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To: All Holders of the Manual of Field Test Procedures

Section: **Test Procedure WAQTC TM 2**

The Oregon Department of Transportation has specified method(s) for this Test Procedure. Please observe the following for our projects:

Under the Apparatus Section, delete bullet 6 and replace with the following:

- **Apparatus for wet sieving, including: a sieve(s), conforming to AASHTO M 92, of suitable size and conveniently arranged and supported so that the sieve can be shaken rapidly by hand.**

SAMPLING FRESHLY MIXED CONCRETE
FOP FOR WAQTC TM 2

Scope

This method covers procedures for obtaining representative samples of fresh concrete delivered to the project site. The method includes sampling from stationary, paving and truck mixers, and from agitating and non-agitating equipment used to transport central mixed concrete.

This method also covers the removal of large aggregate particles by wet sieving.

Sampling concrete may involve hazardous materials, operations, and equipment. This standard does not purport to address all of the safety problems associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices.

Warning—Fresh Hydraulic cementitious mixtures are caustic and may cause chemical burns to skin and tissue upon prolonged exposure.

Apparatus

- Wheelbarrow
- Cover for wheelbarrow (plastic, canvas, or burlap)
- Buckets
- Shovel
- Cleaning equipment, including scrub brush, rubber gloves, water
- Apparatus for wet sieving, including: a sieve(s), conforming to AASHTO M 92, minimum of 2 ft^2 (0.19 m^2) of sieving area, conveniently arranged and supported so that the sieve can be shaken rapidly by hand.

Procedure

1. Use every precaution in order to obtain samples representative of the true nature and condition of the concrete being placed being careful not to obtain samples from the very first or very last portions of the batch. The size of the sample will be 1.5 times the volume of concrete required for the specified testing, but not less than 0.03 m^3 (1 ft^3).
2. Dampen the surface of the receptacle just before sampling, empty any excess water.

Note 1: Sampling should normally be performed as the concrete is delivered from the mixer to the conveying vehicle used to transport the concrete to the forms; however, specifications may require other points of sampling, such as at the discharge of a concrete pump.

3. Use one of the following methods to obtain the sample:

- **Sampling from stationary mixers**

  Obtain the sample after a minimum of 1/2 m^3 (1/2 yd^3) of concrete has been discharged. Perform sampling by passing a receptacle completely through the discharge stream, or by completely diverting the discharge into a sample container. Take care not to restrict the flow of concrete from the mixer, container, or transportation unit so as to cause segregation. These requirements apply to both tilting and nontilting mixers.

- **Sampling from paving mixers**

  Obtain the sample after the contents of the paving mixer have been discharged. Obtain material from at least five different locations in the pile and combine into one test sample. Avoid contamination with subgrade material or prolonged contact with absorptive subgrade. To preclude contamination or absorption by the subgrade, the concrete may be sampled by placing a shallow container on the subgrade and discharging the concrete across the container.

- **Sampling from revolving drum truck mixers or agitators**

  Obtain the sample after a minimum of 1/2 m^3 (1/2 yd^3) of concrete has been discharged. Obtain samples after all of the water has been added to the mixer. Do not obtain samples from the very first or last portions of the batch discharge. Perform sampling by repeatedly passing a receptacle through the entire discharge stream or by completely diverting the discharge into a sample container. Regulate the rate of discharge of the batch by the rate of revolution of the drum and not by the size of the gate opening.

- **Sampling from open-top truck mixers, agitators, non-agitating equipment or other types of open-top containers**

  Obtain the sample by whichever of the procedures described above is most applicable under the given conditions.

- **Sampling from pump or conveyor placement systems**

  Obtain sample after a minimum of 1/2 m^3 (1/2 yd^3) of concrete has been discharged. Obtain samples after all of the pump slurry has been eliminated. Perform sampling by repeatedly passing a receptacle through the entire discharge system or by completely diverting the discharge into a sample container. Do not lower the pump arm from the placement position to ground level for ease of sampling, as it may modify the air content of the concrete being sampled. Do not obtain samples from the very first or last portions of the batch discharge.

