INFLUENCE OF OPTIMIZED SUPER PLASTICIZER EFFECT ON HIGH STRENGTH CONCRETE

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ABSTRACT

Chemical admixtures are a valuable choice in concrete production for achieving better performance and desired properties. Super plasticizers are commonly known as excessive Range Water Reducers because it permits low water cement ratio and it influencing the fresh concrete behavior. To determine the optimum dosage of admixture, an experimental investigation was performed and also the effect of higher dosage into the experimentation together studied. The present paper emphasizes on determining optimum Super plasticizer dosage of desired workability using Marsh Cone Test at pre-determined water cement ratio of 0.35 for M40 grade concrete. This was studied with the two different types of Super plasticizers of Polycarboxylate Ether (PCE) and Sulphonated melamine formaldehyde (SMF) with dosage of 0 to 2 % with the interval of 0.25% on fresh and hardened concrete properties. Experimentation was conducted and conclusions were drawn. A comparative study has been done in this chapter between both the Super Plasticizers.

Keywords—Super Plasticizer, Dosage, Marsh Cone Test,Cement,Concrete Strength, RMC

# INTRODUCTION

In the current civil construction industry admixtures of chemicals and miners are playing a major role for strengthen and enhancement of concrete. The chemical admixtures have the ability to increase the workability of the concrete considerably and also imparts strength enhancement of the concretes considerably. [1,2]. The advantages will be found when chemical admixtures produce high workable concretes objectives are kept with a primary objective for imparting the strength. In our admixture less cement content and low water requirement are used for new chemical admixture in providing fresh and hardened stages of concrete. In chemical admixture we have various uses and have positive effects on the fresh and hardened properties of the concrete. In the fresh stage, use of chemical admixture will generally reduce the bleeding effects due to the decrease in water content [3]. High compressive strength could only be achieved when low water to cement ratio (w/c) is ensured in the mix design , while maintaining adequate workability of the fresh mixture[4]. In the current market so many types of branded brands of chemical admixtures are various types and brands available with various properties. Hence the behavior with particular admixtures which uses certain materials will be also having some changes. Our experimental study providing compatibility between cement and admixture is necessary before its application in field[5]. Therefore, our primary concern of application is to provide a better selection of cement and admixture.

## **Compatibility of Admixtures and Cementitious Materials**

Concrete faces compatibility problems like cement- admixture incompatibility and incompatibility between admixtures when they are added. The admixture materials used may show a incompatibility for various cementing materials and mixtures without any supplementary methods. Some of the incompatibility problems reported between cement and admixtures are:

* Slump loss
* Low strength gain rate
* Early stiffening of concrete
* Segregation of concrete
* Increased water demand

### Origins of Incompatibility

Some of the causes of incompatibility problems like early stiffening, retardation etc. are listed below.

* In cement, admixtures or combination of both materials will be a Incompatibility of cement and admixtures due to the chemical composition of materials used to some extent may be not suitable or incompatibility.
* If SO4/C3A ratio is too low uncontrolled C3A hydration occurs which result in early stiffening (flash set). The high ration of calcium sulphates to a gypsum (false set) provides a high ratio of SO4/C3A
* Temperature is another factor affecting compatibility. Hot weather conditions lead to increased admixture adsorption thereby leads to fluidity whereas low temperature results in low fluidity.
* Higher alkali cements react faster and leads to higher rate of stiffening and higher slump loss.

## **Chemical Admixtures**

Concrete admixtures are broadly divided into two type’s i.e. chemical and mineral admixture. Chemical admixture is integrated to regulate the properties of concrete together with heat of hydration, boost up or retard the setting time, enhance workability, assist in water discount, disperse/deflocculates the cement particles, resource in entrain air and sooner or later improve the impermeability and durability characteristics. They are basically chemical compounds.  These ranges and dosages will vary from 0.2% to 2% by weight of cement[6].

