



Designation: E 518 – 023

Standard Test Methods for Flexural Bond Strength of Masonry¹

This standard is issued under the fixed designation E 518; 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 Department of Defense.

1. Scope*

1.1 These test methods cover determination of the flexural bond strength of unreinforced masonry assemblages. Two procedures are provided:

1.1.1 *Test Method A*—Simply supported beam with third-point loading.

1.1.2 *Test Method B*—Simply supported beam with uniform loading.

1.2 The values stated in SI units are to be regarded as the standard.

1.3 *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 and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 *ASTM Standards:*

C 67 Test Methods for Sampling and Testing Brick and Structural Clay Tile²

¹ These test methods are under the jurisdiction of ASTM Committee C15 on Manufactured Masonry Units and are the direct responsibility of Subcommittee C15.04 on Research.

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

- C 78 Test Method for Flexural Strength of Concrete (Using Simple Beam with Third-Point Loading)³
- C 140 Test Methods for Sampling and Testing Concrete Masonry Units and Related Units²
- C 270 Specification for Mortar for Unit Masonry²
- C 778 Specification for Standard Sand⁴
- E 4 Practices for Force Verification of Testing Machines⁵
- E 72 Methods of Conducting Strength Tests of Panels for Building Construction⁶
- E 575 Practice for Reporting Data from Structural Tests of Building Constructions, Elements, Connections, and Assemblies⁶

3. Significance and Use

3.1 These test methods are intended to provide simplified and economical means for gathering comparative research data on the flexural bond strength developed with different types of masonry units and mortar or for the purpose of checking job quality control (materials and workmanship).

NOTE 1—These test methods are not intended for use in establishing design stresses. For this purpose, Methods E 72 should be used.

4. Apparatus

4.1 *Testing Machine*, conforming to the requirements of Practices E 4.

4.2 *Test Method A*—The third-point loading method is illustrated in Fig. 1. The load is applied by means of a loading apparatus similar to that described in Test Method C 78.

4.3 *Test Method B*—The uniform loading method is illustrated in Fig. 2. The load is applied by means of an air bag typically made of poly(vinyl chloride) 0.5 mm (0.02 in.) thick. The air bag shall be of any convenient thickness and shall have a contact area equal to that of the specimen. It shall be equipped with two valves for inflating and deflating the bag. The air bag shall be backed by a steel channel suspended from the cross head of the testing machine with a suitable stud welded to the web of the channel. The channel shall be an American Standard steel channel whose depth is equal to the width of the air bag. It is recommended that the air pressure in the bag be monitored during the test as a check against the test machine dial indicator.

NOTE 2—When testing specimens constructed with a high bond-strength mortar, or whose thickness is greater than a nominal 100 mm (4 in.), the applied load required to fail the specimen may be such as to rupture the seams of the air bag. In such cases Test Method A is recommended.

5. Sampling and Testing

5.1 *Masonry Units*—Representative masonry units shall be sampled and tested in accordance with the following applicable methods: Test Methods C 67 for brick, or Test Methods C 140 for concrete masonry units. Minimum tests required shall be compressive strength, and initial rate of absorption for brick or absorption for concrete masonry units.

² Annual Book of ASTM Standards, Vol 04.05.
³ Annual Book of ASTM Standards, Vol 04.02.
⁴ Annual Book of ASTM Standards, Vol 04.01.
⁵ Annual Book of ASTM Standards, Vol 03.01.
⁶ Annual Book of ASTM Standards, Vol 04.11.

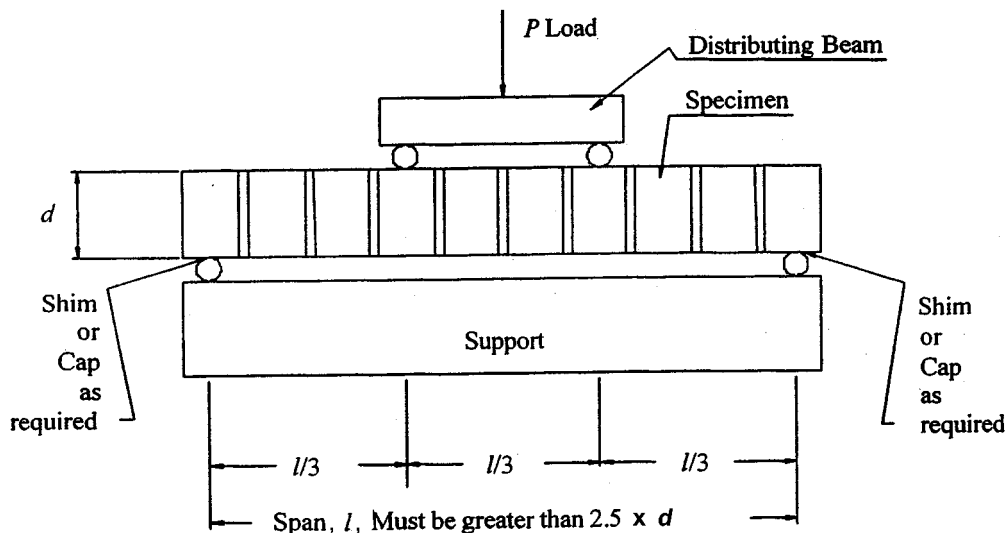


FIG. 1 The Third-Point Loading Method (Test Method A)

