Using SF and CKD as cement replacement materials for producing cement mortar

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Abstract. When considering binding materials, cement mortar is thought to be one of the most conventional and effective materials. The cement mortar is mainly containing cement, sand (fine and rough), and water. In fact, there are many environmental and economical limitations to the usage of raw materials in mortar blends. For considering these limitations, many researchers studied the ability to incorporate waste-materials to fully or partially replace conventional raw materials. In this research, compressive strength and ultrasonic pulse velocity (UPV) will be studied by incorporating (SF) and (CKD) of mortar specimens and study the effect after 7, 14, and 28 days. The obtained results from the collected samples (M1, M2, and M3) were compared with the reference mortar samples that contain ordinary Portland cement (OPC) only. The collected results showed that samples with CKD and SF have less compressive strength than ones with OPC with 28 days of curing. In addition, with higher CKD content, lower compressive strength was obtained. Samples (M1, M2) have the highest (UPV) values at different curing periods.

1. Introduction
Cement mortar could be simply defined as a paste composed of cement, sand, and water. The cement mortar has a wide range of uses in construction using its advantages of high workability and followability. This mortar can be used for masonry construction and also as a binder to fill up the gaps in masonry construction mostly in small buildings and houses. Moreover, cement mortar was also used in bridge construction as epoxy materials [1, 2]. In Ordinary Portland Cement (OPC) manufacturing, raw materials such as river sand and cement which is produced by processing limestone. Recently, many regulations were found regarding the use of raw materials and their negative impacts from an economic and environmental perspective [3, 4]. The environmental effects can be summed up in the fact that a
higher average of pollution is produced in addition to landslide issues that may arise with higher use of raw materials. In addition, the chemical composition of cement allows CO2 releasing and hence, higher energy consumption and then environmental negative impact and contributing in the global warming [5, 6]. The latter is responsible for many environmental problems, such as the shortage of freshwater [7-11], and uneven distribution of water on a global-scale [12-15]. Moreover, the generated wastewater from the cement-based industries are very alkaline and contains high concentrations of organic matter and solid particles [16-18], which heavily pollutes the receiving water bodies and, therefore; efficient treatment methods are needed to control this pollution [19-22]. For example, adsorption [23-26], coagulants [27-29], electrocoagulation [30-39], natural coagulants [40, 41], biological units [42, 43], and hybrid methods [44] were used for this goal. On the other hand, the negative economic impact can be attributed to higher costs of production and maintenance with a higher need for raw materials [45, 46]. On the top of these effects, demolition of concrete structures represent another challenge as these wastes must be managed and disposed in controlled landfills that requires effect high costs [47, 48]. All the mentioned problems with using raw materials are going against the principles of green technology [49]. Another point is that with the increasing world population, more houses need to be built which means more raw materials will be required unless eco-friendly alternatives are developed [50, 51]. Due to this high demand, raw materials are replaced with new materials that ensure low cost and acceptable load-bearing capacity. To contribute to enhancing the environment and reducing the costs to the minimum, the alternative materials used are commonly wastes including agricultural wastes and industrial wastes. Agriculture is producing millions of tons of wastes annually such as harvest residues (including grains, herbs, and root tubers), palm oil fuel, corn cobs, and tobacco [47, 52]. These quantities of wastes with a lack of proper management and planning led to numerous problems concerning the human population and environment. In most cases, a large area is allocated to dump these wastes leading to bigger issues such as continuously reducing the land suitable for agriculture and housing and other environmental issues. The collected wastes are generally processed by burning in the dump area resulting in excessive smoke and CO2 emission. As a result, it is essential to study the ability to utilize these wastes to be useful in different industries [1].

Different types of wastes, such as fly ash, bottom ash, lime, fuel ash… etc., were studied as a replacement for cement and they resulted in acceptable properties and good strength value. Mortar with pozzolanic or mineral materials as cement replacement is called modified mortar. Adding pozzolanic material as a partial replacement of cement could enhance the compressive strength and the durability properties of mortar. Silica Fume (SF) which is generated as waste material in the thermal power plant. A wide range of plants is now using SF as a cement replacement to improve the quality of mortar relating to compressive strength and durability.

One of the main wastes produced by the cement production plants is the Cement Kiln Dust (CKD). It is comparable to the (OPC) in terms of appearance (fine powdery material) and chemical composition. One of the negative properties of CKD is its lack of self-cementitious, this could be solved by combining its other pozzolanic material to use it as a partial OPC alternative in mortar blend with keeping the durability and strength properties. This research investigates the cement mortar engineering properties when using CF mixed with CKD as a cement replacement.

2. Materials and methods

Four mortar specimens were prepared with water and sand ratios to the binder of 0.4 and 2.5 respectively. The first sample was prepared to be as a reference for the collected results as it was made from OPC only, the other specimens (M1, M2, and M3) were made with different ratios of (OPC, SF, and CKD) as illustrated in the table below.

| Description                     | OPC | SF | CKD |
|---------------------------------|-----|----|-----|
| Reference mortar made of OPC only | 100%| 0% | 0%  |

Table 1. The measured concentrations of the studied heavy metals in the collected soil samples.
Mortar made of (OPC, SF, and CKD) (M1) 90 % 5 % 5 %
Mortar made of (OPC, SF, and CKD) (M2) 80 % 10 % 10 %
Mortar made of (OPC, SF, and CKD) (M3) 70% 15 % 15 %

To find the effect of different mixture ratios, both compressive strength and UPV were studied for all collected samples and compared with the reference sample.

