



Designation: C1384 – 23

Standard Specification for Admixtures for Masonry Mortars¹

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1. Scope*

1.1 This specification pertains to admixtures for masonry mortars. Admixtures are substances other than Specification C270 prescribed materials of water, aggregate, and cementitious materials that are used to improve one or more of the recognized desirable properties of conventional masonry mortar.

1.2 This specification does not cover coloring pigments.

NOTE 1—Information on coloring pigments can be found in Specification C979/C979M.

1.3 This specification does not cover additives that are added to the cementitious materials during the manufacture of the cementitious materials.

1.4 Acceptance of an admixture is based on its performance in an admixed mortar. Acceptance of the admixed masonry mortar is based on attainment of performance either equivalent to that required for conventional mortar or improved performance of one or more indicated properties, while maintaining required performance levels for other properties.

1.5 The text of this standard refers to notes and footnotes that provide explanatory material. These notes and footnotes (excluding those in tables and figures) shall not be considered as requirements of the standard.

1.6 The values stated in SI units are to be regarded as the standard. The values given in parentheses are for information only.

NOTE 2—The testing laboratory performing the test methods referenced in this specification should be evaluated in accordance with Practice C1093.

1.7 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

¹ This specification is under the jurisdiction of ASTM Committee C15 on Manufactured Masonry Units and is the direct responsibility of Subcommittee C15.30 on Specifications for Mortars and Grouts.

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2. Referenced Documents

2.1 ASTM Standards:²

- C144 Specification for Aggregate for Masonry Mortar
- C270 Specification for Mortar for Unit Masonry
- C305 Practice for Mechanical Mixing of Hydraulic Cement Pastes and Mortars of Plastic Consistency
- C403/C403M Test Method for Time of Setting of Concrete Mixtures by Penetration Resistance
- C723 Practice for Chemical-Resistant Resin Grouts for Brick or Tile (Withdrawn 2021)³
- C780 Test Methods for Preconstruction and Construction Evaluation of Mortars for Plain and Reinforced Unit Masonry
- C979/C979M Specification for Pigments for Integrally Colored Concrete
- C1072 Test Methods for Measurement of Masonry Flexural Bond Strength
- C1093 Practice for Accreditation of Testing Agencies for Masonry
- C1152/C1152M Test Method for Acid-Soluble Chloride in Mortar and Concrete
- C1180 Terminology of Mortar and Grout for Unit Masonry
- C1218/C1218M Test Method for Water-Soluble Chloride in Mortar and Concrete
- C1403 Test Method for Rate of Water Absorption of Masonry Mortars
- C1437 Test Method for Flow of Hydraulic Cement Mortar

3. Terminology

3.1 Terminology defined in Terminology C1180 shall apply for this specification.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *admixed mortar, n*—masonry mortar that deviates from those combinations of materials recognized by Specification C270 in that it also contains an admixture.

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ The last approved version of this historical standard is referenced on www.astm.org.

*A Summary of Changes section appears at the end of this standard

3.2.2 *admixture, n*—substance other than the Specification **C270** prescribed materials of water, aggregate, and cementitious materials that is added to a masonry mortar to modify one or more properties of the conventional masonry mortar.

3.2.3 *bond enhancer, n*—admixture used to increase the bond strength between the masonry mortar and the masonry unit.

3.2.4 *reference mortar, n*—mortar of the same composition as an admixed mortar except that the reference mortar does not include the admixture and may contain a different amount of water to obtain an equivalent flow or penetration as the admixed mortar.

3.2.5 *set accelerator, n*—admixture used to shorten the time of setting of a masonry mortar.

3.2.6 *set retarder, n*—admixture used to lengthen the time of setting of a masonry mortar.

3.2.7 *water repellent, n*—admixture used to decrease the rate of water absorption of the hardened masonry mortar.

3.2.8 *workability enhancer, n*—admixture used in a masonry mortar to increase the ease of being worked and used.

3.2.8.1 *Discussion*—Workability is a combination of several properties, including: plasticity, consistency, cohesion, adhesion, water retentivity, setting characteristics, and its capacity to remain satisfactory under the influence of masonry unit suction and ambient environmental conditions. Many of these properties have defied exact laboratory measurement. The mason can best assess workability by observing the response of the mortar to the trowel and the masonry unit. For further discussion on workability, see the Appendix of Specification **C270**.

4. Classification

4.1 Admixtures are classified by their effect on the performance characteristics of conventional masonry mortars. Admixed mortars are classified by their modified properties, as compared to a reference mortar. The following classifications are recognized:

- 4.1.1 Bond Enhancer.
- 4.1.2 Workability Enhancer.
- 4.1.3 Set Accelerator.
- 4.1.4 Set Retarder.
- 4.1.5 Water Repellent.

5. Materials

5.1 *Cementitious Materials*—Cementitious materials shall conform to those allowed in Specification **C270** for proportion specification mortars.

5.2 *Sand*—The fine aggregate used in the tests shall conform to the requirements of Specification **C144**. The sand used in preparing the mortars for all tests shall be from the same delivery.

6. Chemical Composition

6.1 The admixture shall not react adversely with embedded or attached materials common to masonry.

NOTE 3—Currently, there is no standard test method for determining the

corrosion potential of masonry mortars toward embedded and attached materials. Nonetheless, the admixture shall not be offered for sale if the manufacturer has evidence that the admixture does react adversely with embedded or attached materials common to masonry.

6.2 At the maximum recommended dosage, the mortar admixture shall add not more than 65 ppm (0.0065 %) water-soluble chloride, or 90 ppm (0.0090 %) acid-soluble chloride to the mortar's overall chloride content as determined by testing of the reference and admixed mortars in accordance with **9.1.1**.

7. Physical Properties

7.1 All modified masonry mortars shall comply with the property specification requirements of Specification **C270**. In addition, the admixed mortars shall conform to all of the specific classification requirements in **Table 1** for which the admixture is obtaining qualification. Unless more specimens are required by a specific test method, a minimum of three specimens shall be tested and the results averaged. These result averages shall meet the requirements of this section.

7.2 Admixture compliance tests shall be the responsibility of the manufacturer of the admixture. These compliance tests shall be completed within the past five (5) years and prior to any admixture composition change.

8. Mortar Types and Proportions

8.1 Design the reference mortar to be a specific type of cement/lime, mortar cement, or masonry cement mortar in conformance with the proportion specification of Specification **C270** except that the aggregate ratio shall be fixed at three times the sum of the separate volumes of cementitious materials. In addition, the aggregate shall meet the requirements in **5.2**.

8.2 The corresponding admixed mortars shall have the same composition as the reference mortars but also shall include the admixture, and the water content shall be adjusted to yield the flow or penetration appropriate for each test method. The admixture dosage rate, time of addition, and mixing sequence shall follow the manufacturer's recommendations.

8.3 A complete set of tests shall be run for all applicable cement/lime, mortar cement, and masonry cement types for which the admixture is to be qualified.

9. Test Methods

9.1 For all required tests, test both the reference mortar and the admixed mortar in accordance with the following test methods:

9.1.1 *Soluble Chloride Content*—Prepare six mortar cubes in accordance with the specimen preparation section of Test Method **C1403** including the drying procedure, except that mortar proportions shall be as specified in Section **8** and aggregates shall be as specified in **5.2**. After 28 days of age, determine the water-soluble chloride content of three cubes, as percent chloride by mass of mortar, in accordance with Test Method **C1218/C1218M** except increase the sample size to 15 g instead of the 10 g specified in Test Method **C1218/C1218M**. Determine the acid-soluble chloride content of the other three cubes, as percent chloride by mass of mortar, in accordance