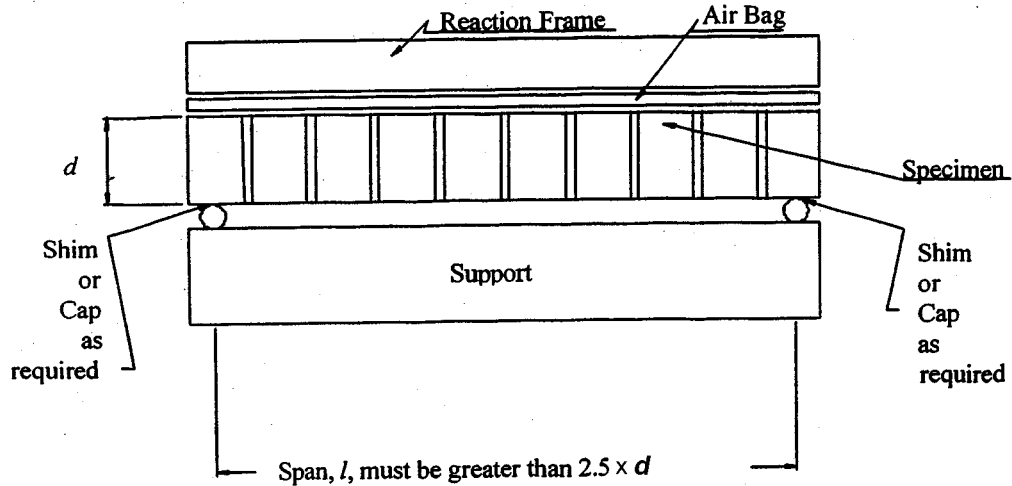


FIG. 2 The Uniform Loading Method (Test Method B)

5.2 *Mortar*—One of the types of mortar in Specification C 270 shall be used, or the mortar shall conform to that specified for the construction. Sand sieve analysis shall be performed and recorded, except when ASTM C 778 standard sand is used. If ASTM C 778 standard sand is used, the record shall identify the sand as 20–30 sand, graded sand, or a blend of indicated proportions of each sand by weight.

5.2.1 Mortar for prism fabrication shall be mixed to a workable consistency. The compressive strength, initial flow, and water retention of the mortar shall be determined in accordance with the requirements of Specification C 270, except that the cubes molded for the compressive strength test, after moist curing in the molds for 24 h, shall be released and stored in the same atmosphere as the prisms as specified in Section 7. The following physical properties of the mortar shall be determined and recorded:

- 5.2.2 Compressive strength (average of three cubes),
- 5.2.3 Initial flow (laboratory-mixed mortar only),
- 5.2.4 Flow after suction (water retention) (laboratory-mixed mortar only).

6. Test Specimens

6.1 A minimum of five test specimens shall be constructed as stack-bonded prisms, at least 460 mm (18 in.) high with mortar joints 10 ± 1.5 mm ($\frac{3}{8} \pm \frac{1}{16}$ in.) in thickness. The number of courses in each specimen shall be such as to permit locating supports and loading points midway between joints for Test Method A tests (4, 7, 10, 13, or 16 courses, depending on face heights of units), and to provide for a span-to-depth ratio that exceeds 2.5. When the test is for the purpose of determining the quality of materials and workmanship during construction, the specimens shall be constructed at the site by the masons involved, utilizing the materials on the site and the same masonry construction techniques.

6.2 Applicable portions of the following procedures shall be observed:

- 6.2.1 Set units on a firm, flat surface without the use of mortar, leaving not less than 50-mm (2-in.) spaces between stretchers.
- 6.2.2 Place a full or face shell mortar bed (in accordance with job specification) on all units without furrowing.
- 6.2.3 Immediately place the next course of units on the mortar beds and tap each unit to level. One Align at least one vertical face of each prism shall be aligned to a plane using a level or other means. (Note 3).

6.2.4 Repeat steps 6.2.2 and 6.2.3 until the prisms are the required number of courses high. Tool or otherwise finish the joints as specified.

