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## MECHANICAL AND PHYSICAL PROPERTIES OF CONCRETE CONTAINING FGD WASTE

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### Abstract

The paper is part of a wide ranging research project on the optimum use of waste from the dry and semi dry flue gas desulphurisation (FGD) processes in concrete. It examines the influence of a typical simulated desulphurised waste (SDW) on the physical and mechanical and physical properties of concrete. SDW was chosen due to the wider variability in the composition of actual FGD waste. Two binder systems were investigated (i) cement and SDW (C-SDW) and (ii) cement, slag and SDW (C-S-SDW). The SDW content ranged from 0-70% and the slag from 0-90% as partial replacement of the cement. The properties examined included compressive and flexural strength, water absorption, shrinkage and expansion. The results showed that replacing cement with SDW beyond 20% systematically reduce strength. An increase in SDW reduces shrinkage. The presence of small amounts of slag allows the use of high proportions of SDW. The use of desulphurised waste in concrete applications is possible as adequate strength can be achieved.

**Keywords:** concrete technology & manufacture, recycling & reuse of materials, environment.

## 1. Introduction

The presence of certain amounts of gypsum (G) in concrete affects its strength. Lerch (1946) reported that gypsum in cement generally increased strength. However, the optimal G content depends mainly on the clinker used. The three main factors influencing optimum G content are fineness, C<sub>3</sub>A content and the alkalis (Na<sub>2</sub>O, K<sub>2</sub>O) present in the clinker used. The presence of sulphate in blended cement containing slag, fly ash and silica fume improve performance (Poon et al 2001; Wang & Song 2013).

Bentur (1976) and Shiyuan (1982) reported that incorporating between 2-4% G in cement paste leads to an increase in strength whereas reduction occurs beyond this level. Increasing the G content increases the C/S ratio of the C-S-H formed, which corresponded to a decrease in strength of the C-S-H gel. The strength of mortars was found to decrease as the G content increased, irrespective of the curing condition.

The large variation in composition of coal combustion wastes from dry and semi-dry desulphurisation process means that the strength properties of binders containing such wastes are significantly different. There have been attempts to investigate the strength of such materials in cement-based systems and non-cement based systems, however, the results seem specific to each investigation (Jeppesen 1990). Demirbas and Aslan (1999) reported that using desulphurised wastes, reduced the early strength however, the strength at 28 days was either equal to or greater than the reference. It was suggested that the strength was dependent on the composition of the waste, and an increase in the SiO<sub>2</sub>+Al<sub>2</sub>O<sub>3</sub>+Fe<sub>2</sub>O<sub>3</sub> (SAF) resulted in a strength decrease. Wastes containing high SAF contents are generally classified as pozzolanic and, therefore, the positive effects of these ashes may not have been observed during the first 28 days. The wastes that performed the best were low in SAF and consisted mainly of CaO and are similar to fly ash with high lime contents (ASTM Class C), which exhibit both cementitious and pozzolanic properties.

Spray dry absorption wastes (SDA) are a semi-dry waste and consist of fly ash, sulphates and sulphites. Cornelissen (1991) reported the strength of concretes containing simulated SDA waste with various sulphate-sulphite ratios. As with other desulphurised wastes, the setting times were slightly retarded meaning that strength development was slightly slower. After 28 days, the strength of the SDA mixes was significantly lower than the reference and increasing the sulphate-sulphite ratio decreased the strength. Drottner and Havlica (1997) indicated the strength development properties of mortars containing fluidised bed combustion ash (FBC) and found the strength is dependent on the content of FBC in the mix and the age of curing.

In this paper, an experimental investigation was carried out to evaluate the properties of concrete containing FGD waste to partially replace the cement. Due to the wider variability in compositions of actual FGD waste, simulated desulphurised waste (SDW) was used which was a blend of fly ash and gypsum. In addition, the influence of including ground granulated blastfurnace slag in these binder systems on concrete properties was investigated. The properties determined were consistence, density, compressive and flexural strength, water absorption and length change.

## 2. Experimental

### 2.1 Materials

A standard 42.5N cement (C) and fly ash (FA) conformed to BS12: 1996 and BS3892: 1997 respectively. Ground granulated blastfurnace slag (S) conforming to BS6699: 1992 and wallboard grade quality Gypsum (G) with a  $\text{CaSO}_4 \cdot 2\text{H}_2\text{O}$  purity of 95% were used. The typical simulated desulphurised waste (SDW) was a blend of 15% gypsum and 85% fly ash to achieve an  $\text{SO}_3$  content of 8.87% by weight (Khatib et al, 2008). The fine aggregate used was class M sand in accordance with BS 882:1983. The coarse aggregate was crushed 10mm single sized aggregate in accordance with BS 882:1983. Further information on chemical and physical properties of the constituent materials is given elsewhere (Mangat et al, 2006; Khatib et al, 2013).

### 2.2 Mix proportions

A total of 13 mixes were used to determine the mechanical and physical properties of concrete containing SDW. The proportions by weight of binder to fine aggregate to coarse aggregate were 1:2:3.5 respectively. The water/binder was 0.5. The binder consists of cement and all cement replacement materials. The replacement materials include slag (S) and simulated desulphurised waste.

Mix 1 represents a reference mix [REF(100<sub>c</sub>)] where the binder is 100% cement. Mixes 2 to 7 contain different blends of cement (C) and a typical simulated desulphurised waste (SDW) and were referred to as C-SDW. The cement was replaced with increasing levels of SDW from 0 to 90%. The proportion of the SDW was 85% fly ash and 15% gypsum. Table 1 shows the proportion of the mixes investigated. The mix ID (column 2) in mixes 2 to 7 represents the constituents of the binder. For example, mix 70<sub>c</sub>30<sub>SDW</sub> represents a binder containing 70% cement and 30% of SDW by mass of binder. Columns 3 and 4 show the cement (C) and typical simulated desulphurised waste (SDW) contents respectively.

Mixes 8 to 13 contain different blends of C, S and SDW (C-S-SDW blends). The C content was kept constant at 10% to initiate the reactivity of the slag and to maximise waste content. The slag content ranged from 90 to 20%, and the SDW content ranged from 0 to 70%. Table 2 shows the proportions of C-S-SDW mixes. The mix ID (column 2) of mixes 8 to 13 represents the constituent of the binder. For example mix 10<sub>c</sub>70<sub>s</sub>20<sub>SDW</sub> represents a binder containing 10% cement, 70% slag and 20% SDW by weight of binder. Columns 3 to 5 show the C, S and SDW content respectively.

### 2.3 Casting

For each mix, eighteen 100mm cubes, six 75mm cubes and four 75mm x 75mm x 300mm prisms were cast in steel moulds. After casting, all specimens were placed in a mist curing room at  $20^\circ\text{C} \pm 1^\circ\text{C}$  and  $95\% \pm 5\%$  relative humidity until demoulding. For most specimens the initial mist curing was for 24 hours, however, several specimens required a longer initial period due to an increase in setting times. These generally included C-SDW blends that contained large amounts of gypsum and all the C-S-SDW blends (i.e. mixes 8-13), in which case the specimens were left for a further 24 hours in the mist

1 room. After demoulding, all cubes and two of the prisms were cured in water at 20°C until testing. The  
2 other two prisms were continuously cured in air at 20°C±1°C and 60%±5% relative humidity.

