

MANUAL OF CONTRACT DOCUMENTS FOR HIGHWAY WORKS
VOLUME 2 NOTES FOR GUIDANCE ON THE SPECIFICATION FOR HIGHWAY WORKS

SERIES NG 800
ROAD PAVEMENTS - (11/04) UNBOUND,
CEMENT AND OTHER
HYDRAULICALLY BOUND MIXTURES

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ROAD PAVEMENTS - (05/01) UNBOUND, CEMENT AND OTHER HYDRAULICALLY BOUND MIXTURES

NG 800 (05/01) General

1 (11/07) Advice on design and construction of subbases and bases (roadbases) is published in the Design Manual for Roads and Bridges (DMRB) Volume 7. The Clauses in Series 800 refer to BS EN 13285, 'Unbound mixtures – Specification' and Parts 1 to 5 and 10 to 14 of BS EN 14227, 'Hydraulically bound mixtures – Specifications' which cover other hydraulically bound mixtures and now form the sub-Series 800. The cement bound Clauses of Series 1000 have been moved to Series 800. These are now part of sub-Series 800 referred to above. BS EN 13285 applies to unbound mixtures of natural, manufactured aggregates such as slags and recycled aggregates. The different parts of BS EN 14227 require aggregates to conform to BS 13242 which apply to aggregates obtained by processing natural or manufactured or recycled materials. DMRB also includes advice on the use of recycled materials, see HD 35 (DMRB 7.1.2).

(11/04) Unbound Mixtures for Subbase

NG 801 (11/04) General Requirements for Unbound Mixtures

1 (11/04) BS EN 13285 specifies the requirements for unbound mixtures used for the construction and maintenance of roads and other trafficked areas. All unbound mixtures used should comply with BS EN 13285. The requirements for the properties of aggregates used in unbound mixtures are defined by appropriate cross-reference to BS EN 13242.

2 (11/04) Because BS EN 13285 aims to satisfy differing custom and practice across many Member States (MS) of the European Economic Area (EEA), the standard contains many choices, which are set out in tables. The structure of the tables allows the user to choose an appropriate category for each mixture property. None of the combinations of categories from BS EN 13285 give a mixture that is directly equivalent to the established types of granular subbase material specified in previous editions of Specification for Highway Works (SHW).

3 (11/04) After detailed review of established practice and the capability of UK suppliers, the unbound mixtures in Table 8/1 have been chosen. The Table

defines each mixture using a combination of categories for:

- i) designation - in terms of lower sieve size (d) and the upper sieve size (D). The lower size sieve (d) = 0 for all unbound mixtures defined by BS EN 13285.
- ii) maximum fines - as measured by the percentage by mass passing the 0.063 mm size sieve.
- iii) oversize - in terms of the percentage by mass of particles passing a sieve size two times the upper sieve size ($2D$) and retained on the upper sieve size (D).
- iv) overall grading - the combination of overall grading category and designation define the grading envelope.

For some mixtures, the overall grading category defines additional requirements to control the grading of individual batches, as detailed in Tables 8/5, 8/6, 8/7 and 8/8.

4 (11/04) It is unlikely that a single source of supply will routinely comply with the requirements for all four of the mixtures. Compliance depends upon the type of aggregate and the capability of the production process. Other BS EN 13285 mixtures not detailed in Table 8/1 should only be used after consultation with the Overseeing Organisation.

5 (11/05) The limiting values for sulfate characteristics in sub-Clauses 801.2 and 801.3 have been chosen to ensure that problems do not occur due to oxidation of reduced sulfur compounds such as pyrite. Further guidance is given in sub-Clause NG 601.8 and Clause NG 644.

6 The scope of BS EN 13285 is limited to the properties of unbound mixtures at the point of delivery; it does not include water content or the properties of the finished layer. To assist in the selection of an appropriate source and to help control compaction, the system of factory production control required for the unbound mixture includes an annual declaration of a typical value of laboratory dry density and optimum water content for each unbound mixture.

Frost susceptibility, plasticity, CBR and trafficking trials are outside the scope of BS EN 13285. The requirements of Series 800 apply to these mixture properties.

Aggregates Used in Unbound Mixtures

7 BS EN 13285 requires the aggregates used in unbound mixtures to comply with BS EN 13242, Aggregates for unbound and hydraulically bound materials for use in civil engineering work and road construction. Because BS EN 13242 aims to satisfy differing custom and practice across many member states of the EEA, the standard contains many choices, which are set out in tables. The structure of the tables allows the user to choose an appropriate category for each required aggregate property. BS EN 13242 also permits the use of the category “No requirement” for properties that are not relevant to a particular end use or origin of the mixture, in the interest of efficiency and economy. Further guidance on the use of BS EN 13242 is given in the Published Document PD 6682-6 ‘Aggregates for unbound and hydraulically bound materials for use in civil engineering work and road construction - Guidance on the use of BS EN 13242’ published by BSI.

8 (11/04) The requirements for aggregates in Table 8/2 have been chosen after detailed review of established practice and the characteristics of UK aggregates. The Table defines each aggregate used in the mixture as a combination of categories for:

- i) Crushed or broken particles - to ensure adequate aggregate interlock. Crushed rock aggregates should be assumed to be in Category C90/3 without further testing. Where permitted, the use of Category C50/10 for crushed gravels ensures that not more than 10% of the particles are fully rounded.
- ii) Los Angeles coefficient - to control resistance to fragmentation. The Los Angeles test replaces the Ten Percent Fines (TPV) and the Aggregate Impact Value (AIV) tests. The Los Angeles test can only test aggregate in a dry condition. There is not a direct correlation between the Los Angeles test and the BS 812 tests it replaces.
- iii) Magnesium sulfate soundness - to ensure resistance to freezing and thawing. Category MS_{35} provides a level of resistance that is directly equivalent to the BS 812-121 value of greater than 65.

9 The micro-Deval test is used in some countries, notably France, to measure the resistance of aggregate particles to the abrasion caused when interlocking particles are subjected to repeated loading in the presence of water; particularly in thinner pavements with greater strains in the lower layers. The property measured by the micro-Deval test is not normally

specified so Category MDENR (no requirement) is used. The supplier of the mixture is required to monitor micro-Deval values as part of the system of factory production control required by BS EN 13242. The value for the aggregate used should be stated to aid comparison between sources and so that the potential for the future use of this property can be reviewed.

10 Water absorption is not normally specified so Category WA_{24} NR (no requirement) is used. The supplier of the mixture is required to monitor water absorption values as part of the system of factory production control required by BS EN 13242. The value for the aggregate used should be stated. If necessary, the value may be used to provide a baseline for routine water absorption tests on delivered material. If any result from the tests on routine deliveries exceeds the declared value (d) by more than 0.5% further investigation will be required. Routine water absorption tests are not generally required for aggregates with a declared value of 2.0% or less.

11 In previous editions, blast furnace and steel slags were identified separately from other materials. The requirements for these materials, including those in BS 1047, are now incorporated into BS EN 13242. Table 8/2 defines requirements using categories for:

- i) Volume stability for blast furnace slags - in terms of disintegration tests based on established UK requirements from BS 1047.
- ii) Volume stability of steel (BOF and AEF) slags - in terms of a steam expansion test for which there is limited UK experience. Where permitted, the specified category is the most onerous. Evidence of recent satisfactory use of steel slag aggregate from the same source should also be obtained.

Recycled Aggregates

12 BS EN 13285 includes manufactured (such as slags and ashes) and recycled aggregates within its scope without specific mention in the requirement clauses. The approach adopted is blind to the source of the aggregate used in the mixture. The suitability of mixtures containing manufactured and recycled aggregates for use in subbase should be assessed in accordance with the requirements of the Series 800 Clauses.

