



Designation: C618 – 23<sup>ε1</sup>

# Standard Specification for Coal Ash and Raw or Calcined Natural Pozzolan for Use in Concrete<sup>1</sup>

This standard is issued under the fixed designation C618; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ε) indicates an editorial change since the last revision or reapproval.

*This standard has been approved for use by agencies of the U.S. Department of Defense.*

<sup>ε1</sup> NOTE—Editorial corrections were made to the text and Table 2 in March 2023.

## 1. Scope\*

1.1 This specification covers coal ash and raw or calcined natural pozzolan, for use in concrete where cementitious or pozzolanic action, or both, is desired, or where other properties normally attributed to coal ash or natural pozzolans may be desired, or where both objectives are to be achieved.

NOTE 1—Finely divided materials may tend to reduce the entrained air content of concrete. Hence, if a coal ash or natural pozzolan is added to any concrete for which entrainment of air is specified, provision should be made to ensure that the specified air content is maintained by air content tests and by use of additional air-entraining admixture or use of an air-entraining admixture in combination with air-entraining hydraulic cement.

1.2 The values stated in SI units are to be regarded as standard. No other units of measurement are included in this standard.

1.3 The text of this standard references notes and footnotes, which provide explanatory information. These notes and footnotes (excluding those in tables and figures) shall not be considered as requirements of the standard.

1.4 *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.*

## 2. Referenced Documents

### 2.1 ASTM Standards:<sup>2</sup>

<sup>1</sup> This specification is under the jurisdiction of ASTM Committee C09 on Concrete and Concrete Aggregates and is the direct responsibility of Subcommittee C09.24 on Supplementary Cementitious Materials.

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<sup>2</sup> For referenced ASTM standards, visit the ASTM website, [www.astm.org](http://www.astm.org), or contact ASTM Customer Service at [service@astm.org](mailto:service@astm.org). For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

[C125 Terminology Relating to Concrete and Concrete Aggregates](#)  
[C136/C136M Test Method for Sieve Analysis of Fine and Coarse Aggregates](#)  
[C311/C311M Test Methods for Sampling and Testing Fly Ash or Natural Pozzolans for Use in Portland-Cement Concrete](#)  
[C1778 Guide for Reducing the Risk of Deleterious Alkali-Aggregate Reaction in Concrete](#)

## 3. Terminology

### 3.1 Definitions:

3.1.1 For definitions of terms used in this specification refer to Terminology [C125](#).

### 3.2 Definitions of Terms Specific to This Standard:

3.2.1 *coal ash, n*—fly ash and bottom ash resulting from the process of combustion of ground or powdered coal obtained either from current power plant production or harvested from landfills or impoundments.

3.2.2 *bottom ash, n*—ash that results from the process of combustion of ground or powdered coal that is not transported by flue gases.

3.2.2.1 *Discussion*—This definition of bottom ash does not include the residue resulting from: (1) fluidized bed combustion, (2) the burning of municipal solid waste or any other refuse with coal, or (3) the burning of industrial or municipal solid waste in incinerators.

## 4. Classification

4.1 *Class N*—Raw or calcined natural pozzolans that comply with the applicable requirements for the class as given herein, such as some diatomaceous earths; opaline cherts and shales; tuffs and volcanic ashes or pumicites, calcined or uncalcined; and various materials requiring calcination to induce satisfactory properties, such as some clays and shales.

4.2 *Class F*—Coal ash that meets the applicable requirements for this class as given herein. This class of coal ash has pozzolanic properties.

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

**TABLE 1 Chemical Requirements**

|                                                                                                                                                     | Class       |                  |       |
|-----------------------------------------------------------------------------------------------------------------------------------------------------|-------------|------------------|-------|
|                                                                                                                                                     | N           | F                | C     |
| Silicon dioxide (SiO <sub>2</sub> ) plus aluminum oxide (Al <sub>2</sub> O <sub>3</sub> ) plus iron oxide (Fe <sub>2</sub> O <sub>3</sub> ), min, % | 70.0        | 50.0             | 50.0  |
| Calcium oxide (CaO), %                                                                                                                              | report only | 18.0 max.        | >18.0 |
| Sulfur trioxide (SO <sub>3</sub> ), max, %                                                                                                          | 4.0         | 5.0              | 5.0   |
| Moisture content, max, %                                                                                                                            | 3.0         | 3.0              | 3.0   |
| Loss on ignition, max, %                                                                                                                            | 10.0        | 6.0 <sup>A</sup> | 6.0   |

<sup>A</sup>The use of Class F coal ash containing up to 12.0 % loss on ignition may be approved by the user if either acceptable performance records or laboratory test results are made available.