4. Transport samples to the place where fresh concrete tests are to be performed and specimens are to be molded. They shall then be combined and remixed with a shovel the minimum amount necessary to ensure uniformity. Protect the sample from direct sunlight, wind, rain, and sources of contamination.

5. Complete test for temperature and start tests for slump and air content within 5 minutes of obtaining the sample. Start molding specimens for strength tests within 15 minutes of obtaining the sample. Complete the test methods as expeditiously as possible.

Wet Sieving

When required due to oversize aggregate, the concrete sample shall be wet sieved, after transporting but prior to remixing, for slump testing, air content testing or molding test specimens, by the following:

1. Place the sieve designated by the test procedure over the dampened sample container.
2. Pass the concrete over the designated sieve. Do not overload the sieve (one particle thick).
3. Shake or vibrate the sieve until no more material passes the sieve. A horizontal back and forth motion is preferred.
4. Discard oversize material including all adherent mortar.
5. Repeat until sample of sufficient size is obtained. Mortar adhering to the wet-sieving equipment shall be included with the sample.
6. Using a shovel, remix the sample the minimum amount necessary to ensure uniformity.

Note 2: Wet sieving is not allowed for samples being used for density determinations according to the FOP for AASHTO T 121.

Report

- On forms approved by the agency
- Date
- Time
- Location
- Quantity represented

Volumetric Properties of Hot Mix Asphalt (HMA)
WAQTC TM 13

Scope

This procedure covers the determination of volumetric properties of plant produced Hot Mix Asphalt, i.e., air voids (V_a), voids in mineral aggregate (VMA), voids filled with asphalt binder (VFA), effective asphalt binder content (P_{be}) and Dust to Binder Ratio ($P_{\#200}/P_{be}$). The in-production volumetric properties are then compared to agency specifications.

Definition of Terms

- G_{mm} = theoretical maximum specific gravity (Gravity $_{mix\ max}$)
- G_{mb} = measured bulk specific gravity (Gravity $_{mix\ bulk}$)
- G_{sb} = oven-dry bulk specific gravity of aggregate (Gravity $_{stone\ bulk}$)
- G_{sa} = apparent specific gravity of aggregate (Gravity $_{stone\ apparent}$)
- G_{se} = effective specific gravity of aggregate (Gravity $_{stone\ effective}$)
- G_b = specific gravity of the binder (Gravity $_{binder}$)
- V_a = air Voids (Voids $_{air}$)
- VMA = Voids in Mineral Aggregate
- VFA = Voids Filled with Asphalt (binder)
- V_{ba} = absorbed binder volume (Voids $_{binder\ absorbed}$)
- V_{be} = effective binder volume (Voids $_{binder\ effective}$)
- P_b = percent binder content (Percent $_{binder}$)
- P_{ba} = percent absorbed binder (Percent $_{binder\ absorbed}$)
- P_{be} = percent effective binder content (Percent $_{binder\ effective}$)
- P_s = percent of aggregate (Percent $_{stone}$)
- DP = Dust proportion to effective binder ratio ($P_{0.075}/P_{be}$)

