



CONCRETE REPAIR

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WITH SIKA SINCE 1991

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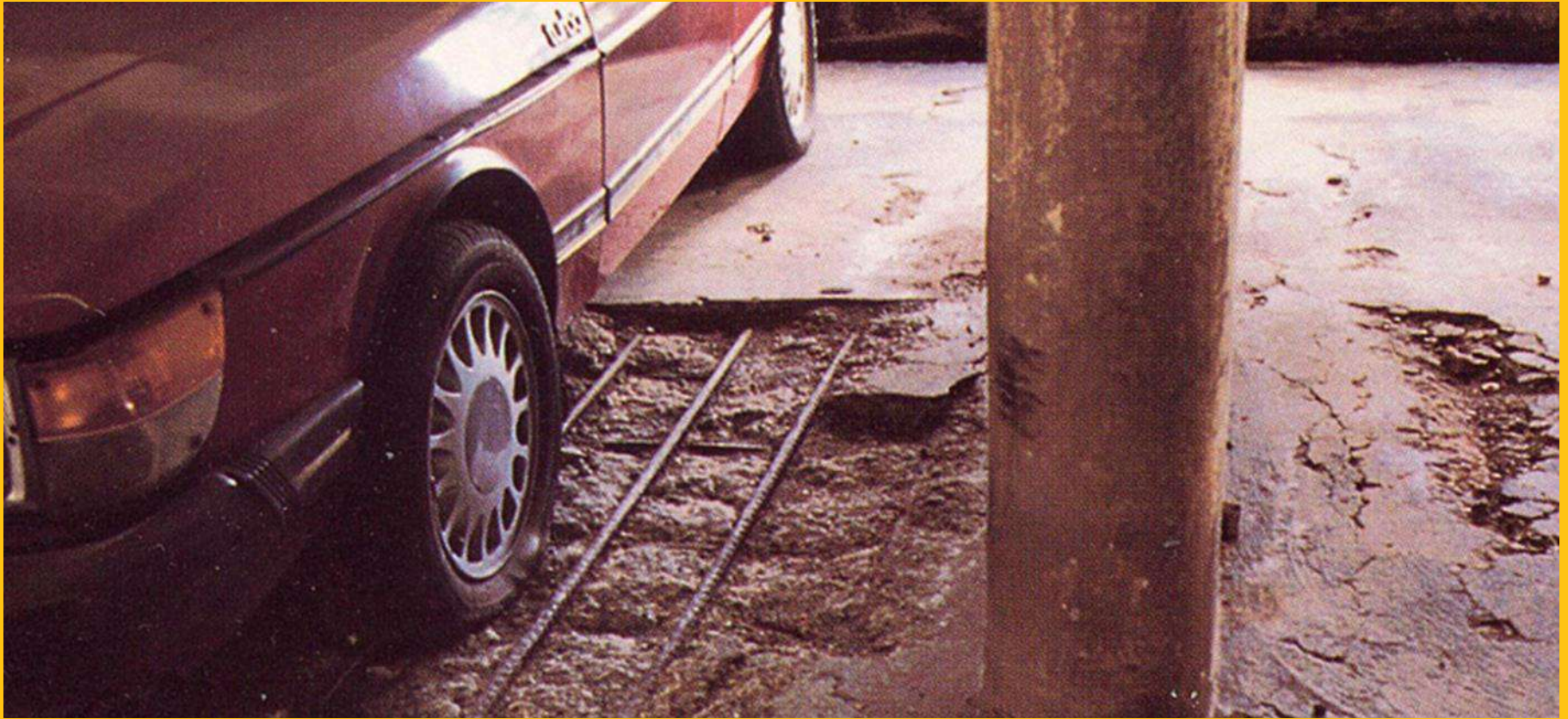
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AGENDA – CONCRETE REPAIR (SPALL REPAIR)

- Brief review
 - Root causes of deterioration
 - Conducting condition survey
 - Determining a repair and protection strategy
- Discuss available application methods
- Focus on material properties and benefits for proper selection





CAUSES OF DETERIORATION CONDITION SURVEY REPAIR AND PROTECTION STRATEGY

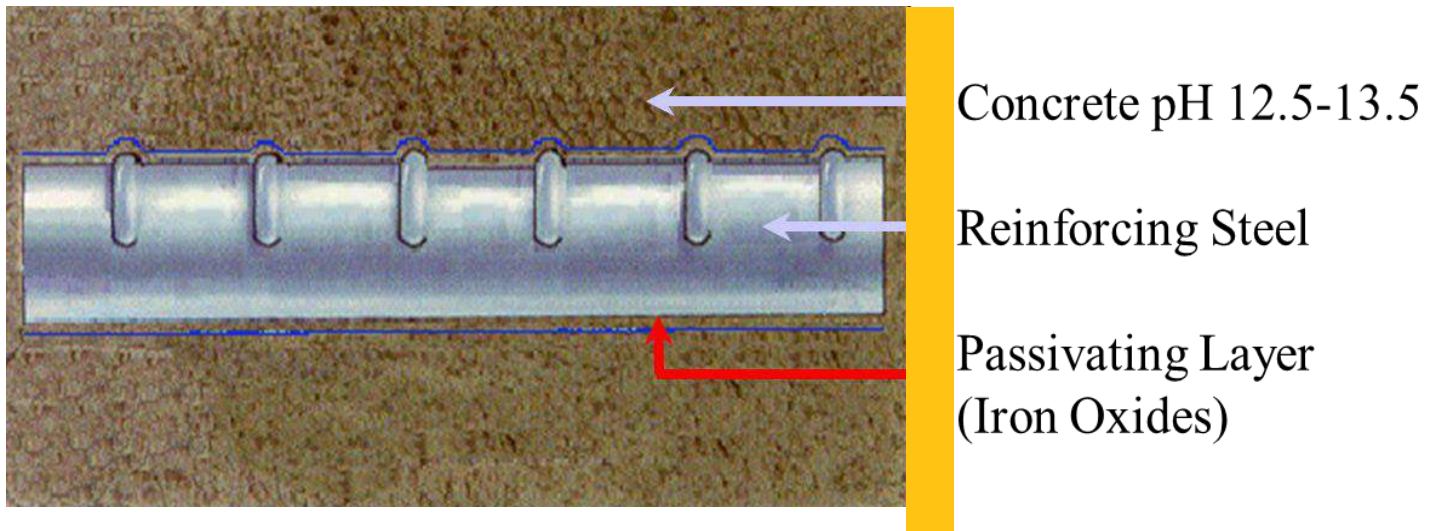
CAUSES OF CONCRETE DETERIORATION

- Impact
- Abrasion
- Freeze/thaw cycles
- Chemicals/sulfates
- Biological (micro-organisms)
- Reactive aggregates (ASR)
- Dissimilar metals
- **Steel reinforcement corrosion**