### 3 2.4 Testing

4  
5 The consistence of concrete was measured using the slump and Vebe tests in accordance with British  
6 Standard (BS EN 12350-3, 2009) and (BS EN 12350-2, 2009) respectively.

7  
8  
9 Compressive strength was conducted on the 100mm cubes at 1 day, 7, 28, and 365 days according to  
10 British Standard (BS EN 12390-3, 2009).

11  
12 Water absorption was carried out on the 75mm cubes. Measurements were taken at 28, 90 and 365  
13 days. At the desired age, samples were removed from the water, oven dried at 105°C±5°C until a  
14 constant mass was achieved. This took approximately 48 hours. The samples were then cooled for 24  
15 hours in a desiccator over silica gel crystals. After drying the samples were submerged in water to a  
16 depth of 25mm±5 mm below the water surface. The increase in mass due to absorption of water was  
17 then recorded after 30 minutes. The water absorption was expressed as a percentage of the original  
18 dry mass of the sample.

19  
20 Drying shrinkage and expansion were conducted on the prisms which were cured in air at 20°C,  
21 65%RH and in water respectively. Two steel demec discs were fixed to each of the longitudinal faces  
22 of the prisms at a spacing of 200mm. Therefore, each measurement is the average of eight readings.  
23 At the end of the length change monitoring period, flexural strength test was carried out on the prisms  
24 in accordance with British Standard (BS EN 12390-5, 2009).

## 25 3. Results

### 26 3.1 Consistence

27  
28 Figure 1 (a & b) shows the consistence of concrete containing C-SDW and C-S-SDW blends  
29 respectively. Both slump and Vebe time are plotted with respect to SDW content. Generally, an  
30 increase of simulated desulphurised waste (SDW) content reduced consistence. Based on the Vebe  
31 time recorded, an increase in the SDW content from 0 to 70% changed the mix from a stiff plastic to  
32 an extremely dry mix. The replacement of cement with S in mix 10c90s0SDW increased consistence  
33 (Figure 1-b). The consistence of the C-S-SDW concrete was reduced when S was replaced with  
34 increasing levels of SDW. The consistence was significantly reduced when the SDW content  
35 exceeded 40%, after which the mix classification goes from stiff to extremely dry based on the Vebe  
36 time test (Neville 2011). The consistence of C-SDW and C-S-SDW concretes is similar for equivalent  
37 SDW contents.

### 38 3.2 Compressive strength

39  
40 The influence of SDW content on the compressive strength of concretes containing C-SDW blends  
41 (mixes 1-7) at the different curing times is shown in Figure 2. The use of 10% SDW as partial  
42 replacement of cement is beneficial especially with regard to long-term strength in that the strength is  
43 higher than the reference. At 20% SDW replacement the long-term strength is equivalent to the  
44 control. Replacement levels beyond 20% SDW cause a gradual decrease in strength with increasing  
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1 amounts of SDW. At 90% SDW the long-term strength is 75% less than the reference. The relative  
2 strength (RS) to the control for the majority of C-SDW blends decreased during the first 7 days of  
3 curing. Between 7 and 90 days of curing, there is large increase in RS for all C-SDW concretes  
4 indicating higher rate of strength development. After 90 days the rate of increase in RS is slowed down  
5 but still higher than the reference.  
6

7  
8 Replacing cement with 10% SDW (mix 90c10<sub>SDW</sub>), slightly retards the strength up to 7 days compared  
9 to the reference. After 7 days, an increase in strength was observed, and the strength surpassed the  
10 reference between 28 and 90 days. After 90 days, the strength continued to increase and at 365 days,  
11 it was 20% higher than the reference.  
12

13  
14 An increase in the SDW content from 10% to 40% decreased the RS. A negative effect on the rate of  
15 RS development was observed during the first seven days. Between 7 and 28 days, a large increase  
16 in RS was observed. After 90 days, the rate of increase in RS was similar to the mix containing 10%  
17 SDW, and greater than the reference mix. At 20% SDW replacement, the strength was equal to the  
18 reference mix at 365 days. Mixes containing 30% and 40% SDW exhibit a RS of 90% and 85%  
19 respectively at 365 days of curing.  
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22  
23 The RS at of mixes 30c70<sub>SDW</sub> and 10c90<sub>SDW</sub> during the first seven days, was very low. Between 7 and  
24 28 days, both mixes exhibit a similar rate of increase in RS, which was greater than that exhibited by  
25 the reference. Between 28 and 90 days, the mix containing 70% SDW, exhibited a similar rate of RS  
26 development as other mixes but the 90% SDW mix did not exhibit an increase in RS.  
27

28  
29 The compressive strength of concretes containing C-S-SDW blends are shown in Figure 3. In general,  
30 all mixes exhibit a decrease in strength compared to the reference at all ages. At 7 days, all C-S-SDW  
31 concretes exhibit an RS of approximately 30%. After 7 days, the increase in RS is negligible for all C-  
32 S-SDW concretes, and at 365 days the RS is between 35% and 50%.  
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### 35 36 37 **3.3 Flexural strength**

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39 Figure 4 (a) and (b) show the flexural strength of C-SDW and C-S-SDW concretes cured in air at 20°C  
40 and 65% relative humidity, and in water at 20°C. The tests were carried out at 570 days on samples  
41 used to measure length change. The strength is plotted with respect to SDW content. The figure  
42 shows that water cured samples exhibited greater strength than samples cured in air. An increase in  
43 SDW content resulted in a larger difference between the strength of water and air cured samples. For  
44 example, the reference mix exhibited a difference of about 30% between the flexural strength of air  
45 and water cured samples, whereas, the mix containing 70% SDW (30c70<sub>SDW</sub>), exhibited a flexural  
46 strength in water more than twice that of air cured samples. It is noticeable that the trend between  
47 strength and SDW content was similar for flexural strength (Figures 2 and 4). In addition, water cured  
48 mixes containing up to 40% SDW exhibited a higher flexural strength than the reference mix. Under air  
49 curing, only the 10% SDW concrete showed a flexural higher than the reference mix.  
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52  
53 The strength of C-S-SDW concretes cured in water was greater than under air curing (Figure 4-b).  
54 There was little difference in the flexural strength for all the C-S-SDW concretes (excluding the  
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reference) when cured in air or water. Water curing resulted in higher flexural strength compared with air curing.

### **3.4 Water absorption (WA)**

Figure 4 (a) and (b) shows the influence of SDW content on the water absorption (WA) of respectively C-SDW and C-S-SDW concretes at 28 and 365 days. An increase in the SDW content generally increased the WA. Concrete is defined to have low, medium and high absorption if the WA is below 3%, between 3% and 5%, and above 5% respectively (Concrete Society 2008).