### Types of Admixtures

Chemical admixtures can be classified into the following types:

* Set Accelerators
* Air Entertainers
* Super plasticizers
* Set Retarders
* Specialty Admixtures
* Water Reducers

## **Super Plasticizers**

When describing about the chemical admixture super plasticizers which is also called as high range water reducer in admixture. This chemical admixture was developed in the years 1960 and 1979 by Germany and Japan respectively. This is a different when we compared with normal plasticizers with various dose levels of super plasticizers having higher conventional water reducer ratio of (0.5 to 3.0%) and lesser undesirable properties of concrete with (0.18 to 0.47). This admixture concrete provides 30% reduction of water producing very effective results on the workability i.e. without reduction in the workability of concrete[7]. The basic advantages of super-plasticizers are

* This admixture provides a very easy placement with higher strength providing a high workability of concrete;
* Uses Lower water content with a higher strength concrete; and
* Provides a Use of less cement concrete mix having more strength and workability

The admixture is a homogenous cohesive concrete without any bleeding, segregation for provided tendency. It also produces flowing concrete in situation where placing in accessible locations, in floor or pavement slab or where very rapid placing is required. A second use of Super plasticizer is in the production of very high strength concrete, using normal workability but a very low water/cement ratio[8].

### Types of Super Plasticizers

Overall, four different Super plasticizer categories can be defined [9]:

1. Naphthalenesulfonate based Super plasticizers (SNF)
2. Melamine-sulfonate based Super plasticizers (SMF)
3. Lignosulfonate based Super plasticizers (MLS), and
4. Polycarboxylates ether-based Super plasticizers

In the described categories of Naphthalenesulfonate based Super plasticizers (SNF), Melamine-sulfonate based Super plasticizers (SMF). and Lignosulfonate based Super plasticizers (MLS) which were very widely used as a types of super plasticizers for the past decade and they are also named as 1st,2nd generation admixture super plasticizers. But in the provided Category of D which as used in 90’s called as 3rd generate category which is currently used in cement industry. The older generations of Super plasticizer have shown an improved dispersion of cement material particles with electro steric repulsions. These categories are generally used for cement concrete as given below:

* Sulphonated melamine formaldehyde condensates – It is suitable in low temperature areas – dosage: 0.5 - 3% by weight of cement
* Sulphonated naphthalene formaldehyde condensates – It is more suitable in high temperature areas – dosage: 0.5 - 3% by weight of cement
* Modified Lignosulphates – It is suitable for conditions where temperature variation is high – dosage not more than 0.25% by weight of cement
* Carboxylated admixture – It is suitable where workability is required to be retained for large duration. The Super plasticizer is adsorbed onto the cement particles, thereby lowering inter-particle attraction and producing a more uniform dispersion of cement grains as with a normal water-reducer[10].

The mechanism of Super plasticizer action is gives the cement particles highly negative charge to repel each other due to the same electrostatic charge. By deflocculating the cement particles, more water is provided for concrete mixing. For general usage, dosage of Super plasticizer is between 1- 3 L / m3. However, the dosage can be increased to as high as 5 - 20 l/m3. Effectiveness of a given dosage of Super plasticizer depends on the water/cement ratio. It increases when w/c decreases. Compatibility with actual cement is one of the most important parameters that needed to be considered, and it is not recommended that the cement and Super plasticizer conform the standard separately[11].

### Sulphonated Melamine Formaldehyde(SMF)

Sulfonated melamine formaldehyde (SMF) is a polymer used in cements and plaster – based formulations to reduce water content , while increasing the fluidity and the workability of the mix, In concretes , adition of SMF in an appropriate mix design results in lower porosity . higher mechanical strength and improved ressistance to aggressive environments.

* In self leveling flooring materials and grout for the base of casing equipment.
* In high strength gypsum and gypsum products
* In ready mixed concrete , pumping concrete , flowing concrete , high strength and high performance concrete , self compacted concrete and high strength cement mortar
* One of major components of water proofing materials for improving impermiability of concrete or mortar.

### Polycarboxylic Ether

Polycarboxylate concrete admixtures next generation concrete accelerator is a ready-to-use liquid admixture with outstanding performance and no chloride. Initial concrete setting time is one to three times faster with special polycarboxylate concrete admixtures than with regular mortar and concrete. It enhances the workability and strength of cement while also speeding up the hydration process. It makes it easier to place the mix and speeds up construction by reducing the time it takes for the concrete to set. Because forms and alternative protection will be removed early and finishing will begin, labour costs and time will be saved.

### Applications

* For fast setting, self compacting concrete and mortars.
* Pavers Block, Brick, Cement-Pipes, Tiles, Cement Poles.
* Concrete roads, High-rise and large scale building construction.
* Swimming pool construction.
* For setting mortars & concrete in law temperature climate.

### Dosage

Practical trials should be used to establish the best dosage. The dosage is determined by the temperature, kind of cement, needed strength, and type of acceleration. A dose range of 0.5 to 2.0 percent by weight of cement is usually advised as a guideline. Precast elements, on the other hand, utilise lower dosages, whereas shot cresting uses greater dosages.