13 The test procedure adopted in Clause 710 for identifying and quantifying constituent materials in recycled coarse aggregate and recycled concrete aggregate is a qualitative method. Where constituents other than those deemed to comply with the particle density requirements by the qualitative classification can be shown to be of a higher particle density, they

may be included within these higher density fractions provided that written agreement has been given by the Overseeing Organisation.

14 (11/04) Sub-Clauses 803.4, 804.4, 805.4 and 806.4 describe requirements for material passing the 0.425 mm sieve. Were the foreign materials component of recycled coarse aggregate or recycled concrete aggregate to be 'clay lumps', the material may fail these tests and hence fail to meet the Specification.

Unbound Mixtures Produced as Part of The Works

15 BS EN 13242 (see Annex C) and BS EN 13285 (see Annex D) specify the operation of a factory production control system to confirm conformance with the relevant requirements of the standards. Although unbound mixtures produced on site as part of the Permanent Works are not placed on the market, a factory production control system (or a quality plan with equivalent requirements) is still required to provide the necessary level of assurance.

Frost Heave

16 (11/04) The frost heave test described in BS 812-124 is costly and time consuming and is not suitable for routine control checks on Site. The test has been developed from earlier test methods to overcome problems of repeatability and reproducibility. The test is primarily intended as a method to establish whether or not an aggregate from a particular source is likely to be frost-susceptible when used in an unbound condition within that part of the road pavement subject to frost penetration. Material for the frost heave test should be representative of the source and comply with all other requirements of the Specification otherwise the test is superfluous. Once a material has been established as non-frost-susceptible the test need only be repeated if the material varies from the original sample, or where the source is changed.

17 Clause 6 of BS 812-124 sets down the procedure for adjusting the water level in the self-refrigerated unit (SRU). A possible problem has been identified that with the tolerances given to the dimensions for the cradle and specimen carriers it is possible for the porous discs in the specimen carriers to be located incorrectly in relation to the water level. In order to guard against this it is recommended that before testing commences the cradle and specimen carriers be put into the SRU without samples. A check is then made to ensure that discs are set at the level specified in the above-mentioned standard.

18 (11/07) The requirement for material to be non-frost susceptible within 450 mm of the surface of a road or paved central reserve may be reduced to 350 mm if the Mean Annual Frost Index (MAFI) of the site is less than

50. The Frost Index is a measure of the severity of a period of cold weather and provides a means of assessing likely penetration of frost into a road. Frost index is measured in 'degree days Celsius below zero' and is calculated by taking the mean air temperature for each twenty four hour period and adding those values together. Frost penetration into a modern road in the British Isles may be estimated using the formula $x = 40\sqrt{I}$ where x is the approximate penetration in mm and I is the frost index for the freezing spell. The Annual Frost Index is the frost index accumulated over a year commencing September 1st. Mean Annual Frost Index (MAFI) is the average of all the frost index values computed for each year since September 1959. The MAFI for a site is determined using records from one or more meteorological stations close to the site, taking account of local geographical variation, such as high ground or frost hollows. Different requirements for different parts of a contract length may be used.

Further information on the MAFI can be found in HD 25.

Advice relating to any site, including the MAFI calculated for that site, may be purchased from:

Met. Office Customer Centre
FitzRoy Road
Exeter
Devon
EX1 3PB
United Kingdom

Tel No: 0870 900 0100

Fax No: 0870 900 5050

E-mail: claimate@metoffice.gov.uk

NG 803 (11/04) Type 1 Unbound Mixtures

1 The inclusion of up to 10% natural sand passing the 4 mm test sieve is permitted at the discretion of the supplier to adjust the material grading. Maximum limits of material content are included for asphalt and foreign material in recycled coarse aggregate and recycled concrete aggregate.

2 (11/04) BS EN 13285 details additional requirements to control individual batches of unbound mixtures with an overall grading Category G_p within a system of factory production control. Table 8/5 in Clause 803 illustrates this. The supplier should nominate a supplier declared value for the intermediate sieves in the grading envelope as part of the system of factory production control for the mixture. The nominated value should lie within the supplier declared value grading range in Table 8/5. Individual batches are then assessed using the tolerances in Table 8/5, applied to the supplier declared values. As explained in Annex

B (informative) of BS EN 13285, the use of tolerances does not change the overall grading range.

3 Table 8/5 also includes requirements for the calculated difference between the values of percentage by mass passing selected adjacent sieves. These requirements are taken from BS EN 13285 and ensure a 'well graded' mixture by controlling the continuity of the grading curve.

4 Because the requirements for aggregates used in the unbound mixtures now refer to the requirements of BS EN 13242, confirmation of conformity with the categories for Los Angeles coefficient and magnesium sulfate soundness can be obtained from the CE Mark Certificate for the aggregates used in the mixture. If a CE Mark Certificate is not available to confirm the suitability of the source, test certificates should be provided from a testing laboratory accredited by an appropriate organisation accredited in accordance with sub-Clauses 105.3 and 105.4 for the test, showing a value in excess of the minimum specified and dated not more than 6 months prior to the start of the contract.

5 Whilst there is no specified moisture content for laying and compacting unbound mixtures to Clause 803, in order to satisfy the requirements of sub-Clauses 802.8 and 803.7 it will be necessary to carry out these operations at optimum moisture content or thereabouts.

Mixtures Containing Crushed Gravel Aggregates

6 Previous editions of Clause 803 excludes all gravels from granular subbase material Type 1 but crushed gravel aggregate is permitted by BS EN 13285. Where local experience indicates that mixtures containing crushed gravel materials can be used successfully, the Overseeing Organisation may permit their use.

7 This edition of Clause 803 incorporates the requirements for crushed gravel subbase materials previously published as Clause 850SE. Trafficking trials of crushed gravel subbases used in Scotland have produced rut depths well within the upper limit (30 mm) recommended by the Transport Research Laboratory for the assessment of subbase materials if laid on Works contracts provided that:

- (i) strict control over the grading is maintained; and
- (ii) the crushed, broken and totally rounded particles requirements are met.

8 (11/04) No limiting value of design traffic has been imposed for Type 1 unbound mixtures containing crushed gravel. However their use on roads designed to carry more than 1500 commercial vehicles per lane per

day should be clearly identified in the As-Built Records.

9 (11/04) For flexible roads with Type 1 unbound mixtures containing crushed gravel and carrying a traffic loading of more than 2 msa, the subbase strength should be at least an equivalent of CBR 30%. Further guidance about CBR is given in Clause NG 804. A trafficking trial should be considered for flexible roads carrying a traffic loading of more than 2 msa.

NG 804 (11/04) Type 2 Unbound Mixtures

1 (11/07) Current design requirements exclude Type 2 unbound mixtures from flexible roads carrying a traffic loading of more than 5 msa. Where local experience indicates that these materials can be used successfully at higher traffic levels, the Overseeing Organisation may require that a Substitute Clause should be written to permit their use. Mixtures containing a high proportion of asphalt arisings have been shown to perform well at design traffic levels higher than 5 msa, but performance should be assessed using a trafficking trial.

2 Table 8/6 in Clause 804 includes requirements for the calculated difference between the values of percentage by mass passing selected adjacent sieves. These requirements are taken from BS EN 13285 and ensure a 'well graded' mixture by controlling the continuity of the grading curve.

3 The value of CBR required for materials to Clause 804 will depend upon traffic loading. For flexible roads carrying a traffic loading of more than 2 msa the subbase strength should be at least an equivalent of CBR 30%. For traffic ranges below 2 msa the strength may be reduced to CBR 20%.