At 28 days the WA increased with increasing SDW content. Concretes with SDW contents of 0 or 10% exhibit low WA. Mixes with SDW ranging of 20 to 40% exhibit medium WA whereas high WA is obtained at 70% SDW. All SDW concretes exhibit a reduction in WA between 28 and 365 days, the 365 days values being under 3%. For the mix containing 70% SDW, there was little change in WA between 28 and 365 days, giving a value of about 6%. The trend in the absorption is similar to the of total pore volume reported elsewhere (Khatib et al, 2013; Khatib et al, 2014)

For the C-S-SDW concretes (Fig. 4-b), the WA was in the range of low to medium at all ages based on limits set down by the concrete society. The values of WA decreased slightly with age of the C-S-SDW concretes. The increase in SDW content made a modest increase in WA.

### **3.5 Drying shrinkage**

Figure 6 shows the drying shrinkage-time relationship for C-SDW concretes. For all mixes, the majority of shrinkage occurs during the first 30 days. After that shrinkage reduces with increasing SDW content. At 90% SDW, the long-term shrinkage is about 30% of the reference.

Figure 8 shows the change in drying shrinkage-time relationship for C-S-SDW concretes. Most of the drying shrinkage occurred during the first 28 days. Unlike with C-SDW concretes (Fig. 6) there appears to be no relationship between drying shrinkage and the SDW content of the C-S-SDW blends.

The effect of SDW content on the 28 and 365 days drying shrinkage for concretes with and without S is shown in Figure 7. An increase in the SDW content of C-SDW concretes shows a decrease in shrinkage, however, the shrinkage of the C-S-SDW concretes shows no clear trend.

### **3.6 Expansion**

Figure 8 shows the expansion-time relationship for C-SDW concretes. Most expansion for C-SDW concretes occurred during the first 28 days. After 90 days, there is hardly any expansion. Generally, an increase in the SDW content increased the expansion of the concretes. There is no significant expansion up to 20% SDW content. Expansion of 1100 $\mu$ s was observed for mix containing 70% SDW.

Figure 9 shows the expansion with time for C-S-SDW concretes. As in Figure 8, most of the expansion occurred during the first 28 days followed by hardly any expansion. There was no apparent relationship between SDW content and expansion. During the first seven days, mixes containing 10% and 40% SDW exhibit shrinkage, whereas, mixes containing 20%, 30% and 70% SDW all exhibit expansions. The mix containing 70% SDW (10c20s70<sub>SDW</sub>), exhibits the largest expansion of 500 $\mu$ m.

## 4. Discussion

### 4.1. Consistence

The consistence of C-SDW and C-S-SDW concretes, as measured by Vebe time, was significantly reduced once the SDW content exceeded 20%. An increase in the SDW content from 40% to 70%, and subsequently to 90%, resulted in the mix changing from a stiff mix, to a very stiff mix, and then to an extremely dry mix (Concrete Society 2008). The SDW contains approximately 85% fly ash, which is known to increase the consistence of cement mixes (Bai et al 1999). The increase in consistence is generally attributed to the spherical nature of the fly ash particles, which has a deflocculating effect on the cement particles, and allows them to flow more easily. In addition, the introduction of fly ash into cement can retard hydration, thus reducing the amount of hydration products formed, which could enhance or prolong consistence (Taylor 1997). The continuous decrease in consistence with increasing SDW contents may be attributed, therefore, to the presence of gypsum. The SDW contains 15% gypsum, which in normal cements is used to regulate setting and avoid flash setting of the clinker minerals. However, in binders with high gypsum contents, a rapid setting and subsequent hardening occurs as in gypsum plasters (Karni and Karni 1995, Kovler 1998). This may explain the reduction in consistence with the increase in gypsum content.

### 4.2. Strength

The effect of SDW content on the retardation of C-SDW and C-S-SDW concretes was more apparent in the compressive strength data. Strength provides an indirect measurement of the rate and degree of hydration. The replacement of cement with SDW resulted in a loss of strength during the first 28 days compared to the reference mix. An increase in the SDW content increased the strength reduction during this period. After seven days, all mixes show an increase in relative strength with age, the rate of increase was higher in lower SDW content mixes. C-SDW concretes containing 10% and 20% SDW exhibit a compressive strength greater than the reference mix. The optimum SDW content was 10%, which gave the maximum relative strength of 120% at 365 days. However, all C-S-SDW mixes showed systematic reduction in strength with the increase in SDW content.

Replacing cement with SDW in concrete has a retarding effect on strength. This retardation increased as the level of SDW in the concrete increased. The SDW composition was 85% fly ash and 15% gypsum both of which have retarding effects on the hydration of cement (Lea 1998; Wild et al 1995). Gypsum is generally introduced to regulate the setting of cement, or more specifically the hydration of the  $C_3A$  component, in addition, fly ash retards the hydration of clinker minerals such as  $C_3S$  and  $C_3A$  (Fajun et al 1985). The CH, which is commonly supplied by cement, reacts with the silica and alumina parts of the fly ash to form additional calcium silicate and aluminate hydrates (C-S-H, C-A-H). However, compared to Portland cement, the reaction of fly ash is relatively slow (Khatib and Mangat, 1995; Khatib and Mangat, 2002). An increase in the SDW content, increased the proportion of fly ash in the mix, therefore, reducing the reaction rates (Khatib, 2008). Hence, the early strength



1 development of fly ash cements is retarded. This would explain the reduction in early strength as the  
2 SDW in the C-SDW content was increased.

3 The blending of gypsum and fly ash in C-SDW concretes may also improve strength compared to  
4 normal fly ash concretes based on evidence from tests on pastes and mortars in which blending fly  
5 ash and gypsum did result in higher long-term strengths than fly ash alone (Poon et al 2001). The  
6 aluminate phase of the fly ash reacts with the sulphate ions, which breaks down the glassy and  
7 crystalline phases of the fly ash (Uchikawa, 1986). The addition of gypsum was shown to accelerate  
8 the reaction of fly ash with calcium hydroxide (CH) supplied by the cement, and strengthen the bond  
9 between the fly ash grains and the hydrates around them. Increasing the gypsum content beyond the  
10 optimum amount tends to reduce early strength but considerably increases long-term strength  
11 (Shiyuan 1982).  
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17 For the C-S-SDW concretes, strength development was greatly retarded compared to the reference  
18 mix. Even at 365 days, the relative strength of the C-S-SDW concrete ranged between 35% and 50%  
19 of the reference. The reduction in strength may be attributed to the reduction in alkali to allow the slag  
20 and the SDW to react. The use of slag usually requires some form of alkali activator such as CH,  
21 which reacts with its glassy parts to form C-S-H (Neville 2011). The contribution to strength usually  
22 occurs between 7 and 90 days depending on the slag content. Optimum cement replacement levels of  
23 slag, for maximising strength, lies between 40 to 50% (Roy and Idorn, 1982; Khatib and Hibberd,  
24 2005). Improvements in strength for mixes containing up to 40% slag is commonly attributed to  
25 changes in the microstructure of the cement matrix. In slag cements, the amount of calcium hydroxide  
26 (CH) formed is reduced, and additional calcium silicate hydrates (C-S-H) are formed, which produce a  
27 much denser microstructure (Neville 2011). Slag content exceeding 50% reduce strength due to a lack  
28 of calcium hydroxide (CH), which reacts with the slag. The C-S-SDW concretes contain 10% cement,  
29 which was insufficient to produce strength similar to the reference mix. When cured in water the C-S-  
30 SDW concretes possessed a much more durable structure and damage to the samples was less  
31 common. The C-S-SDW concrete containing no SDW, (mix 10<sub>C</sub>90<sub>S</sub>0<sub>SDW</sub>), exhibit an increase in  
32 strength after 28 days compared to the remaining C-S-SDW concretes. This is because slag  
33 possesses hydraulic properties and was more reactive than the fly ash present in the SDW (Concrete  
34 Society 2011).  
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#### 45 **4.3. Length change**

