

X-ray Diffraction of Slag-based Sodium Salt Waste Forms

C.A. Langton D.M. Missimer September 2014 SRNL-STI-2014-00397, Revision 1

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September 2014



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EXECUTIVE SUMMARY

The attached report documents sample preparation and x-ray diffraction results for a series of cement and blended cement matrices prepared with either water or a 4.4 M Na salt solution. The objective of the study was to provide initial phase characterization for the Cementitious Barriers Partnership reference case cementitious salt waste form. This information can be used to: 1) generate a base line for the evolution of the waste form as a function of time and conditions, 2) potentially to design new binders based on mineralogy of the binder, 3) understand and predict anion and cation leaching behavior of contaminants of concern, and 4) predict performance of the waste forms for which phase solubility and thermodynamic data are available.

Both water and a 4.4 M sodium salt solution were used to hydrate the cementitious reagents. One of the mixes containing the sodium salt solution and blended binder was approximated by the Cementitious Barriers reference case salt waste form. The other mixes contained combinations of the reference case binder ingredients. Mixes prepared with water were compared to literature data of typical blended cement matrices.

The intent was to use this characterization data as a starting point for more detailed phase characterization using various techniques including neutron diffraction techniques in addition to quasi-elastic neutron scattering techniques for characterization of water at the ORNL Spallation Neutron Source, Oak Ridge, TN and other methods such as, thermogravimetric techniques, electron diffraction, scanning electron microscopy and energy-dispersive X-ray spectroscopy. The initial characterization is complete. Due to extensive substitutions of cations and anions in the layered double hydroxide phases and the very fine intermixing of poorly crystalline hydrated phases in the reference case blend (10 : 45 : 45 cement : slag : fly ash), electron diffraction and transmission electron spectroscopy are recommended as the next step for characterization.

Characterization of the mineralogy and differences in the mineralogy between blended portland cement construction materials and sodium salt waste forms is also important for understanding and predicting the buffering effects that the waste form has on infiltrating water / leachates. The mineralogy of the cured cementitious matrices influences the physical properties (strength, stiffness, etc.) of the cured material due to the degree of polymerization (chain length) and tetrahedron arrangement. Information about the mineralogy of hydrated cementitious materials and blends of these ingredients is needed to design waste form matrices, select ingredients and make adjustments in material proportions. Information presented in this report is an initial step in developing phase diagrams for the hydrated systems in which caustic sodium salt solutions are used as the hydration fluid for waste forms, such as, the SRS saltstone waste form and the Hanford Cast Stone waste form.

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Cementitious Barriers Partnership

X-ray Diffraction of Slag-Based Sodium Salt Waste Forms

CBP CBP CBP CBP

X-ray Diffraction of Slag-based Sodium Salt Waste Forms

Cementitious Barriers Partnership

September 2014

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SUMMARY

Cementitious materials are used to solidify and stabilize aqueous based radioactive waste containing sodium salts. The types and proportions of cementitious ingredients used to treat these alkaline aqueous radioactive salt waste streams depend on the performance objectives for the waste forms and the compositions of the waste streams. Matrix phases can stabilize certain contaminants by co-precipitation, substitution, exchange, and / or sorption. Matrix phases also effect processing properties and are responsible for the physical properties and durability of the cured waste forms. Consequently, characterization of the matrix (binder) mineralogy (chemical compositions and crystal structures) is important for predicting contaminant leaching and evolution of the materials as a function of time and changing conditions.

This report documents sample preparation and x-ray diffraction results for a series of materials made with water or highly alkaline sodium salt simulated waste water and cementitious binders. The objective of this study was to provide initial phase characterization for the CBP reference case cementitious salt waste form. This information can be used to: 1) generate a base line for the evolution of the waste form as a function of time and conditions, 2) potentially to design new binders based on mineralogy of the binder, 3) understand and predict anion and cation leaching behavior of contaminants of concern, and 4) predict performance of the waste forms for which phase solubility and thermodynamic data are available. Characterization of the mineralogy is also important for understanding the buffering effects that the waste form has on infiltrating water / leachates.

Identification of hydrated phases capable of sequestering anions in the structures and crystallinity of the calcium silicate binder phases were of particular interest. The intent was to use this characterization data as a starting point for more detailed phase characterization using electron and neutron diffraction techniques in addition to quasi-elastic neutron scattering techniques for characterization of water in the matrix. The initial characterization is complete.

In summary, the hydrated mixtures of Type II portland cement, Grade 100 ground granulated blast furnace slag (GGBFS) and carbon burn-out (CBO) Class F fly ash contained hydrated phase assemblages which were typical of those reported in the literature. The mineralogy and bulk oxide composition of the blends analyzed in this study controlled the mineralogy of the hydrated material. The calcium silicate hydrate phase assemblage in samples hydrated with the alkaline 4.4 M sodium salt simulated waste solution was found to be a function of the (CaO + MgO) / (SiO₂ + Al₂O₃) ratio of the samples characterized. Based on x-ray diffraction results, no significant differences were detected in samples cured 2 months and 14 months in sealed containers at ambient indoor temperatures.

Slag and a blend of slag and cement hydrated with caustic 4.4 M Na salt solution resulted in the most crystalline matrix. In addition to poorly ordered C-S-H, these samples contained fairly well ordered C-S-H I (a precursor of 14Å tobermorite) and 11 Å Al-substituted tobermorite. These crystalline C-S-H phases did not form or were present in only trace amounts in slag blends containing about 45 to 62 mass percent fly ash. These slag-Class F fly ash blends had a higher silica plus alumina content relative to lime and magnesia than the blends that produced C-S-H I and Al-substituted tobermorite. The calcium silicate binder in the 10:45:45 mixture of cement : slag : fly ash was made up of poorly ordered C-S-H. The sample cured for 14 months may contain a small amount of the more crystalline calcium silicate hydrate phases.

Layered double hydroxides in the hydrotalcite (magnesium-aluminum carbonate hydroxide) and hydrocalumite / AFm phases (calcium aluminum hydroxide) were present in mixtures containing slag.

The specific phase(s) were not identified because these phases form solid solutions and have a considerable amount of overlap in their x-ray patterns.

Sodium nitrate was the only sodium salt phase identified in x-ray diffraction patterns of the samples hydrated with salt solution. Drying during x-ray diffraction sample preparation may have resulted in precipitation of the sodium nitrate or it may have been present in the samples prior to x-ray sample preparation.

Sodium sulfate, aluminate, and carbonate may have been incorporated in the structures of the layered double hydroxide (AFm) type phases. These mixed metal layered double hydroxides make up an important fraction of the matrix in the slag containing blends hydrated with caustic salt solution. They are among the few oxide-based phases that exhibit substantial, permanent anion exchange capacity [Kirkpatrick, et al. 1999, Plamer, et al., 2009, and Zhang and Reardon, 2003]. They also contribute to the structural properties of cementitious matrices [Taylor, 1997].