## **Objectives of the Study**

The main objective of the study is to determine the Optimum dosage of two different super plasticizers PCE & SMF for M40 grade concrete and its influence on fresh and hardened properties of concrete.

## **Step by Step procedure**

* To determine the Optimum dosage of two different S.P of PCE & SMF using ‘Marsh Cone Test’.
* Work is carried out in comparing the compressive strengths and Split tensile strength of conventional concrete with the dosage of 0 %, 0.25%, 0.5%, 0.75%, 1.0%, 1.5%, 1.75% and 2.0% of PCE and SMF separately. With the same time fresh concrete properties of Slump cone and compaction factor test were observed in terms of workability of same dosages.
* As per the replacements, cubes and cylinders are casted using OPC 53 grade cement for M40 grade concrete.
* The cubes and Cylinders were cured for 7 and 28 days and the compressive strength and split tensile strength of the concrete is determined.
* Later the analysis of test results is done to draw conclusions.

# LITERATURE REVIEW

## **Effect of Super Plasticizers on Properties of Concrete**

The compressive strength of 0- 3.5% level of super plasticizer at water cement ratio of 0.4 – 0.55 ranged from 11.38 – 18.04N/mm2 at 7days curing, while the compressive strength at the same percentage level of super plasticizer and water-cement ratio at 14 days curing ranged from 12.78–18.80N/mm2. The compressive strength of 0-3.5% level of super plasticizer at water cement ratio of 0.4 – 0.55 ranged from 14.00 – 21.90N/mm2 and 15.00 – 23.10N/mm2 for 21 and 28 days curing respectively. The slump test of 0-3.5% level of super plasticizer at 0.4 – 0.55 water-cement ratio ranged from 10-90mm[10]. Effect of Super plasticizing Admixture on Concrete Properties was the topic of a research study presented. The goals of this study were to identify the optimum dosage of concrete super plasticizer for normal concrete and to evaluate the influence of super plasticizer on concrete parameters, with a focus on 30 N/mm2 characteristic strength at 28 days. Ordinary Portland cement, 20 mm granite coarse aggregate, and sea sand were used to make one control mix. Finally, the study found that super plasticizer had a considerable impact on both fresh and hardened concrete properties [8]. SP concrete's compressive strengths are often higher than the comparable strengths of reference mixes. A water reducer of up to 32-33 percent c is used when SP is employed can be accomplished SP concrete's compressive strength increases as a result of this phenomenon. New generations of SP have recently been created to produce extremely high strength concrete with compressive strengths of 15000 psi and higher, as well as very high early strength at 2 to 4 hours. There is no unnecessary segregation or bleeding of concrete in water-reduced SP concrete since the water content is lower [13]. The slump and compaction factor experiments revealed that concrete containing fly ash and super plasticizer produces good workability and marginally accelerates and increases the compressive strength of self-compacting concrete[10]. Plasticizers also increased workability at constant water-cement ratios while increasing compressive strength at lower water-cement ratios. To avoid bleeding and segregation, the cement content was reduced while the sand content was increased [9]. The study demonstrated the effect of re-dosing super plasticizer to regain slump on concrete with the goal of determining the variance of super plasticizer contribution and its effect on the compressive strength of concrete owing to re-dosing. Ordinary Portland cement was used to make one control mix. M-sand with a fineness modulus of 2.96 and crushed stone that has been sieved at 20mm. The results obtained showed that:

* Those blends with a higher initial dose of super plasticizer had less slump loss in the period allotted.
* The qualities of hardened concrete, such as compressive strength, were found to be higher in super plasticized concrete than in control mix, indicating that super plasticizers improved the strength of concrete by improving its workability, resulting in a denser and less porous structure[14].

The non destructive testing values were also found to be in good agreement with the strength behaviour of super plasticized concrete for destructive testing, and the compatibility of Sulphonated Naphthalene Formaldehyde and Lignosulphonates based superplasticizers with Portland slag cements was investigated. Even when the coarse and fine aggregates, water, chemical additive family, and concrete mix design procedure were all maintained same, different brands of cement performed differently [15].

