



## A STUDY ON MECHANICAL AND DURABILITY PROPERTIES OF CONCRETE BY PARTIAL REPLACEMENT OF NATURAL ZEOLITE IN CEMENT

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**Abstract:-** In conventional concrete we want to gain more strength with the optimum materials. That's why here we are using zeolite in concrete for the replacement of cement which might absorbing CO<sub>2</sub>. Due to rapid change in metrology, deep minimizing emission will be required in coming decades. Global warming is controlled by the process of reducing greenhouse gases like CO<sub>2</sub>, HFC and Sulphur-di-oxide in atmosphere. Zeolite powder is good agent to absorb harmful gases. Natural zeolites form where volcanic rocks and ash layers react with alkaline groundwater. Zeolites also crystallize in post-depositional environments over periods ranging from thousands to millions of years in shallow marine basins. Concrete with zeolite as partial replacement material with mean ratio it absorbs harmful gases and gives high compressive strength, hence it is eco friendly.

In this project, concrete made with cement is partially replaced with zeolite and then compared with normal concrete. Here cement in concrete is partially replaced with the zeolite in the respective proportions such as 10%, 20%, 30%, and 40% and the specimens were casted and tested for their mechanical and durability properties.

**Keywords:** Zeolite, compressive strength, split tensile, Young's Modulus, Flexure Test, Rapid Chloride Permeability test, water permeability test.

### I. INTRODUCTION

Concrete is a composite material made out of coarse aggregate bonded together with a liquid cement that solidifies after some time. Most cements utilized are lime-based cements, for example, Portland cement concrete or cements made with other pressure driven concrete, for example, bond found. Be that as it may, black-top solid which is every now and again utilized for street surface, is likewise a kind of solid, where the bond material is bitumen, and polymer cements are now and again utilized where the establishing material is a polymer. At the point when aggregate is combined with dry Portland cement and water, the mixture frames liquid slurry that is effectively poured and formed into shape. The cement responds artificially with the water and different fixings to shape a hard network that binds the materials together into a strong stone-like material that has many employments. Regularly, added substances, (for example, pozzolons or super plastisizer) are incorporated into the blend to enhance the physical properties of the wet blend or the completed material. Most concrete is poured with reinforcing materials implanted to give rigidity, yielding reinforced concrete.

Zeolites happen actually but at the same time are created modernly on a substantial scale. As of September 2016, 232 one of a kind zeolite systems have been famed, and more than 40 normally happening zeolite structures are known. Each new zeolite structure that is gotten must be endorsed by the International Zeolite Association Structure Commission and gets a three letter assignment. Common zeolites frame where volcanic shakes and fiery debris layers respond with antacid groundwater. Zeolites additionally take shape in post-depositional conditions over periods extending from thousands to a large number of years in shallow marine bowls. Normally happening zeolites are once in a while immaculate and are sullied to changing degrees by different minerals, metals, quartz, or different zeolites. Thus, normally happening zeolites are rejected from numerous imperative business applications where consistency and immaculateness are fundamental.

Zeolites are the aluminates individuals from the group of smaller scale permeable solids known as "sub-atomic strainers" for the most part comprising of Si, Al, O, and metals including Ti, Sn, Zn, et cetera. The term sub-atomic sieve refers to a specific property of these materials, i.e., the capacity to specifically sort particles construct basically in light of a size prohibition prepare. This is because of an exceptionally standard pore structure of sub-atomic measurements. The most extreme size of the sub-atomic or ionic species that can enter the pores of a zeolite is controlled by the measurements of the channels. These are expectedly characterized by the ring size of the opening, where, for instance, the expression "8-ring" refers to a shut circle that is worked from eight tetrahedral composed silicon (or aluminum)

particles and 8 oxygen atoms. These rings are not generally perfectly symmetrical because of an assortment of impacts, including strain actuated by the bonding between units that are expected to create the general structure, or coordination of a portion of the oxygen molecules of the rings to cations inside the structure. Hence, the pores in numerous zeolites are not cylindrical

## II. Literature Review

**Jonie Tanijaya(2008)** Direct use of natural zeolites as partial replacement for ordinary Portland cement in concrete up to 10% by mass did not improve the concrete compressive strength. In fact, the compressive strength decreased with the increase of natural zeolites content. The incorporation of natural zeolites in concrete tends to reduce the slump value of fresh concrete due to its cubical particle shape and rough surface. Due to smaller specific gravity of natural zeolites compared to ordinary Portland cement, the specific gravity of concrete incorporating zeolites slightly reduced. As in the case of concrete without natural zeolites, the tensile splitting strength and the modulus of elasticity of concrete with zeolites are function of its compressive strength. Thus, concrete with zeolites possesses lower tensile splitting strength and modulus elasticity.