4 (11/04) If more than 15% of the material is retained on a 16 mm test sieve the whole material can be assumed without test to have a CBR value of 30% or more. CBR tests should be carried out (when necessary) on specimens which are compacted at a density and moisture content which represent equilibrium conditions under the completed pavement. In most cases the moisture content and density specified in sub-Clause 804.7 will apply but where this is not so it will be necessary to specify separately the required values of density and moisture content for the CBR test. The density relating to a particular air voids content can be calculated using the formula given in BS 1377-4. Compaction into the CBR mould should be carried out in such a way that the required density is obtained uniformly. The number of surcharge discs used in the CBR test should be equivalent to the weight of road construction above the subbase.

5 Although parameters related to the control of the construction of the pavement layer are outside the scope of BS EN 13285, it is appropriate to make information available to assist the purchaser's choice of unbound mixture. BS EN 13285 requires the laboratory dry density and optimum water content of an unbound mixture to be declared at least once each year, as part of the system of factory production control. BS EN 13285 permits choice from a list of four test methods for these properties, reflecting the range of mixtures and techniques used across Europe. In the UK, it is recommended that the vibrating hammer test (BS EN 13286-4) is used. This method is very similar to the established UK method defined in BS 1377-4. BS EN 13286-4 also includes a test method similar to that developed as BS 5835. That test procedure for the determination of optimum moisture content was developed specifically for graded aggregates and gives more reproducible results than the vibrating hammer test for these materials.

NG 805 (11/04) **Type 3 (open graded) Unbound Mixtures**

1 (11/04) Current design requirements permit the use of open graded mixtures in circumstances where a free draining layer is to be preferred. Type 3 (open graded) unbound mixtures is similar to the granular subbase materials previously known as Type 3 (Clause 850NI) and Type 1X, a grading derived by TRL.

2 (11/04) BS EN 13285 details additional requirements to control individual batches of unbound mixtures with an overall grading Category G_o , within a system of factory production control. Table 8/7 in Clause 805 illustrates this. The supplier should nominate a supplier declared value for the intermediate sieves in the grading envelope as part of the system of factory production control for the mixture. The nominated value should lie within the supplier declared value grading range in Table 8/7. Individual batches are then assessed using the tolerances in Table 8/7, applied to the supplier declared values. As explained in Annex B (informative) of BS EN 13285, the use of tolerances does not change the overall grading range.

3 Table 8/7 also includes requirements for the calculated difference between the values of percentage by mass passing selected adjacent sieves. These requirements are taken from BS EN 13285 and ensure a 'well graded' mixture by controlling the continuity of the grading curve.

4 Because the requirements for aggregates used in the unbound mixtures now refer to the requirements of BS EN 13242, confirmation of conformity with the categories for Los Angeles coefficient and magnesium

sulfate soundness can be obtained from the CE Mark Certificate for the aggregates used in the mixture. If a CE Mark Certificate is not available to confirm the suitability of the source, test certificates should be provided from a testing laboratory accredited by an appropriate organisation accredited in accordance with sub-Clauses 105.3 and 105.3 for the test, showing a value in excess of the minimum specified and dated not more than 6 months prior to the start of the contract.

5 The chosen category for resistance to fragmentation in Table 8/2 is LA_{40} . A maximum Los Angeles coefficient of 35 is more appropriate for aggregates that have been used successfully in similar mixtures, but BS EN 13242 does not permit the choice of this value. Aggregate sources with a Los Angeles coefficient of 35 or more should be used with caution. Unless local experience indicates otherwise, aggregate sources with a Los Angeles coefficient in the range 30 to 35 should generally be considered as acceptable.

6 Whilst there is no specified moisture content for laying and compacting unbound mixtures to Clause 805, in order to satisfy the requirements of sub-Clauses 802.8 and 805.5 it will be necessary to carry out these operations at optimum moisture content or thereabouts.

NG 806 (11/04) **Category B (close graded) Unbound Mixtures**

1 For selected end uses where greater control of particle size distribution and consistency of performance is required than is available using the standard Type 1 unbound mixture, an unbound mixture with designation 0/31,5 and an overall grading category G_B can be used. This is known as a close graded granular mixture. The tighter tolerances of category G_B are unlikely to be achievable without special production regimes, probably involving batch blending of different aggregate sizes.

2 BS EN 13285 details additional requirements to control individual batches of unbound mixtures with an overall grading Category G_B , within a system of factory production control. Table 8/8 in Clause 806 illustrates this. The supplier should nominate a supplier declared value for the intermediate sieves in the grading envelope as part of the system of factory production control for the mixture. The nominated value should lie within the supplier declared value grading range in Table 8/8. Individual batches are then assessed using the tolerances in Table 8/8, applied to the supplier declared values. As explained in Annex B (informative) of BS EN 13285, the use of tolerances does not change the overall grading range.

3 Table 8/8 also includes requirements for the calculated difference between the values of percentage by mass passing selected adjacent sieves. These requirements are taken from BS EN 13285 and ensure a 'well graded' mixture by controlling the continuity of the grading curve.

4 Because the requirements for aggregates used in the unbound mixtures now refer to the requirements of BS EN 13242, confirmation of conformity with the categories for Los Angeles coefficient and magnesium sulfate soundness can be obtained from the CE Mark Certificate for the aggregates used in the mixture. If a CE Mark Certificate is not available to confirm the suitability of the source, test certificates should be provided from a testing laboratory accredited by an appropriate organisation accredited in accordance with sub-Clauses 105.3 and 105.3 for the test, showing a value in excess of the minimum specified and dated not more than 6 months prior to the start of the contract.

5 The chosen category for resistance to fragmentation in Table 8/2 is LA_{40} . A good resistance to fragmentation is required to ensure that a closely controlled product does not degrade excessively during handling and compaction. Aggregate sources with a Los Angeles coefficient of more than 30 should be used with caution. It may be appropriate to monitor changes in grading during laying and compaction if the Los Angeles coefficient is 35 or more.

6 Whilst there is no specified moisture content for laying and compacting materials to Clause 806, in order to satisfy the requirements of sub-Clauses 802.8 and 806.5 it will be necessary to carry out these operations at optimum moisture content or thereabouts.

NG 807 (11/07) Type 4 (asphalt arisings) Unbound Mixtures

1 (11/07) Trafficking trials of mixtures containing a high proportion of asphalt arisings carried out by TRL have produced rut-depths well within the upper recommended limit of 30 mm.

However the effects of this material on the surrounding environment should be fully assessed and approvals from statutory bodies obtained where necessary, before including this material as a permitted option in Appendix 7/1.

2 (11/07) When dry, asphalt arisings exhibit a considerable resistance to compaction due to the friction of the bitumen coating. The addition of water has a significant effect on the state of compaction by reducing the friction between the bitumen coated particles. Type 4 (asphalt arisings) unbound mixtures should, therefore, be compacted at moisture contents

close to the declared value of optimum water content discussed in sub-clause NG 807.8.

3 (11/07) The particle size distribution of asphalt arisings is best described by the term 'lump size distribution' because of the binding effect of bitumen. The grading envelope obtained will be dependent on the duration of shaking, the temperature at which the determination is carried out and the grading of the mineral particles within the asphalt arisings.

Agglomeration of lumps can occur in stockpiled material especially in hot weather or when the material is stored for long periods. It is important that, at the time of placing, the asphalt arisings comply with the specified lump size distribution and care should be taken to ensure that, material taken from a stockpile is to the required grading. It may be necessary to demonstrate that the material actually placed meets the grading specification rather than to rely on tests at an earlier time.

Lumps, or individual particles of aggregate separated by the planing process, should be angular in appearance. Rounded particles that can be present when using arisings containing gravel aggregates can lead to difficulties in meeting the rutting criterion.

4 (11/07) Particle durability in terms of the magnesium sulfate soundness test need not be verified for mixtures containing a high proportion of asphalt arisings as the aggregates will have been tested prior to the introduction of bitumen.