Many physico-chemical properties of cement and concrete are affected by superplasticizers (SMF, SNF, MLS, and other organic admixtures). Physical properties include theology, morphology, microstructure, compressive strengths, pore size distributions, workability, and so on; chemical properties include adsorption behaviour, conductivity changes, zeta potential changes, heat of hydration, chlorine penetration, and sulphate attack, among others. The slump and compaction factor experiments revealed that concrete containing fly ash and super plasticizer produces good workability and marginally accelerates and increases the compressive strength of self-compacting concrete[16].

# MATERIALS AND METHODS

Concrete is a building material composed of cement, sand as fine aggregate, crushed rock as coarse aggregate, water and admixture. Hence, it is important to make physical characteristic tests on materials used for the investigation before any concrete experiments are carried out.

## **Project Design**

The purpose of these experimental design were determining optimized dosage of super plasticizer using OPC 53 grade cement and Two different types of Super plasticizers PCE and SMF with pre-determining of water to cement ratio of 0.35 (constant) , to observe the effects of Super plasticizer on workability of fresh concrete and concrete strength.

## **Variable Parameters**

Following are selected as the variable parameters in this study. To determine the effect of concrete components on overall concrete behavior, cement types, dosage of Super plasticizer and amount of water were selected as variables.

* As per IS 10262-2009 & IS 456-2000 recommends the following components with the specified content to achieve good Concrete
* For slumps 25 to 100mm,
* A minimum cement content of 8 bags per m3 of concrete
* Nominal maximum sizes of aggregates (20mm)
* A maximum water content of 207 kg/m3 (w/c of 0.45)

### Variables were selected as follows

* Super plasticizer - from 0%, to 2.5% for Marsh Cone Test
* Water to Cement ratio – 0.35
* Super plasticizer - 0%, 0.5%, 0.75%, 1.0%, 1.25%, and 1.5% for Slump Test & strength tests of concrete.
* Marsh Cone Time and Slump values were recorded.

## **Materials**

### Cement

IS Mark OPC-53 grade cement become used for all concrete mixes. The cement used become fresh and with none lumps. Testing of cement changed into executed as in step with IS: 8112-1989. The various assessments outcomes conducted at the cement are mentioned in Table 1 and selected cement properties are within limits and is suitable for experimentation.

**Table 1: Properties of cement**

|  |  |  |  |
| --- | --- | --- | --- |
| **S.No.** | **Description** | **Test Results** | **IS Code Limits** |
| 1. | Specific Gravity | 3.14 | 3.10-3.15 |
| 2. | Fineness Modulus | 4.16 | <10% |
| 3. | Normal Consistency | 29% | >26% |
| 4. | Initial Setting Time | 68 Minutes | >30 Minutes |
| 5. | Final Setting Time | 169 Minutes | <3 Hours |

### Coarse Aggregate

In our present work we have used coarse aggregates having 10mm and 20mm sizes which are available local market, and the testing coarse aggregates were done as per IS: 383-1970 and their results are shown in Table 2. The 10mm aggregates used were first sieved through 10mm sieve and then through 4.75 mm sieve and 20mm aggregates were firstly sieved through 20mm sieve.

**Table 2: Properties of Coarse Aggregate**

|  |  |  |
| --- | --- | --- |
| **S.No.** | **Characteristics** | **Value** |
| 1. | Type | Crushed |
| 2. | Maximum Size | 20 mm |
| 3. | Specific Gravity (10mm) | 2.704 |
| 4. | Specific Gravity (20mm) | 2.825 |
| 5. | Total Water Absorption (10mm) | 1.6432% |
| 6. | Total Water Absorption (20mm) | 3.645% |
| 7. | Moisture Content (10mm) | 0.806% |
| 8. | Moisture Content (20mm) | 0.7049% |
| 9. | Fineness Modulus (10mm) | 6.46 |
| 10. | Fineness Modulus (20mm) | 7.68 |

### Fine Aggregate

The aggregates most of which pass through 4.75 mm IS sieve are termed as fine aggregates. In this experimental program**,** fine aggregate was locally procured and conformed to Indian Standard Specifications IS: 383-1970 and their results are shown in Table 3. The sand was sieved through 4.75 mm sieve to remove any particles greater than 4.75 mm and conforming to grading zone I.