The mineralogy of the hydrated calcium-silicate matrices in cured cementitious waste forms influences the physical properties (strength, stiffness, porosity, hydraulic conductivity, shrinkage, expansion, etc.) of the cured waste form matrix material due to the degree of polymerization (chain length) and tetrahedron arrangement. Information about the mineralogy of hydrated cementitious materials and blends is needed to design waste forms, i.e., select ingredients and proportions. Information presented in this report is an initial step in developing phase diagrams for the hydrated systems in which caustic sodium salt solutions are used as the hydration fluid for waste forms.

ABBREVIATIONS

AAS	Alkali Activated Slag
ASTM	American Society of Testing and Materials
С-Ѕ-А-Н	Alumina Substituted Hydrated Calcium Silicate Gel
	(non to poorly crystalline solid)
C-S-H	Hydrated Calcium Silicate Gel (non to poorly ordered solid)
DOE	US Department of Energy
EDX	Energy Dispersive X-Ray
GGBFS	Ground Granulated Blast Furnace Slag
ICDD	International Center for Diffraction Data
LDH	Layered Double Hydroxide
Μ	Molar
MAS	Magic Angle Scattering
NMR	Nuclear Magnetic Resonance
ORNL	Oak Ridge National Laboratory
R&D	Research and Development
rpm	Revolutions per minute
SEM	Scanning Electron Microscopy
SRNL	Savannah River National Laboratory
TDS	Total Dissolved Solids
TT/QAP	Task Technical and Quality Assurance Plan

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INTRODUCTION

Cementitious materials are used to solidify and stabilize aqueous based radioactive waste containing sodium salts. The types and proportions of cementitious ingredients used to treat aqueous radioactive waste streams containing sodium salts depend on the performance objectives for the waste forms and the compositions of the waste streams. Matrix phases can stabilize certain contaminants (co-precipitation, substitution, ion exchange, and / or sorption), influence processing properties, and are responsible for physical properties and durability of the cured waste forms. Consequently, characterization of the matrix (binder) mineralogy (chemical compositions and crystalline / non crystalline structures) is important for predicting contaminant leaching and evolution of the materials as a function of time and changing conditions.

This report documents sample preparation and x-ray diffraction results for a series of mixtures of sodium salt waste and cementitious binders.

OBJECTIVE

The objective of this report was to characterize the phase assemblages in the Cementitious Barriers Partnership reference case sodium salt waste form [Langton, 2009]. This information can be used to: 1) generate a base line for the evolution of the waste form as a function of time and conditions, 2) design new binders based on matrix mineralogy, 3) understand and predict anion and cation leaching behavior of contaminants of concern, and 4) predict performance of the waste forms and 5) identify appropriate phase solubility and thermodynamic data. Characterization of the mineralogy is also important for understanding the buffering effects that the waste form has on infiltrating water / leachates.

BACKGROUND

Sodium salt waste forms generated in the DOE complex typically consist of a blend of ground granulated blast furnace slag (GGBFS), portland cement, and Class F fly ash. Blends of these ingredients have been used to treat caustic aqueous sodium salt waste streams generated from separation and recovery of isotopes for defense programs. The objective of the treatment is to provide a diffusion barrier for soluble contaminants, stabilize selected contaminants, and convert a liquid waste into a solid waste form suitable for disposal.

This effort was intended to obtain preliminary phase / mineralogy data for subsequent electron and neutron diffraction and microscopy analyses of the hydrated binder phases. An experimental plan to characterize the matrix phases was developed by SRNL researchers in conjunction E. Pierce, ORNL and documented in Task Technical and Quality Assurance Plan (TT/QAP) [Langton, 2012].

At the present time, the matrices of these cementitous waste forms are not well characterized because a large portion of the matrix is made up of phases that have poorly ordered structures and form solid solutions involving cation and anion substitutions. In addition, the matrix consists of micrometer and sub-micrometer particles inter grown to the extent that individual particles are difficult to characterize using scanning electron microscopy (SEM) and energy dispersive x-ray spectroscopy (EDX).

EXPERIMENTAL METHOD

ASTM Type I water and a simulated sodium salt waste solution were used as the mixing fluids for the materials analyzed in this study. The simulated waste solution was based on the CBP reference case salt waste form. The simple salt solution composition is provided in Tables 1 and 2. This solution had a density of 1.207 g / ml and contained 25.13 weight percent total dissolved solids (TDS).

Component	М
Na	4.4E+00
Al	1.1E-01
Cr	5.8E-03
Re	1.6E-03
В	1.1E-02
К	5.4E-03
NO ₃	2.2E+00
NO_2	3.7E-01
OH	1.8E+00
CO ₃	1.4E-01
SO_4	4.6E-02
C_2O_4	9.3E-03
Cl	4.6E-03

Table 1. Sodium salt waste solution with a molar composition of a simple simulated sodium salt solution.

Table 2.	Ingredients used	to	prepare the	simulated	salt solution.
	ingi carentos asea				

Compound	g / L
Water	balance
KNO3	0.55
NaNO ₃	154.37
NaOH (50%)	142.4
$Al(NO_3)_3 \cdot 9H_2O$	42.01
NaNO ₂	25.66
Na ₂ CO ₃	14.73
Na_2SO_4	6.59
Na ₂ CrO ₄	0.94
Na ₃ PO ₄ ·12H ₂ O	1.9
Na ₂ C ₂ O ₄	1.24
H ₃ BO ₃	0.71
NaCl	0.27

The ingredients and proportions in the cementitious materials and mixtures prepared for x-ray diffraction characterization are provided in Table 3. Each mix was prepared as a large batch in a chemical fume hood using a paddle mixer with the blade set about 2 cm above the bottom of a 2000 ml beaker. The cementitious reagents were premixed by shaking them in a sealed plastic bag. The liquid was added to the beaker before the mixer was turned on and the rotational speed was adjusted to about 250 revolutions per minute (rpm). The corner of the bag containing the cementitious reagents was cut, and the contents of the bag were slowly added to the solution. After all of the solid reagents were added, the slurry was mixed for 3 minutes at a paddle speed adjusted to form a vortex but minimize air entrapment. After mixing, each mixture was cast into multiple 70 mL plastic containers. The containers were filled completely and capped. After setting on the bench top for 3 days the samples were over packed in a plastic bag to which a damp cloth was added to provide a moisture curing environment in case the caps were breeched. All samples were cured at ambient laboratory conditions.

	Sai	Water to				
Sample No.	Portland cement I/II	Ground Granulated Blast Furnace Slag (Grade 100)	Class F fly ash	ASTM Type 1 water	4.4 M Na Salt Waste Simulant	cementitious materials mass ratio
	1/11	(01440 100)	(g)	Water	Simulati	
448-1A, 1B, 1C	Anhydrous cement					NA
448-2A, 2B, 2C		Anhydrous slag				NA
448-3A, 3B, 3C			Anhydrous fly ash			NA
448-4A to 4G	500			300		0.60
448-5A to 5G		500		300		0.60
448-6A to 6G			500	300		0.60
448-7A to 7G	751				602	0.60
448-8A to 8G		751			602	0.60
448-9A to 9G			751		602	0.60
448-10A to 10G	150	601			602	0.60
448-11A to 11G	150		601		602	0.60
448-12A to 12G		375.5	601		602	0.60
448-13A to 13G	75	338	338		602	0.60

Table 3. Material prepared for x-ray-diffraction characterization.

