



September 17, 2019

Mr. Daniel Furr  
Carolina Stalite  
P.O. Box 186  
Gold Hill, North Carolina 28071

Phone: (704) 279-8614  
Email: dfurr@stalite.com

Subject: **Final Report of ASTM C330**  
**Carolina Stalite ¾ Inch Coarse Lightweight Aggregate**  
**TEC Services Project No: 04-0514**  
**TEC Services Sample ID: 19-459**

Dear Mr. Furr:

SGS TEC Services (TEC Services) is an AASHTO R18, ANS/ISO/IEC 17025:2005, and Army Corps of Engineers accredited laboratory. TEC Services is pleased to present this final report of our testing on the ¾-inch lightweight aggregate submitted to our laboratory in April of 2019. The results of this testing pertain only to the samples tested. The aggregate was tested in accordance with ASTM C330-17a *Standard Specification for Lightweight Aggregates for Structural Concrete* as authorized by the service agreement (TEC-PRO-04-0514) dated March 29, 2005.

This specification covers lightweight aggregates intended for use in structural concrete in which the prime considerations are reducing the density while maintaining the compressive strength of the concrete. The maximum and minimum requirements for this specification are presented in Section 4 *Chemical Composition* and Section 5 *Physical Properties* of ASTM C330 and are reported in Table 1. Based on the results, the ¾-inch lightweight aggregate submitted to our laboratory meets and/or exceeds the requirements of ASTM C330.



Testing, Engineering & Consulting Services, Inc.  
235 Buford Drive | Lawrenceville, GA 30046  
770-995-8000 | 770-995-8550 (F) | [www.tecservices.com](http://www.tecservices.com)



**Table 1: Summary of Test Results**

<b>Section 5 - Chemical Composition</b>	<b>Test Results</b>	<b>ASTM C330 Requirements</b>
Organic Impurities (Color change)	< 1	3 (max)
Staining (Stain index)	20	60 (max)
Loss on Ignition	0.05	5% (max)
<b>Section 6 – Physical Properties</b>		
Clay Lumps and Friable Particles (Dry mass)	0.1 %	2% (max)
Bulk Density (Loose)	48 lb/ft <sup>3</sup>	55 lb/ft <sup>3</sup> (max)
Relative Density (Specific Gravity – Wetted Surface Dry)	1.509	----
72-Hour Absorption	5.1 %	----
Compressive Strength (Requirement based off of Calculated Equilibrium Density)	5,130	3,180 psi (min)
Splitting Tensile (Requirement based off of Calculated Equilibrium Density)	385	313 psi (min)
Drying Shrinkage	-0.022	-0.070 % (max)
Popouts	No Popouts	No Popouts
Grading	See Section 5.1.2 Below	
Resistance to Freezing and Thawing - Average Relative Dynamic Modulus (%)	98	

## **Test Results**

### **Organic Impurities**

Requirement – Lightweight aggregate subjected to the test for organic impurities shall not produce darker color than standard.

Result – The lightweight aggregate did not show any color change.

### **Iron Staining**

Requirement – Lightweight aggregate shall have a stain index of less than sixty.

Result – The lightweight aggregate showed light stain, which indicates an index of 20.

### **Loss on Ignition**

Requirement – Lightweight aggregate shall have a loss of ignition not more than five percent.

Result – The lightweight aggregate had a loss on ignition of 0.05 percent.

### **Clay Lumps and Friable Particles**

Requirement – The amount of clay lumps and friable particles shall not exceed two percent by dry mass.

Results – The lightweight aggregate had 0.1 percent clay lumps and friable aggregate.

**Grading**

The grading shall conform to the requirements in Table 1 of ASTM C330. The Grading and the required grading are reported in Table 2.

**Table 2: Grading & Required Grading**

Sieve Size	% Passing	Required % passing (¾" to #4)
1 in (25mm)	100	100
¾ in (19mm)	96.7	90-100
½ in (12.5mm)	36.9	---
⅜ in (9.5mm)	19.3	10 - 50
#4 (4.75mm)	3.3	0-15
#8 (2.36mm)	2.7	---

**Bulk Density (Loose)**

Requirement – The maximum bulk density (loose) for coarse aggregate is 55 lbs/ft<sup>3</sup>.

Result – The lightweight aggregate had an average bulk density (loose) of 48 lb/ft<sup>3</sup>.

**Specific Gravity & Absorption**

The density factor was tested in accordance with ASTM C128 - 12 *Standard Test Method for Density, Relative Density (Specific Gravity) & Absorption of Coarse Aggregate*. The sample was dried to a constant mass and soaked for 72 hours. The specific gravity and absorption are reported in Table 3.

**Table 3: Specific Gravity & Absorption**

Absorption after 72-hour Soak (percent)	Relative Density (Specific Gravity) (OD)	Relative Density (Specific Gravity) (SSD)
5.1	1.435	1.509

Concrete mixtures containing the lightweight aggregate were batched in order to make test specimens for compressive strength, splitting tensile, drying shrinkage and resistance to freezing and thawing. The material sources and amount of material used in the concrete mix are reported in Table 4. Fresh properties are reported in Table 5.