**Table 3: Properties of Coarse Aggregates**

|  |  |  |
| --- | --- | --- |
| **S.No.** | **Characteristics** | **Value** |
| 1. | Type | Uncrushed (Natural) |
| 2. | Specific Gravity | 2.566 |
| 3. | Total Water Absorption | 1.02% |
| 4. | Moisture Content | 1% |
| 5. | Net Water Absorption | 0.86% |
| 6. | Fineness Modulus | 4.02 |
| 7. | Bulk Density | 1.3 |
| 8. | Grading Zone | I |

**Graph 1: Sieve Analysis of Fine Aggregate**

### Super Plasticizers

In this project we are using two types of super plasticizers

#### Polycarboxilite Ether

Polycarboxilite ether is a chemical admixture was used in the experiment .It is produced by Sri Krishna Overseas company located in New Delhi and purchased through online. It is highly effective admixture for concrete especially suitable for the production of free flowing concrete and high strengths concrete. Its chemical bases are either and the tests/standards comply with EN 934-2. As a guide a dosage range of 0.5 to 2.0 percent by weight of cement is normally recommended. The properties are in table 4.

**Table 4: Typical properties of PCE Super plasticizer up to 25°C**

|  |  |
| --- | --- |
| **Properties** | **Value** |
| Form | Liquid |
| Appearance/Color | Dark Brown Liquid |
| Density | 1.2 ± 0.02kg/l |
| Chloride content | Nill |
| pH (23 ± 2 ºC) | 8 ± 1 |

#### Sulfonated Melamine Formaldihide

SMF is melamine based on the form of liquid super plasticizer for high performance concrete. SMF converts stiff concrete to flow able concrete due to its high workability to concrete mixes. It gives excellent slump, retention properties without effecting the setting time and could be used to affect considerably water reduction resulting high performances both in plastic and hardening state of concrete. It is produced by Sri Krishna Overseas Company located in New Delhi and purchased through online. The properties are presented in table 5.

**Table 5: Typical properties of SMF Super plasticizer up to 25°C**

|  |  |  |
| --- | --- | --- |
| **S.No.** | **Chemical and Physical Properties** | **SMF Liquid** |
| 1. | Appearance | White to off white powder |
| 2. | Moisture, max % | 4 |
| 3. | Bulk Density, g/cc | 55 to 85 |
| 4. | pH value of 20% aqueous solutions@ 200C | 7.0 to 10.0 |
| 5. | Particle Size, >200mm, % | 5 to 25 |
| 6. | Particle Size, <100mm, % | 15 to 40 |
| 7. | Free formaldehyde, max % | 0.1 |
| 8. | Chloride, Max % | 0.05 |
| 9. | Sodium % | 9 to 11 |

## **Marsh Cone Test**

To test the workability for various specifications and quality control of cement pastes the marsh cone was implemented In our experiential results. Though the test standards are varying from country to country result the principle output is same. In the marsh cone test various amount of materials, their flow out, time are recorded for measuring the flow time which is l inked with the fluidity of the tested material. As longer the flow time we have observed lower the fluidity. As the proposed approach Marsh cone test is very simple to observe the data readings about cement pastes behavior. In our used cement based materials, mix design order to define the saturation point, i.e. the dosage beyond which the flow time does not decrease appreciably. As Marsh Cone test is tested with filled fluid material with nozzle kept closed and also measured the quantity of fluid with nozzle opened for freely flow activity. Used Marsh cone time for measuring time, quantity of materials to record the flow out activity. The saturation point is defined as the chemical admixture dosage beyond which the flow time dose not decrease appreciably. The dosage at which the Marsh cone time is lowest is called the saturation point. The dosage is the optimum dosage for that brand of cement and admixture (plasticizer or super plasticizer) for that w/c ratio. The apparatus of Marsh Cone is shown in Figure 1.

### Methodology

Observations for 1 minute retention period are taken.

* In our first test, water cement ratio is kept as 0.35 and PCE dosage of 0, 0.5, 0.75, 1, 1.25 and 1.5 % is administered. Temperature is noted down.
* Mix the 2 kg of OPC cement, for preparation of 1 liter of cement paste, water and PCE super plasticizer thoroughly in a mechanical mixer for two minutes. While mixing, first put the water in mixing bowl and then add 2 Kg of cement to this water. Stirred for 1 minute and then add PCE super plasticizer of desired dosage and stirring operation is continued for next one minute. Thus slurry is formed.
* Pour one liter slurry measured with 1000 ml jar into marsh cone duly closing the aperture with a finger at bottom.
* Start the stop watch and simultaneously remove the finger. Note the time taken for emptying the Marsh Cone. This time is called the “Marsh Cone Time”.
* Repeat the test for remaining dosages for same retention period for same mix and duly noting Marsh Cone time. The mixture of cement and admixture should be kept stirred throughout the test.
* Repeat the test for another super plasticizer SMF dosage for all the dosage levels.
* A typical graph of Marsh Cone Time in Seconds vs Admixture/Cement dosage in percentage is drawn and for optimum dosage is ascertained. This point is known as “Saturation Point”