NOTE 3—A convenient method of aligning one face is to use a jig as illustrated in Fig. 3.

~~6.2.4 Repeat steps 6.2.2 and 6.2.3 until the prisms are the required number of courses high. Tool or otherwise finish the joints as specified.~~

7. Handling and Curing Conditions

7.1 Unless otherwise specified, all prisms shall be cured for 28 days. The prisms together with corresponding mortar cubes shall be cured in laboratory air maintained at a temperature of $24 \pm 8^\circ\text{C}$ ($75 \pm 15^\circ\text{F}$), with a relative humidity between 30 and 70 %, and free of drafts. These environmental conditions generally will not require special air-conditioning equipment. A continuous graphical record of temperature and humidity will suffice to detect unusual dryness or excessive moisture, together with unusual fluctuations of temperature.

7.1.1 Where prisms are made during construction at the job site, they shall be constructed in a place where they will not be disturbed, but will be subjected to air conditions similar to those in the masonry structure.

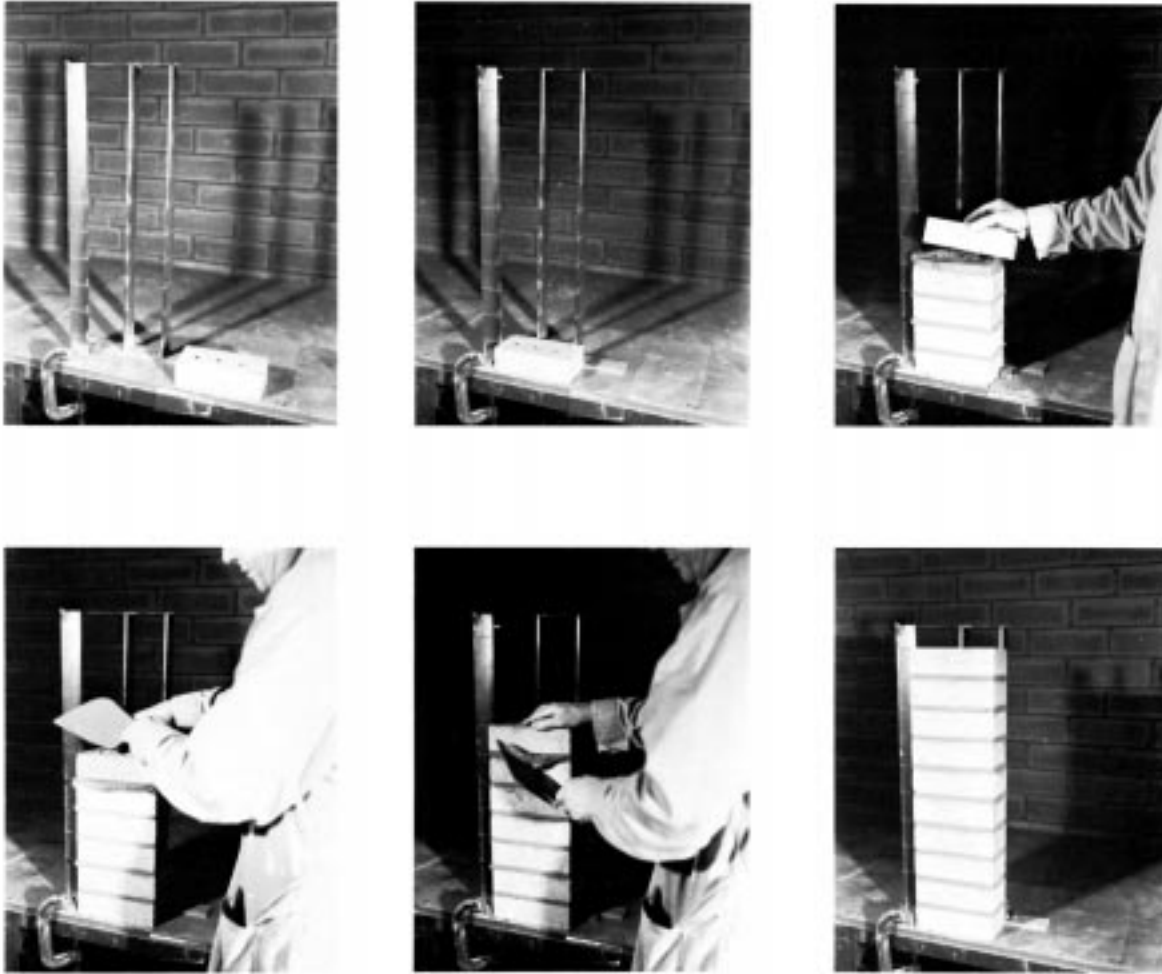


FIG. 3 Use of a Jig to Align One Face of the a Prism to a Plane

8. Procedure

8.1 Place the test specimen horizontally on its supports as a simply supported beam. If full contact is not obtained between the specimen and the load-applying blocks and supports, compressible shims or a bed of gypsum capping material shall be used to level and seat the specimen thereby ensuring the uniform application of load. If compressible shims are used, they shall be shims made of leather or similar compressible material of uniform thickness, not less than 6 mm (1/4 in.) thick, 25 to 50 mm (1 to 2 in.) in width, and shall extend across the full width of the specimen.