One sample of each material was sent to E. Pierce, Oak Ridge National Laboratory, Oak Ridge, TN, after curing for 28 days. The intent was to obtain x-ray diffraction powder patterns at the ORNL as a precursor to neutron diffraction analyses at the ORNL Spallation Neutron Source. The neutron diffraction analyses were to be arranged by E. Pierce.

In addition, D. M. Missimer, SRNL Analytical R&D Programs, performed x-ray diffraction analyses on identical samples cured for 14 months to evaluate the effect of curing time on the mineralogy. A Bruker DA Advance x-ray diffractometer with CuK α radiation (1.5405982 Å wave length) was used to generate the diffraction patterns. JADE x-ray analysis software from Materials Data Inc. was used to identify phases along with chemistry of the materials and information from the literature.

LITERATURE REVIEW

Portland cement, GGBFS and Class F fly ash, and pastes made from these ingredients and combinations of ingredients have been extensively characterized in the literature. Limited data on pastes made with salt solutions are available in the literature. The review presented in this report is intended to illustrate that portland cement, GGBFS, Class F fly ash, and blends of these ingredients are multi-phase materials which have differing and variable compositions. In addition hydration products of these materials and blends are also multiphase. In addition, the mineralogy of the hydrated phases depends on many factors including the mineralogy of the starting materials, bulk oxide compositions of ingredients and blends, amount of water available for hydration, temperature, time, and other environmental conditions.

Portland cement: ASTM C-150 does not identify proportions of the phases in portland cement. Instead, oxide chemical requirements are identified and a method of estimating phase proportions based on chemical analysis is provided. Phases and materials in Type I/II portland cement are listed in Table 4. Minor phases present in portland cement clinker may include: periclase (Mg) and sodium and potassium sulfate phases: arcanite, aphthitalite, and langbeinite.

Phase	Cement Shorthand Terminology*		
Cement clinker			
Casio	C ₃ S		
	Alite and polymorphs		
Ca-SiO	C_2S		
	Belite, Larnite and polymorphs		
$Ca_3A_2O_6$	C ₃ A		
Co.(Al Fo.).O. sories	C_4AF where $x = 0.5$		
$Ca_2(AI_x, \Gamma c_{1-x})_2O_5$ series	Ferrite		
K SO	$K_2 S$		
K ₂ 50 ₄	Arcanite		
$(K,Na)_3Na(SO_4)_2$	$(K,N)_3NS_2$		
	Aphthitalite		
$(K M_{\sigma}(SO))$	$K_2M_2S_3$		
$(\mathbf{K}_{2}\mathbf{W}\mathbf{g}_{2}(\mathbf{S}\mathbf{O}_{4})_{3})$	Langbeninite		
MgO	М		
MgO	Periclase		
Interground material			
Gypsum CaSO ₄ · ₂ H ₂ O	C S		
Limestone (calcite CaCO ₃ + mineral phases	CC.		
occurring in limestone)			
Cuinding aids and norticle dispersents	Inorganic: fly ash or slag (< 3%) [Stutzman, 2014]		
Grinding aids and particle dispersants	Organic: e.g., aliphatic amines, complex amines, glycol		
	compounds, phenol and phenolic derivatives [Katsioti, et al. 2009]		

Table 4.	Portland	cement	mineral	logv.
тарист.	1 UI tianu	centent	minuta	iugy.

* Cement notation uses capital letters of the first letter in the chemical symbol to indicate one mole of the oxide, e.g., C = CaO, $A = Al_2O_3$, $S = SiO_2$, M = MgO, $F = Fe_2O_3$, N = NaO, and $H = H_2O$. The letters C and S overlain with bars \overline{C} , \overline{S} are used to represent SO_4^{2-} and CO_3^{2-} in conventional cement notation as are the bold italic letters C and S.

Hydrated Portland Cement: Phases formed in Type I/II portland cement hydrated with potable water (water to cement (w/c) ratio of 0.4 to 0.6) and cured under ambient laboratory conditions are listed in Table 5. Hydrated portland cement consists of calcium-rich gels with a range of Ca/Si ratios, calcium hydroxide, and one or more hydrated calcium aluminate phases. The C-S-H gels are often described as non-cross linked tobermorite- and jennite-like structures [Myers, 2013].

Inner product C-S-H forms within the space originally occupied by either alite or belite grains in the portland cement and also in space originally occupied by slag grains. The Ca/Si of the inner C-S-H hydration product is typically between 1.5 and 2.0 [Taylor, 1997]. Outer product C-S-H forms in the space originally filled by water. It typically has a lower Ca/Si ratio than the inner product C-S-H. In hydrated portland cement paste the outer product typically contains a mixture of inter-grown portlandite and AFm and AFt phases and has a fibrous morphology. Blends of portland cement and GGBFS result in a foil-like C-S-H morphology rather than a fibrous like morphology.

The inner product C-S-H typically displays a dense, coarse morphology. Rims of particles oriented perpendicular to the original grain boundaries are often formed around the alite, belite, and slag grains which may persist for years. The inner product can also contain laths or platelets of AFm and relicts of AFt needles [Richardson and Groves, 1992, and Taylor, 1997]. AFt phases have the general formula

 $[Ca_3(Al,Fe)(OH_6)]$ ·X₃·xH₂O, where X represents one formula unit of a doubly charged anion or 2 formula units of a singly charged anion.

AFm phases are layered double hydroxides (LDHs) and have a distorted layered structure derived from portlandite, $Ca(OH)_2$. The entire family of AFm phases is often grouped together as the hydrocalumite phases. In the simplest structures, one Ca^{2+} ion in three is typically replaced by Al^{3+} or Fe^{3+} . The Ca : Al ratio is 2:1 and SO_4^{2-} , CO_3^{2-} , or OH⁻ occupy the anion positions. The cation layers alternate with layers containing anions and H₂O. AFm phases typically found in hydrated portland cements and blended cements include: hydroxy AFm, $4CaO \cdot Al_2O_3 \cdot 13-19 H_2O$, hemicarboaluminate, monocarboaluminate, Friedel's salt, $3CaO \cdot Al_2O_3 \cdot CaCl_2 \cdot xH_2O$, and stratlingite, a calcium aluminate silicate hydrate. A large number of AFm minerals occur naturally and can sequester both multivalent anions and cations.

Phase	Composition
C-S-H (inner product)	Ca/Si ~ 2
C-S-H (outer product)	Ca/Si ~ 1.5 to 1.1
Portlandite	Ca(OH)2
Ettringite (Aft)	$Ca_6Al_2(SO_4)_3(OH)_{12}$ ·26H ₂ O
Monosulfoaluminate (AFm)	Ca ₄ Al ₂ (SO ₄)(OH) ₁₂ ·6H ₂ O
Monocarboaluminate*	$Ca_4Al_2(CO_3)(OH)_{13} \cdot 5.5H_2O$
Hemicarboaluminate*	Ca ₄ Al ₂ (CO ₃) _{0.5} (OH) ₁₂ ·5H ₂ O
Hydrogarnet	$Ca_3[Al(OH)_6]_2$

Table 5. Hydrated Portland cement mineralogy (w/c = 0.4 to 0.6; ambient temperature curing).