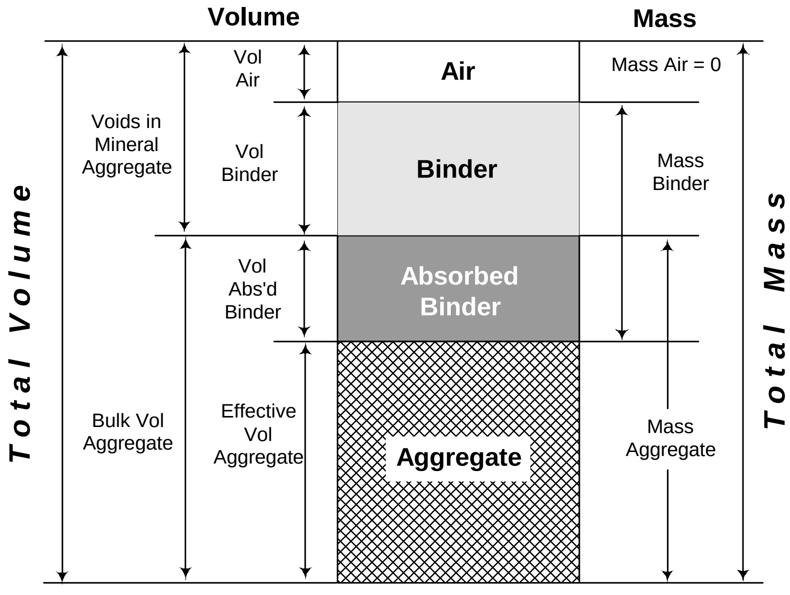
Background

Whether a mix design is developed through a Marshall, Hveem, or Superpave mix design process there are basic volumetric requirements of all. Volumetric properties are the properties of a defined material contained in a known volume. HMA Volumetric properties HMA Volumetric properties can include bulk specific gravity, theoretical maximum specific gravity, air voids, and voids in mineral aggregate.

Many agencies specify values of the volumetric properties to ensure optimum performance of the pavement. The HMA must be designed to meet these criteria. In production the HMA is evaluated to determine if the mix still meets the specifications and is consistent with the original mix design (JMF). The production HMA may vary from the mix design and may need to be modified to meet the specified volumetric criteria.

To compare the in-production volumetric properties to agency specifications and the JMF a sample of loose HMA mix is obtained in accordance with FOP for AASHTO T 168. The sample is then compacted in a gyratory compactor to simulate the in-place HMA pavement after it has been placed, compacted, and the volumetric properties of the compacted sample are determined.

HMA Phase Diagram

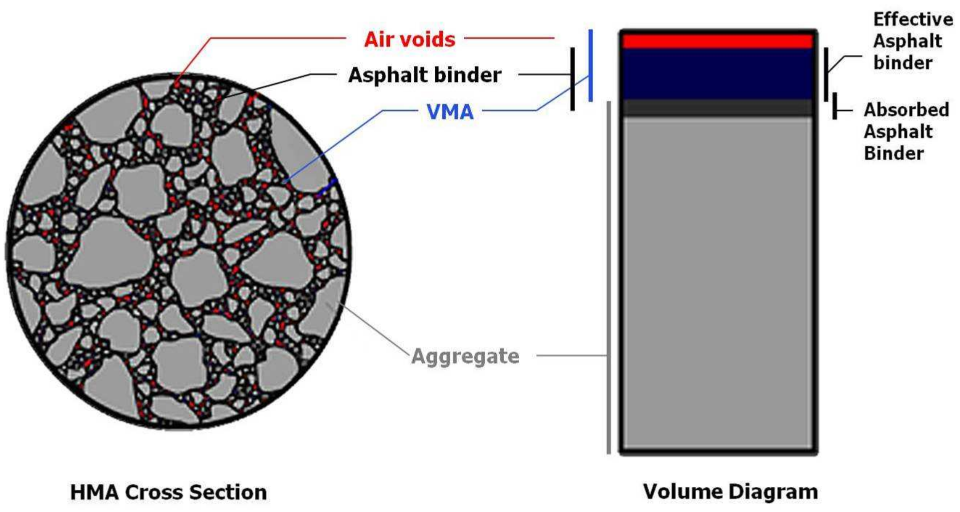


Each of the properties in the HMA phase diagram can be measured or calculated. For example: The mass of the aggregate is measured; the voids in mineral aggregate (VMA) is calculated; total asphalt binder can be measured but the amount available to act as a binder in the mix must be calculated because it is the quantity left after the aggregate has absorbed some of the asphalt binder.

The volumetric proportions of the asphalt binder and aggregate components of an asphalt mixture and their relationship to the other components are considered. The mass of the components and their specific gravities are used to determine the volumes of each of the components in the mix. The volumetric properties of a compacted HMA paving mixture: air voids (V_a), voids in mineral aggregate (VMA), voids filled with asphalt binder (VFA), and effective asphalt binder content (P_{be}) provide some indication of the mixtures probable performance.