**E.Vejmelkoval (2012)** Experimental results presented in this paper showed that natural zeolite can be considered an environmental friendly binder with a potential to replace a part of Portland cement in concrete in building industry. However, although it would be desirable from both environmental and economical points of view to use its highest possible amounts in concrete production, the extent of Portland cement replacement which could be chosen in preparation of high performance concrete mixes was found to have relatively strict limitations. The resistance against de-icing salts appeared as the main limiting parameter; even the mix with the lowest zeolite content of 10% did not meet the criteria of the ČSN 731326/Z1:1984 standard. Therefore, this type of concrete should not be used in such cases where de-icing salts are likely to act during its service life. The limitations related to other parameters were not so strict. The mechanical and liquid water transport parameters were satisfactory up to the 20% replacement level, the water vapour transport parameters, water storage parameters and thermal parameters were acceptable for all studied mixes. Summarizing the above results, it can be concluded that the replacement of Portland cement by natural zeolite in the amount of 20% by mass can be considered the most suitable option among the studied mixes.

**Ali Akbar Ramezaniapour (2013)** self-consolidating concrete with low portland cement and a minimum 28-day compressive strength of 30 MPa can be produced by partial replacement (10–25%) of portland cement with NZ and application of a dense-packing concept.

The mixtures with NZ replacement levels of 10–25% satisfied the flow ability, passing ability, and stability criteria of EFNARC (2002). Therefore, by using NZ, SCC mixtures containing total cementitious materials of 350 kg/m<sup>3</sup> could be produced. However, a SCC mixture without any NZ incorporation could not be achieved because of substantial bleeding. The fresh test results demonstrate that using higher percentages of NZ results in higher demand for HRWRA to maintain the required flow ability. Considering the fresh test results, it was shown that using NZ leads to high viscosity, which provides the required stability and high segregation resistance needed for SCC mixtures.

Considering compressive strength results at different ages (up to 270 days), NZ replacement increases the compressive strength at ages greater than 28 days. Furthermore, the highest strength values at later ages were achieved by the Z10 mixture, which reached 60 MPa after 270 days of curing, whereas 48 MPa was measured for NC - CTRL mixture at the same age. According to ASTM C1202 and FM 5-578 (FDOT 2004), the permeability classes of all the NZ-incorporated mixtures were rated as low or very low at the age of 90 days, whereas the permeability class of the control mixture was moderate at this age. Considering RCPT and electrical resistivity test results, it can be concluded that NZ incorporation could enhance the durability performance of SCC mixtures, which is intensified at higher replacement levels.

**Ali Akbar Ramezaniapour (2014)** In general, the use of zeolite decreases slumps of concrete, so a super plasticizer is needed. The addition of zeolite delays the strength development during the first 28 days, after that age concretes having up to 10% zeolite provide competitive compressive strength with PC concrete. With increasing w/c ratio, the growth rate of compressive strength decrease at early ages and increase by the time. Less water absorption and water permeability was observed in the concretes containing up to 15% zeolite. The substitution of cement with 15% natural zeolite reduced the chloride penetration of concrete mixtures according to the RCPT test. The rate of reduction increase with increasing w/c ratio. The electrical resistivity of concrete samples containing zeolite increased 2 to 4 times compared to control samples. Adding higher percentages of zeolite to cement produces high electrical resistivity. The addition of zeolite up to 15 % in concretes with W/C = 0.5 delays higher electrical resistivity and lower passing charge in RCPT test, compared PC concretes with W/C = 0.35, so the addition of zeolite is more effective than the reduction of w/c ratio. The performance of concrete with cement replacement by zeolite is considerable in RCPT and electrical resistivity test which are in many cases the most important characteristic concerning durability and corrosion prevention. The depth of carbonation increases with increasing zeolite replacement.

**H. Eskandaria (2015)** The compressive strengths of concretes containing additives were lower than the concrete without supplementary replacement at all ages. However, the percentages of reduction were lower for high ageing times, which can be attributed to lump in transition zone. Decrease rate of tensile strength is less than compressive strength in all ages. Also effectiveness of additives on strengths for mixtures with 0.45 W/C is less than 0.4 W/C, probably because of the lack of water, strength have been decreased.