* The presence of inter-ground fine limestone in the current portland cements is likely to produce carbonate hydrates.

Ground Granulated Blast Furnace Slag: GGBFS is produced by quenching molten iron slag in water or steam (wet quenching), then drying and grinding it into a fine powder. The main components of blast furnace slag are CaO (30-50%), SiO₂ (28-38%), Al₂O₃ (8-24%), and MgO (1-18%). GGBFS is 90 to 100 % glass. The amount of glass depends on the cooling rate and temperature at which the quenching is initiated. GGBFS used in concretes and mortars is specified in ASTM C989. Li, et. al, 2011 concluded that GGBFS glass is separated into two phase: a Ca-rich phase and a Si-rich phase that approximates akermanite (Ca₂Mg[Si₂O₇]). Most of the Si is distributed around Mg and calcium is associated with both Si and Al. Depending on the characterization techniques and slag preparation, micro- to nano-crystallites have been reported in GGBFS slag glasses.¹

Alkali Activated Slag (AAS): GGBFS is a glass which is slow to react with water. However, in the presence of alkali and water, it is activated and forms hydrated cementitious phases. Examples of phases formed when GGBFS is activated by different chemicals are provided in Table 6. The main hydration product of Na(OH) activated slag is a sodium substituted calcium-aluminum-silicate hydrate, C(N)-A-S-H, typically with a lower Ca/Si ratio (1.1 to 1.2, i.e. close to the ratio in unreacted slag) and higher Al/Si ratio than the C-S(A)-H resulting from portland cement hydration [Richardson and Groves, 1992]. The aluminum substituted gel is charge balanced with alkali and the gel structure can be described as tobermorite-like with the possibility of some cross-linking between the tobermorite chains [Myers, et.al, 2013]. The C-S-H gel formed in hydrated cement-slag mixtures is reported to be more like that formed from portland cement hydration (no cross-linking) and forms along with calcium hydroxide [Taylor, 1997].

¹ Sulfur in slag is often assumed to be associated with calcium in the glass structure because crystallized slags contain minor amounts of reduced sulfur as CaS with varying amounts of Mg and Fe substituted for Ca.

	Taylor	, H.F.W.,	Fernandez-Jimenez, A. and F. Puertas,			
	Cement Chemi	stry, 2 nd ed., 1997	J. Am Ceram. Soc. 86(8) 1389-94 (2003)			
	Cement Activated	Alkali Activated Slag			Na Silicate Activated Slag	
Phase	Slag (1:1)	(3.5-5.5M NaOH)	NaOH Activated Slag	NaCO ₃ Activated Slag	(water glass)	
C-S-H	Ca/Si ~1.55 Al/Ca ~ 0.09	C-S-H(I) relatively highly ordered Ca/Si ~1.1 to 1.2 Al/Ca ~0.19 Al in C-S-H substituted exclusively in bridging sites of dreierketten w/mean chain length 4.83 tetrahedron	C-S-H with dreierkette-type (3 chain) structure shows high Q2 Si values indicative of long linear chains but no Q3 Si values, i.e., low strength. Semi-crystalline, Foil like morphology Ca/Si = 0.9-1.0 (lower than starting slag) Na/Al = 2.0-2.22 Tetrahedral condensation ratios are higher in NaOH AAS and Water glass activated than in Na ₂ CO ₃ AAS indication Al is incorporated in tet chains with charge balanced by Na+ (TEM/EDS).	C-S-H shows low Q3 Si values. Med. Strength Semi-crystalline, Foil like morphology Ca/Si = 0.9 to 1.0 (lower than in the starting slag)	C-S-H with highly condensed anions, Si in Q2 and Q3 sites which favors formation of cross-linked structures that result in increased strength	
CaCO ₃	Not mentioned	Not mentioned	Yes	Yes		
Hydrotalcite-type phase Mg ₆ Al ₂ (CO ₃)(OH) ₆ •4(H ₂ O)	Mg/Al = 3 to 2.5 if Fe replaces Al		Yes	Yes		
AFm phase		possible				
AFm Carboaluminate phase(s) of the C4AC3H11-Type			Yes	Yes		
Zeolites	Formed at temp. > 120 °C in hydrated systems	Formed at temp. > 120 °C in hydrated systems	Zeolite formation requires high Al/Si and low Ca/Si	Not mentioned		
$Na_2Ca(CO_3)_2 \cdot 0.5 H_2O$				Yes		

Table 6. Hydrated Slag Mineralogy.

Poorly ordered hydrotalcite-like phase, $Mg_6Al_2(OH)_{16}CO_3 \cdot 4H_2O$, is also characteristic of GGBFS hydration. Hydrotalcite is structurally related to brucite in a way that is analogous to AFm phases being related to portlandite and is a layered double hydroxide. Some of the Mg ions may be replaced by Al^{3+} and Fe³⁺ and the charge balanced by anions which together with H₂O molecules occupy interlayer sites [Taylor, 1998]. The layer thicknesses are similar to that of the AFm phases and it is difficult to distinguish between the two groups by x-ray diffraction if only the basal reflections are observed.

Other phases that may form from alkali activated slag include: Fe-rich cubic hydrogarnet, $Ca_3[Al(OH)_6]_2$ and one or more AFm phases, $Ca_2(Al,Fe)(OH)_6] \cdot X \cdot xH_2O$ where X is one formula unit of a singularly charged anion or half of a formula unit of a doubly charged anion. Other phases which can form include: C_4AH_{13} , tetracalcium aluminum hydrate; C_2ASH_8 , stratlingite, $Ca_2Al_2(SiO_2)(OH)_{10} \cdot 2.5(H_2O)$; and/or hydrocalumite, $Ca_4Al_2(OH)_{12}(CO_3,OH)_2 \cdot 4H_2O$ [Chen and Brouwers, 2007 and Taylor, 1997].

The type of alkali used to activate the slag has an effect on the reaction products. Na(OH) activation of GGBFS results in poorly-ordered C-S-H with a foil like morphology and Ca/Si = 0.9 to 1.0 (lower than in the starting slag) and Na/Al of 2.0 to 2.22. This gel has a dreierkette-type structure (three chain structure). The relatively long linear chains correlate with mechanical strength. The mean chain length is about 8 tetrahedra [Fernandez-Jimenez and Puertas, 2003, Schilling et. al, 1994 and Richardson et. al 1982]. Other phases found in NaOH activated slag included: calcite, hydrotalcite, and carboaluminates.

Based on ²⁹Si and ²⁷Al magic-angle spinning (MAS) nuclear magnetic resonance (NMR) spectroscopy, Na₂CO₃ activated slag also results in poorly-ordered C-S-H with a foil like morphology and lower Ca/Si ratio than that formed from NaOH activation. The strengths of the Na₂CO₃ activated slag gels are reported to be higher than those formed from NaOH activated slag. The highest strengths are reported to be obtained from sodium silicate (water glass) activation slag. The C-S-H formed from the highly condensed anions in the case of sodium silicate favored formation of cross-linked structures that contributed to increased mechanical strength [Fernandez-Jimenez and Puertas, 2003].