Volumetric Properties

Volumetric Relationship of HMA Constituents



Required Values

The specific gravities listed in Table 1 and the percent by mass of each of the components in the HMA are needed to determine the volumetric properties. Other values required are also listed. Some of these values are obtained from the JMF and some are measured from a plant produced HMA sample.

Table 1

Data	Test Method	Obtained
G_{sb} - combined aggregate bulk specific gravity	AASHTO T 84 / T 85 or agency approved test method	JMF or performed at the beginning of placement
G_b – measured specific gravity of the asphalt binder	AASHTO T 228	JMF or from the supplier
G_{mm} – measured maximum specific gravity of the loose mix	FOP for AASHTO T 209	Performed on the field test sample
G_{mb} – measured bulk specific gravity of the compacted paving mix	FOP for AASHTO T 166	Performed on the field compacted specimen
P_b – percent asphalt binder	FOP for AASHTO T 308	Performed on the field test sample
$P_{-\#200}$ – aggregate passing the #200 (0.075 mm) sieve	FOP for AASHTO T 30	Performed on the field test sample

Air Voids (V_a)

Air voids are the total volume of the small pockets of air between the coated aggregate particles throughout a compacted paving mixture. Appropriate air voids contribute to the stability of the HMA and help the pavement withstand the combined action of environment and traffic loads. The designated percent air voids allows for thermal expansion of the asphalt binder and contributes a cushion for future compaction. Air voids are expressed as a percent of the bulk volume of the compacted mixture (G_{mb}) when compared to the maximum specific gravity (G_{mm}).

$$V_a = 100\left[\frac{(G_{mm} - G_{mb})}{G_{mm}}\right]$$

Where:

V_a = air voids in compacted mixture, percent of total volume (report to 0.1)
G_{mm} = maximum specific gravity of paving mixture (AASHTO T 209)
G_{mb} = bulk specific gravity of compacted mixture (AASHTO T 166)

Percent Aggregate (Stone) (P_s)

P_s is the percent aggregate (stone) content, expressed as a percentage of the total mass of the sample.

$$P_s = 100 - P_b$$

Where:

P_s = percent aggregate (stone) (report to 0.1) percent by total weight
P_b = asphalt binder content (AASHTO T 308)

Voids in the Mineral Aggregate (VMA)

VMA is the volume of intergranular void space between the aggregate particles of the compacted paving mixture that includes the air voids and the effective binder content, expressed as a percent of the total volume of the sample.

$$VMA = 100 - \left[\frac{(G_{mb} \times P_s)}{G_{sb}}\right]$$

Where:

VMA = voids in mineral aggregate, percent of bulk volume (report to 0.1**)**

G_{sb} = bulk specific gravity of combined aggregate (AASHTO T 85 / T 84 or agency approved method from Job Mix Formula)

G_{mb} = bulk specific gravity of compacted mixture (AASHTO T 166)

P_s = aggregate content, percent by total weight = 100 – P_b

P_b = asphalt binder content (AASHTO T 308) percent by total weight

Voids Filled with Asphalt (binder) (VFA)

VFA is the volume of space between the aggregate particles of the compacted paving mixture filled with asphalt binder, expressed as a percent of the total volume of the sample. The VFA increases as the asphalt binder content increases as it is the percent of voids that are filled with asphalt which doesn't include the absorbed asphalt.

$$VFA = 100\left[\frac{(VMA - V_a)}{VMA}\right]$$

Where:

VFA = voids filled with asphalt, percent of VMA (report to 1)
VMA = voids in mineral aggregate, percent of bulk volume
V_a = air voids in compacted mixture, percent of total volume.