The optimized mixture for achieving high quality of durability is incorporation of 2% nano silica and 8% micro zeolite. The concrete contained 8% micro zeolite has high resistance for penetration chloride ion.

**M. Sedlmajer (2015)** some properties of concrete in which cement was substituted by a natural raw material, i.e. finely milled zeolite (clinoptilolite) with substitution of up to 30% of the mass of the cement. The use of zeolite in concrete as a partial cement substitute appears to be appropriate. Zeolite as a silicate material is entirely compatible with other concrete components. Given the structure of zeolite, one must bear in mind the need for a greater content of water in the mixture which is also visible in the composition of the concretes. If the composition of concrete with the original water content is kept, e.g. by a change or a greater amount of the plasticizing agent, very good properties can be attained even at higher content of zeolite while decreasing the need of Portland cement. Worse mechanical properties with a higher portion of zeolite are believed to be due to the greater content of water in the mixtures. Another possible option could be to adapt the granulometry of the zeolite being used, especially as far as very fine grades are concerned. This step could lead to the reduction of the amount of water necessary in the concrete production.

When substituting cement with zeolite by up to 22%, after 90 and 360 days of curing compressive strength values were reached comparable to those of the concrete with Portland cement only. A smaller amount of Portland cement and the use of zeolite can thus result in similar properties as those of concretes with Portland cement only.

From this perspective, zeolite can be considered an active admixture which over time contributes to the formation of microstructure and to the improvement of required resulting properties of hardened concrete. For this reason, finely milled natural zeolite appears to be a suitable raw material in the production of concrete with which it is possible to partially substitute Portland cement.

**V. Praveen Kumar (2016)** In zeolite mixed concrete gives the grade of M30 concrete strength in the proportion of M20 concrete mix. In both substitution of 10% & 30% of zeolite in concrete brings similar compressive strength. To reduce the cost of construction to use 10 % of zeolite is preferable.

**Ehsan Mohseni(2017)** Concrete containing 15% tuff and 10% zeolite showed the highest compressive strength. Replacement of cement by zeolite substantially decreased the water absorption. However, in concrete samples with tuff as sand replacement, considerable absorption was not observed. The chloride diffusion coefficient of the control specimen diminished by up to 55% in T15Z10 sample. Thus, it is identified that the chloride resistance of the specimens was significantly enhanced by the use of tuff and zeolite.

The compressive strength reduction of concrete samples in sulphuric acid after 236 days of immersion varied between 9.2% and 15.7% in tuff-included samples and also 13.07% and 21.4% in tuff- and zeolite-included samples, however the strength reduction of plain concrete sample was 5.01%. The highest mass loss of 4.8% was recorded for specimen 15T15Z after 180 days of exposure to hydrochloric acid.

### **III. Materials**

#### **A. Cement**

Cement is a binder material, which is used to bind the other material together. Ordinary Portland Cement of 53 grade manufactured by Zuari company conforming ISO 50001:2011 is used. The main benefit is the faster rate of development of strength. The specific gravity of cement is 3.1 and fineness modulus is 225kg/m<sup>3</sup>

#### **B. Aggregates**

After cement, the aggregate is the basic material used in any concrete to comprise the body of concrete for increasing the strength to the material quantity, and to minimize the consequential volume change of concrete. The fine and coarse aggregates generally occupy 60% to 75% of concrete volume and strongly influence the concrete freshly mixed and hardened properties, mixture proportions and economy.

##### **1. Coarse aggregates:**

In this research investigation crushed graded aggregate of 20mm size was used. The specific gravity of coarse aggregate is 2.74

##### **2. Fine aggregates**

The quantity of the fine aggregate important is main to fill the voids present in coarse aggregate. In this research natural sand was used as fine aggregate. The specific gravity of sand is found to be 2.63.

#### **C. Zeolite**

Generally, reactive components of pozzolanic material such the same as silica fume, fly ash and natural pozzolans are glassy or amorphous. However, natural zeolites, which are crystalline, be able to act as pozzolanic materials. It has been ascertain to natural zeolite is a commendable complementary cementitious material. The huge amount of reactive  $\text{SiO}_2$  and  $\text{Al}_2\text{O}_3$  in zeolite chemically combines among the calcium hydroxide formed by the hydration of cement to form additional C-S-H gel and aluminates, resulting in the expansion of microstructure of hardened cement. Like other pozzolanic materials, replacement of cement by natural zeolite can improve the mechanical properties of cement and concrete composite.