**TABLE 2 Physical Requirements**

|                                                                                                                                                                                                | Class           |                 |                 |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------|-----------------|-----------------|
|                                                                                                                                                                                                | N               | F               | C               |
| <i>Fineness:</i>                                                                                                                                                                               |                 |                 |                 |
| Amount retained when wet-sieved on 45 µm (No. 325) sieve, max, %                                                                                                                               | 34              | 34              | 34              |
| Amount retained on 150-µm (No. 100) sieve, max, % <sup>A</sup>                                                                                                                                 |                 | 10 <sup>†</sup> | 10 <sup>†</sup> |
| <i>Strength activity index:</i> <sup>B</sup>                                                                                                                                                   |                 |                 |                 |
| With portland cement, at 7 days, min, percent of control                                                                                                                                       | 75 <sup>C</sup> | 75 <sup>C</sup> | 75 <sup>C</sup> |
| With portland cement, at 28 days, min, percent of control                                                                                                                                      | 75 <sup>C</sup> | 75 <sup>C</sup> | 75 <sup>C</sup> |
| Water requirement, max, percent of control                                                                                                                                                     | 115             | 105             | 105             |
| <i>Uniformity requirements:</i>                                                                                                                                                                |                 |                 |                 |
| The density and fineness of individual samples shall not vary from the average established by the ten preceding tests, or by all preceding tests if the number is less than ten, by more than: |                 |                 |                 |
| Density, max variation from average, %                                                                                                                                                         | 5               | 5               | 5               |
| Percent retained on 45-µm (No. 325), max variation, percentage points from average                                                                                                             | 5               | 5               | 5               |

<sup>A</sup> Limit only applies to coal ash that is harvested or coal ash containing bottom ash. Determine the amount retained in accordance with Test Method C136/C136M using a sample size of 15 g ± 5 g

<sup>B</sup> The *strength* activity index with portland cement is not to be considered a measure of the compressive strength of concrete containing the coal ash or natural pozzolan. The mass of coal ash or natural pozzolan specified for the test to determine the *strength* activity index with portland cement is not considered to be the proportion recommended for the concrete to be used in the work. The optimum amount of coal ash or natural pozzolan for any specific project is determined by the required properties of the concrete and other constituents of the concrete and is to be established by testing. *Strength* activity index with portland cement is a measure of reactivity with a given cement and is subject to variation depending on the source of both the coal ash or natural pozzolan and the cement.

<sup>C</sup> Meeting the 7 day or 28 day *strength* activity index will indicate specification compliance.

<sup>†</sup> Editorially corrected in March 2023.

**4.3 Class C**—Coal ash that meets the applicable requirements for this class as given herein. This class of coal ash, in addition to having pozzolanic properties, also has some cementitious properties.

NOTE 2—Class F coal ash is typically produced from burning anthracite or bituminous coal, but may also be produced from subbituminous coal and from lignite. Class C coal ash is typically produced from burning lignite or subbituminous coal, and may also be produced from anthracite or bituminous coal.

## 5. Materials and Manufacture

5.1 It is permitted to process coal ash and natural pozzolans to meet the requirements of this specification.

NOTE 3—Processing may include but is not limited to one or more of the following unit operations: grinding, drying, sieving, de-agglomeration, sizing, and carbon removal.

## 6. Ordering Information

6.1 The purchaser shall specify any supplementary optional physical requirements.

6.2 The purchaser shall indicate which procedure, A or B, shall be used when specifying requirements for effectiveness in contribution to sulfate resistance under Table 3.

## 7. Chemical Composition

7.1 Coal ash and natural pozzolans shall conform to the requirements as to chemical composition prescribed in Table 1.

NOTE 4—The chemical component determinations and the limits placed on each do not predict the performance of the coal ash or natural pozzolan with hydraulic cement in concrete, but collectively help describe composition and uniformity of the material.

## 8. Physical Properties

8.1 Coal ash and natural pozzolans shall conform to the physical requirements prescribed in Table 2. Supplementary optional physical requirements are shown in Table 3.

## 9. Methods of Sampling and Testing

9.1 Sample and test the coal ash or natural pozzolan in accordance with the requirements of Test Methods C311/C311M.