**Figure 1: Cement, PCE, SMF, Marshcone Setup**

## **Moulds**

For preparation of concrete specimens of various dosages we have used size 150mm x 150mm Cubical moulds to provide two super plasticizers to the determination of compressive strength Care was taken in using proper compaction through casting and vibrator was used for proper compaction. For determination of split tensile strength we have used cylindrical mould of size 150 mm x 300 mm with concrete specimens and also followed and prepared in accordance with Indian Standard Specifications IS: 516-1959.

**Table 6: Quantity of materials in kg for 1m3, M40 grade concrete grade production**

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| **Target Mean Strength = 48.25 MPa** | **Water in Liters** | **Cement (kg)** | **Fine Aggregate** | **Coarse Aggregate** | **Super Plasticizer** | **W:C** |
| **(kg)** | **(kg)** | **(ml)** |
| 1m3 | 146 | 417 | 797 | 1211 | 4170 | 0.35 |

### Preparation and Casting of Specimens

Proper preparation and casting of concrete specimens are essential parts of testing process in this section, we will show the sum of figs which are represented as preparation and casting of specimens. All the specimens were cast having mix proportions as given in Tables 6. For these mix proportions, required quantities of materials were weighed.

# RESULTS AND DISCUSSION

The test has performed by considering 0.35 water-cement ratio based varying percentage of super plasticizer. Moreover, the test also conducted on harden concrete using testing machines to observe the compressive and split tensile strength of concrete after curing of 7 days and 28 days using different Super plasticizer dosage in concrete mixtures.

## **Determination of Optimum Dosage of Super plasticizer on Marsh Cone Test**

The study was performed Marsh Cone Test to decide the optimum dosage of chemical admixture for each batch to observe compatibility of OPC cement with two different type of SP. Super plasticizers PCE and SMF, for particular water to cement ratio of 0.35. The time needed for a fixed volume of paste pass through the funnel was recorded. The test was carried out according to EN 445 and ASTM 939 94a test procedure.

When carrying out the experimental works, Marsh Cone Time was recorded as shown in Table 7 and Table 8 in Figure 2, Y axis is the Marsh Cone Time in Seconds and X axis is Super plasticizer percentage of dosage was drawn through optimum dose ascertained. This point is known as “Saturation Point”. Figure 2 is demonstrated Marsh Cone Test experimental outputs. During performing the test, predetermined volume of paste poured into metal cone and the time required is measured using stopwatch. The test was carried out using OPC – 53 grade cement with PCE for constant w/c ratio of 0.35.

From Table 4.1 the lowest the Marsh Cone Time (MCT1) is 32 sec at 1% Super plasticizer dosage. Therefore, 1.0% is an optimum dosage for 0.35 water cement ratio, as indicted in Figure 2. The optimum dosage of Poly carboxylic Ether (PCE) for water cement ratio of 0.35 is 1.0% for OPC cement type as shown in Table 7 and Figure 2. Since, those are considering optimum dose of cement and super plasticizer for selected water cement ratio.

**Table 7: Mix Proportions for Cement Paste in Marsh Cone Test using PCE super plasticizer with constant w/c of 0.3**

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| **Mix No.** | **W/C ratio** | **Cement (gm)** | **Water ml** | **PCE dosage , %** | **PCE in (ml)** | **Marsh Cone Time (sec)** |
| T1 | 0.35 | 2000 | 700 | 0 | 0 | 60 |
| T2 | 2000 | 700 | 0.25 | 5 | 48 |
| T3 | 2000 | 700 | 0.5 | 10 | 44 |
| T4 | 2000 | 700 | 0.75 | 15 | 40 |
| T5 | 2000 | 700 | 1 | 20 | 32 |
| T6 | 2000 | 700 | 1.25 | 25 | 33 |
| T7 | 2000 | 700 | 1.5 | 30 | 35 |
| T8 | 2000 | 700 | 1.75 | 35 | 34 |
| T9 | 2000 | 700 | 2 | 40 | 33 |
|  |  |  |  |  |  |