**Figure 1. Zeolite Powder**

**Chemical composition of Natural Zeolite powder**

| Compound    | $\text{SiO}_2$ | $\text{Al}_2\text{O}_3$ | $\text{Fe}_2\text{O}_3$ | $\text{CaO}$ | $\text{MgO}$ | $\text{Na}_2\text{O}$ | $\text{K}_2\text{O}$ | $\text{SO}_3$ | $\text{P}_2\text{O}_5$ | $\text{CO}_2$ |
|-------------|----------------|-------------------------|-------------------------|--------------|--------------|-----------------------|----------------------|---------------|------------------------|---------------|
| Content %wt | 57.5           | 8                       | 2.65                    | 5            | 10.5         | 1.35                  | 0.2                  | 0.3           | 0.02                   | 1             |

## Experimental Procedure

### Mix proportions:

In this investigation  $M_{30}$  grade concrete used with a constant water/cement ratio of 0.5. Concrete specimens were prepared by varying the percentage of replacement of cement in concrete with zeolite (10%, 20%, 30%, 40%)

### Casting specimen

The specimens were casted for compressive strength of size 150mm x 150mm x 150mm cubes, split tensile strength and young's modulus of size 150mm diameter x 300 mm height cylinders, rapid chloride permeability test specimen size 100mm diameter X 50mm height and water permeability specimen size is 200mm diameter and 120mm height specimens are to be casted. For each test 3 specimens were casted and average value is calculated.

### Mix proportion for Normal concrete

The present study was carried out as per IS 10262-2009 for  $M_{30}$  grade concrete. The mix proportion of normal concrete is given below

| Mix | Cement<br>( $\text{kg/m}^3$ ) | Fine aggregate<br>( $\text{kg/m}^3$ ) | Coarse aggregate<br>( $\text{kg/m}^3$ ) | Water |
|-----|-------------------------------|---------------------------------------|---|-------|
| M30 | 362                           | 681.8                                 | 1196.1                                  | 181   |
| M30 | 1                             | 1.88                                  | 3.30                                    | 0.5   |

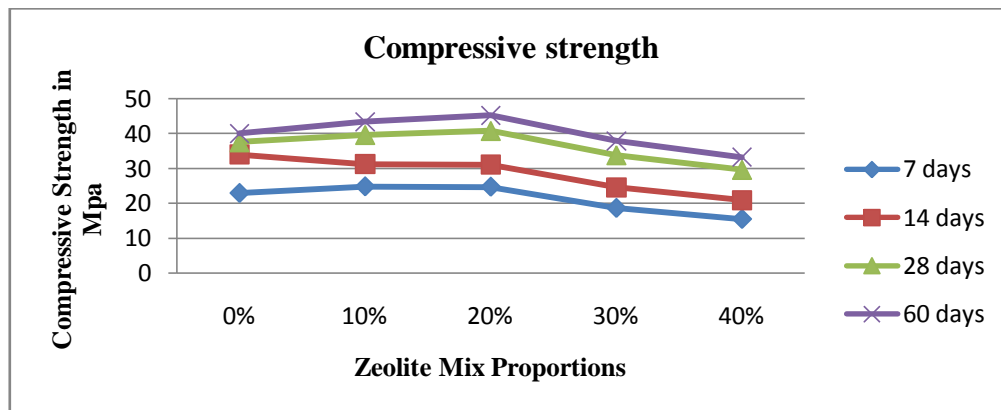
| Mix Designation | Proportion of Binding Materials |
|-----------------|---------------------------------|
| A1              | 100% cement                     |
| A2              | 90% cement + 10% zeolite        |
| A3              | 80% cement + 20% zeolite        |
| A4              | 70% cement + 30% zeolite        |
| A5              | 60% cement + 40% zeolite        |

#### IV. Experimental Results

##### Compressive Strength:

Results of M30 grade of OPC concrete with various proportions of Zeolite powder tested for compressive strength as shown in below. The compressive strength of concrete mixes by replacing OPC with Zeolite Powder of 10%, 20%, 30%, 40% are investigated. The results of compressive strength for these concrete mixtures tested at 7 days, 14 days, 28 days and 60 days are presented.