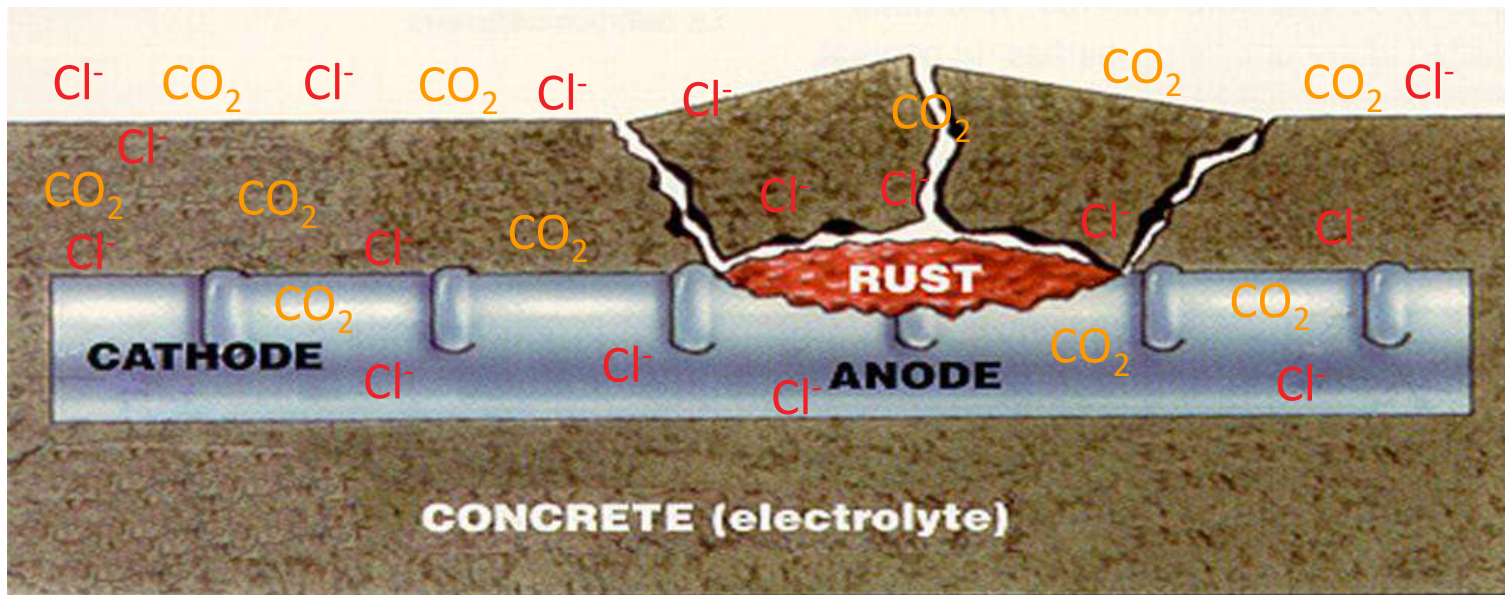
STEEL REINFORCED CONCRETE

- Concrete and steel are compatible
- Steel is passivated in concrete
- Alkaline environment protects steel from corrosion despite moisture and oxygen



ROOT CAUSES OF REINFORCEMENT CORROSION

- Chlorides and carbonation destroy the passivating layer
- As steel corrodes it expands causing cracking and spalling of the concrete



UNDERSTANDING THE CONDITIONS

Learn the condition of the concrete

- Strengths
- Air entrainment
- Chloride content
- Carbonation depth
- Reactive aggregates

Evaluate the status of the steel

- Depth of cover
- Contaminated or non-contaminated environment

Quantify the existing damage

- Identify spalls and delaminations

Predict the latent/future damage

- Determine benefit of protection



SELECTING A REPAIR AND PROTECTION STRATEGY

Now that we know the conditions, we can design a solution to best meet the project requirements

Basic approach

- Remove the unsound concrete
- Clean or replace the steel
- Coat the steel
- Repair the spalls
- Repair the cracks
- Treat the latent corrosion
- Apply protective sealers or coatings

Considerations

- Short or long term goals
- Safety and liability
- Cover over reinforcement
- Reinforcement in contamination
- Service conditions
- Aesthetics
- Budget



CONCRETE REPAIR

CONCRETE REPAIR

- Choose method of application
- Select repair materials
 - Reinforcement coating
 - Bonding agent
 - Repair mortar/concrete
- Prepare substrate and reinforcement
- Install the repair materials



APPLICATION METHODS

Trowel

- Smaller areas
- Shallower repairs

Form and pour

- Larger volumes
- Easy to pour and enter formwork

Form and pump

- More difficult access to formwork
- Need to move material from source through line to formwork
- Soffit repairs

Spray (wet/dry, high/low pressure)

- Large volume of vertical or overhead
- Often large area but not so deep

(All methods effective when performed properly)

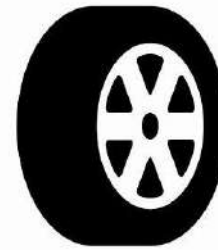


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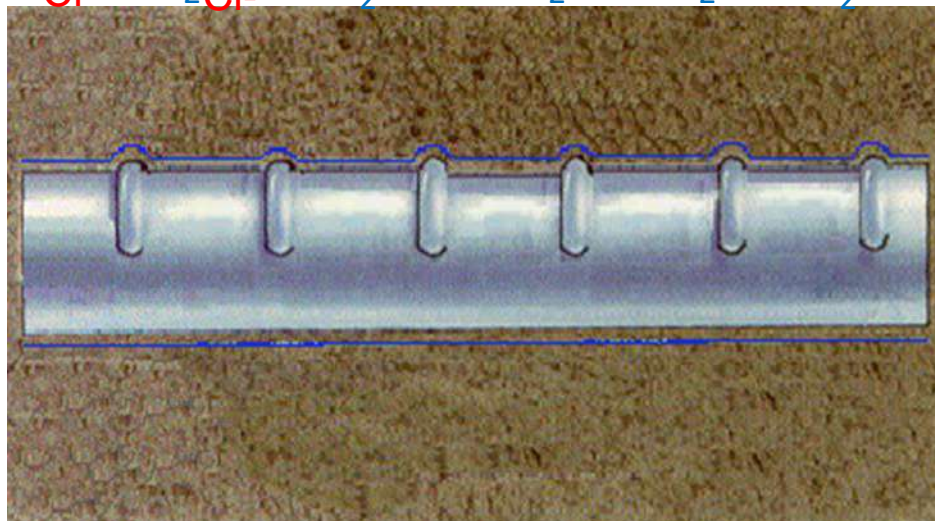
SELECTING THE REPAIR MATERIALS

- Resist the causes of damage, perform in the environment
- Meet time constraints
- Consider the role in the overall repair and protection strategy
- Allow for most productive installation