5 (11/07) Particle hardness in terms of the Los Angeles test need not be verified for mixtures containing a high proportion of asphalt arisings as the test is unsuitable for materials containing bitumen and because the aggregate components will have been tested prior to the introduction of bitumen.

6 (11/07) The performance of unbound mixtures in subbase layers is dependent on the bearing strength of the compacted material. The measurement of bearing capacity in terms of CBR should not be specified for mixtures containing a high proportion of asphalt arisings. The measurement of CBR for mixtures containing bitumen is problematical because the results are dependent upon the temperatures at the time of compaction, the temperature at the time of testing and the duration of loading. However, as the grading envelope ensures that at least 19% of the mixture is retained on the 16 mm test sieve, it can be assumed without test that the material will have an adequate CBR value. Appendix 7/1 can be used to require a trafficking trial, if the additional assurance of performance is required.

(05/09) Cement and Other Hydraulically Bound Mixtures

NG 810 (11/04) General Requirements for Cement and Other Hydraulically Bound Mixtures

(05/09) General

1 (05/09) Cement and other hydraulically bound mixtures; collectively referred to as 'HBM', form a sub-series of Series 800 of the specification. The term 'mixtures' is used in preference to 'materials' to conform to BS EN 14227, Hydraulically bound mixtures, Specifications. The Parts of BS EN 14227 provide specifications for mixture composition and laboratory mechanical performance but do not cover production and construction methods. Series 800 Clauses provide options from which mixtures may be selected to suit design requirements and provide specifications for the construction of the pavement layers. The variety of terms introduced within the HBM family has prompted the inclusion of a glossary in Clause 810.

2 (05/09) Throughout BS EN 14227 there are options, from which the designer and compiler may choose. Where the designer wishes to use materials covered by BS EN 14227 but not included in Series 800, the use of such materials should be referred to the Overseeing Organisation for approval under the Departure from Standards procedure

3 (05/09) BS EN 14227 is published in Parts to allow the specification of mixtures with different types of hydraulic binder. Separate part numbers are used for mixtures made with granular aggregates and for mixtures made with soil. Hydraulically bound mixtures (HBM) are grouped within Series 800 by reference to their aggregate type and their binder type as indicated in Table NG 8/1. The mixtures are then defined by their strength. Test methods for HBM are published in the Parts of BS EN 13286.

(05/09) HBM Grading Characteristics

4 (05/09) Cement bound granular mixture (CBGM) is relatively fast setting, in comparison with most other types of HBM. It also generally contains less binder for a specified strength. Because of this, the mass of the binder has less influence on the total grading than it does for other types of HBM. This means the grading of CBGM is generally defined for the aggregate alone. However, where CBGM is required to take early trafficking, or where special considerations of shrinkage or density apply, it may be specified using the mixture

grading, including the binder. This can be done by specifying CBGM C using Clause 823 or by specifying the alternative mixture grading for CBGM B in Clause 822.

5 (05/09) The mass of material added to FABM, HRBBM and SBM as a binder and/or activator can be relatively large. These types of HBM are usually required to carry site traffic and in-service traffic before they have developed their full strength. This means that the mixture should have some initial mechanical stability to prevent rutting and to allow the formation of cementitious bonds. Therefore grading is specified for the complete mixture, including the binder and any activators

6 (05/09) In order to provide initial mechanical stability, the grading tolerances are more important for FABM, HRBBM and SBM than for CBGM A or CBGM B, unless the latter are to be trafficked early. The particular grading characteristics of FABM, HRBBM and SBM are discussed further in NG 830 to NG 835. The quantity of binder in FABM, HRBBM and SBM is often dictated more by the need to produce a smooth grading curve than mechanical performance considerations.

7 (05/09) FABM has slightly different mixture gradings dependent upon whether the fly ash is siliceous or calcareous. Currently British coal fired power stations mainly produce siliceous fly ash. Until experience of calcareous ash is obtained in the UK, only siliceous fly ash should be permitted.

(05/09) Strength Classification

8 (05/09) Two methods of strength classification are included in Series 800 for all granular and soil mixtures. Classification by compressive strength using unconfined cylindrical or cubic specimens and measured in accordance with BS EN 13286-41 is the more commonly applied. However, classification by tensile strength in combination with elastic modulus ($R_{p,E}$) provides a modelling regime closer to the performance of bound pavement layers.

9 (05/09) The $R_{p,E}$ classification requires that materials be placed into tensile strength/elastic stiffness category envelopes. Tensile strength can be measured on cylindrical specimens either by direct tensile testing in accordance with BS EN 13286-40 or indirect (cylinder-splitting) testing in accordance with BS EN 13286-42. Elastic modulus (E) is measured in accordance with BS EN 13286-43, either in direct compression or tension or in indirect tension tests. Measurement of tensile strength in indirect tension and E in direct compression is considered to be adequate for the purposes of classification and compliance testing.

TABLE NG 8/1: (05/09) Cement and Other Hydraulically Bound Mixtures - Classification

HBM designation	General description	Principal binder or binder constituent	SHW Clause number	BS EN 14227: - Specification part reference
CBGM A	Mixtures with broad grading envelope	Cement	821	-1: Cement bound granular mixtures
CBGM B	Graded aggregate mixture		822	
CBGM C	0/20 mm, 0/14 mm or 0/10 mm well graded mixture with compacity requirement		823	
FABM 1	0/31,5 mm Graded mixture	Fly ash	830	-3: Fly ash bound mixtures
HRBBM 1		Hydraulic road binder		-5: Hydraulic road binder bound mixtures
SBM B2	0/10 mm, 0/14 mm, 0/20 mm well graded mixture with compacity requirement	Ground granulated, or granulated, blast furnace slag	831	-2: Slag bound mixtures
FABM 2		Fly ash		-3: Fly ash bound mixtures
HRBBM 2		Hydraulic road binder		-5: Hydraulic road binder bound mixtures
SBM B3	0/6,3 mm mixture	Ground granulated, or granulated, blast furnace slag	832	-2: Slag bound mixtures
FABM 3		Fly ash		-3: Fly ash bound mixtures
HRBBM 3		Hydraulic road binder		-5: Hydraulic road binder bound mixtures
FABM 5	Treated fly ash	Fly ash	834	-3: Fly ash bound mixtures
SBM B1-1, B1-2, B1-3 and B1-4	Graded mixtures with low fines content	Granulated blast furnace slag	835	-2 Slag bound mixtures
SC	Soil or aggregate	Cement	840	-10: Soil treated by cement
SS		Ground granulated blast furnace slag		-12: Soil treated by slag
SFA		Fly ash		-14: Soil treated by fly ash
SHRB		Hydraulic road binder		-13: Soil treated by hydraulic road binder

10 (05/09) The mechanical performance class will be determined by the design requirements. Further guidance is given in HD 25 (DMRB 7.2.2) and HD 26 (DMRB 7.2.3).

11 (05/09) Appendix 7/1 should show the allowable alternatives of strength and the associated layer

thickness. The designation should be the mix specification name followed by the appropriate strength class in BS EN 14227. For example, for a CBGM A mixture with C5/6 class the designation should be 'CBGM A C5/6'. For a mixture defined using the R_E system, an equivalent designation may be 'CBGM A T2'.

12 (05/09) BS EN 14227-1 defines strength using a characteristic strength based on the average values for three test specimens. However, for the purposes of the Series 800 Clauses the strength of CBGM mixtures is defined using the mean value of any consecutive five results.

13 (05/09) Wherever possible, curing times longer than 28 days should be used in order to establish a robust relationship between early age strength and the strength at 360 days. For site control purposes, HBM may be assessed at ages earlier than 28 days where the Contractor so requests, provided that a robust correlation is established between strength test results at the required age and results at 28 days using representative samples of the aggregates and binder used in the works.