| Mix Proportions | Compressive strength N/mm <sup>2</sup> |         |         |          |
|-----------------|--|---------|---------|----------|
|                 | 7-Days                                 | 14-Days | 28-Days | 60 -Days |
| A1              | 22.9                                   | 34      | 37.5    | 39.96    |
| A2              | 24.8                                   | 31.2    | 39.6    | 43.37    |
| A3              | 24.7                                   | 31.1    | 40.75   | 45.21    |
| A4              | 18.6                                   | 24.6    | 33.8    | 37.84    |
| A5              | 15.43                                  | 20.89   | 29.6    | 33.18    |

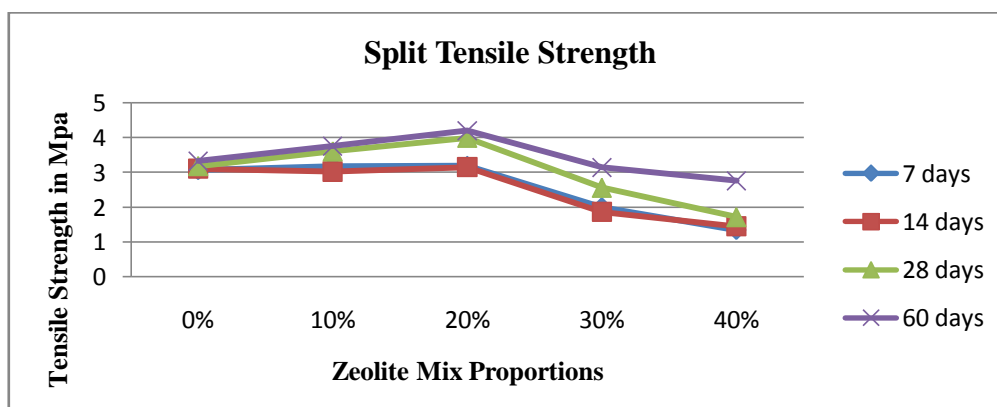


In this compressive strength at 28 days strength 10% zeolite replaced increased 5.30% strength, 20% of zeolite replaced in concrete increased 7.97% strength, adding 30% zeolite is added decreases strength of 10.9% and then 40% zeolite replaced decreased strength 26.6%. At 60 days strength 10% zeolite replaced increased 7.86% strength, 20% of zeolite replaced in concrete increased 11.97% strength, adding 30% zeolite is added decreases strength of 5.6% and then 40% zeolite replaced decreased strength 20.43% as compared to conventional concrete.

##### Split Tensile Strength:

The split tensile strength of concrete mixes by replacing OPC with Zeolite Powder of 10%, 20%, 30%, 40% are investigated. The results of split tensile strength for these concrete mixtures tested at 7 days, 14 days, 28 days and 60 days are presented.

| Mix Proportions | Tensile Strength N/mm <sup>2</sup> |         |         |          |
|-----------------|------------------------------------|---------|---------|----------|
|                 | 7-Days                             | 14-Days | 28-Days | 60 -Days |
| A1              | 3.07                               | 3.10    | 3.18    | 3.33     |
| A2              | 3.18                               | 3.02    | 3.60    | 3.76     |
| A3              | 3.19                               | 3.15    | 3.99    | 4.2      |
| A4              | 2.3                                | 1.86    | 2.56    | 3.15     |
| A5              | 1.34                               | 1.45    | 1.72    | 2.76     |