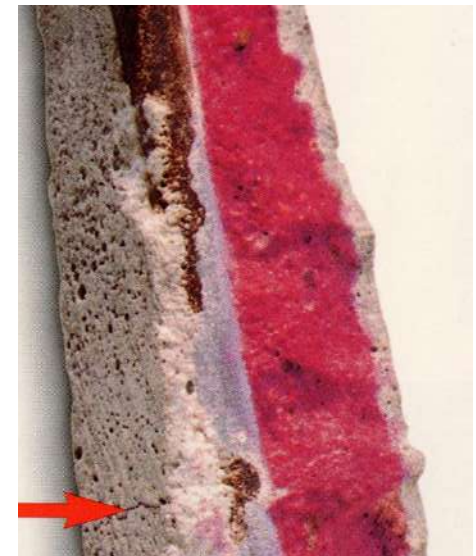
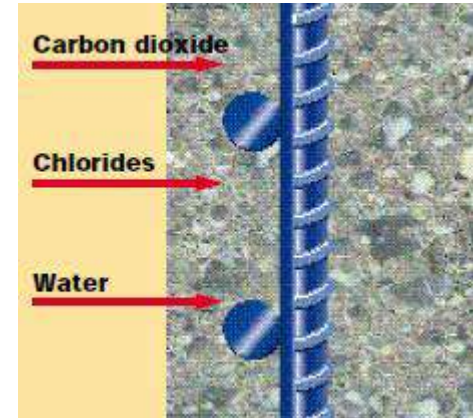
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Available
Cover



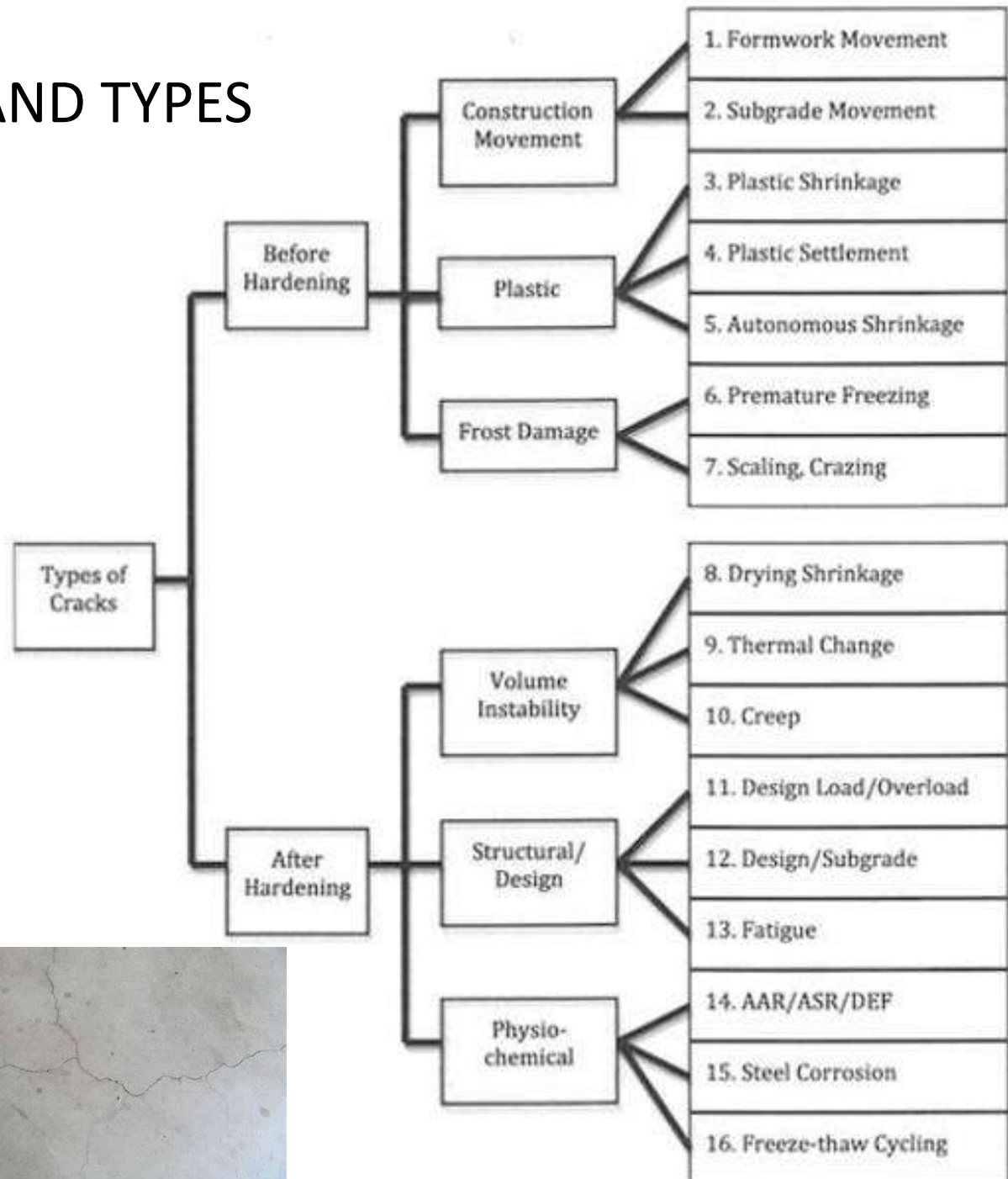
FACTORS INFLUENCING LONGEVITY OF REPAIR MATERIAL

- Cracks in (and around) repair material allow quickest access of chlorides and carbonation to reach reinforcement
- Permeability of repair material determines rate of chloride and carbonation penetration through repair material to reach reinforcement
- Reinforcement coating provides substantial layer of additional corrosion protection
- Functioning corrosion inhibitor offers last line of defense against corrosion of reinforcement in and around repair material
- Compatibility of repair material with parent concrete required for long term performance
- Freeze/thaw resistance of repair material determines durability against surface deterioration in that exposure
- Strengths of repair material must meet the application criteria



CRACK CONCERNS AND TYPES

- Unsightly
- Leakage
(ACI 224.R.72 Guideline maximum allowable width for water retaining structures is 4 mils)
- Structural
- Widen
- Corrosion
(ACI 224.R.72 Guideline maximum allowable width for exposure to deicing chemicals is 7 mils)



[Sheet of 20# paper is 4 mils thick]



COMMON CRACKING IN CONCRETE REPAIR

Design - Reflective Cracking

- Installing repair material over a crack or joint in the substrate will result in the crack propagating through repair material



- Completely chip out cracks during surface preparation
- Epoxy inject the cracks
- Honor existing joints, create joints



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COMMON CRACKING IN CONCRETE REPAIR

Design - Stress Cracking

- Weak points increase likelihood of cracking such as at re-entrant corners and around penetrations

Avoid

- Try to design around (core later)
- Select low shrinkage repair material
- Respect the mix
- Honor material limitations
- Use finishing aid
- Cure