8.2 Apply the load at a uniform rate of travel of the moving head such that the total load is applied in not less than 1 nor more than 3 min.

8.3 Record the maximum applied load in Newtons (pounds) as P and the location of the break.

9. Calculation

9.1 For specimens built with solid masonry units (75 % or more net area), calculate the gross area modulus of rupture as follows:

9.1.1 For Test Method A, with third-point loading:

$$R = \frac{(P + 0.75 P_s)l}{bd^2} \quad (1)$$

where:

- R = gross area modulus of rupture, MPa (or psi),
- P = maximum applied load indicated by the testing machine, N (or lbf),
- P_s = weight of specimen, N (or lbf),
- l = span, mm (or in.),
- b = average width of specimen, mm (or in.), and
- d = average depth of specimen, mm (or in.).

9.1.2 For Test Method B, with uniform loading:

$$R = \frac{0.75 (P + P_s)l}{bd^2} \quad (2)$$

where the terms are the same as those described in 9.1.1.

9.2 For specimens built with hollow masonry units (less than 75 % net area), calculate the net area modulus of rupture as follows:

9.2.1 For Test Method A, with third-point loading:

$$R = \frac{(0.167 P + 0.125 P_s)l}{S} \quad (3)$$

where:

S = section modulus of actual net bedded area, mm³(or in.³).

9.2.2 For Test Method B, with uniform loading:

$$R = \frac{0.125 (P + P_s)l}{S} \quad (4)$$

where S is the same as in 9.2.1.

9.3 If the failure occurs in a joint outside of the middle third of the span length for Method A, discard the test results.

10. Report

10.1 The report shall be prepared in conformance with Practice E 575 and shall include the following:

- 10.1.1 Identification number,
- 10.1.2 Average width of specimen to the nearest 1.0 mm (0.05 in.),
- 10.1.3 Average depth of specimen to the nearest 1.0 mm (0.05 in.),
- 10.1.4 Weight of specimen, N (or lbf),
- 10.1.5 Method of applying load (Method A or B),
- 10.1.6 Maximum applied load, N (or lbf),
- 10.1.7 Individual and average gross or net area moduli of rupture calculated to the nearest MPa (or psi); standard deviation; and coefficient of variation.
- 10.1.8 Curing history and age of specimen,
- 10.1.9 Defects in specimen,
- 10.1.10 Description of failure,
- 10.1.11 Type and mix design of mortar,
- 10.1.12 Compressive strength of mortar, kPa (or psi),
- 10.1.13 Initial flow of mortar as used (laboratory-mixed mortar only),
- 10.1.14 Water retention of mortar (laboratory-mixed mortar only),
- 10.1.15 Physical properties of masonry units, and
- 10.1.16 Sketch of masonry unit showing core configuration and mortar bedded area, full or face shell.
- 10.1.17 Results of the sand sieve analysis or, if ASTM C 778 sand is used, identify which of the defined sands were used.

11. Precision and Bias

11.1 No statement is made either on the precision or on the bias of these test methods due to the variety of materials and combinations of materials involved. Sufficient test data for all materials and combinations of materials are not presently available to permit the development of precision and bias statements.

12. Keywords

12.1 flexural bond strength; masonry units; mortar; simply supported beam; stack bonded prism; third point loading; uniform load

SUMMARY OF CHANGES

Committee C15 has identified the location of selected changes to the standard since the E-518-00a 518-02 version that may impact the use of this standard.

(1) Section 6.2.3 was revised to clarify language regarding alignment of test specimens.

(2) 8.1 and Figure 3 were modified to allow other methods of seating the specimen.

(3) Figures 1 and 2 were changed to drawings, replacing the previous photographs.

Committee C15 has identified the location of selected changes to the standard since the E 518-00 version that may impact the use of this standard.

(1) Paragraph 6.2.5, which required dry-stacking units on top of the prisms to provide a surcharge load, was removed from the standard.

(2) Paragraph 5.2 was revised to clarify and simplify the required testing of the mortar. Sand sieve analysis is waived when a sand of known gradation is used.

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