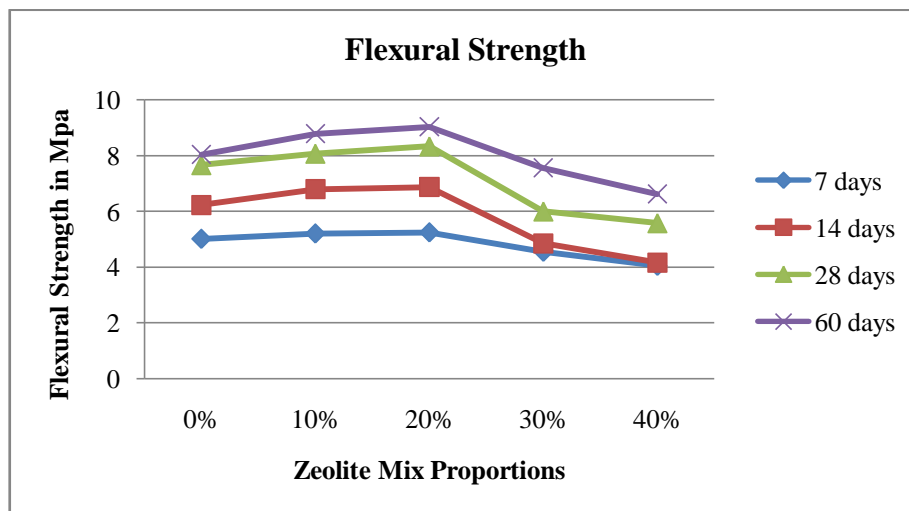


In this split Tensile strength at 28 days strength 10% zeolite replaced increased 11.66% strength, 20% of zeolite replaced in concrete increased 20.3% strength, adding 30% zeolite is added decreases strength of 19% and then 40% zeolite replaced decreased strength as 45%. At 60 days strength 10% zeolite replaced increased 11.43% strength, 20% of zeolite replaced in concrete increased 20% strength, adding 30% zeolite is added decreases strength of 5.40% and then 40% zeolite replaced decreased strength 17% as compared to conventional concrete.

### Flexure Test

The Flexure strength of concrete mixes by replacing OPC with Zeolite Powder of 10%, 20%, 30%, 40% are investigated. The results of Flexure strength for these concrete mixtures tested at 7 days, 14 days, 28 days and 60 days are presented.

| Mix Proportions | Flexure Strength N/mm <sup>2</sup> |         |         |          |
|-----------------|------------------------------------|---------|---------|----------|
|                 | 7-Days                             | 14-Days | 28-Days | 60 -Days |
| A1              | 5.02                               | 6.24    | 7.67    | 8.05     |
| A2              | 5.21                               | 6.8     | 8.08    | 8.8      |
| A3              | 5.25                               | 6.88    | 8.34    | 9.04     |
| A4              | 4.56                               | 4.86    | 6.01    | 7.56     |
| A5              | 4.06                               | 4.17    | 5.59    | 6.63     |

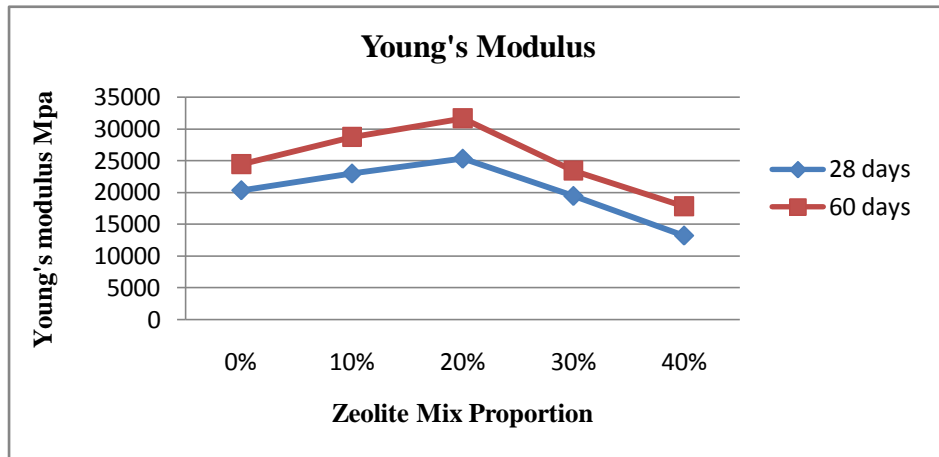


In this flexural strength at 28 days strength 10% zeolite replaced increased 5.07% strength, 20% of zeolite replaced in concrete increased 8% strength, adding 30% zeolite is added decreases strength of 21.64% and then 40% zeolite replaced decreased strength 37.20%. At 60 days strength 10% zeolite replaced increased 8.5% strength, 20% of zeolite replaced in concrete increased 10.95% strength, adding 30% zeolite is added decreases strength of 6.08% and then 40% zeolite replaced decreased strength 17.67% as compared to conventional concrete.