46 The replacement of cement with fly ash generally has little effect on the drying shrinkage of fly ash  
47 concretes compared to reference concretes (Baoju et al 2000). Drying shrinkage for fly ash concrete  
48 lies between 500 $\mu$ s and 600 $\mu$ s at 365 days, which is also common for normal concretes. However, an  
49 increase in the SDW content in C-SDW concretes resulted in a decrease in the drying shrinkage.  
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54 Figure 10 shows the relationship between drying shrinkage and compressive strength of cubes cured  
55 in water at different curing times. The relationship suggests that an increase in compressive strength  
56 leads to an increase in drying shrinkage. This indicates that drying shrinkage is related to the degree  
57 of hydration. A decrease in hydration will reduce the surface area of the gel formed, and would reduce  
58 the adsorbed water on the surface of the gel particles, thus minimising the shrinkage on drying. In  
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1 addition, drying shrinkage occurs from the removal of intracrystalline water from the C-S-H (Neville  
2 2011). Therefore, a reduction in the C-S-H formed due to the retardation of the hydration process may  
3 contribute to the reduction in drying shrinkage.

4  
5 The drying shrinkage of C-S-SDW concretes follows no apparent trend with respect to SDW content  
6 and varied between 250µs and 500µs at 365 days. Hogan and Meusel (1981) reported that the drying  
7 shrinkage of concrete containing 50% slag generally increased at all ages compared to normal  
8 concretes. However, the presence of slag in the C-S-SDW concretes does not lead to any significant  
9 drying shrinkage. It was suggested that the shrinkage could be reduced with the addition of gypsum.  
10 This may explain why the C-S-SDW concretes all exhibit a drying shrinkage similar to or less than the  
11 reference mix. All C-S-SDW concretes possess lower compressive strengths than the reference mix,  
12 however, the drying shrinkage of several C-S-SDW concretes was similar to the reference mix.  
13 Therefore, it is more likely that the drying shrinkage is governed by the physical properties of the  
14 binder materials such as fineness, water reducing properties or even the type of hydrates formed  
15 during hydration.  
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17  
18 The expansion of C-SDW concretes cured in water exhibited the opposite trend to drying shrinkage,  
19 i.e. an increase in the SDW content, increased the expansion in the C-SDW mixes. The increase in  
20 expansion with increasing SDW content was accompanied by a retardation of strength. Expansion  
21 appeared to cease in C-SDW concretes once the compressive strength reached approximately  
22 15N/mm<sup>2</sup>. For the reference mix, this occurred between one and three days, whereas, for the mix  
23 containing 70% SDW (mix 30<sub>C</sub>70<sub>SDW</sub>) this occurred between 28 and 90 days. The expansion of C-S-  
24 SDW concretes follows no particular trend with respect to SDW content. The only significant  
25 observation was that C-S-SDW concretes, which exhibit a large drying shrinkage, also exhibit small  
26 expansion. In mixes containing 10% SDW (10<sub>C</sub>80<sub>S</sub>10<sub>SDW</sub>) and 40% SDW (10<sub>C</sub>50<sub>S</sub>40<sub>SDW</sub>) there was an  
27 initial shrinkage followed by a small expansion with time.  
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29  
30 Increasing the SDW content increased the gypsum content in the mix, which can influence expansive  
31 properties of concrete (Pickett 1947). Lerch (1946) reported that in normal cements and under moist  
32 curing conditions, minimal expansions were observed at SO<sub>3</sub> contents up to 4%. Many researchers  
33 have reported results on why calcium sulphate and the ratio of SO<sub>3</sub>/Al<sub>2</sub>O<sub>3</sub> cause expansions in cement  
34 (Sorka and Abayneh 1986; Mulongo and Ekolu 2013). However, many views are contradictory. The  
35 consensus is that large amounts of gypsum in the mix can result in excessive ettringite formation, and  
36 subsequent expansions.  
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## 38 **5. Conclusions**

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40 Physical and mechanical properties were tested on concrete with proportions of binder to sand to  
41 coarse aggregate of 1:2:3.5, and a water/binder (w/b) of 0.5. The influence of cement replacement  
42 level with a typical simulated desulphurised waste (SDW) was evaluated for binders containing cement  
43 and SDW (C-SDW blends), and cement, ground granulated blastfurnace slag and SDW (C-S-SDW  
44 blends). There is a potential to use desulphurised wastes in construction applications provided the  
45 limitations of the materials are recognised.  
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1 The replacement of cement with increasing levels of SDW beyond 10% generally reduced  
2 compressive strength, drying shrinkage and increased water absorption and expansion.

3 The drying shrinkage of C-SDW concrete appeared to be related to the degree of hydration and  
4 strength. Increasing the SDW content retards strength, which coincided with a decrease in drying  
5 shrinkage for samples cured in air. All C-SDW concretes exhibited a drying shrinkage lower than the  
6 reference concrete. For example, the reference mix exhibited a drying shrinkage of 500 $\mu$ s, however,  
7 an increase in the SDW content up to 70% decreased drying shrinkage to 150 $\mu$ s.  
8

9 The expansion of C-SDW concretes appeared to be inversely related to drying shrinkage, i.e. an  
10 increase in drying shrinkage was accompanied by a decrease in expansion. An increase in expansion  
11 occurred when the level of SDW was increased. For example, the reference mix exhibited no  
12 expansion, however, an increase in the SDW content up to 70% increased the expansion to 1100 $\mu$ s.  
13

14 The performance of all C-S-SDW concrete was inferior to the reference concrete. Generally,  
15 compressive strength, drying shrinkage were decreased, and water absorption and expansion were  
16 increased. However, if sufficient curing was provided it was possible to produce concrete with waste  
17 contents as high as 90% (slag and SDW). For example, the strength of all C-S-SDW concretes was  
18 approximately 35 N/mm<sup>2</sup> at 365 days, compared to 67 N/mm<sup>2</sup> for the reference concrete.  
19

20 There appears to be a relationship between drying shrinkage and expansion, i.e. large expansions  
21 were observed for mixes that exhibited small drying shrinkage. The expansion of C-S-SDW concretes  
22 was less than the expansion exhibited by the C-SDW concretes with equivalent SDW contents. For  
23 example, C-S-SDW concrete containing 70% SDW exhibited an expansion of 500 $\mu$ s, whereas the C-  
24 SDW concrete containing the same level of SDW exhibited an expansion of 1100 $\mu$ s after 570 days.  
25