**Figure 2: Analysis of Marsh Cone Test results using PCE**

**Table 8: Mix Proportions for Cement Paste in Marsh Cone Test using SMF super plasticizer with constant w/c of 0.35**

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| **Mix No.** | **W/C ratio** | **Cement (gm)** | **Water ml** | **SMF dosage, %** | **SMF in (ml)** | **Marsh Cone Time (sec)** |
| T1 | 0.35 | 2000 | 700 | 0 | 0 | 60 |
| T2 | 2000 | 700 | 0.25 | 5 | 52 |
| T3 | 2000 | 700 | 0.5 | 10 | 46 |
| T4 | 2000 | 700 | 0.75 | 15 | 42 |
| T5 | 2000 | 700 | 1 | 20 | 39 |
| T6 | 2000 | 700 | 1.25 | **25** | **31** |
| T7 | 2000 | 700 | 1.5 | 30 | 34 |
| T8 | 2000 | 700 | 1.75 | 35 | 35 |
| T9 | 2000 | 700 | 2 | 40 | 34 |

**Figure 3: Analysis of Marsh Cone Test results using SMF**

**Table 9: Summary of Cement Super plasticizer Compatibility Study**

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| **No** | **Cement Type** | **Chemical Admixture Type** | **Water cement ratio** | **Optimum Dosage of** |
| 1 | OPC -53 | PCE | 0.35 | **1%** |
| 2 | SMF | **1.25%** |

The optimum dosage given a water cement ratio of 0.35 is 1.25% using of Sulphonated Melamine Formaldehyde (SMF) for OPC cement type as shown in Table 8 and Figure 3. Since, those are considering optimum dose of super plasticizer and cement for selected water cement ratio.

## **Effects of Super plasticizer Dosage on Slump Test**

Also, slump cone was carried out on fresh concrete materials without and with super plasticizers at water to cement ratio 0.35 and variable water amount reduction. Hence, the slump test were performed in accordance with the requirements of IS codes, shown in table 10. Various slump values which are measured (in mm) are resulted for Super plasticizer for with or without values.

**Table 10: Slump Test with & without Super plasticizer – PCE & SMF**

|  |  |  |  |
| --- | --- | --- | --- |
| **S.No** | **SP dosage %** | **Slump Cone test , mm** | |
| **PCE** | **SMF** |
| 1 | 0 | 5 | 5 |
| 2 | 0.25 | 20 | 25 |
| 3 | 0.5 | 30 | 34 |
| 4 | 1 | 60 | 51 |
| 5 | 1.25 | 115 | 70 |
| 6 | 1.5 | 125 | 110 |
| 7 | 1.75 | 130 | 128 |

Slump values results of super plasticizer are been described in Table 10 and Fig 4 for PCE & SMF super plasticizers respectively. Percentage of SP, SP amount and slump value were recorded. It is demonstrated in Figure 4 Y-axis is the slump height (mm) and X-axis is Super plasticizer in percentage. It was clear the required slump 60 mm and 70 mm was achieved at both super plasticizers optimum dosage of 1 % & 1.25 % and without SP slump value close to ‘0’ because of lesser water cement ratio.

**Figure 4: Effect of SP of PCE & SMF in Slump Cone**

Hence, the SP dosage increased on the concrete mix with the two types of SP of PCE and SMF has distinct results as shown in Figure 4. However, water cement ratios are not altered through super plasticizing through admixtures which has increase the workability. Based on the required slump value of specific construction of structure the dosage of both the Super plasticizers were increased.

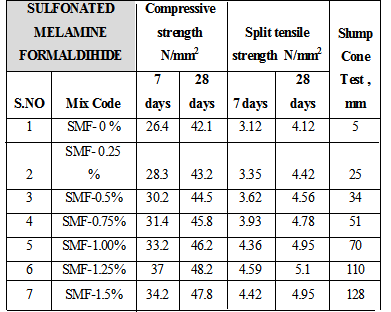
## **Effect of Super plasticizer on Properties of Hardened Concrete Strength**

The intense effect of Super plasticizer (SP) on properties of hardened concrete has also providing a enhanced compressive strength which are using the properties of concrete using the tensile strength. These tests were performed on 7 days and 28 days. The values of SP dosage and Compressive and Splitting Tensile strength at different specific dosage of Super plasticizer also demonstrated in Table 11 and Figure 7 consequently.