### Young's Modulus

The Young's Modulus test of M<sub>30</sub> grade of concrete by replaces in ordinary Portland cement with Natural zeolite like 10%, 20%, 30% and 40%. The results of Young's Modulus at 28 days and 60 days are presented.

| Mix Proportions | Young's Modulus at 28 days (Mpa) | Young's Modulus at 60 days (Mpa) |
|-----------------|----------------------------------|----------------------------------|
| A1              | 20347.2                          | 24416.64                         |
| A2              | 22986.1                          | 28732.62                         |
| A3              | 25325.4                          | 31656.75                         |
| A4              | 19444.4                          | 23468.30                         |
| A5              | 13194.4                          | 17812.44                         |

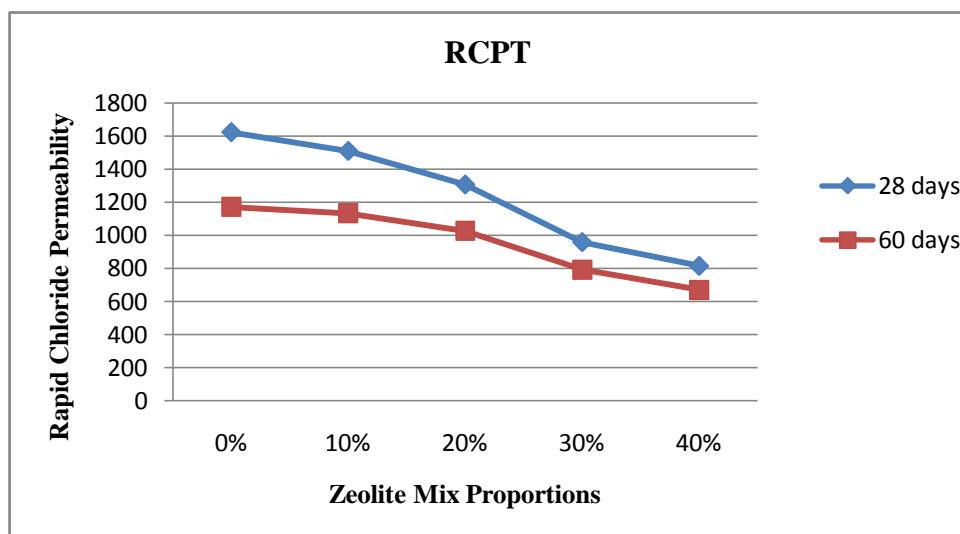


In this young's Modulus Test at 28 days strength 10% zeolite replaced increased 11.48% strength , 20% of zeolite replaced in concrete increased 19.6% strength, adding 30% zeolite is added decreases strength of 4.4% and then 40% zeolite replaced decreased strength 35%. At 60 days strength 10% zeolite replaced increased 15% strength , 20% of zeolite replaced in concrete increased 25% strength, adding 30% zeolite is added decreases strength of 3.88% and then 40% zeolite replaced decreased strength 27.04% as compared to conventional concrete.

#### Rapid Chloride Permeability Test

The Rapid Chloride Permeability test was used for determining the chloride penetration resistance ion of the concrete is prescribed by ASTM C1202. The test results of chloride ion permeability were given below.

| Mix Proportions | RCPT for 28 days (Mpa) | RCPT for 60 days (Mpa) |
|-----------------|------------------------|------------------------|
| A1              | 1622.7                 | 1171.8                 |
| A2              | 1509.5                 | 1131.7                 |
| A3              | 1306.8                 | 1027.3                 |
| A4              | 959.4                  | 792                    |
| A5              | 815.8                  | 669.15                 |