## 26 **6. Recommendations for practical mix design**

27 The research reported in this paper was part of a larger project funded by the EC, on FGD waste  
28 produced by the semi-dry and dry desulphurisation processes used in Eastern Europe. The variability  
29 of the FGD ashes produced by different power stations was significant and, therefore, mix design can  
30 only be based on any specific selected source. Chemical characterisation and grading of these FGD  
31 ashes would be the first step leading towards their application. 10 – 15% replacement of cement with  
32 FGD waste in plain concrete mixes would be a suitable mix design for products without steel  
33 reinforcement. Durability of steel reinforcement in the material needs to be verified before its use in  
34 reinforced concrete.  
35

## 36 **Acknowledgment**

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38 Copernicus) for the research project (Project No. ERBIC 15 CT 960741) on the waste of the dry and  
39 semi dry FGD processes.  
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**Table 1: Binder details for C-SDW mixes**

Mix No	Mix ID	Proportions (% mass of binder)		SO <sub>3</sub>
		Cement (C)	SDW	(% mass of binder)
1	REF (100C)	100	0	3.12
2	90C10SDW	90	10	3.70
3	80C20SDW	80	20	4.27
4	70C30SDW	70	30	4.85
5	60C40SDW	60	40	5.42
6	30C70SDW	30	70	7.15
7	10C90SDW	10	90	8.30

**Table 2: Binder details for C-S-SDW mixes**

Mix No	Mix ID	Proportions (% weight of binder)			SO <sub>3</sub>
		Cement (C)	SDW	Slag (S)	(% mass of binder)
8	10C90S0SDW	10	0	90	1.06
9	10C80S10SDW	10	10	80	1.86
10	10C70S20SDW	10	20	70	2.67
11	10C60S30SDW	10	30	60	3.47
12	10C50S40SDW	10	40	50	4.28
13	10C20S70SDW	10	70	20	6.69

1 **Article type: paper (3000-5000 words with one illustration per 500 words).**

2 **Paper**

3 **Date text written or revised.**

4 15 May 2015

5 Number of words in your main text and tables, followed by the number of figures.

6 **Manuscript (4692) + Table (86) = 4831**

7 **2 Tables**

8 **10 Figures**

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Figure-1

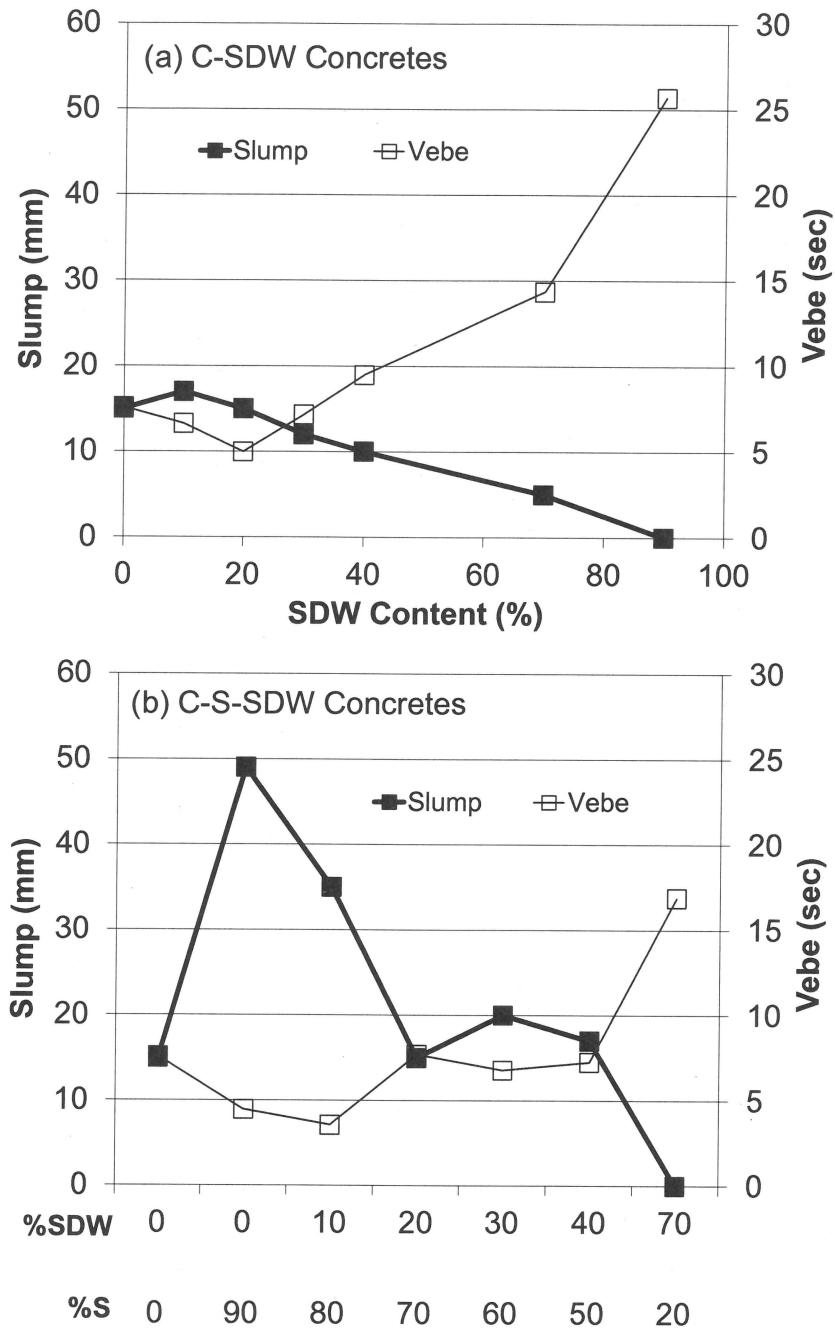


Figure 1. Consistence of (a) C-SDW and (b) C-S-SDW Concretes

Figure-2

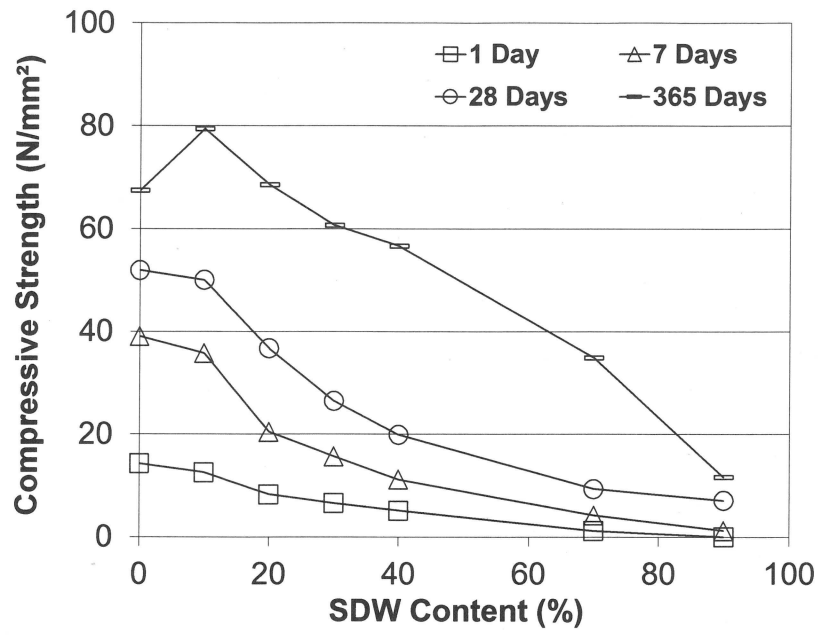


Figure 2: Influence of SDW content on compressive strength at different curing times.