**Table 4: Mix Proportions**

Material	Source	Amount (pcy)
Portland Type I/II Cement	Lehigh, Leeds	564
Fine Aggregate	Lambert, Natural Sand	1387
¾-inch Lightweight Aggregate	Carolina Stalite	899
Air Entrainment	Vinsol Resin	1.25 oz/yd <sup>3</sup>
Water Reducer	Type F – High Range	8.7 oz/yd <sup>3</sup>
Water	Lawrenceville City Water	285
Total		3135

**Table 5: Fresh Properties**

Slump (inches)	3.00
Unit Weight (lb/ft <sup>3</sup> )	115.4
Air Content (%)	5.75
Concrete Temperature (°F)	73

The oven-dry density of the concrete mixture was calculated by the mixture quantities, aggregate moisture content, and the volume of the concrete batch. The calculated equilibrium density of 110.9 lb/ft<sup>3</sup> was calculated by adding 3 lb/ft<sup>3</sup> to the calculated oven-dry density. The calculated equilibrium density is used to determine the specification requirements for the compressive and split tensile strengths.

**Compressive Strength and Splitting Tensile Strength**

**Compressive Strength**

Requirement – For a concrete with combinations of normal weight and lightweight aggregates and a calculated equilibrium density of 110.9 lb/ft<sup>3</sup>, the minimum compressive strength is 3,180 psi. This was calculated by interpolation from the values presented in section 5.2.1 and are reported in Table 6. The specimens tested were 4” x 8” cylinders and the results are reported in Table 7.

**Table 6: Compressive & Splitting Tensile Strength Requirements**

Calculated Equilibrium Density (lbs/ft <sup>3</sup> )	Splitting Tensile Strength Requirements (psi)	Compressive Strength Requirements (psi)
115	330	4,000
110	310	3,000

**Table 7: Compressive Strength Results**

Sample ID	Compressive Strength (psi)
19-459-A	4,860
19-459-B	5,210
19-459-C	5,650
19-459-D	4,800
<b>Average</b>	<b>5,130</b>

Splitting Tensile

Requirement – For a concrete with combinations of normal weight and lightweight aggregates and a calculated equilibrium density of 110.9 lb/ft<sup>3</sup>, the minimum splitting tensile strength is 313 psi. The specimens tested were 6” x 12” cylinders and the results are reported in Table 8.

**Table 8: Splitting Tensile Strength Result**

Sample ID	Splitting Tensile Strength (psi)
19-459-1	350
19-459-2	430
19-459-3	430
19-459-4	340
19-459-5	460
19-459-6	355
19-459-7	320
19-459-8	400
<b>Average</b>	<b>385</b>

### **Drying Shrinkage**

Three length change beams (4" x 4" x 11 1/4") were moist cured for seven days. Upon the completion of the 7-day moist curing an initial reading was obtained, which was used as the base length for the drying shrinkage calculations. The samples were then placed in a curing cabinet maintained at  $100 \pm 2^\circ\text{F}$  with a relative humidity of  $32 \pm 2\%$  for 28 days.

Requirement – The drying shrinkage of the concrete specimens shall not exceed 0.07% at 28days.

**Table 9: Drying Shrinkage at 28 Days**

<b>Sample ID</b>	<b>Length Change at 28 Days (%)</b>
19-459 (1)	-0.021
19-459 (2)	-0.022
19-459 (3)	-0.023
<b>Average</b>	<b>-0.022</b>

### **Popouts**

Requirement – There shall be no popouts observed after test concrete made with the tested lightweight aggregate is subjected to an autoclave in accordance with ASTM C151-09 *Standard Test Method for Autoclave Expansion of Hydraulic Cement*.

Result – No popouts were observed.

### **Resistance to Freezing and Thawing**

The freeze-thaw samples were tested in accordance with ASTM C666-15 *Resistance of Concrete to Rapid Freezing and Thawing – Procedure A (freezing and thawing in water)* with the curing modifications listed in ASTM C330. Test results are reported in Table 10.

**Table 10– Freeze-Thaw Testing – Cast Concrete Samples (3 beams)**

Total Cycles Completed	Fundamental Transverse Frequency, khz			Relative Dynamic Modulus (%)			Weight Change (grams)			Length Change (inches)		
	Beam 1	Beam 2	Beam 3	Beam 1	Beam 2	Beam 3	Beam 1	Beam 2	Beam 3	Beam 1	Beam 2	Beam 3
0	1.816	1.797	1.816	100	100	100	0	0	0	0	0	0
27	1.801	1.783	1.816	98	98	100	0	0	0	0	0	0
52	1.801	1.783	1.801	98	98	98	0	0	0	0	0	0
72	1.801	1.783	1.801	98	98	98	0	0	0	0	0	0
108	1.801	1.783	1.801	98	98	98	0	0	0	0	0	0
142	1.801	1.783	1.801	98	98	98	0	0	0	0	0	0
161	1.801	1.783	1.801	98	98	98	0	0	0	0	0	0
185	1.801	1.783	1.801	98	98	98	0	0	0	0	0	0
220	1.801	1.783	1.801	98	98	98	0	0	0	0	0	0
256	1.801	1.783	1.801	98	98	98	0	0	0	0	0	0
291	1.801	1.783	1.801	98	98	98	0	0	0	0	0	0
300	1.801	1.783	1.801	98	98	98	0	0	0	0	0	0
<b>Average Relative Dynamic Modulus</b>				<b>98</b>			<b>0</b>			<b>0</b>		

We appreciate the opportunity to provide our services to you on this project. Should you have any questions or comments regarding this report, please feel free to contact us at your convenience

Sincerely,

**SGS TEC Services**



Steven Maloof  
 Laboratory Principal/Sr. Project Manager



Brian Smith  
 Project Manager