**Table 11: Compressive and split tensile Strength of concrete of super plastered Concrete using PCE super plasticizer**

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**Table 12: Compressive and split tensile Strength of concrete of super plastered Concrete using SMF super plasticizer**



**Figure 5: Effect of SP of PCE & SMF on 7 days Compressive strength of concrete with comparison of 0 % of super plasticizer**

**Figure 6: Effect of SP of PCE & SMF on 28 days Compressive strength of concrete with comparison of 0 % of super plasticizer**

### Compressive Strength

From the Figure 5 and Figure 6, it is obviously shown that the strength gains continuously with the increment of Super plasticizer dosage. It also observed that Super plasticizer has a lowest and highest dosage value corresponding to compressive strength. Continuous addition of Super plasticizer Agent may not be capable of growth the compressive strength of concrete continuously; instead excessive dosage reduces the electricity drastically It is true that if dosage increases the compressive strength also increased. But excessive addition of SP disturbed the hydration process because extra addition of SP (Over dosage) provides more water to mix the concrete. Over dosage results also acceleration of deflocculating of cements particles.

Figure 5 demonstrate strength verses dosage of Super plasticizer using PCE & SMF in concrete mixture. It is observed the compressive strength of concrete is maximum at 1 and 1.25 % Super plasticizer dosage and obtained as 49.2 N/mm2 and 48.2 N/mm2 respectively of PCE and SMF for 28 days.

Hence, it can be concluded that the optimum dosage of Super plasticizer for strength criteria is obtained for PCE and SMF super plasticizers with respect to 0 % of super plasticizers; along this competitively PCE super plasticizer gives good compatibility it means cohesiveness PCE with OPC is well as uniformity of the concrete. With OPC cement with lesser dosage value of 1 % instead of SMF. With the acceptance of the statement of PCE was better than SMF for higher strength development of concrete same time SMF also very much better other than 0 % SP usage in development of higher strength concrete development

### Split Tensile Strength

In this concrete it is very difficult to measure directly to determine by tension method because of the problem associated gripping test specimens. For this reasons, the indirect tests such as splitting tensile test and the flexural are used. The indirect tension test is also called the Brazilian test, splitting test. The determination of tensile strength of concrete was carried out by splitting tensile test. Cylinders of 150mm dia. x 300mm high were cast from concrete mixes and kept on moisture condition in laboratory.

# CONCLUSIONS

From our experiential results we concluded and provide outlined Information:

* From the investigation, Optimum Dosage of super plasticizer of PCE and SMF are 1.0% and 1.25% in the respect of OPC 53 grade Cement for a selected water cement ratio of 0.35 of M-40 grade concrete.
* It observed that the top of the line dosages derived from the above tests fall inside the range encouraged via manufactures and it can be point out the two SPs are compatible with the cement used for decided on water cement ratio
* The super plasticizer admixture doses as shown a effective and useful optimization with marsh cone test results.
* From the observation of test result, the addition of Super plasticizers admixtures improves the workability without increasing water demand. As per the requirement of IS 10262 – 2009 and IS 456-200 standard, the addition of 0.5% Super plasticizer admixture in the concrete mix does not provide a significant improvement on workability on cement concrete mix. However, 1%, 1.5% and 2% of SPs on concrete mix have significant change on workability on cement. Also, the additions of 0.5%, 1.0% and 1.5%, of SPs in trial mix using OPC cement, they have shown increment in degree of workability. However, beyond 1.5% SP, have effects of bleeding and segregation of concrete mix.
* Through our performed experimental results and observations the admixture Super plasticizer as shown a very impressive Compressive strength of concrete mix. It is observed the compressive strength of concrete is maximum at 1 % and 1.25 % Super plasticizer dosage and obtained as 49.2 N/mm2 and 48.2 N/mm2 respectively of PCE and SMF for 28 days.
* It is observed the split tensile strength of concrete is maximum at 1 and 1.25 % Super plasticizer dosage and obtained as 4.94 N/mm2 and 5.1 N/mm2 respectively of PCE and SMF for 28 days.
* It also observed that amount of water can be reduced by 24.5 % using these types of high water reducer Sp of PCE and SMF; It was did while designing the mix design of M40 grade concrete, the actual requirement of water is 196 liters for 1 m3 with the usage of these type of SP designed water quantity are 146 liters.
* Furthermore, it is observed that the super plasticized concrete specimens contributed higher strength in splitting Tensile Strength and compressive than the control specimens at 7 and 28 days. Hence, the rates compressive and splitting Tensile strengths are improved when admixtures added to fresh concrete.

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