14 (05/09) When assessing the acceptability of the aggregate grading for fast setting mixtures such as CBGM, allowance should be made for the grading of the added binder. This is usually 100% by mass passing the 0.063 mm test sieve.

15 (05/09) The Specification allows the use of mixtures with a compressive strength below 3 MPa. Because this value is considered to be the lowest strength at which frost heave resistance is always likely to be achieved within a reasonable time, other factors should be considered if a mixture is not expected to have a compressive of 3 MPa before the 1 November. The factors to be considered should include:

- i. the frost penetration depth, as discussed in sub-Clause 801.7;
- ii. whether a sufficient depth of overlying layers will give protection against temperatures less than 0°C;
- iii. the position of the water table;
- iv. the nature of any seal to the surface of the HBM layer;
- v. the indirect tensile strength of the mixture – this should be greater than 0.25 MPa at the time of the first frost.

NG 811 (05/09) **Binder Constituents**

1 (05/09) Care should be taken when mixing HBM when the proportion of binder or binder constituent is very low, as it may be difficult to obtain complete dispersion throughout the mixture.

2 (05/09) HBM has been mixed successfully using volume batching and in-situ stabilisation with the total binder content at, or close to, the minimum values

shown in Table 8/9. Success at such low cement contents depends on:

- (i) grading and cleanliness of the soil to be stabilised;
- (ii) close control of the binder addition rates;
- (iii) efficiency of the binder dispenser or spreader;
- (iv) mixing efficiency.

3 (05/09) The minimum binder requirements of Table 8/9, particularly for cement based HBM, may be relaxed if recent and well-documented evidence shows that consistent mixing can be achieved with the same plant and operators using similar soils or aggregates. If evidence is not available, a trial should be carried out over a period of not less than 5 full working days, covering a total area of not less than 3000 m². The success of the trial should be judged on the cubes or cylinders made from samples taken at a minimum of 10 evenly spaced locations per day and tested for strength after not less than 7 days curing. A trial should normally be considered successful if the results showed consistent compliance with the specification, after adjusting the test results to reflect the age of test specimens using a laboratory correlation of strength against age. A successful trial may be incorporated into the Permanent Works.

4 (05/09) The minimum values for binder additions given in Table 8/9 for FABM, HRBBM and SBM are related firstly to the need for a smooth grading curve to allow use by site traffic, and secondly long-term mechanical performance. Usually, if the first criterion is satisfied the second will also be met.

5 (05/09) Any variation to the minimum binder content agreed by the Overseeing Organisation should be subject to reassessment if the source materials, method of working or the operatives change.

NG 813 (05/09) **General Requirements for Production and Layer Construction**

1 (05/09) Three methods of blending and mixing are recognised in Clause 813; in-plant mixing with batching by mass, in-plant mixing with batching by volume, and in-situ mixing for which batching can only be carried out by volume. Continuous mixing plants, where the mass of the aggregate and binder are constantly recorded using load cells or similar devices, are considered to be mass batching plants. Where a mixture is mixed insitu and then excavated and transported to the point of laying, the construction requirements for in-situ mixing should apply. This technique has advantages over normal insitu methods because it can

improve the consistency of mixing, aid compliance with surface level tolerances and help to disperse potentially harmful minerals.

2 (05/09) The values of construction period in Table 8/10 allow for the variation in the rate of hydration of different types of HBM binder with temperature. Until further research indicates otherwise, no hydration is assumed at temperatures below 3°C. Although this is an established figure for cement it may be that other hydraulic binders have higher threshold temperatures and/or may have strength temperature development curves that cannot be approximated by a linear relationship. Where problems related to this factor are of concern (e.g. for a binder without local or independently documented performance data) laboratory trials should be carried out.

3 (05/09) For the mix-in-plant method of construction, the mixture can be placed using a grader, a dozer or a paver. If pavement foundation layers are constructed in 2 lifts, the depth of the lower lift should be compatible with the strength of the subgrade. A thicker first lift is needed over a weak subgrade, to enable effective compaction of the first lift without damage to itself or the subgrade beneath it. The thicker first lift will also minimise movement during the construction of the second lift, particularly if the first is still workable. This helps to ensure proper compaction. It will also prevent degradation of the lower lift when the construction of the second lift takes place after the lower one has set.

4 (05/09) Care should be taken during spreading to control the depth of uncompacted mixture so that trimming can be undertaken quickly and effectively within the construction period. The trimming of over-thick layers can also result in segregation.

5 (05/09) Clause 813.4 requires base layer mixtures to be laid using a paver, to assure consistent compaction and compliance with surface level tolerance. The Overseeing Organisation may permit the use of other laying methods, if the Contractor can confirm satisfactory performance using a method statement and demonstration area, as required by Clause 817.

6 (05/09) If any quick lime in a mixture has not fully hydrated, it will subsequently hydrate and may disrupt the compacted layer. Such disruption is possible with lime-based mixtures where the water content of the HBM is on the dry side of the OWC or the MCV is greater than 12, particularly when the time between lime addition and compaction is just a few hours. The risk of disruption is usually minimised by controlling the moisture content so that it is on the wet side of the OWC or MCV curve, and by using fine quick lime with a high reactivity. The characteristics of quicklime are controlled by Clause 811.1, which uses the requirements

of BS EN 14227-11 to specify the use of high reactivity quick lime with Grading Category 1. The potential for disruption can be avoided by using hydrated lime instead of quick lime.

7 (05/09) The Contractor is responsible for protecting the works from weather damage. To protect HBM from drying or wetting during transport, it is normally necessary to sheet delivery vehicles. Some slow setting HBM is suitable for stockpiling and for hauling over a long distance. Care is needed to avoid surface or local drying and segregation when a mixture is stockpiled or double handled in any way. If a visual inspection or test confirms that the water content is variable, the load or stockpile should be rejected or reprocessed through a mixing plant, adding water if necessary.

8 (05/09) Segregation can be seen as zones of coarse aggregate without enough fine aggregate to fill the gaps between the larger particles. It should be avoided because it leads to an increase in the proportion of air voids. Large air voids can fill with water, giving rise to a large reduction in strength of the mixture and destruction of local inter-layer bond. Coarse and rounded aggregates and non-cohesive mixtures are prone to segregation. When a mixture is found to be prone to segregation, consideration should be given to reducing the specified aggregate size. Clause 823 for CBGM C mixtures also has a requirement for compacity. Compliance with the compacity requirement requires close control of the volume of air and free water in the mixture. This usually results in a mixture that is less prone to segregation.

9 (05/09) Segregation can occur with the mix-in-plant methods if an all-in aggregate is used, because segregation often occurs in the aggregate stockpile prior to mixing. Segregation at the mixing stage can be minimised by using a number of aggregate fractions, each with a separate aggregate feed hopper.

10 (05/09) To assure layer integrity, the surface must be free of surface shearing and aggregate degradation. Fine graded and uniformly graded mixtures are often prone to surface shearing, when a thin plate of compacted mixture becomes detached from the top surface. Surface shearing can be mitigated by using a combination of vibratory compaction followed by a pneumatic tyred roller (PTR). Aggregate degradation by the crushing of weaker particles in some aggregates such as sandstone, limestone, chalk or recycled aggregate can also be reduced by the use of pneumatic tyred rollers.

11 (05/09) Surface shearing with fine mixtures with a long construction period such as FABM 5 has been avoided by constructing the compacted layer 30 to 40 mm high and then trimming to remove the excess without further compaction. The trimmed material can

be used in the works, provided this is carried out within the workability period of the mixture.

12 (05/09) The water content in the top part of the layer can be adversely affected by high temperatures and/or low humidity, particularly when associated with a high wind speed. This makes compaction difficult and can prevent setting and hardening in the top part of the layer. In order to maintain the water content, it may be necessary to spray water on the surface during compaction and start the curing stage immediately on completion of compaction.