Figure-3

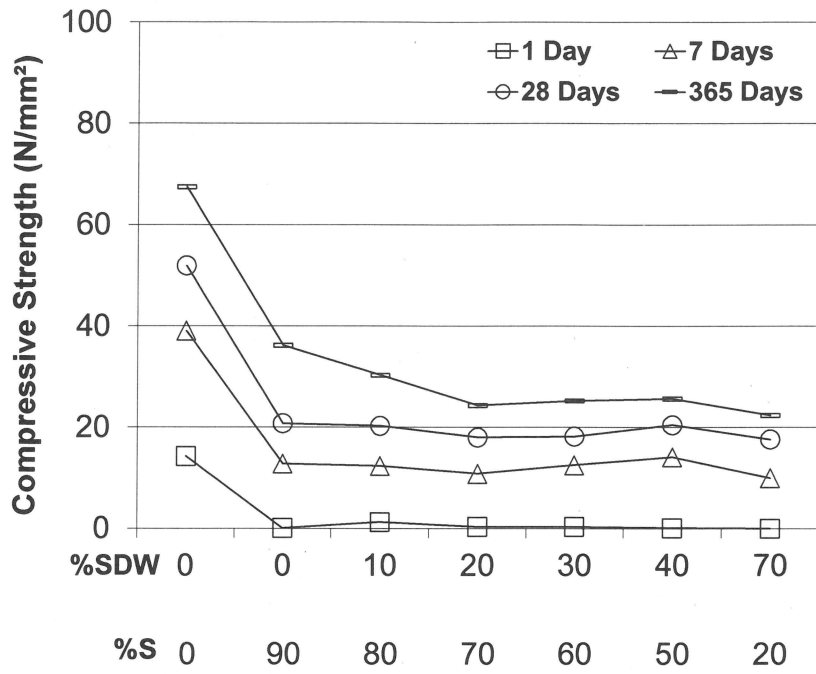


Figure 3: Influence of SDW and S contents on compressive strength at different curing times.

Figure-4

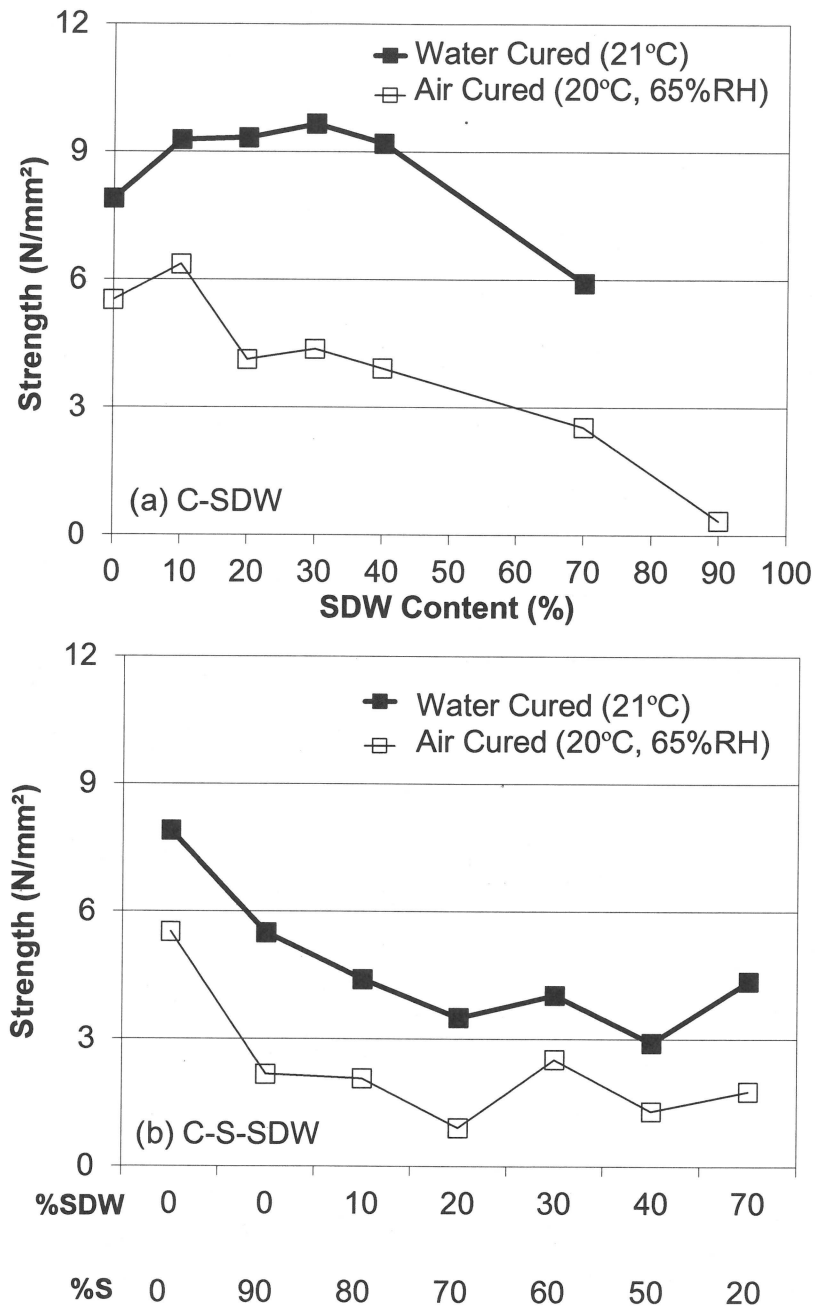


Figure 4: Influence of SDW content on the flexural strength of (a) C-SDW, and (b) C-S-SDW concretes