COMMON CRACKING IN CONCRETE REPAIR

Design - Stress Cracking

- Poor geometrics



Avoid

- Create rectangular repairs (up to 2:1)
- Select low shrinkage repair material
- Respect the mix
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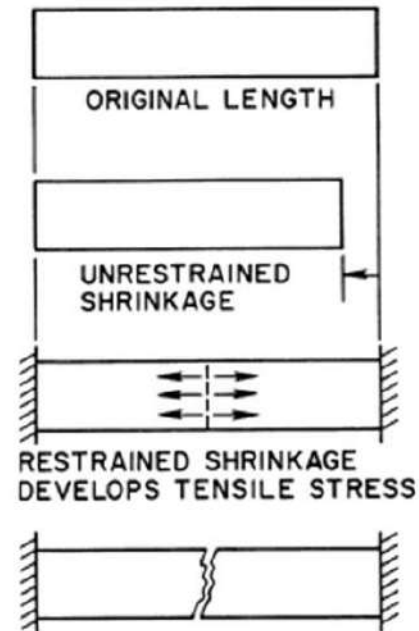
COMMON CRACKING IN CONCRETE REPAIR

Shrinkage cracking

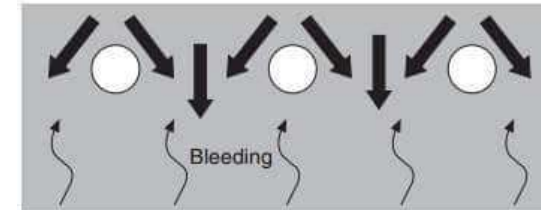
- A race between developing tensile strength versus shrinkage stress
- Shrinkage stress comes from volume decrease as water evaporates



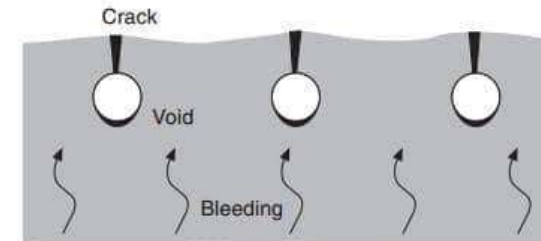
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IF TENSILE STRESS IS GREATER THAN TENSILE STRENGTH, CONCRETE CRACKS

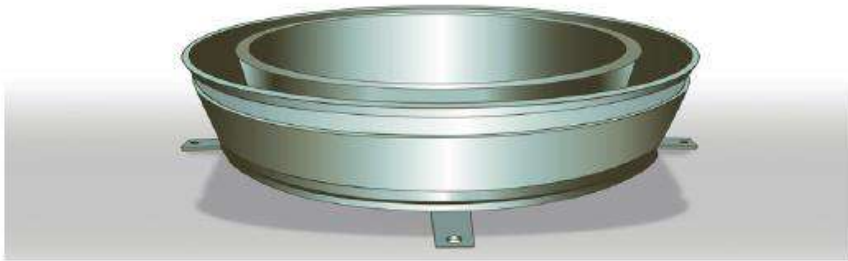


(a) Initiation

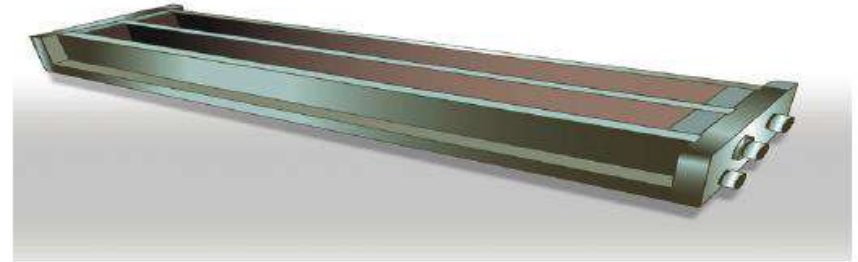


(b) After a few hours

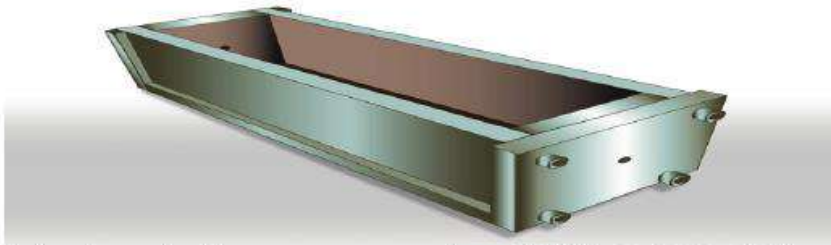
SHRINKAGE TESTING



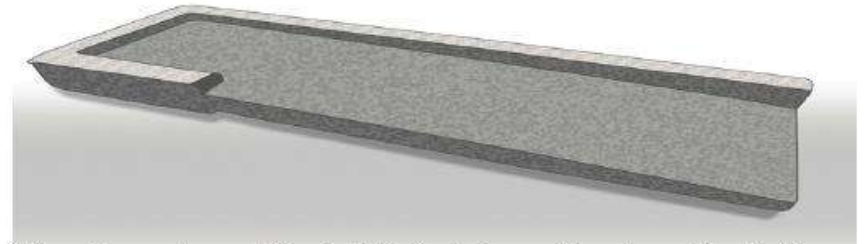
(a) ASTM C 1581/C 1581M: Ring shaped specimens used for determining age at cracking and induced tensile stress of mortar and concrete under restrained shrinkage



(b) Length change measured per ASTM C 157/C 157M modified in ICRI TDS Protocol using 3" X 3" X 11 1/4" mold



(c) Length change measured per ASTM C 157/C 157M modified in ICRI TDS Protocol using 1" X 1" X 11 1/4" mold



(d) Baenzinger Block: Sika's internal test method. Also confirmed as the optimal geometry for evaluating the sensitivity of a repair material to cracking in an independent study by the U.S. Department of the Interior, Bureau of Reclamation.

MIX WATER VERSUS WATER FOR HYDRATION

Common mix water of 8 pints



- Polycarboxylate superplasticizer replaces water used for workability

Mix water of 6.5 pints
19% reduction



Mix water of 4.5 pints
44% reduction



FINISHING AID

- Use instead of finishing water
- Slickens better
- Reduces moisture loss and crusting
- Repair materials often stickier and set faster
- Very economical
- Remove before coating or sealing



CURING

- Start curing as soon as possible after applying finish
- Objective is to keep moisture in the repair material
- Burlap needs to remain wet
- Soakers and misters can be used
- Polyethylene needs to lay flat
- Burlene needs to lay flat



CURING

- Keep curing until at least 75% of design strength is reached
- Vertical surfaces are hard to keep in contact with burlap
- Forms can prevent moisture loss



CURING

- Curing compounds meeting ASTM C-309 are effective
- Use water based curing compounds with materials containing polymers
- Curing compounds need to be removed before applying coatings and sealants



