

6.3 Field Technicians—The field technicians making and curing specimens for acceptance testing shall meet the personnel qualification requirements of Practice **C1077**.

⁵ Tanesi, J; Ardani, A. Leavitt, J. "Reducing the Specimen Size of Concrete Flexural Strength Test (AASHTO T97) for Safety and Ease of Handling," *Transportation Research Record: Journal of the Transportation Research Board*, No. 2342, Transportation Research Board of National Academies, Washington, D.C., 2013.

⁶ Carrasquillo, P.M. and Carrasquillo, R. L "Improved Concrete Quality Control Procedures Using Third Point Loading", *Research Report 119-1F*, Project 3-9-87-1119, Center for Transportation Research, The University of Texas at Austin, November 1987.

⁷ Bazant, Z. and Novak, D. "Proposal for Standard Test of Modulus of Rupture of Concrete with its Size Dependence," *ACI Materials Journal*, January-February 2001.

7. Sampling Concrete

7.1 The samples used to fabricate test specimens under this standard shall be obtained in accordance with Practice **C172/C172M** unless an alternative procedure has been approved.

7.2 Record the identification of the sample with respect to the location of the concrete represented and the time of casting.

8. Slump, Air Content, and Temperature

8.1 Slump—Measure and record the slump of each batch of concrete from which specimens are made immediately after remixing in the receptacle, as required in Test Method **C143/C143M**.

8.2 Air Content—Determine and record the air content in accordance with either Test Method **C173/C173M** or Test Method **C231/C231M**. The concrete used in performing the air content test shall not be used in fabricating test specimens.

8.3 Temperature—Determine and record the temperature in accordance with Test Method **C1064/C1064M**.

NOTE 6—Some specifications may require the measurement of the unit weight of concrete. The volume of concrete produced per batch may be desired on some projects. Also, additional information on the air content measurements may be desired. Test Method **C138/C138M** is used to measure the unit weight, yield, and gravimetric air content of freshly mixed concrete.

9. Molding Specimens

9.1 Place of Molding—Mold specimens promptly on a level, rigid surface, free of vibration and other disturbances, at a place as near as practicable to the location where they are to be stored.

9.2 Casting Cylinders—Select the proper tamping rod from **5.4** and **Table 1** or the proper vibrator from **5.5**. Determine the method of consolidation from **Table 3**, unless another method is specified. If the method of consolidation is rodding, determine molding requirements from **Table 4**. If the method of consolidation is vibration, determine molding requirements from **Table 5**. Select a scoop of the size described in **5.7**. While placing the concrete in the mold, move the scoop around the perimeter of the mold opening to ensure an even distribution of the concrete with minimal segregation. Each layer of concrete shall be consolidated as required. In placing the final layer, add an amount of concrete that will fill the mold after consolidation.

9.3 Casting Beams—Select the proper tamping rod from **5.4** and **Table 1** or proper vibrator from **5.5**. Determine the method of consolidation from **Table 3**, unless another method is specified. If the method of consolidation is rodding, determine the molding requirements from **Table 4**. If the method of consolidation is vibration, determine the molding requirements from **Table 5**. Determine the number of roddings per layer, one for each 14 cm² [2 in.²] of the top surface area of the beam.

TABLE 3 Method of Consolidation Requirements

Slump, mm [in.]	Method of Consolidation
≥ 25 [1]	rodding or vibration
< 25 [1]	vibration