13 (05/09) A good bond between the lifts of a multi-lift layer is an important factor in achieving the expected pavement stiffness and durability. Because of this, Clause 817 requires the Contractor's method statement and demonstration area to include multi-lift working when necessary, and the methods of assuring and checking that a good bond has been achieved. Bond can usually be encouraged by making sure that the lower lift is not allowed to dry out before the upper lift is placed. It may also be necessary to scarify the surface of the lower lift.

14 (05/09) The rate of hydration of HBM binders slows down at low temperatures and hydration can stop if the mixture temperature falls to close to 0°C. If freezing occurs in a mixture which has yet to attain full strength it may disrupt the bond between the binder and the aggregate. The formation of ice lenses can also displace aggregate from some HBM mixtures. The HBM mixture chosen by the Contractor should develop sufficient tensile strength to resist internal freezing, if it is likely to be subject to temperatures close to 0°C. Strength develops relatively quickly in a HBM mixture with a cement content of at least 3%, so it is unlikely to be affected by low temperatures. When a HBM mixture has a cement content of less than 3%, there is a danger of hardening taking place so slowly that the integrity of the mixture is put at risk by low temperatures. Construction using HBM mixtures with a cement content of less than 3% is usually not allowed in the winter, particularly if the layer is to be left exposed. However, where rapid construction of the overlaying layers is proposed, the overlaying layers can provide adequate insulation to enable the winter working restrictions to be relaxed. The Contractor should use a risk assessment approach to evaluate and define appropriate weather and construction time criteria for the HBM layers by considering:

- (i) the depth of cover provided by the overlying layers;
- (ii) the type and durability of the aggregates used in the mixture;

- (iii) the likely strength gain of the mixture prior to overlay;
- (iv) the site location (TRL Report RR 45 provides guidance on the influence of location);
- (v) the likely construction date.

15 (05/09) Rain can degrade HBM mixtures, particularly if the mixture has a high proportion of fine aggregate or if the mixture is to be trafficked soon after laying. Because of this, Clause 817 requires the Contractor's method statement to clearly define the action to be taken to mitigate any adverse effects caused by rain. If the rain is light, it may be possible to continue laying by adjusting the amount of water added during production of the mixture. Fly Ash Bound mixtures are particularly vulnerable to rain in the fresh state prior to compaction, so the works must be carefully planned.

16 (05/09) Early trafficking of the pavement may be permitted, if the traffic is well controlled. It should be noted that:

- (i) well-graded mixtures made with crushed hard aggregate should be suitable for immediate trafficking without demonstration;
- (ii) subject to performance when compacted using a PTR, well-graded mixtures made with 100% crushed weak aggregate should be suitable for immediate trafficking;
- (iii) subject to performance when compacted using a PTR and provided the IBI is greater than 50, well graded mixtures with not less than 50% crushed hard aggregate should be suitable for immediate trafficking;
- (iv) subject to performance when compacted using a PTR and provided the IBI is greater than 40, mixtures with a high proportion of fine aggregate should be suitable for immediate trafficking.

NG 814 (05/09) **Mix-in-Plant Method of Construction Using Batching by Mass**

1 (05/09) Forced action mixers should be used so that relatively small proportions of binder or activator are distributed and thoroughly mixed with the aggregates or soils. This forced action is normally produced by one of the following methods:

- (a) a batch mix system using a vertical axis rotating pan mixer with fixed location vertical blades to force the flow to the center of the pan and prevent the agglomeration of fine material at the pan wall;

- (b) a continuous mix system where horizontal pairs of counter rotating helical blades blend and then mix the constituents as they are fed into the mixer.

2 (05/09) The free flow of constituents into the mixer is essential for the production of a mixture with consistent characteristics. With fine graded, silty or clayey constituents, it is usually necessary to use hoppers with a number of design features that assist free flow, such as vibrators and friction reducing internal coatings.

3 (05/09) Further advice about the mix-in-plant construction method can be found in CCIP-009 available from the Concrete Centre (www.concretebookshop.com) and in TRL611 available from the Transport Research Laboratory (www.trl.co.uk).

NG 815 (05/09) **Mix-in-Plant Method of Construction Using Volume Batching**

1 (05/09) Batching by volume assumes that the mixture constituents are fed into the mixer at a constant rate that is varied in a predictable way by changing the settings of the control system. This means that any variation in the density and flow characteristics of a mixture component will affect the consistency of the HBM mixture. Because of this potential variability, Clause 813 does not permit volume batching for mixtures used in base layers.

2 (05/09) The guidance given in NG 814 also applies to volume batching.

NG 816 (05/09) **Mix-in-Place Method of Construction**

1 (05/09) Mix in place methods can produce high quality mixtures when the process is carefully controlled. It is essential that the pulveriser-mixer used has sufficient power to fully pulverise cohesive and bound agglomerations at a water content high enough to comply with the Moisture Condition Values (MCV) specified in Appendix 7/1. It is also essential that water is introduced into the mixture in a controlled way so that a consistent mixture is produced. The required degree of pulverisation and MCV limits must be rigorously maintained if full integration and activation of binder(s) is to be effective. Thorough dispersion of sufficient mixing water is necessary to ensure rapid slaking of quick lime, if used. This is needed to promote satisfactory reactions between the lime and clay, and helps to prevent long-term volume stability problems.

The introduction of mixing water from a spray bar under the mixing hood is currently the only effective method of adding water in a reliable enough way for pavement construction.

2 (05/09) Binders and activators are usually laid in front of the pulveriser-mixer by a separate metered spreader but can be distributed directly by some types of pulveriser-mixer. The second method can be particularly helpful on sites when fine powdered materials could cause a dust nuisance.

3 (05/09) Uniformity of binder distribution and depth of pulverisation and mixing are important factors in achieving the expected pavement stiffness and durability. Because of this, sub-Clause 870.4 requires the excavation of trialpits to check the depth of mixing. It is essential that the binder be distributed to the full depth of pulverisation to avoid the formation of a residual layer of loosed unbound soil.

4 (05/09) Further advice about the mix-in-place construction method can be found in CCIP-009, available from the Concrete Centre (www.concretebookshop.com) and in TRL Report TRL611, available from the Transport Research Laboratory (www.trl.co.uk).

NG 817 (05/09) **Method Statement and Demonstration Area**

1 (05/09) The method statement prepared by the Contractor should describe the proposed method of working for the demonstration area and for the main works. It should contain a description of all stages of construction, including:

- (i) facilities for storing of constituents;
- (ii) plant to be used for mixing, transport and laying;
- (iii) estimated time durations and intervals between the main stages of the work;
- (iv) site preparation details prior to laying the HBM layer;
- (v) lime flocculation stage, control and timing;
- (vi) mixing method, time of residence in mixer, output, etc;
- (vii) transport, journey time, protection during transport etc;
- (viii) compaction and levelling;
- (ix) curing and protection;
- (x) action to be taken during inclement weather

- (xi) production control checks including:
- site preparation;
 - powder spreading;
 - mixing and pulverization;
 - water addition;
 - batching and mixing records;
 - controlling MCV;
 - depth of mixing;
 - compaction;
 - in-situ density measurement;
 - level control for bottom and top of layer;
 - procedures to assure and check the integrity of any multiple lift layers.

NG 818 (05/09) Induced Cracking of HBM

1 (05/09) The need for inducing transverse and longitudinal cracks in HBM is determined by the design requirements. Further guidance is given in HD 25 (DMRB 7.2.2) and HD 26 (DMRB 7.2.3).

NG 820 (05/09) Aggregates

1 (05/09) Table 8/12 gives requirements for aggregates using the Categories from BS EN 13242.