COMMON CRACKING IN CONCRETE REPAIR

Perimeter Separation

- Cement has weak bond to smoother saw cut surface profile (usually ½" deep)



- Select low shrinkage repair material
- Respect the mix
- Honor material limitations
- Use finishing aid
- Cure
- **Tool and seal perimeter**
- Use epoxy bonding agent



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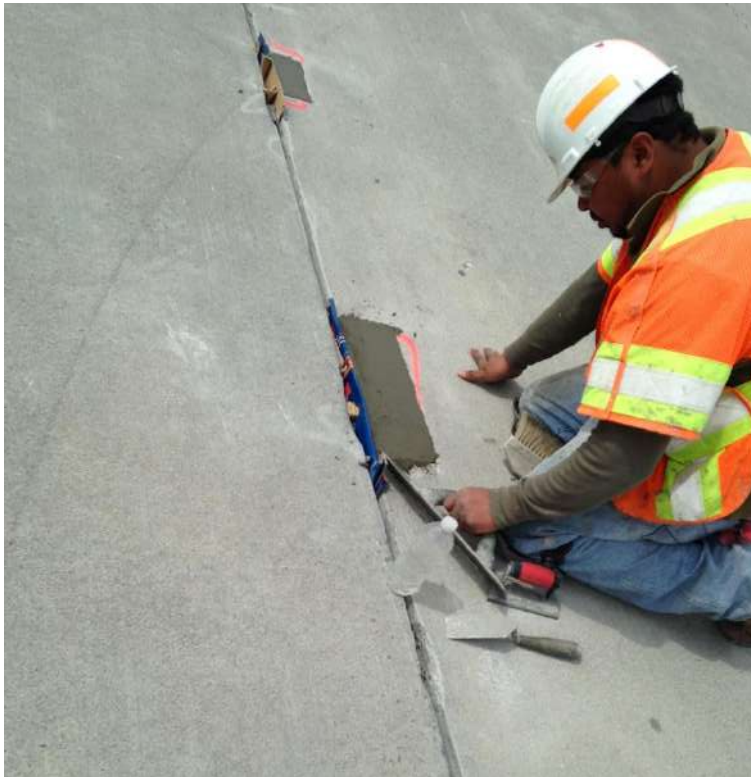
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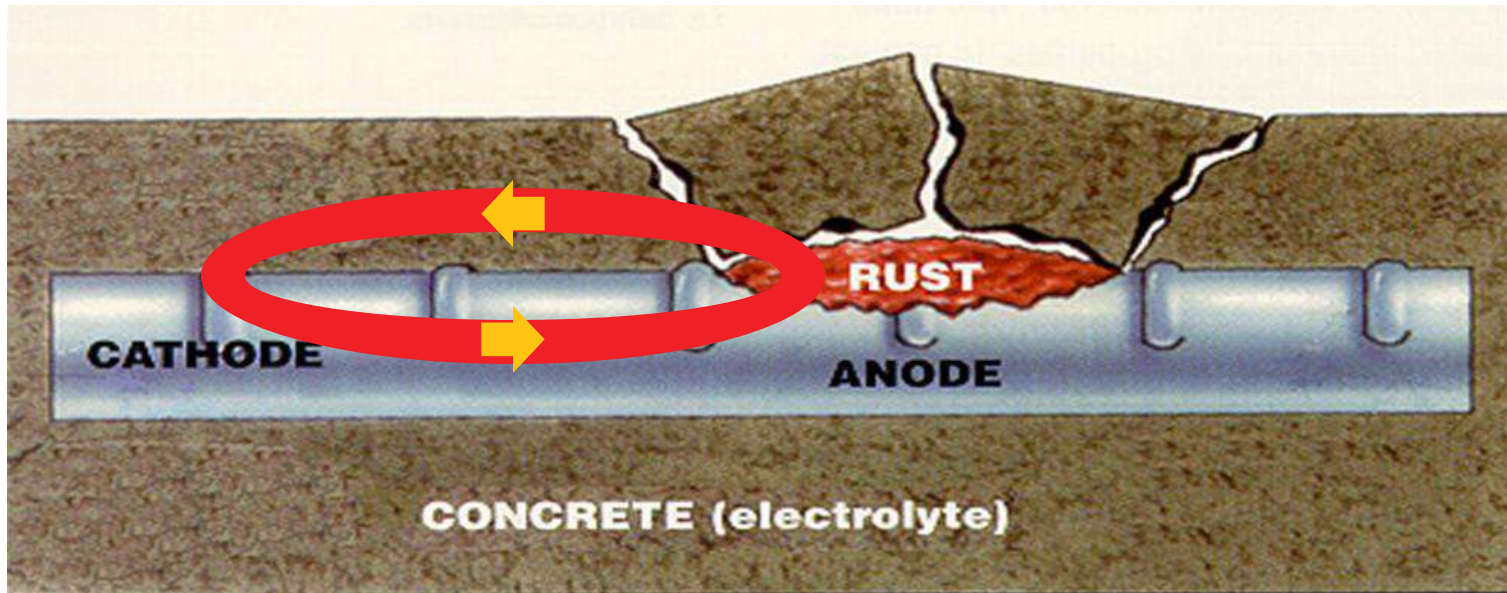


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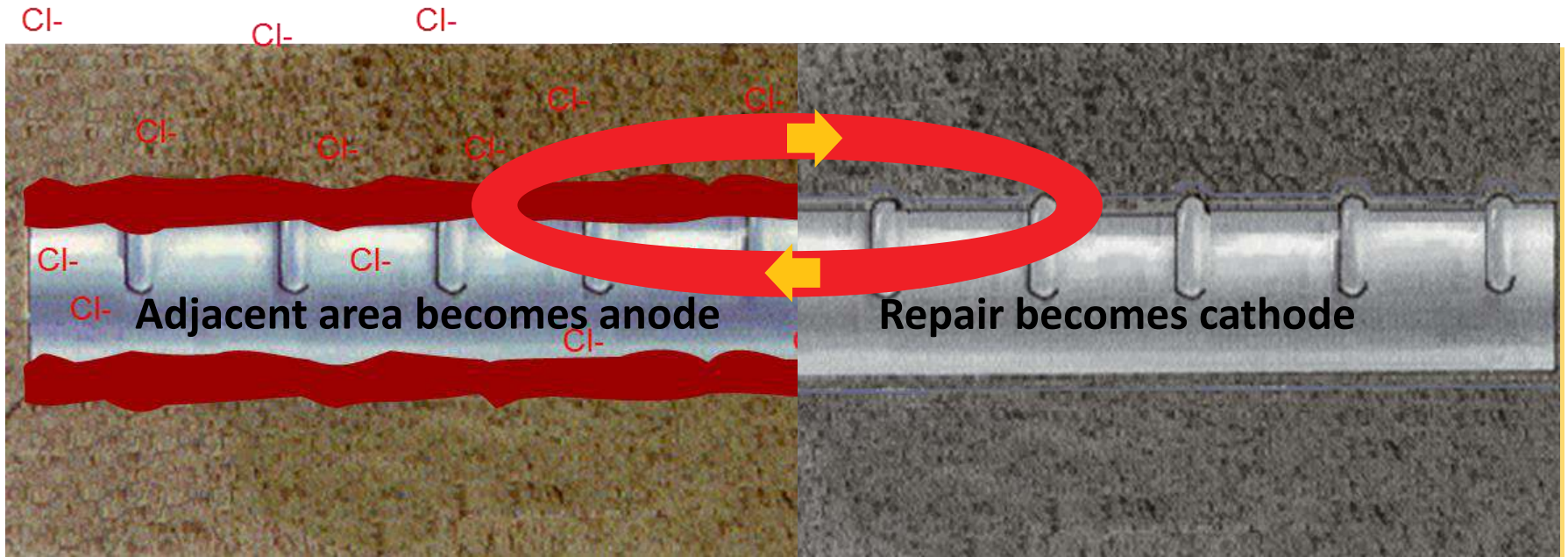
CORROSION PROCESS