Effective Specific Gravity of the Aggregate (Stone) (G_{se})

The G_{se} is used to quantify the asphalt binder absorbed into the aggregate particle. This is a calculated value based on the specific gravity of the mixture, G_{mm}, and the specific gravity of the asphalt binder, G_b This measurement includes the volume of the aggregate particle plus the void volume that becomes filled with water during the test soak period minus the volume of the voids that absorb asphalt binder. Effective specific gravity lies between apparent and bulk specific gravity.

G_{se} is formally defined as the ratio of the mass in air of a unit volume of a permeable material (excluding voids permeable to asphalt binder) at a stated temperature to the mass in air (of equal density) of an equal volume of gas-free distilled water at a stated temperature.

$$G_{se} = \frac{P_s}{\left[\left(\frac{100}{G_{mm}}\right) - \left(\frac{P_b}{G_b}\right)\right]}$$

Where:

G_{se} = effective specific gravity of combined aggregate (report to 0.001)
P_s = aggregate content, percent by total weight = 100 – P_b
G_{mm} = maximum specific gravity of mix (AASHTO T 209)
P_b = asphalt binder content (AASHTO T 308) percent by total weight
G_b = specific gravity of asphalt binder (JMF or asphalt binder supplier)

Percent of Absorbed (asphalt) Binder (P_{ba})

P_{ba} is the total percent of the asphalt binder that is absorbed into the aggregate, expressed as a percentage of the mass of aggregate rather than as a percentage of the total mass of the mixture. This portion of the asphalt binder content does not contribute to the performance of the mix.

$$P_{ba} = 100\left[\frac{(G_{se} - G_{sb})}{(G_{sb} \times G_{se})}\right] G_b$$

Where:

P_{ba} = absorbed asphalt binder (report to 0.01) percent of aggregate

G_{se} = effective specific gravity of combined aggregate
G_{sb} = bulk specific gravity of combined aggregate (AASHTO T 85 / T 84 or agency approved method from Job Mix Formula)
G_b = specific gravity of asphalt binder (JMF or asphalt binder supplier)

Percent of Effective (asphalt) Binder (P_{be})

P_{be} is the total asphalt binder content of a paving mixture minus the portion of asphalt binder that is lost by absorption into the aggregate particles, expressed as a percentage of the mass of aggregate. It is the portion of the asphalt binder content that remains as a coating on the outside of the aggregate particles. This is the asphalt content that controls the performance of the mix.

$$P_{be} = P_b - \left[\frac{P_{ba}}{100} \times P_s\right]$$

Where:

P_{be} = effective asphalt binder content (report to 0.01), percent by total weight

P_s = aggregate content, percent by total weight = 100 – P_b

P_b = asphalt binder content (AASHTO T 308) percent by total weight

P_{ba} = absorbed asphalt binder

Dust Proportion – DP (Dust to Effective (asphalt) Binder Ratio)

The DP is the percent passing the No. 200 sieve of the gradation divided by the percent of effective asphalt binder. Excessive dust reduces asphalt binder film thickness on the aggregate which reduces the durability. Insufficient dust may allow excessive asphalt binder film thickness, which may result in a tender, unstable mix.

$$DP = \frac{P_{-\#200}}{P_{be}}$$

Where:

DP = Dust Proportion, (dust-to-binder ratio) (report to 0.01)

$P_{-\#200}$ = aggregate passing the -#200 (0.075 mm) sieve, percent by mass of aggregate (AASHTO T 30)

P_{be} = effective asphalt binder content, percent by total weight

Mix Design and Production Values

Job Mix Formula

Table 2 includes example data required from the JMF. Some of these values are used in the example calculations.

Note: Some of the targets may change after the HMA is in production based on field test data.

Table 2

JMF Data	
Asphalt binder grade	PG 64-28
N_{values}	N_{ini} = 7 **N_{des} = 75** N_{max} = 115
G_{sb} (combined specific gravity of the aggregate)	2.678
Target P_b	4.75%
Initial sample mass for gyratory specimens	4840 grams
Mixing temperature range	306 – 312 °F
Laboratory compaction temperature range	286 – 294 °F
G_b (specific gravity of the asphalt binder)	1.020
Target gradation	
Sieve Size mm (in.)	**Percent Passing**
19.0 (3/4)	100
12.5 (1/2)	85
9.5 (3/8)	80
4.75 (No. 4)	50
2.36 (No. 8)	30
01.18 (No. 16)	25
0.600 (No. 30)	15
0.300 (No. 50)	10
0.150 (No. 100)	7
75 µm (No. 200)	5.0

Sample Test Result

Tables 3 and 4 include data from test results performed on a field sample of HMA used in the example calculations.