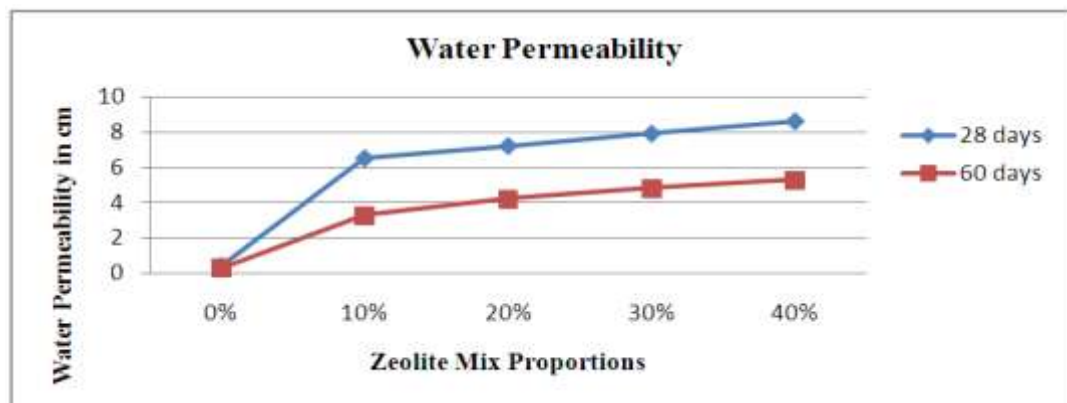


In this RCPT Test at 28 days strength 10% zeolite replaced decreased 6.97% strength , 20% of zeolite replaced in concrete decreased 7.67% strength, adding 30% zeolite is added decreases strength of 19.46% and then 40% zeolite replaced decreased strength 19.46%. At 60 days strength 10% zeolite replaced decreased 3.4% strength , 20% of zeolite replaced in concrete increased 12.3% strength, adding 30% zeolite is added decreases strength of 32% and then 40% zeolite replaced decreased strength 42% as compared to conventional concrete as compared to normal concrete.

## Water Permeability

The Water Permeability test of M<sub>30</sub> grade of concrete by replaces in ordinary Portland cement with Natural zeolite like 10%, 20%, 30% and 40%. The results of Water Permeability A1, A2, A3, A4, and A5 concrete mixtures tested at 28 days and 60 days the data are presented in the given below table and graphical presentation of Water Permeability.

| Mix Proportion | Depth of penetration (in cm) |         | Coefficient of permeability (K in m/sec) |                        |
|----------------|------------------------------|---------|--|------------------------|
|                | 28 days                      | 60 days | 28 days                                  | 60 days                |
| A1             | 0.4                          | 0.3     | $8.94 \times 10^{-11}$                   | $6.63 \times 10^{-14}$ |
| A2             | 6.5                          | 3.3     | $3.11 \times 10^{-11}$                   | $9.88 \times 10^{-13}$ |
| A3             | 7.2                          | 4.2     | $5.58 \times 10^{-12}$                   | $2.10 \times 10^{-12}$ |
| A4             | 7.9                          | 4.8     | $1.11 \times 10^{-11}$                   | $3.46 \times 10^{-12}$ |
| A5             | 8.6                          | 5.3     | $1.61 \times 10^{-11}$                   | $6.69 \times 10^{-12}$ |



In this water permeability test at 28 days strength 10% zeolite replaced decreased 0.55% strength, 20% of zeolite replaced in concrete decreased 0.91% strength, adding 30% zeolite is added decreases strength of 0.84% and then 40% zeolite replaced decreased strength 0.76%. At 60 days strength 10% zeolite replaced increased 0.57% strength, 20% of zeolite replaced in concrete increased 0.72% strength, adding 30% zeolite is added decreases strength of 0.41% and then 40% zeolite replaced decreased strength 0.63% as compared to conventional concrete.

## V. CONCLUSION

- In this investigation for M30 grade of concrete it can be calculated that the cement can be replaced up to 10%, 20%, 30% and 40% of zeolite.
- In this present research work, it is concluded that the strength of the concrete by using zeolite up to 40% replaced in cement.
- In compressive strength of concrete 28 days and 60 days increases up to 20% replacement of zeolite.
- zeolite as 28 days and 60 days decreases the strength of concrete up to 40% of zeolite replaced in concrete as compared with conventional concrete
- Split tensile strength of concrete 28 days strength increases the concrete replacement of zeolite up to 20% replaced as zeolite in concrete.
- Modulus of rupture for 28 days strength decreases the 30% & 40% of replace the zeolite in cement.
- Flexure test of concrete strength 28days increases strength up to 20% of zeolite and decreases the strength up to 40% of zeolite is replaced.
- Modulus of elasticity of concrete according to stress strain curves 28 days of strength increases up to 20% of zeolite and decreases the up to 40% of zeolite is replaced in concrete compared to normal concrete.
- Durability of concrete as rapid chloride permeability test s 28 days and 60 days of concrete.
- In rapid chloride permeability test as 28days as increased strength compared to 60days of rapid chloride test.
- Rcpt values of 28days and 60 days of values increased up to 20% of zeolite and decreases the up to 40% of zeolite
- Water permeability of 28 days and 60days strength increased up to 20% of zeolite replaced in concrete and decreases the strength 30% and 40% of zeolite as replaced in concrete.



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