- Current flows between cathode and anode through steel and concrete
- Electrical current flow is governed by Ohm's Law
- $V = IR$ Potential Difference (V) = Current (I) x Resistance (R)
- $V = IR$ Current (I) is the concern
- $I = V/R$ Current (I) = Potential Difference (V) / Resistance (R)
- To lower Current (I), increase Resistance (R)



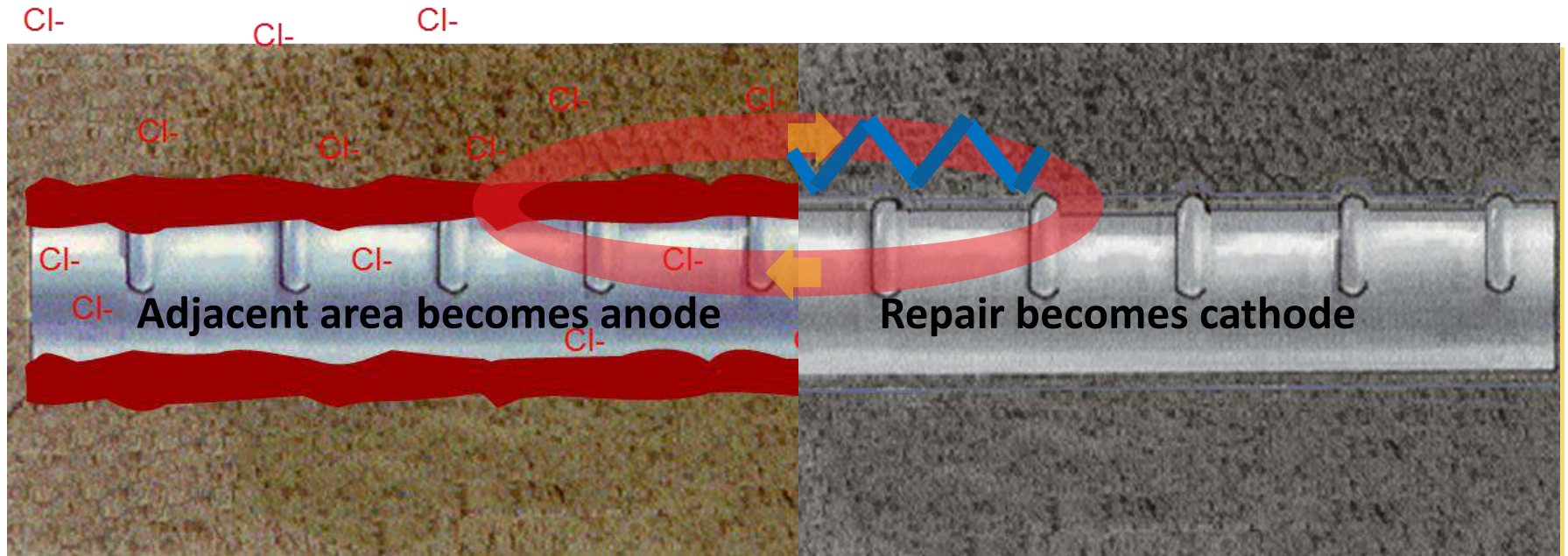
RESISTANCE OF REPAIR MATERIALS

- Resistance (Permeability) of repair materials is measured in coulombs
- Typical concrete about 3,000 – 4,000 coulombs (moderate)
- A repair turns the anode to a cathode
- Increased corrosion activity around perimeter of repair referred to as ‘incipient anode’, ‘anodic ring effect’, or ‘halo effect’



RESISTANCE OF REPAIR MATERIALS

- Increase resistance using a higher resistant (lower permeability) repair material
- Repair materials available with < 500 coulombs (very low)
- 6 times better resistance than moderate permeability repair materials to currents and intrusion of chlorides and carbonation



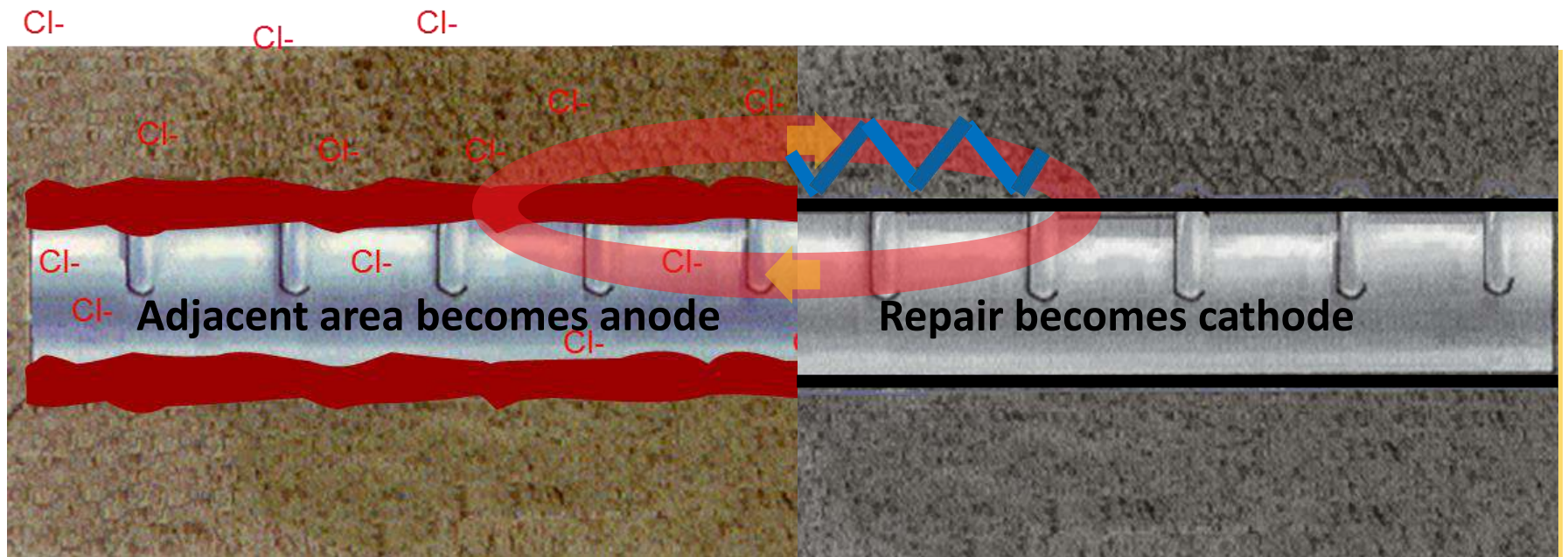
REINFORCEMENT COATING

- This epoxy coated rebar was investigated after 30 years, revealing protective value
- Using epoxy coated rebar on top mat of garage decks and uncoated rebar on bottom mat, has resulted in corrosion and spalling on the underside where chloride content is lower