Class F Fly Ash: Class F fly ash is a byproduct of burning bituminous coal in a coal-fired electric and steam producing power plants. The molten fly ash material solidifies while suspended in the exhaust gases and is collected by electrostatic precipitators or filter bags before the gases are discharged. Since the particles solidify rapidly, fly ash particles are generally cenospheres, (single or joined spheres), or plerospheres (spheres with in spheres), and range in size from $< 0.5 \,\mu$ m to 300 μ m. Due to the rapid cooling, most of the fly ash is amorphous (glass). Crystalline phases in fly ash are either refractory phases in the coal or formed from minerals in the coal. These phases are typically incorporated in the glass cenospheres and plerospheres. In summary, fly ash is a heterogeneous material. Most of the material is a glass which may contain quartz, mullite, iron oxides(hematite and/or maghemite), cristobalite, anhydrite, free lime, periclase, calcite, rutile and anatase. Examples of fly ash mineralogy are provided in Table 7. Detailed structural analysis of the amorphous material in Class F fly ash suggests that the glass is not homogeneous at the time it is quenched [Bumrongjaroen, et.al, 2007].

Hydrated Class F Fly Ash: Class F fly ash is mostly inert when exposed to water and air. However, when calcite, $CaCO_3$, is detected in Class F fly ash it is an indication that the ash contained a small amount of CaO which typically hydrates and then carbonates. Class F fly ash is pozzolanic and reacts with calcium, aluminum, and water to produce poorly ordered cementitious material.²

 $^{^{2}}$ Geopolymers can also be formed from Class F fly ash when activated by alkali solutions such as sodium hydroxide or sodium silicate (water glass).

Phase	Taylor, H. F. W. Cement Chemistry, 2 nd ed. , 1997	Bumrongjaroen, W., I. S. Muller, and I. L. Pegg, 2007 VSL-07R520X-1	McCarthy, G. J., 1988
Glass	Cu Kα peaks around 22-23° 2θ	71.9 wt. % Mullite-rich ~ 53.6 Class F glass ~ 24.1 Spinel rich ~ 12.8 Low-silica glass ~ 5.8 Class C glass ~ 2.0 Quartz rich ~ 1.7	X
Mullite Al ₆ Si ₂ O ₁₃ prisms in glass	Х	18.9	х
Quartz SiO ₂ prisms in glass or angular particles	Х	6.7	х
K ₂ SO ₄ particles adhering to spheres	Х		
CaSO ₄ particles adhering to spheres		Trace	
Hematite Fe ₂ O ₃ particles adhering to spheres or separate particles	Х	1.07	х
Magnetite Fe ₃ O ₄ particles adhering to spheres or separate particles	х	1.13	х
Ferrite Spinel Sub Mg, Al, Ti, Ni, Cr		0	Al substituted for Fe and could be misidentified as magnetite [Wingurn, R. S., S.S. Lerach, G. J. McCarthy, 2000 JCPDS Data Advances in X-ray Analysis V. 43, p.350]
Carbon Porous particles	Х	Not determined	Not determined
Cenospheres (hollow spheres)		Not evaluated	Not evaluated
Plerospheres (spheres filled with other spheres or particles)		Not evaluated	Not evaluated

Table 7. Class F fly ash mineralogy.

RESULTS

X-ray powder diffraction is one of several complimentary techniques for identifying phases in solid materials. In this study, an attempt was made to identify changes in the mineralogy starting with the anhydrous cement, slag, and fly ash and progressing to characterization of these materials hydrated with water and also with sodium salt solution. This information was used to help interpret and characterize the reaction products of selected blends of these cementitious materials as the result of hydration in water and salt solution was also performed.

Anhydrous starting materials: Phases identified in the anhydrous Type II portland cement, Grade 100 GGBFS, and carbon burn-out (CBO) Class F fly³ ash are listed in Table 8. The mineralogy of these materials is consistent with the phases reported in the literature. The x-ray diffraction techniques used in this study can detect minor amounts (greater than about 3 weight percent) of crystalline phases in the samples. Broad low intensity peaks in the powder x-ray diffraction patterns are indicative of anhydrous and hydrated poorly ordered silicate- based phases.

The portland cement, Sample 1A, contained alite (Ca_3SiO_5) , larnite (Ca_2SiO_4) , a ferrite phase $(Ca_2(Al,Fe)O_5)$ and calcite $(CaCO_3)$. Neither gypsum nor anhydrite was detected in the x-ray patterns although it is known to be inter-ground with the cement to control the initial hydration reactions. Since this cement contained a low amount of tricalcium aluminate $(Ca_3A_2O_6)$ which was below the detection limit for the x-ray diffraction technique used, the amount of calcium sulfate required to control the tricalcium aluminate hydration reaction was probably also low.

The Grade 100 slag, Sample 2A, was predominantly a silicate glass (non-crystalline material) containing a trace amount of akermanite ($Ca_2Mg[Si_2O_7]$), a refractory calcium magnesium silicate phase that formed during the slag production. Calcite was also detected in the x-ray diffraction pattern and was assumed to form as the result of lime in the slag reacting with CO_2 in the air.

The Class F fly ash, Sample 3A, also consists of glassy material (non-crystalline) which contains mullite $(Al_6Si_2O_{13})$ and quartz (SiO_2) . The mullite formed as a refractory aluminum silicate phase when clays in the coal were melted and were subsequently crystallized. The quartz is a residual phase from the coal itself.

Hydration of starting materials in water: Phases detected in the cementitious starting materials hydrated in water are also listed in Table 8. These samples were cured in sealed containers at room temperature for 2 and 14 months. The amount of non-crystalline or poorly ordered C-S-H in the cement + water samples, 4A and 4G, may have increased between 2 and 14 months but quantitative x-ray diffraction was not performed. Ettringite, an AFt phase, $Ca_6Al_2(SO_4)_3(OH)_{12}$ ·26H₂O, calcium aluminum sulfate hydrate, and a trace amount of an AFm phase, probably monosulfoaluminate were detected in the x-ray patterns.

Poorly ordered material, interpreted as unreacted anhydrous glass, was the predominant phase in the GGBFS samples 5A and 5G cured in water for 2 and 14 months, respectively. However, some hydration of the slag in water seems to have occurred in the 14 month old sample as indicated by detection of a

³ Carbon Burn Out consists of combusting residual carbon in fly ash to produce a consistent, low carbon (< 2.5 wt. %) high quality pozzolan. The drivers for CBO are to control the amount of carbon in fly ash to levels acceptable for construction applications and to eliminate ammonia contamination of the ash. Introduction of low NOx burners in recent years at coal fired power plants has resulted in increased levels of residual carbon in the ash. Also ammonia injection is used in some plants to enhance electrostatic precipitator performance and is being applied in selective catalytic reduction and selective non-catalytic flue gas treatment systems to meet the new more stringent NOx off gas standards. (Removal of ammonia is considered for fly ash if it contains more than about 50 -100 ppm if it is to be used in concrete applications.)