Table 3

Field Data		
	Test method	**Example values**
P_b	FOP for AASHTO T 308	4.60%
G_{mb}	FOP for AASHTO T 166	2.415
G_{mm}	FOP for AASHTO T 209	2.516

Table 4

Sieve Analysis FOP for AASHTO T 30	
Sieve Size mm (in.)	**Percent Passing**
19.0 (3/4)	100
12.5 (1/2)	86
9.5 (3/8)	77
4.75 (No. 4)	51
2.36 (No. 8)	34
01.18 (No. 16)	23
0.600 (No. 30)	16
0.300 (No. 50)	12
0.150 (No. 100)	8
75 µm (No. 200)	4.9

Sample Calculations

Air Voids (V_a)

$$V_a = 100\left[\frac{(G_{mm} - G_{mb})}{G_{mm}}\right]$$

$$V_a = 100\left[\frac{(2.516 - 2.415)}{2.516}\right] = 4.0\%$$

Given:

G_{mm} = 2.516
G_{mb} = 2.415

Percent Aggregate (Stone) (P_s)

$$P_s = 100 - P_b$$

$$P_s = 100 - 4.60\% = 95.40\%$$

Given:

P_b = 4.60%

Voids in the Mineral Aggregate (VMA)

$$VMA = 100 - \left[\frac{(G_{mb} \times P_s)}{G_{sb}}\right]$$

$$VMA = 100 - \left[\frac{2.415 \times 95.40\%)}{2.678}\right] = 13.96\%$$

Given:

G_{sb} =2.678

Voids Filled with Asphalt (binder) (VFA)

$$VFA = 100\left[\frac{(VMA - V_a)}{VMA}\right]$$

$$VFA = 100\left[\frac{(13.96\% - 4.0\%)}{13.96\%}\right] = 71\%$$

Effective Specific Gravity of the Aggregate (Stone) (G_{se})

$$G_{se} = \frac{P_s}{\left[\left(\frac{100}{G_{mm}}\right) - \left(\frac{P_b}{G_b}\right)\right]}$$

$$G_{se} = \frac{(100 - 4.60\%)}{\left[\left(\frac{100}{2.516}\right) - \left(\frac{4.60\%}{1.020}\right)\right]} =$$

$$G_{se} = \frac{95.40\%}{39.7456 - 4.5098} = 2.707$$

Given:

G_b = 1.020

Percent of Absorbed (asphalt) Binder (P_{ba})

$$P_{ba} = 100\left[\frac{(G_{se} - G_{sb})}{(G_{sb} \times G_{se})}\right] G_b$$

$$P_{ba} = 100\left[\frac{(2.707 - 2.678)}{(2.678 \times 2.707)}\right] 1.020 =$$

$$P_{ba} = 100\left[\frac{0.0290}{7.2493}\right] 1.020 = 0.41\%$$

Percent of Effective (asphalt) Binder (P_{be})

$$P_{be} = P_b - \left[\frac{P_{ba}}{100} \times P_s\right]$$

$$P_{be} = 4.6 - \left[\frac{0.41\%}{100} \times (100 - 4.60\%)\right] = 4.21\%$$

Dust Proportion – DP (Dust to Effective (asphalt) Binder Ratio)

$$DP = \frac{P_{-\#200}}{P_{be}}$$

$$DP = \frac{4.9\%}{4.21\%} = 1.16$$

Given:

$P_{-\#200}$ = 4.9%

Report

- Results on forms approved by the agency
- Air Voids, V_a to 0.1 percent
- Voids in the Mineral Aggregate, VMA to 0.1 percent
- Voids Filled with Asphalt, VFA to nearest whole value
- Effective Specific Gravity of Aggregate (stone), G_{se} to 0.001
- Percent of Absorbed (asphalt) Binder, P_{ba} to 0.01
- Percent Effective (asphalt) Binder, P_{be} to 0.01
- Dust Proportion, DP to 0.01

Appendix - Formulas

Air Voids (V_a)

$$V_a = 100\left[\frac{(G_{mm} - G_{mb})}{G_{mm}}\right]$$

Where:

V_a = air voids in compacted mixture, percent of total volume (report to 0.1)
G_{mm} = maximum specific gravity of paving mixture (AASHTO T 209)
G_{mb} = bulk specific gravity of compacted mixture (AASHTO T 166)

Percent Aggregate (Stone) (P_s)

$$P_s = 100 - P_b$$

Where:

P_s = percent aggregate (stone) (report to 0.1) percent by total weight
P_b = asphalt binder content (AASHTO T 308)

Voids in the Mineral Aggregate (VMA)

$$VMA = 100 - \left[\frac{(G_{mb} \times P_s)}{G_{sb}}\right]$$

Where:

VMA = voids in mineral aggregate, percent of bulk volume (report to 0.1)

G_{sb} = bulk specific gravity of combined aggregate (AASHTO T 85 / T 84 or agency approved method from Job Mix Formula)

G_{mb} = bulk specific gravity of compacted mixture (AASHTO T 166)

P_s = aggregate content, percent by total weight = 100 – P_b

P_b = asphalt binder content (AASHTO T 308) percent by total weight

Voids Filled with Asphalt (binder) (VFA)

$$VFA = 100\left[\frac{(VMA - V_a)}{VMA}\right]$$

Where:

VFA = voids filled with asphalt, percent of VMA (report to 1)
VMA = voids in mineral aggregate, percent of bulk volume
V_a = air voids in compacted mixture, percent of total volume.

Effective Specific Gravity of the Aggregate (Stone) (G_{se})

$$G_{se} = \frac{P_s}{\left[\left(\frac{100}{G_{mm}}\right) - \left(\frac{P_b}{G_b}\right)\right]}$$

Where:

G_{se} = effective specific gravity of combined aggregate (report to 0.001)
P_s = aggregate content, percent by total weight = 100 – P_b
G_{mm} = maximum specific gravity of mix (AASHTO T 209)
P_b = asphalt binder content (AASHTO T 308) percent by total weight
G_b = specific gravity of asphalt binder (JMF or asphalt binder supplier)

Percent of Absorbed (asphalt) Binder (P_{ba})

$$P_{ba} = 100\left[\frac{(G_{se} - G_{sb})}{(G_{sb} \times G_{se})}\right]G_b$$

Where:

P_{ba} = absorbed asphalt binder (report to 0.01) percent of aggregate
G_{se} = effective specific gravity of combined aggregate
G_{sb} = bulk specific gravity of combined aggregate (AASHTO T 85 from Job Mix Formula)
G_b = specific gravity of asphalt binder (JMF or asphalt binder supplier)

Percent of Effective (asphalt) Binder (P_{be})

$$P_{be} = P_b - \left[\frac{P_{ba}}{100} \times P_s\right]$$

Where:

P_{be} = effective asphalt binder content (report to 0.01), percent by total weight

P_s = aggregate content, percent by total weight = 100 – P_b

P_b = asphalt binder content (AASHTO T 308) percent by total weight

P_{ba} = absorbed asphalt binder

Dust Proportion – DP (Dust to Effective (asphalt) Binder Ratio)

$$DP = \frac{P_{-\#200}}{P_{be}}$$

Where:

DP = Dust Proportion, (dust-to-binder ratio) (report to 0.01)

$P_{-\#200}$ = aggregate passing the -#200 (0.075 mm) sieve, percent by mass of aggregate (AASHTO T 30)

P_{be} = effective asphalt binder content, percent by total weight