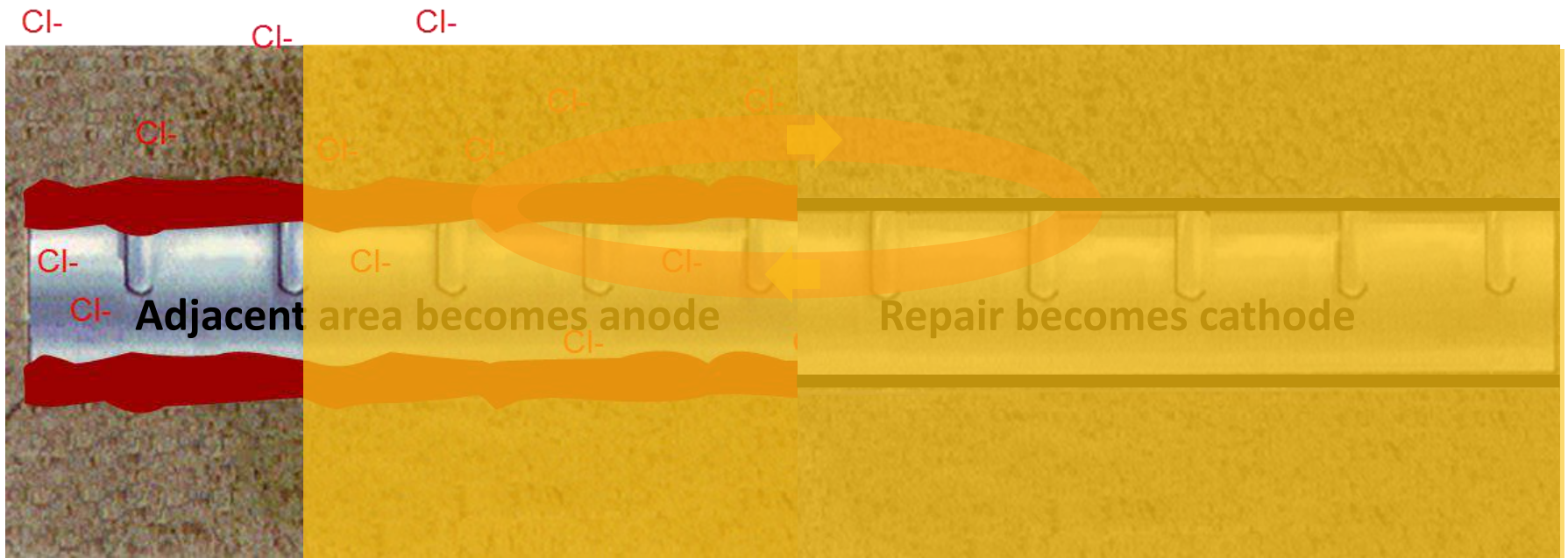
REINFORCEMENT COATING

- Reinforcement coatings add substantially more barrier properties and resistance
- Epoxy, epoxy-cement, enhanced-cement, and zinc-rich materials



INTEGRAL CORROSION INHIBITOR

- Integral corrosion inhibitor protects within the repair and migrates inches outside repair to reduce incipient anode corrosion (amino alcohol)
- Corrosion inhibitor electrochemically bonds to steel surface and excess remains in concrete to replenish itself



COMPATIBILITY WITH PARENT CONCRETE

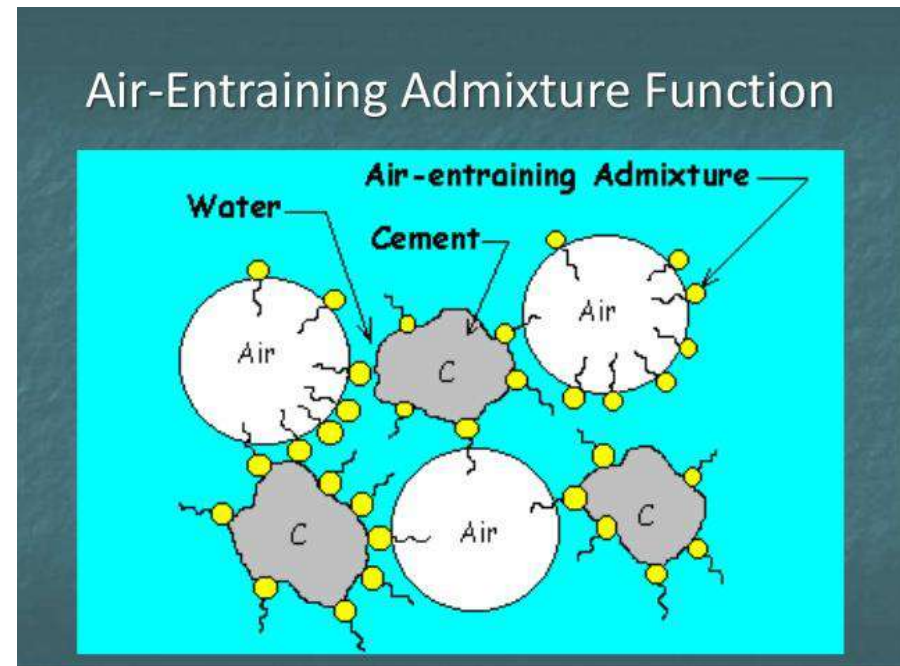
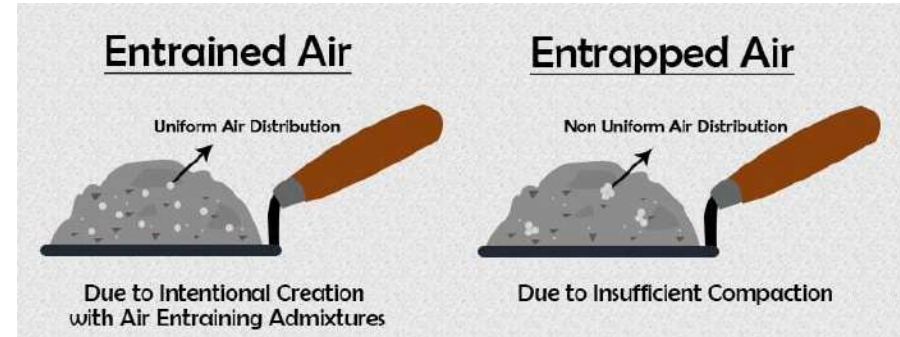
- If mix is chiefly Portland cement and silica aggregates, then it will be thermally compatible
- Low modulus epoxy mortars are acceptably compatible up to ½” depth
- Neat epoxy and high modulus resins generally acceptable up to ¼” depth
- Interior/temperature stable environments would allow for deep epoxy mortar/concrete repairs
- Repair material can have higher compressive strength than parent concrete while having lower modulus of elasticity (latex polymer)