	Sample No.	Glass	Hyd- rated	CSH 034-	11Å Al- Tober- morite 019-	Hydro- talcite 041-	Hydro- calumite AFm 031-	Ettring- ite AFt 041-	Port- landite	Ca ₃ SiO ₅ 049-	Ca2SiO4 033- 0902, 033-	Brown- millerite Ca2(Al,Fe)O5	Gyp- sum	Quartz SiO ₂	Mullite Al ₆ Si ₂ O ₁₃	Aker- manite 035-	Calcite CaCO ₃ 005-	Natra- tine NaNO ₃ 036-	Comments
Material	Time)	NCS	NCS	0002	0052	1428	0245	1451	004-0733	0442	0302	042-1469	0311	1045	015-0776	0592	0586	1474	
Type II cement	1A									х	Х	х				-	x		
Grade 100 slag	2A	х														?	?		
Class F Fly ash	3A	Х												Х	Х				
Type II	4A (2 mo.)		?	?	?	x		Х	X		?								Bad pattern
Cement + Water	4G (14 mo.)		Х		?	х		Х	Х	Х			?						? Calcium iron sulfate hydrate 040-0292
Slag	5A (2 mo.)	Х	?	?	?														
+ Water	5G (14 mo.)	Х	?	-		x	?									X	x	1	
Fly ash + Water	6A (2 mo.)	х												Х	Х				
v ater	6 (14 mo.)	5 Not evaluated																	

Table 8. Phases identified in XRD powder patterns of anhydrous cementitious reagents and individual hydrated materials and the corresponding International Center for Diffraction Data (ICDD) database card numbers.

X = Several major peaks identified. x = Peaks identified with low relative intensity. ? = Peaks overlap other peaks, no unique peak identified, Tr = Identified based on small peaks and chemistry. -- = Not identified.

small amount of a hydrotalcite-type phase⁴ or a mixture of hydrotalcite and hydrocalumite (AFm). C-S-H may be present in the sample but SEM/EDX or other techniques are required to determine whether it formed. Calcite and possibly akermanite, present in the unreacted slag, were also detected in the GGBFS hydrated in water for 2 and 14 months.

Class F fly ash was essentially inert in the presence of water (samples 6A) which was cured for 2 months. The same phases present in the unhydrated the CBO Class F fly ash were detected in this sample, i.e. glass, and the refractory phases mullite and quartz.

Hydration of Starting Materials in 4.4 M Na Salt Solution: Phases detected in samples of the starting reagents, Type I/II portland cement, GGBFS, and CBO Class F fly ash, hydrated in 4.4 M Na salt solution are listed in Table 9. The phases detected by x-ray diffraction for the cement hydrated in salt solution samples (7A and 7E) included: poorly ordered C-S-H gel phase, portlandite, an AFm phase (calcium aluminate sulfate hydrate), unreacted larnite, and nitratine (NaNO₃) a component in the salt solution / pore solution.

Based on the powder pattern phase identifications, hydration of GGBFS in 4.4 M Na solution (Samples 8A and 8G) resulted in formation of fairly well crystallized material C-S-H I and aluminum substituted 11 Å tobermorite, in addition to a hydrotalcite-like phase and / or a mixture of hydrotalcite- and hydrocalumite-like phases. Some material, either unreacted glass or poorly ordered C-(Al)-S-H, may also be present in samples cured for 2 and 14 months. Additional characterization techniques are required to determine if residual slag or poorly ordered C-(Al)-S-H or other amorphous phases are present. Quartz and a calcium iron oxide were identified based on d-spacings but were not detected in the slag and could not have formed during hydration. Addition work is being performed to obtain reasonable phase identification for those d-spacings attributed to those diffraction peaks.

No additional crystalline phases were detected in the Class F fly ash cured in 4.4 M Na salt solution (Samples 9A and 9F). Residual mullite and quartz were detected in the x-ray diffraction patterns along with poorly ordered or amorphous material which is probably a mixture of silicate glass and hydrated glass. Exposure to caustic solutions results in partial to complete dissolution of the fly ash cenospheres.

Hydration of Blends in Salt Solution: Mineralogies of the blended binders are listed in Table 10. Samples 10 A and B were prepared with a 1 : 3 mixture by weight of cement : slag and were hydrated with 4.4 M Na salt solution for 2 and 14 months, respectively. Both samples contained fairly well ordered C-S-H I and aluminum substituted 11 Å tobermorite in addition to more than one AFm-type phase, either hydrotalcite or a mixture of hydrotalcite and hydrocalumite. Poorly ordered C-S-H may be present but could not be differentiated from residual slag glass. Larnite (from the anhydrous cement) and akermanite and calcite (from the anhydrous slag) were also detected in trace amounts. NaNO₃ was also present in both x-ray diffraction patterns and in all patterns for materials hydrated with the sodium salt solution. The samples cured for 2 and 14 months had similar phase assemblages.

Samples 11A and 11G were prepared with a 1 : 3 mixture of cement : Class F fly ash. These samples were hydrated for 2 and 14 months with 4.4 M Na salt solution. The reaction product in both of these samples was primarily poorly ordered C-S-H. Residual larnite, mullite, and quartz were also detected in both samples in addition to NaNO₃. The 2 and 14 month old samples do indicate changes in the calcium aluminate (sulfate) hydrate phases as a function of curing time. More detailed characterization is required to determine the composition and structure of these layered hydrates.

 $^{^{4}}$ Hydrotalcite-type phases are layered double hydroxides (LDHs) with metal cations in the main layers and anion and water in the interlayers. They are structurally related to brucite, Mg(OH)₂. The general formula is Mg₆Al₂(OH)₁₆.

Material	Sample No. Cure Time (mo)	Sili- cate Glass NCS	C-S-H Hyd- rated NCS	CSH I 034- 0002	11Å Al- Tober- morite 019- 0052	Hydro- talcite 041- 1428	Hydro calu- Mite 031- 0342	Ettring- ite 041- 1451	·Hydro- garnet	Port- landite 004- 0733	Ca ₃ SiO ₅ 049- 0442	Ca2SiO4 033- 0902	Ca2(Al,Fe)O5 042-1469	Gyp- sum 033- 0311	Quartz 046- 1045	Mullite 015- 0776	Aker- manite 035- 0592	Calcite 005- 0586	NaNO ₃ 036- 1474	Comments
Cement +	7A (2)		X				x 049- 0457			Х		x							Х	
Salt Solution	7E (14)		х				x 049- 0457			х		x							Х	
Slag +	8A (2 mo.)	?	x	X	Х	х	?								Х				х	
Salt Solution	8B (14 mo.)	?	x	x	Х	х	?								Х				х	
Fly ash +	9A (2 mo.)	x		-											Х	х			х	Low Counts
Salt Solution	9F (14 mo.)	X													Х	Х			Х	X

Table 9. Phases identified in XRD powder patterns of individual cementitious materials hydrated with 4.4 M Na salt solution and the International Center for Diffraction Data (ICDD) Database Card Numbers.

X = Several major peaks identified. x = Peaks identified with low relative intensity. ?= Peaks overlap other peaks, no unique peak identified, Tr = Identified based on small peaks and chemistry, -- = Not identified.