Figure-5

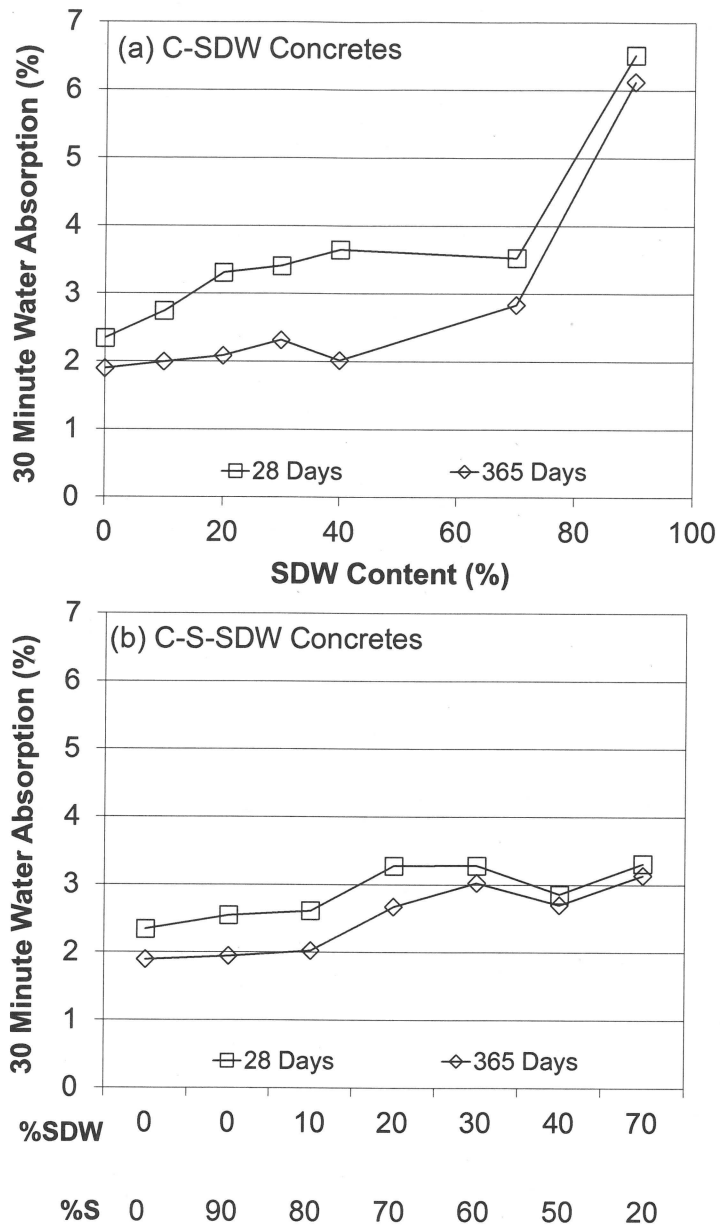


Figure 5: Water absorption of (a) C-SDW and (b) C-S-SDW concretes

Figure-6

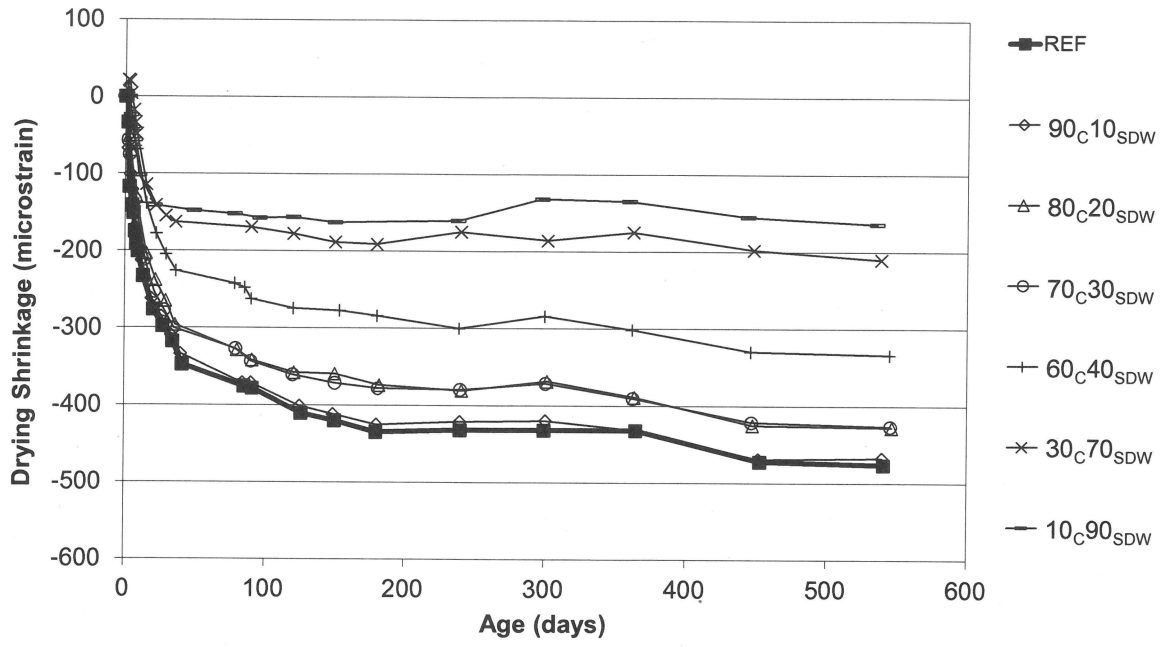


Figure 6: Change in drying shrinkage with time for C-SDW concretes

Figure-7

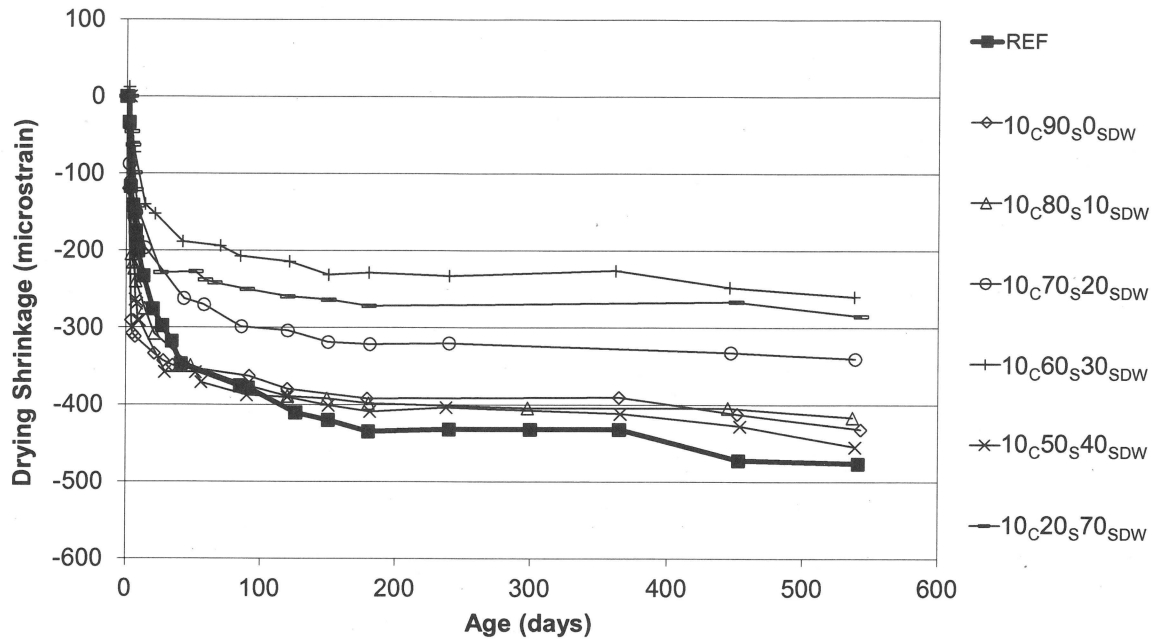


Figure 7: Change in drying shrinkage with time for C-S-SDW concretes