Material	Compressive	Elastic Modulus
Concrete	4,500 psi	4×10^6
SikaTop 111 PLUS	6,500 psi	3×10^6
Sikadur 22 Lo-Mod mortar	7,900 psi	6.6×10^4

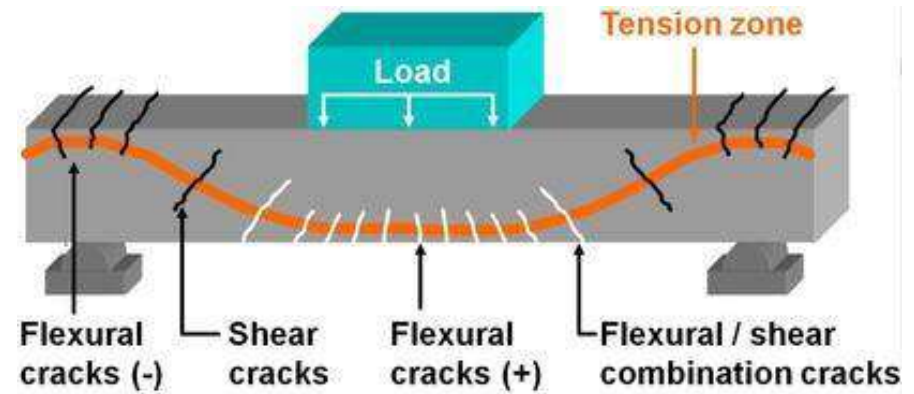
FREEZE/THAW RESISTANCE

- Air entrainment (usually 4-7%) provides tiny voids (where liquid water does not enter) around pores where liquid water does enter. When the water freezes in the pores, it can expand into the air entrainment voids.
- Air entrainment can be worked out of surface from excess finishing
- Mortars inherently have more air entrainment than concretes
- Air entrainment is very good indicator of freeze/thaw resistance, but actual freeze/thaw testing is the best
- Polymer modification can greatly improve freeze/thaw resistance by reducing water absorption



STRENGTHS

- Select materials with appropriate adhesion and physical properties for the application
- Generally, similar or higher strengths than parent concrete



REPAIR MATERIAL SELECTION

Application	Premium Performance	High/Speed Performance	Quality Performance
Vertical/Overhead Trowel Mortar	SikaTop 123 PLUS SikaRepair 224	SikaQuick VOH	SikaRepair 223
Pour/Pump Concrete	Sikacrete 211 SCC Plus	Sikacrete 421 CI Rapid	Sikacrete 100 CI Sikacrete 211
Pour/Pump Mortar (3/8" gravel can be added)	SikaTop 122 PLUS SikaTop 111 PLUS Sikadur 43 Patch-Pak	SikaQuick 2500 SikaQuick 1000 SikaQuick FNP	SikaRepair 222 SikaGrout 328
Leveling Mortar	SikaTop 121 PLUS SikaTop 122 PLUS Sikadur 22 Lo-Mod	SikaQuick Smooth Finish SikaQuick Resurfacer SikaQuick EZ Patch	SikaRepair SHB SikaRepair 222
Coating Mortar	SikaTop Seal 107	Sikagard FlexCoat	SikaTop 144
Spray Apply Mortar	Sikacem 133 SikaRepair 224	Sigunit L72 AF	Sikacem 103 Sikacem 103F
Grout	SikaGrout 328 SikaGrout 528 SF Sikadur 42 GP/PT/LE	SikaGrout 428 SikaSet Plug	SikaGrout 212
Underlayment	SikaLevel 325	SikaLevel 325	SikaLevel 125

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PERFORMANCE ANALYSIS

Property	SikaTop 123 PLUS	SikaQuick VOH	SikaRepair 223
Components	2	1	1
Compressive 28 day	7,000 psi	5,500 psi	7,500 psi
Polymer	Yes - liquid	Yes - dry	No – optional liquid
Fibers	No	Yes	No
Permeability	<500 coulombs	< 1000	No data (3000-4000)
Corrosion Inhibitor	Yes – Data (>65%)	Yes – No data	No
Applied Thickness	1/8”-2” per lift	1/8”-3” per lift	1/4”-1.5” per lift
Shrinkage	<.05%	<.05%	No data
Overcoat Time	3 day	6 hour	5 day

PRICE AND VALUE ANALYSIS (EXAMPLE)

- Example of a typical 2” vertical trowel-applied repair assuming installed price without repair material to be \$50.00/SF.
- Corrosion resistance in equivalency to 3,000 coulomb concrete.

Property	SikaTop 123 Plus	SikaQuick VOH	SikaRepair 223
Price/SF at 2” Depth	\$16.03	\$6.31	\$5.41
Installed Price/SF	\$66.03	\$56.31	\$55.41
Corrosion Resistance	9 times more for 19% more money	3 times more for 2% more money	1
Value	Highest value	Better value	Lowest price

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Value	Highest value	Better value	Lowest price

- Consider the conditions and service environment
- Consider role in the project repair and protection strategy

SPECIFICATION DO'S & DON'TS – PREPACKAGED MATERIALS

DO SPECIFY PERTANENT PROPERTIES

- Strengths
 - (> 5,000 psi ... ASTM C-109)
- Shrinkage
 - (< .06% ... ASTM C-157)
- Permeability
 - (< 500 coulombs ... ASTM C-1202)
- Freeze/thaw resistance
 - (> 97% @300 cycles ... ASTM C-666)

DON'T SPECIFY A MIX DESIGN

- Water-cement ratio
- Aggregates
- Air entrainment
- Polymer modified
- Microsilica/Silica fume
- Water reducers/other admixtures
- Fibers

Prepackaged materials already have a specific mix design to deliver performance properties

AVAILABLE RELATED PRESENTATIONS

- Concrete Repair & Protection
- Concrete Repair (Part 1 – Materials)
- Concrete Repair (Part 2 – Installation)
- Crack Repair
- Concrete Protection



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Sustainability Award Winner

THANK YOU FOR YOUR ATTENTION!

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