Material	Sample No. Cure Time (mo)	Glass NCS	Hyd- rated NCS	CSH I 034- 0002	11Å Al- Tober- morite 019- 0052	Hydro- talcite 041- 1428	Hydro- calu- mite 031- 0245	Ettring- ite 041- 1451	·Hydro- garnet	Port- landite 004- 0733	Ca ₃ SiO ₅ 049- 0442	Ca2SiO 033- 0902, 033- 0302	4Ca ₂ (Al, Fe)O ₅ 042- 1469	Gyp- sum	Quartz 046- 1045	Mullite 015- 0776	Aker- manite 035- 0592	Calcite 005- 0586	NaNO ₃ 036- 1474	Comments
Cement + Slag	10A (2 mo.)	?	X?	х	Х	Х	?				х	x					X	X	Х	061-0217 CaAl₂O₄10∙H₂O
+ Salt Solution	10B (14 mo.)	?	X?	х	Х	х	?					x					Х	x?	Х	061-0217 CaAl₂O₄10∙H₂O
Cement + Flv Ash	11A (2 mo.)	?	х				x					x			х	Х			Х	
+ Salt Solution	11C (14 mo.)	?	X					?				x			х	Х			Х	Possibly 2 new phases K ₂ SO ₄ , NaAl(AlSi ₃)O ₁₀ (OH) ₂
Slag + Fly Ash	12A (2 mo.)	?	х				Х								х	Х			Х	
+ Salt Solution	12F (14 mo.)	?	Х				х								х	Х			Х	
Cement + Slag +	13A (2 mo.)	?	х			Х	??								x	х	?	?	X	
Fly Ash + Salt Solution	13G (14 mo.)	?	X	?		x	??								х	х	?	x	Х	

Table 10. Phases identified in XRD powder patterns of blends of cementitious materials hydrated with 4.4 M Na salt solution and the International Center for Diffraction Data (ICDD) Database Card Numbers.

X = Several major peaks identified. x = Peaks identified with low relative intensity. ? = Peaks overlap other peaks, no unique peak identified, Tr = Identified based on small peaks and chemistry, -- = Not identified.

Samples 12A and 12F were prepared with a 2 : 3 mixture of slag and fly ash and cured for 2 and 14 months, respectively. These samples contained poorly ordered C-S-H and one or more layered double hydroxide phases (hydrotalcite, hydrocalumite, carboaluminate phase or a mixture of these phases) in addition to residual mullite, quartz, and NaNO₃. Crystalline C-S-H I and Al substituted tobermorite were not formed in this blend.

Samples 13A and 13G were prepared with a 10 : 45 : 45 mixture of cement : slag : fly ash and were cured for 2 and 14 months, respectively. These samples contained mainly poorly ordered C-S-H and hydrotalcite. Trace amounts of CSH I and / or Na substituted 11 Å tobermorite (2-theta of 6-7°) and one or more layered double hydroxide phases (hydrotalcite, hydrocalumite, or a mixture of these phases), residual mullite, quartz, calcite, and possibly akermanite in addition to NaNO₃.

DISCUSSION

The mineralogy of the samples cured for 2 and 14 months is determined by the mineralogy and bulk composition of the hydraulic and pozzolanic components and the chemistry of the mixing water or aqueous salt solution. The compositions of the cement, slag, and fly ash used to prepare the paste samples analyzed in this study are provided in Attachment 2. The values for five oxides, CaO, MgO, Al₂O₃, Fe₂O₃, and SiO₂, which together make up about 90 or more of the mass percent of each binder material were averaged and normalized. See Tables 11 and 12, respectively.

The sums of the normalized basic oxides were divided by sums of the acidic oxides, i.e., (CaO and MgO) / $(SiO_2, Al_2O_3, and Fe_2O_3)$ for individual ingredients (cement, slag, and fly ash) and for four blends all of which were hydrated with the 4.4 M Na salt solution. Results are tabulated in Table 12 and plotted in Figure 1. (Aluminum as aluminate in the salt solution was not included in the calculation.)

Based on the $(CaO + MgO) / (SiO_2 + Al_2O_3)$ ratios the mineralogy of the three individual ingredients and four blends hydrated with the alkaline salt solution can be loosely grouped into four categories shown below:

$(CaO + MgO) / (SiO_2 + Al_2O_3)$	Binder Phases
> 2	Poorly ordered C-S-H gel $(Ca/Si > 1.5) + Ca(OH)_2$
~ 1 to 1.3	Ordered CSH I (Ca/Si \sim 1.1 to $>$ 1.5) + 11 Å tobermorite
~ 0.3 to 0.5	Poorly ordered C-S-H gel
~ 0.05	Si dissolution

The $(CaO + MgO) / (SiO_2 + Al_2O_3)$ ratios of the ternary blends currently used and being considered for DOE salt waste forms fall in the 0.3 to 0.5 range and result in poorly ordered C-S-H (possibly with Na and Al substitution) matrix phases. Mineralogy is related to some physical properties, such as, dimensional stability as a function of temperature and moisture conditions, porosity, hydraulic conductivity, and durability. Consequently, mineralogy of waste form matrices is important to performance and evolution as a function of changing conditions and time. Mineralogy is also important for selecting appropriate thermodynamic data for long term equilibrium calculations used in chemical degradation scenarios.

			Cement						
Oxide	Cement A	Cememt B	Ave	Slag A	Slag B	Slag Ave	Fly Ash A	Fly Ash B	Fly Ash Ave
	Wt. %	Wt. %	Wt. %	Wt. %	Wt. %	Wt. %	Wt. %	Wt. %	Wt. %
CaO	64.4	64.4	64.4	35.8	36.7	36.3	2.4	2.4	2.4
MgO	1.19	1.2	1.2	13.3	12.9	13.1	1.5	1.5	1.5
Al ₂ O ₃	5.25	5.1	5.2	7.8	8.1	8.0	24.9	24.8	24.9
Fe ₂ O ₃	3.72	3.9	3.8	0.3	0.3	0.3	12.8	12.8	12.8
SiO ₂	19.2	19.7	19.5	39.8	39.2	39.5	48.4	47.9	48.2
TOTAL	93.76	94.3	94.0	97.0	97.2	97.1	90.1	89.4	89.8

Table 11. Major oxide results for cement, slag and Class F fly ash.

Table 12. Normalized selected oxides for starting materials and four blends.

	Normalized Blend 10 cement:	Normalized Blend	Normalized Blend	Normalized Blend			Normalized
Oxide	45 slag: 45 fly ash	25 cement: 75 fly ash	25 cement: 75 slag	38 slag: 62 fly ash	Normalized Cement	Normalized Slag	Class F Fly Ash
	Wt. %	Wt. %	Wt. %	Wt. %	Wt. %	Wt. %	
CaO	24.9	19.2	45.1	15.8	68.5	37.3	2.7
MgO	7.0	1.6	10.4	6.2	1.2	13.5	1.7
Al ₂ O ₃	16.7	22.2	7.5	20.3	5.5	8.2	27.7
Fe ₂ O ₃	7.0	11.8	1.3	9.0	4.1	0.3	14.3
SiO ₂	44.5	45.4	35.7	48.7	20.7	40.7	53.6
TOTAL	100.0	100.0	100.0	100.0	100.0	100.0	100.0
Oxide Ratios							
$(CaO + MgO) \div$ $(SiO_2 + Al_2O_3)$	0.52	0.31	1.29	0.32	2.66	1.04	0.05
$(CaO + MgO) \div$ $(SiO_2 + Al_2O_3 +$ $Fe_2O_3)$	0.47	0.26	1.25	0.28	2.30	1.03	0.05
$CaO \div (SiO_2 + Al_2O_3)$	0.41	0.28	1.04	0.23	2.61	0.76	0.03

Shaded ratios are plotted in Figure 1.