2 (05/09) For some HBM mixtures, a Category for the proportion of crushed or broken particles in coarse aggregate is specified. This is because crushed rock aggregate will support construction and in-service traffic better than rounded aggregate with the same grading curve. HBM with slow setting binders may need a well graded crushed aggregate to support site traffic whilst allowing the development of the expected strength and stiffness. The specification for the mixtures in Clauses 830, 831 and 835 can require either Category $C_{90/3}$ or Category $C_{50/10}$. Compilers of Appendix 7/1 should not routinely specify Category $C_{90/3}$ if that selection inhibits the use of local or recycled aggregate. However, Category $C_{90/3}$ should be specified when heavy early traffic loads are anticipated, as is often the case in maintenance works.

3 (05/09) The Los Angeles coefficient of coarse aggregate is a measure of its resistance to fragmentation and an indicator of mechanical strength. A lower value indicates greater resistance. The selection of Category LA_{50} is appropriate for HBM layers subject to heavy traffic, particularly if the layer is used by site traffic before an overlying pavement layer is constructed.

4 (05/09) Requirements for Categories that specify acid-soluble sulfate content and total sulfur content are introduced to the current edition, pending the results of continuing research into correlation of sulfate and sulfur swelling induced damage to the loss of strength after immersion tests. Feedback on the performance of sulfate bearing aggregates in the immersion tests and, where appropriate, in the works would be welcomed by HA Pavement Engineering Group, even when the acid-soluble sulfate and total sulfur contents are below the critical values.

The upper limits stated in Table 8/12 for wood and other impurities have been set to encourage the use of processed recycled aggregates and aggregates from secondary sources. A separate requirement is given for the maximum proportion of glass for similar reasons.

5 (05/09) It is often difficult to determine the characteristics of the aggregate components of an existing bound pavement layer before it is recycled. If the site investigation indicates that there are no problems with durability or chemical characteristics, it is usual to assume that aggregates derived from an existing pavement will comply with the requirements of Clause 820 and Table 8/12. If necessary, additional testing of the processed recycled aggregate before it is used in a mixture can be specified in Appendix 7/1.

Further guidance about recycling existing pavement layers can be found in TRL Report TRL611, available from the Transport Research Laboratory (www.trl.co.uk).

NG 821 (05/09) Cement Bound Granular Mixtures A (CBGM A)

1 (05/09) The grading curve for the aggregates for CBGM A is specified using Envelope A from BS EN 14227-1, Figure 1. This grading envelope covers a wide range of readily available aggregates from 0/2 (MP) size fine aggregate to 0/32 size all-in aggregate.

NG 822 (05/09) Cement Bound Granular Mixtures B (CBGM B)

1 (05/09) The grading curve for the aggregates for CBGM B is specified using Envelope B from BS EN 14227-1, Figure 1. Envelope B covers a more restricted range of available aggregates when compared to those permitted for CBGM A. It has much lower limits for the proportion of particles passing the 2 mm size and 0.063 mm size test sieves.

2 (05/09) As an alternative, a 20 mm size mixture may be specified using the mixture grading envelope from BS EN 14227-1, Figure B2 (Category G2). This grading envelope applies to the whole mixture, including the binder.

3 (05/09) As explained in NG 820.2, resistance to traffic can be improved by ensuring a high proportion of crushed or broken particles by specifying Category C_{90/3} in Appendix 7/1.

NG 823 (05/09) Cement Bound Granular Mixtures C (CBGM C)

1 (05/09) Clause 823 allows the option of specifying a CBGM that can be expected to have enhanced and more consistent structural and trafficking properties when compared to CBGM A and CBGM B.

2 (05/09) The grading curve for the aggregates for CBGM C are specified using the mixture grading envelopes from BS EN 14227-1, Annex B2 (Category G1). The specified grading envelopes allow a choice of 0/20 mm size, 0/14 mm size and 0/10 mm size mixtures, each with a tightly controlled grading curve and a compacity requirement to control the proportion of air voids. The grading curve applies to the whole mixture, including the binder.

3 (05/09) Compliance with the tightly controlled grading curve will usually require a mixing plant with a number of aggregate feed hoppers so that different aggregate sizes can be added to the mixer in a controlled way.

4 (05/09) As explained in NG 820.2, resistance to traffic can be improved by ensuring a high proportion of crushed or broken particles by specifying Category C_{90/3} in Appendix 7/1.

(05/09) NG 830, NG 831, NG 832, NG 834 and NG 835 Slag, Fly Ash Bound Mixtures and Hydraulic Road Binder Bound Mixtures

(05/09) General

1 (05/09) Slag bound mixtures (SBM) can be made with slag binder derived from either air-cooled steel slag (ASS) or from blast furnace slag. There are three types of blast furnace slag binder - granulated blast furnace slag (GBS), ground granulated blast furnace slag (ggbs) and partially ground blast furnace slag (pgbs). ASS binders harden by a reaction that produces carbonates whilst blast furnace slag binders harden by hydraulic reaction.

2 (05/09) Granulated blast furnace slag (GBS) is a sand size granulate that must be activated by lime (quicklime or hydrated lime). Fine-grained air-cooled steel slag can also be used as an activator because it is a source of lime. The setting process and the consequent gain in strength happen slowly.

3 (05/09) Ground granulated blast furnace slag (ggbs) is a powder that is activated by lime (quicklime or hydrated lime) or by cement. Hardening is more rapid than with ASS or GBS. Mixtures activated by lime develop strength only slightly less rapidly than those activated by cement. There is little experience with the use of partially ground blast furnace slag (pgbs) in the UK.

4 (05/09) Fly ash bound mixtures (FABM) are made with fly ash that is activated either by lime (quicklime or hydrated lime) or by cement. The setting time for lime-activated mixtures is longer than that of cement activated mixtures.

5 (05/09) As a consequence of the various combinations of binder and activator, slag and fly ash bound mixtures have a range of setting times. This means that the performance of the mixture under traffic loading will often not depend on setting and hardening but on the grading of the mixture. This means that crushed aggregate will be required for mechanical stability and resistance to traffic loads. If the mixture is not mechanically stable, satisfactory long-term performance will not be achieved.

(05/09) Fly Ash Bound Mixture 1 (FABM 1) and Hydraulic Road Binder Bound Mixture 1, Clause 830

6 (05/09) FABM 1 and HRBBM 1 are well-graded 0/31.5 mm mixtures with a grading envelope defined by BS EN 14227-3 or BS EN 14227-5, as appropriate. The grading is similar to that for a 0/31,5 mm size CBGM B mixture.

(05/09) Slag Bound Mixture B2 (SBM B2), Fly Ash Bound Mixture 2 (FABM 2) and Hydraulic Road Binder Bound Mixture 2 (HRBBM 2), Clause 831

7 (05/09) Group 2 graded mixtures differ from the mixtures specified using Clause 831 and Clause 835 because both BS EN 14227-2, BS EN 14227-3 and BS EN 14227-5 have a requirement for a minimum compacity of 0.80.

8 (05/09) Compacity is a measure of the voids occupied by air and free water (water that is not needed for hydration) in compacted specimens. It limits the amount of water available to lubricate compaction and indirectly constrains the amount of binder. Mixtures

designed to comply with compacity limits will usually have a better balance between grading, drying shrinkage and workability than mixtures specified by grading and binder content alone.

9 (05/09) The use of a compacity limit permits the use of smaller aggregate sizes. This can reduce segregation in transport and laying, and give enhanced in-service performance. BS EN 14227-2, BS EN 14227-3 and BS EN 14227-5 set out grading envelopes for 0/20 mm size, 0/14 mm size and 0/10 mm size mixtures. However, the Standards have an additional requirement for the 0/10 mm size mixtures. They must have an immediate bearing index (IBI) of not less than 50 to allow use by site traffic. The IBI is determined using a version of the California Bearing Index test.