Figure-8

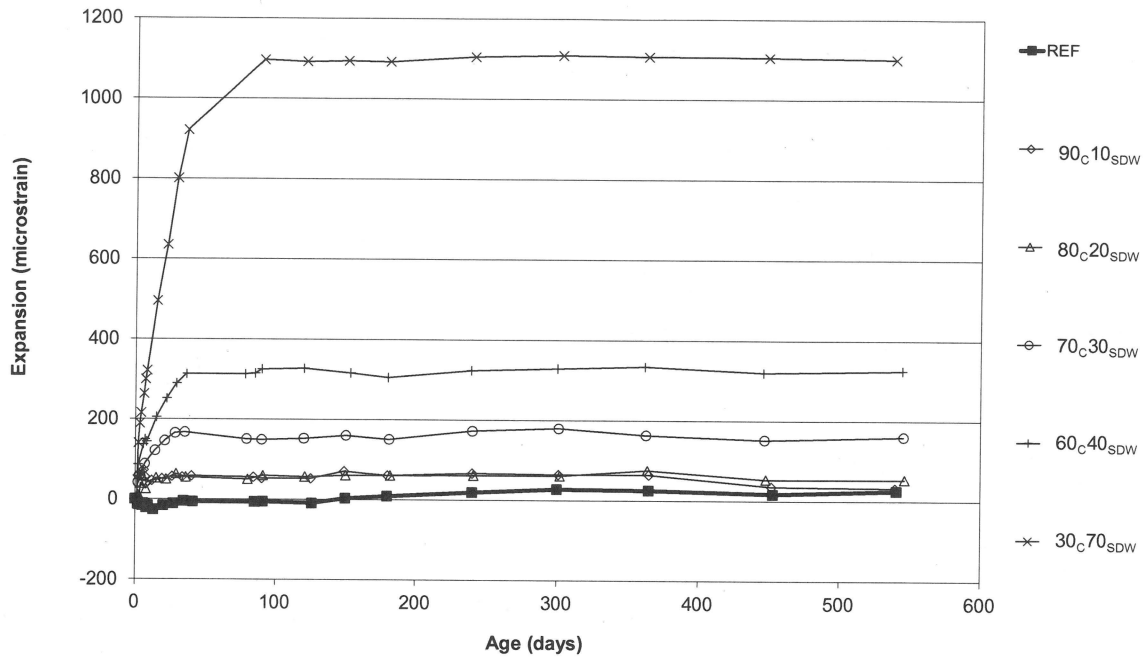


Figure 8: Influence of age on the expansion of C-SDW concretes



Figure-9

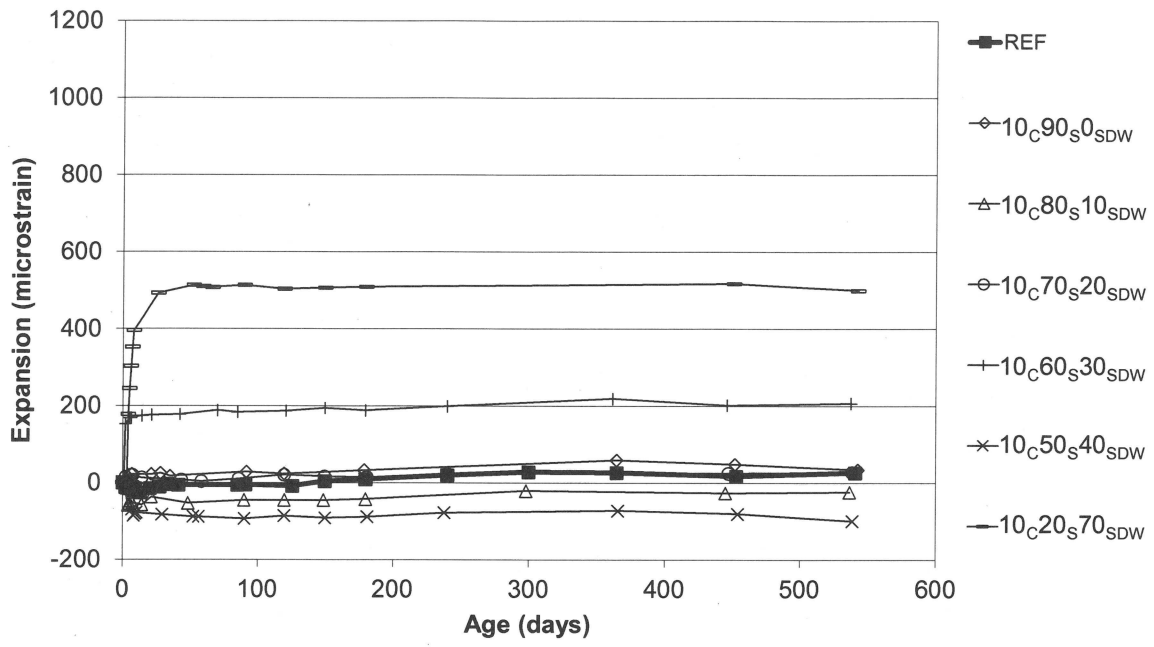


Figure 9: Influence of age on the expansion of C-S-SDW concretes

Figure-10

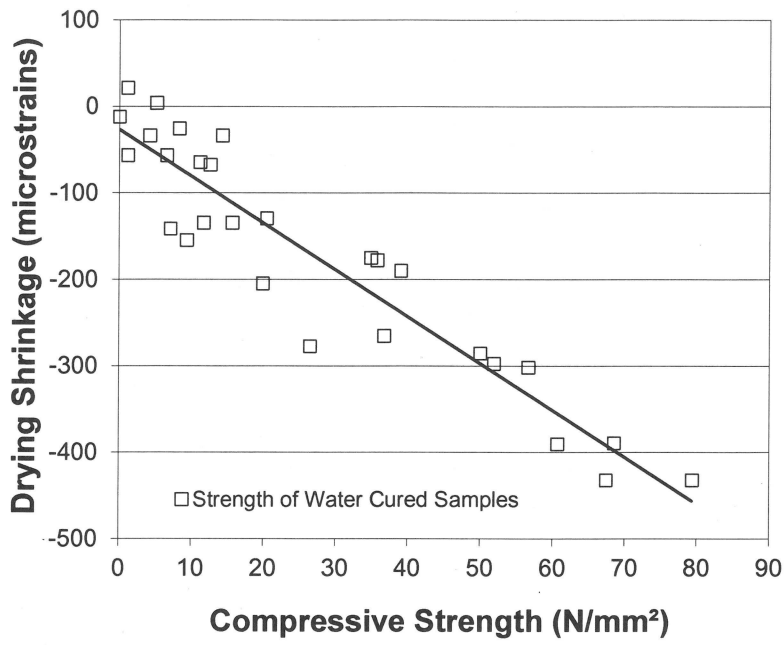


Figure 10: Relationship between drying shrinkage and strength of C-SDW concretes