



Designation: C94/C94M – 24a

Standard Specification for Ready-Mixed Concrete¹

This standard is issued under the fixed designation C94/C94M; 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.

1. Scope*

1.1 This specification covers ready-mixed concrete as defined in 3.2.2 (Note 1). Requirements for quality of ready-mixed concrete shall be either as stated in this specification or as ordered by the purchaser. When the purchaser's requirements, as stated in the order, differ from those in this specification, the purchaser's requirements shall govern. This specification does not cover the placement, consolidation, curing, or protection of the concrete after delivery to the purchaser.

NOTE 1—Concrete produced by volumetric batching and continuous mixing is covered in Specification C685/C685M. Fiber-reinforced concrete is covered in Specification C1116/C1116M.

1.2 As used throughout this specification the producer manufactures ready-mixed concrete and the purchaser buys ready-mixed concrete.

1.3 The values stated in either SI units, shown in brackets, or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

1.4 The text of this specification references 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 specification.

1.5 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

¹ This specification is under the jurisdiction of ASTM Committee C09 on Concrete and Concrete Aggregates and is the direct responsibility of Subcommittee C09.40 on Ready-Mixed Concrete.

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(Warning—Fresh hydraulic cementitious mixtures are caustic and may cause chemical burns to skin and tissue upon prolonged use.²)

1.6 *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:³

- C31/C31M Practice for Making and Curing Concrete Test Specimens in the Field
- C33/C33M Specification for Concrete Aggregates
- C39/C39M Test Method for Compressive Strength of Cylindrical Concrete Specimens
- C125 Terminology Relating to Concrete and Concrete Aggregates
- C138/C138M Test Method for Density (Unit Weight), Yield, and Air Content (Gravimetric) of Concrete
- C143/C143M Test Method for Slump of Hydraulic-Cement Concrete
- C150/C150M Specification for Portland Cement
- C172/C172M Practice for Sampling Freshly Mixed Concrete
- C173/C173M Test Method for Air Content of Freshly Mixed Concrete by the Volumetric Method
- C231/C231M Test Method for Air Content of Freshly Mixed Concrete by the Pressure Method
- C260/C260M Specification for Air-Entraining Admixtures for Concrete
- C330/C330M Specification for Lightweight Aggregates for Structural Concrete

² See Section on Safety Precautions, Manual of Aggregate and Concrete Testing, *Annual Book of ASTM Standards*, Vol 04.02.

³ 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.

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



C494/C494M Specification for Chemical Admixtures for Concrete
 C567/C567M Test Method for Determining Density of Structural Lightweight Concrete
 C595/C595M Specification for Blended Hydraulic Cements
 C618 Specification for Coal Ash and Raw or Calcined Natural Pozzolan for Use in Concrete
 C637 Specification for Aggregates for Radiation-Shielding Concrete
 C685/C685M Specification for Concrete Made by Volumetric Batching and Continuous Mixing
 C979/C979M Specification for Pigments for Integrally Colored Concrete
 C989/C989M Specification for Slag Cement for Use in Concrete and Mortars
 C1064/C1064M Test Method for Temperature of Freshly Mixed Hydraulic-Cement Concrete
 C1077 Practice for Agencies Testing Concrete and Concrete Aggregates for Use in Construction and Criteria for Testing Agency Evaluation
 C1116/C1116M Specification for Fiber-Reinforced Concrete
 C1157/C1157M Performance Specification for Hydraulic Cement
 C1240 Specification for Silica Fume Used in Cementitious Mixtures
 C1582/C1582M Specification for Admixtures to Inhibit Chloride-Induced Corrosion of Reinforcing Steel in Concrete
 C1602/C1602M Specification for Mixing Water Used in the Production of Hydraulic Cement Concrete
 C1611/C1611M Test Method for Slump Flow of Self-Consolidating Concrete
 C1697 Specification for Blended Supplementary Cementitious Materials
 C1797 Specification for Ground Calcium Carbonate and Aggregate Mineral Fillers for use in Hydraulic Cement Concrete
 C1798/C1798M Specification for Returned Fresh Concrete for Use in a New Batch of Ready-Mixed Concrete
 C1866/C1866M Specification for Ground-Glass Pozzolan for Use in Concrete

2.2 ACI Documents:⁴

ACI 211.1 Standard Practice for Selecting Proportions for Normal, Heavyweight, and Mass Concrete
 ACI 211.2 Standard Practice for Selecting Proportions for Structural Lightweight Concrete
 ACI 301 Standard Specifications for Structural Concrete
 ACI 305.1 Specification for Hot Weather Concreting
 ACI 305R Guide to Hot Weather Concreting
 ACI 306R Guide to Cold Weather Concreting
 ACI 318 Building Code Requirements for Structural Concrete and Commentary

2.3 Other Documents:⁵

NIST 105-1 National Institute of Standards and Technology Handbook

3. Terminology

3.1 *Definitions*—The terms used in this specification are defined in Terminology C125.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *concrete, central-mixed, n*—ready-mixed concrete mixed completely in a stationary mixer.

3.2.2 *concrete, ready-mixed, n*—concrete manufactured and delivered to a purchaser in a fresh state.

3.2.3 *concrete, shrink-mixed, n*—ready-mixed concrete partially mixed in a stationary mixer with mixing completed in a truck mixer.

3.2.4 *concrete, truck-mixed, n*—ready-mixed concrete completely mixed in a truck mixer.

3.2.5 *water, target batch, n*—quantity of water to be added to the batch through the water measuring system after compensating for the quantity of ice, if used, surface moisture on the aggregates and water in the admixtures, when applicable, and by subtracting a quantity of water that is anticipated to be added at the job site or in transit to adjust slump or slump flow of the concrete batch.

4. Basis of Purchase

4.1 The basis of purchase shall be a cubic yard or cubic meter of fresh concrete as discharged from the transportation unit.

4.2 The volume of fresh concrete in a given batch shall be determined from the total mass of the batch divided by the density of the concrete. The total mass of the batch shall be determined as the net mass of the concrete in the batch as delivered, including the total mixing water as defined in 9.4. The density shall be determined in accordance with Test Method C138/C138M. The yield shall be determined as the average of at least three measurements, one from each of three different transportation units sampled in accordance with Practice C172/C172M.

NOTE 2—It should be understood that the volume of hardened concrete may be, or appear to be, less than expected due to waste and spillage, over-excavation, spreading forms, some loss of entrained air, or settlement of wet mixtures, none of which is the responsibility of the producer.

5. Materials

5.1 In the absence of designated applicable material specifications, the following material specifications shall be used:

5.2 Cementitious Materials:

5.2.1 *Hydraulic Cement*—Hydraulic cement shall conform to Specification C150/C150M, Specification C595/C595M, or Specification C1157/C1157M.

⁵ NIST Handbook 105-1 (revised 1990), "Specifications and Tolerances for Reference Standards and Field Standard Weights and Measures-1. Specifications and Tolerances for Field Standard Weights (NIST Class F)," National Institute of Standards and Technology, U.S. Dept. of Commerce, <http://www.nist.gov/pml/wmd/upload/105-1.pdf>.

⁴ Available from American Concrete Institute (ACI), P.O. Box 9094, Farmington Hills, MI 48333-9094, <http://www.concrete.org>.