

Under Revision See DR 96016

1379-91

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Australian Standard®

**The specification and manufacture
of concrete**



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This Australian Standard was prepared by Committee BD/49, Manufacture of Concrete. It was approved on behalf of the Council of Standards Australia on 19 April 1991 and published on 12 July 1991.

The following interests are represented on Committee BD/49:

Australian Construction Services
Austroads
Cement and Concrete Association of Australia
Master Builders Construction and Housing Association Australia
Metal Trades Industry Association of Australia
National Ready Mixed Concrete Association
Royal Australian Institute of Architects
The Association of Consulting Engineers Australia
University of New South Wales
University of Sydney

Additional interests participating in preparation of Standard:

Bemac Laboratories
The Fowler Mixer Co.

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**The specification and manufacture
of concrete**

First published as AS (E)A.502—1941.
Revised and redesignated AS A/64—1960.
Second edition 1971.
Revised and redesignated AS 1379—1973.
AS A/64—1960 withdrawn 1976.
AS 1379 second edition—1991.

PREFACE

This Standard was prepared by the Standards Australia Committee on the Manufacture of Concrete to supersede AS 1379—1973, *Ready-mixed concrete*.

The scope of this Standard represents a significant expansion of the scope of AS 1379—1973 in that it covers the manufacture of site-mixed and factory-mixed concrete in addition to truck-mixed concrete. It also covers the manufacture of flexural and indirect-tensile strength grades as well as compressive grades of concrete, including those compressive grades which fall outside the range covered by AS 3600—1988, *Concrete Structures*.

All of the specification, classification (normal and special-class), ingredient materials and quality control, requirements of AS 3600 have now been incorporated into this Standard. This is an essential step in the rationalization process of formulating AS 3600 as a purely structural design Standard and this Standard as an independent material/product Standard.

Another rationalization which will follow the publication of this Standard will be the withdrawal of the 'Codes of Practice' for the use of chemical admixtures and fly ash in concrete (AS 1492 and AS 1130). As these materials are most frequently incorporated into concrete at the manufacturing stage, their usage is now covered by this Standard.

Many modern concrete plants are either partially or fully automated with electronic control and digital readouts. In addition to the traditional batch mixers, continuous and split-drum mixers are also finding their place in concrete manufacture. This Standard takes account of these developments in plant technology, which have occurred since the previous edition.

Sampling and testing regimes aim at achieving satisfactory levels of quality control over slump, air content and strength. All concrete specified by compressive strength is now required to be assessed for quality by the manufacturer, at levels appropriate to the rate of production. Additional assessments may also need to be carried out where specifiers require the concrete manufactured for a specified project to be separately assessed.

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Australian Standard

The specification and manufacture of concrete

SECTION 1 SCOPE AND GENERAL

1.1 SCOPE This Standard sets out minimum requirements for—

- (a) the materials, plant and equipment used in the manufacture of concrete;
- (b) the production and, if applicable, the delivery of concrete in the plastic state;
- (c) specifying, sampling, testing and compliance with specified properties, of plastic and hardened concrete; and
- (d) the uniformity of mixing.

This Standard applies to the manufacture of all concrete. It is not intended to apply to mortars or grouts.

NOTES:

- 1 Requirements for mortars for masonry construction are given in AS 3700 and the methods for sampling and testing mortars in AS 2701.
- 2 Requirements for grouts to be used for the grouting of prestressing tendons in ducts, are given in Clause 9.1.11 of AS 3600.
- 3 It is not intended that this Standard should take precedence over existing Australian Standards for the manufacture of specific concrete products.

1.2 REFERENCED DOCUMENTS The following documents are referred to in this Standard.

AS

1012	Methods of testing concrete
1012.1	Part 1: Method for sampling fresh concrete
1012.3	Part 3: Methods for the determination of properties related to the consistence of concrete
1012.4	Part 4: Methods for the determination of air content of freshly mixed concrete
1012.5	Part 5: Method for determination of mass per unit volume of freshly mixed concrete
1012.8	Part 8: Method for making and curing concrete compression, indirect tensile and flexure test specimens in the laboratory or in the field
1012.9	Part 9: Method for the determination of the compressive strength of concrete specimens
1012.10	Part 10: Method for the determination of indirect tensile strength of concrete specimens ('Brazil' or splitting test)
1012.11	Part 11: Method for the determination of the flexural strength of concrete specimens
1012.12	Part 12: Methods for the determination of mass per unit volume of hardened concrete
1012.13	Part 13: Determination of drying shrinkage of concrete
1012.18	Part 18: Determination of setting time of fresh concrete, mortar and grout by penetration resistance
1012.19	Part 19: Accelerated curing of concrete compression test specimens (laboratory or field)—Hot water and warm water methods
1141	Methods for sampling and testing aggregates
1141.6	Part 6: Determination of particle density
1141.35	Part 35: Sugar
1289	Methods of testing soils for engineering purposes
1289.02.1	Part D: Soil chemical tests—Determination of sulphate content of ground water
1315	Portland cement
131	Blended cement
1470	Chemical admixtures for use in concrete
1.30	Paints and related materials—Methods of test
1580.505.1	pH of water based paints
2758	Aggregates and rock for engineering purposes
2758.1	Part 1: Concrete aggregates
3550	Methods for the analysis of waters
3550.1	Part 1: Determination of dissolved sulfide
3550.4	Part 4: Determination of solids
3582	Supplementary cementitious materials for use with portland cement
3582.1	Part 1: Fly ash
3582.2	Part 2: Ground granulated blast-furnace slag