(05/09) Slag Bound Mixture B3 (SBM B3), Fly Ash Bound Mixture 3 (FABM 3) and Hydraulic Road Binder Bound Mixture 3, Clause 832

10 (05/09) Group 3 mixtures allow the use of mixtures with a large proportion of fine aggregate. The grading requirements for Group 3 mixtures in BS EN 14227-2, BS EN 14227-3 and BS EN 14227-5 are the same, with at least 85% of the particles in the mixture must pass the 6.3 mm size test sieve. Both Standards limit the proportion passing the 0.063 mm size test sieve (including the binder) to a maximum of 35%.

11 (05/09) In order to accommodate immediate use by traffic, a minimum value of immediate bearing index (IBI) is specified using Category IPI₄₀. This requirement may be relaxed to Category IPI₂₅, if the mixture is not to be used by site traffic.

(05/09) Fly Ash Bound Mixture 5 (FABM 5), Clause 834

12 (05/09) FABM 5 is a mixture where fly ash is used as both the main aggregate and, together with added activator, the binder. The activator can be cement, lime (quicklime or hydrated lime), or lime and gypsum.

13 (05/09) Good compaction of FABM 5 requires close control of moisture content. As explained, in NG811.11, care must also be taken to minimise surface shearing. Lime activated mixtures are prone to damage, so the next layer should be constructed within their construction period. This provides some re-compaction of the FABM 5 mixture and heals any surface cracks. The overlying layer should preferably be one that can be laid without direct trafficking of the FABM 5 layer.

(05/09) Slag Bound Mixtures B1 (SBM B1), Clause 835

14 (05/09) BS EN 14227-2 sets out grading envelopes for four sub-types of SBM B1. SBM B1-1 is 0/22,4 mm

size; SBM B1-2 and SBM B1-4 are 0/31,5 mm size; and SBM B1-3 is 0/45 mm size.

15 (05/09) The grading envelopes limit the proportion of the mixture (including the binder) passing the 0,063 mm size test sieve to not more than 6%. This means that GBS is usually used as a binder instead of ggbs. The grading curves give mixtures that are often relatively permeable. This means the mixtures are suitable for use in inclement and winter conditions. However, their mechanical properties are not usually as good as those for the mixtures specified using Clause 830 and Clause 831.

NG 840 (05/09) Soil Treated by Cement (SC), Soil Treated by Slag (SS), Soil Treated by Fly Ash (SFA) and Soil Treated by Hydraulic Road Binder (SHRB)

1 (05/09) European experience and research carried out at TRL in full-scale trials has shown that satisfactory foundation layers that are suitable for direct trafficking can be made using hydraulically bound mixtures with a compressive strength of about 1 MPa. It has also been shown that hydraulic binders can be used with types and sizes of aggregates and soil (including cohesive soil) that are not routinely used to produce subbase layers. More details can be found in HA 74 (DMRB 4.1.6).

2 (05/09) Clause 840 gives requirements for soil treated by cement (SC), soil treated by slag (SS), soil treated by fly ash (SFA) soil treated by hydraulic road binder (SHRB). These mixtures are often known as stabilised soil. Use of this technique often gives environmental and economic benefits by minimising the need to transport aggregates and by using fly ash or slag as the major part of the binder. The need to dispose of surplus soil from excavations can also be minimised.

3 (05/09) The requirements for cohesive soils in Table 8/13 assume a minimum of 15% by mass passing the 0.063 mm test sieve and a plasticity index (PI) greater than 10.

4 (05/09) When cohesive soils are stabilised, a two stage process is required. The first step is flocculation with lime to give a more granular soil. This then allows efficient mixing with a second binder to develop the specified strength. Traditionally cement has been used for the second stage, but experience has shown that fly ash and ground granulated blast furnace slag binders can produce layers with greater tolerance of sulphates than layers made with cement.

5 (05/09) The limiting value for Total Potential Sulfate (TPS) has been chosen to control the risk of problems due to oxidation of reduced sulfur compound such as pyrite. If the TPS is in excess of the specified limit,

reference should be made to the Overseeing Organisation. The soil should be tested to determine the form of the sulfur species present and the associated risk evaluated. More details can be found in TRL 447 (updated in 2005) and HA 74 (DMRB 4.1.6).

6 (05/09) Many overconsolidated clays and some alluvial sands and gravels contain significant concentrations of sulfates and sulfides, which could affect the stabilization process. The occurrence of sulfate and sulfide minerals in the UK is summarised in Appendix B of HA 74 (DMRB 4.1.6).

7 (05/09) Where the TPS exceeds the limiting value, its effect can be modelled by volumetric expansion tests with samples of soil and the proposed proportions of the intended binder combinations prepared as mixed and cured specimens. As sulfur bearing minerals are not uniformly distributed in natural soil care needs to be taken that tested samples model the true level of the relevant minerals. Specimens should be analysed on completion of the tests to determine their individual TPS values to check that they correctly modelled the site conditions.

8 (05/09) The volumetric expansion test is preferred to the CBR swell test. The presence of sulfate or potential sulfate may not mean that the soil is unable to be permanently stabilised, but it could mean that special measures need to be taken. These could include additional mixing, mellowing, temperature limitations, and a limited choice of binder types.

9 (05/09) Current best practice for the stabilisation of sulfate and sulfide bearing soils can be found in Britpave document BP/16, 'Stabilisation of sulfate-bearing soils', obtained from www.britpave.org.uk

10 (05/09) The general notes in NG 830, NG 831, NG 832, NG 834 and NG 835 about the different rates of strength gain for different binder and activator combinations also apply to treated soil.

11 (05/09) There are no limitations on the level of individual impurities in treated soils, because unacceptable levels of deleterious constituents will result in failure to pass the requirements of the immersion test. However, an excess of reactive glass will not be revealed by the immersion test and alkali aggregate susceptibility will need to be investigated. Where the receptor soil is 'made ground', secondary or recycled material, the aggregate requirements given in Table 8/12 for Clause 832 mixtures can be taken as a guide to the level of impurities likely not to be deleterious to the performance of treated soil.

NG 870 (05/09) **Testing, Control and Checking of HBM**

1 (05/09) HBM specified using BS EN 14227 are tested using the test methods in the relevant Parts of BS EN 13286. The scope of the test methods is restricted to mixture tests and tests on specimens made from mixtures. Tests for water content and plasticity are found in BS 1924-1, grading in BS EN 933-1, and in-situ density in BS 1924-2.

NG880 (05/09) **Laboratory Mixture Design Procedure**

1 (05/09) A schedule of testing similar to that shown in Table NG 8/2 should be used for each combination of binder and water content.

(05/09) **TABLE NG 8/2: Suggested Schedule of Testing for Laboratory Mechanical Performance of One Combination of Binder and Water Content**

HBM Type	Curing Temperature	Age of Sealed Specimens at Time of Test (3 Specimens for Each Test Age)					
		7 days	14 days	28 days	56 days	91 days	1 year
Without cement	40°C	✓	✓	✓	-	-	-
	20°C	-	-	✓	✓	✓	✓
With cement	20°C	✓	✓	✓	✓	✓	✓

NOTES:

- Testing at ages beyond 28 days is optional.
- For mixtures using binders without cement, cylindrical specimens compacted to refusal, cured at 40°C and tested at 28 days have been found to be at least equivalent to the 360-day strength/stiffness using 20°C curing.
- For mixtures using binders containing cement, cylindrical or cube specimens compacted to refusal, cured at 20°C and tested at 28 days have been found to be equivalent to 80% of the 360-day strength at 20°C curing.

2 (05/09) The Contractor should provide evidence of strength development over a minimum of 28 days. This information should be used by the Contractor to declare the age of testing for site control purposes.