2.1. Compressive strength test
All prepared samples with different proportions were tested for compressive strength following BS EN 196-1 (British Standards) for the sample preparation and testing. In the beginning, dry materials were mixed properly to guarantee homogeneity using an electrical mixer. The dry blend is then mixed with the proper percentage of water. A prism with dimensions of (40 x 40 x 160 mm). Before placing the mortar, the prism was oiled in order to make it easier when extraction after hardening. To minimize the moisture loss in the time of curing, the samples were wrapped in polyethylene bags. To ensure the reliability of the results, three samples of each mixing proportion were prepared and tested.

2.2. The ultrasonic pulse velocity test
The Ultrasonic pulse velocity test is essential as it contributes to making important decisions about conditions of concrete structure such as deterioration control and structure quality [53]. This test was carried out following the British Standard BS EN 12504-4 (2004). In the same way with a compressive strength test, the samples were prepared using a cubic mold with dimensions of 100 mm x 100 mm x 100 mm. For each mixing proportion, three samples were prepared in order to meet the standard requirements. After casting the samples, they left in the laboratory with (20±2 °C) and 100% relative humidity for different curing periods (7, 14, and 28) days. The principle of calculating UPV is by projecting sound waves inside the material and measure the time it needs to transfer through it. As the distance is known, it would be possible to calculate the UPV [53].

3. Results and discussion
The compressive strength test results showed that using OPC only showed the highest compressive strength among all with 28 curing days. On the other hand, both M2 provided higher resistance than OPC mortar with a value of 10.875 MPa at 7 days. At 14 days, the compressive strength of the mixed mortar M3 was on the top reaching 11.78 MPa compared with 11.37 MPa for M2 and 11.35 for the OPC only mortar. It is worth mentioning that using mix design (M1) which contains 5% SF and 5 % CKD resulted in a drop for the compressive strength at all curing ages. In fact, the compressive strength top value was fluctuating between (OPC, M1, M2) with the three studied curing ages as shown in Figure 1. All the tested specimens followed the same pattern where it reached the peak of compressive strength at 14 days to face a noticeable decrement at age of 28 days.

The obtained results were coinciding with what was found by Shoaib and Balaha [54] when he studied the impact of adding blast furnace sludge cement (BFSC) with (CKD) as cement replacement on the compressive strength. In the same way, two concrete mixes were used with two cement kinds (OPC and BFSC) with mixing proportion of (1Cement: 1.9 sand: 3.52 Gravel: and 0.5 W/C) and the CKD replacement proportions were 0, 10, 20, 30 and 40 %. Different curing ages were considered (1, 3, and 6) months, and the compressive strength test was carried out at each age. The results obtained showed that compressive strength was inversely proportional to CKD addition percent. The OPC mixture achieved a compressive strength of 27, 28.5, and 32 MPa at (1, 3, and 6) months respectively. With concrete containing (40% CKD), the compressive strength was reduced by about 44% of the OPC concrete only. This decrement is caused by replacing cement clinker which is responsible for the compressive strength development.
On the other hand, the UPV test was carried out in the same conditions (mixtures and curing time). In general, it was clear that the UPV average develops with longer curing time. In the M1 mortar mixture, UPV achieved the optimum value at all curing periods, see Figure 2.

![Figure 1. Compressive strength values with different ages.](image1)

Additionally, the UPV value was developing with more curing time from 3887 m/s at 7 days to 4171 at 28 days. Incorporating pozzolanic materials (SF and CKD) will result in pore structure tightens and highly reduce the mortar porosity which in turn will enhance the UPV [1, 53]. Though the UPV is a

![Figure 2. UPV test results.](image2)
world-wide recognised test and it provides dependable results, real-time data is still needed to have a better understanding of structural behaviour under different conditions, therefore embedding sensors in the concrete could be a very efficient monitoring tool as reported by many relevant studies [55-58].

**4. Conclusions**

Based on the obtained results and analysis, the study could be concluded in the following points:

- The compressive strength was negatively impacted when replacing cement with pozzolanic materials (CKD&SF) at all ages.
- Between the other mortar mixes, M3 with (15% SF and 15% CKD) was higher than M1 and M2 and it was slightly less than OPC mortar.
- The optimum UPV was obtained using the M1 mortar mix at all curing ages.
- In general, incorporating pozzolanic materials (SF & CKD) in mortar is directly proportional to the UPV value.
- Increasing the curing age generally resulted in higher UPV at all mortar mixes.

In terms of recommendations, it has been mentioned in the main text that although the UPV is a world-wide recognised test and it provides dependable results, real-time data is still needed to have a better understanding of structural behaviour under different conditions, therefore embedding sensors in the concrete could be a very efficient monitoring tool. A number of studies could be focused on this goal.

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