Figure 1. Calcium silicate hydrate phases in binders hydrated with 4.4 M Na salt solution as a function of (CaO + MgO) / (Al₂O₃ + SIO₂) ratio.

CONCLUSIONS

The mineralogy of the reaction products for materials and blends of materials hydrated with caustic 4.4 M Na salt solution depended on the mineralogy and proportions of the cementitious ingredients and the bulk oxide compositions of the mixtures. Poorly ordered /amorphous C-S-H was detected in mixtures of cement and slag, cement and fly ash, slag and fly ash and the waste form blend containing cement, slag, and fly ash when hydrated with caustic 4.4 M Na salt solution. Only the neat slag and cement + slag mixture hydrated with caustic 4.4 M Na salt solution contained fairly well crystallized C-S-H I and Al substituted 11 Å tobermorite.

Hydrotalcite and hydrocalumite-like phases and mixtures of these LDH phases were present in the all of the blended samples. However the proportions of these phases and probably their compositions varied. Not surprisingly, the phase assemblage in the 10:45:45 blend of cement : slag : fly ash resembled that of the slag : fly ash blend.

The mineralogy of the hydrated materials evaluated did not change significantly between 2 months and 14 months curing in sealed containers. Characterization of samples cured for much longer times is

recommended. Both drying conditions and curing in the presence of excess water are expected to result in changes in the mineralogy.

Cement hydrated for up to 14 months in water and up to 14 months in salt solution contained, poorly ordered C-S-H, portlandite $(Ca(OH)_2)$, and an AFm phase. The AFm phase identified in the salt solution hydrated sample was a sodium aluminate sulfate. Ettringite, an Aft phase $(Ca_6(Al,Fe)_2(OH)_{12}(SO_4)_3.26H_2O)$ was identified in the water hydrated cement sample but not in the salt solution hydrated sample. Unreacted larnite (Ca_2SiO_4) from the cement and NaNO₃ from the salt solution were detected in the salt solution hydrated sample.

Class F fly ash showed no significant reaction with water in the samples hydrated for 2 and 14 months. Hydration of the fly ash in salt solution resulted in dissolution of some of the glassy material as indicated by residual mullite "baskets". The only crystalline phases detected in the x-ray diffraction patterns were the refractory phases, mullite and quartz, present in the anhydrous fly ash.

GGBFS did not hydrate or hydration was very limited after 2 months in water based on x-ray diffraction results. However, after 14 months, a small amount of LDH phase (hydrotalcite and / or hydrocalumite (AFm) or a mixture) was detected in the x-ray pattern. In contrast, activation of the slag in the 4.4 M Na salt solution resulted in formation of fairly well crystallized C-S-H I and Al substituted 11 Å tobermorite ($Ca_5Si_3Al(OH)O_{17}$ ·5H₂O). These two ordered calcium silicate hydrates were detected in slag and mixtures of slag and cement hydrated with 4.4 M Na salt solution.

The mineralogy of the cured cementitious material influences the physical properties (strength, stiffness, etc.) of the cured material due to the degree of polymerization (chain length) and tetrahedron arrangement. Information about the mineralogy of hydrated cementitious materials and blends of these ingredients is needed to design waste form matrices, select ingredients and make adjustments in material proportions. Information presented in this report is an initial step in developing phase diagrams for the hydrated systems in which caustic sodium salt solutions are used as the hydration fluid for waste forms.

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Attachment 1. X-Ray Diffraction Powder Patterns

Materials Data Inc., JADE 20/10 software was used to analyze the diffraction patterns. Due to the complex patterns and presence of poorly ordered and amorphous material in a few cases the software identified refractory phases which could not be present.

Anhydrous Cementitious materials



















[309561] 448-7E Langton

























Attachment 2. Analysis of Ingredients Used to Prepare Samples

SRNL Process Science Analytical Laboratory Customer: Alex Cozzi Date: 3/25/08 Sample ID: 3/08 Cement, 3/08 Slag, 3/08 Fly Ash Lab ID: 08-0630 through 08-0632 Units: wt% Comments: Li2B407 digestion (cations), KOH digestions (anions)

Sample ID	Lab ID														
(wt%)		Al	Ba	Ca	Cr	Fe	<u>K</u>	Mg	<u>Mn</u>	Na	Р	S	<u>Si</u>	<u>Ti</u>	I
3/08 Cement (A)	08-0630	2.78	0.014	46.0	<0.010	2.60	0.511	0.714	0.019	<0.100	0.106	1.16	8.99	0.166	I
3/08 Cement (B)	08-0630	2.71	0.013	46.0	<0.010	2.75	0.486	0.693	0.019	<0.100	0.103	1.16	9.20	0.162	I
3/08 Slag (A)	08-0631	4.14	0.030	25.6	<0.010	0.215	0.347	8.00	0.282	0.160	<0.100	0.307	18.6	0.178	I
3/08 Slag (B)	08-0631	4.29	0.031	26.2	<0.010	0.231	0.356	7.78	0.292	0.174	<0.100	0.303	18.3	0.188	I
3/08 Fly Ash (A)	08-0632	13.2	0.077	1.76	<0.010	8.96	1.74	0.921	0.012	0.320	0.125	0.159	22.6	0.685	I
3/08 Fly Ash (B)	08-0632	13.1	0.076	1.74	<0.010	8.95	1.69	0.898	0.011	0.310	0.125	0.150	22.4	0.681	I
(wt%)		<u>AI2O3</u>	<u>BaO</u>	<u>CaO</u>	Cr2O3	Fe2O3	<u>K2O</u>	MgO	<u>MnO2</u>	<u>Na2O</u>	P2O5	<u>SO4</u>	<u>SiO2</u>	<u>TiO2</u>	Total
3/08 Cement (A)	08-0630	5.25	0.016	64.4	0.000	3.72	0.613	1.19	0.030	0.000	0.243	3.48	19.2	0.277	98.5
3/08 Cement (B)	08-0630	5.12	0.015	64.4	0.000	3.93	0.583	1.15	0.030	0.000	0.236	3.48	19.7	0.271	98.9
3/08 Slag (A)	08-0631	7.82	0.034	35.8	0.000	0.307	0.416	13.3	0.446	0.216	0.000	0.921	39.8	0.297	99.4
3/08 Slag (B)	08-0631	8.11	0.035	36.7	0.000	0.330	0.427	12.9	0.461	0.235	0.000	0.909	39.2	0.314	99.6
3/08 Fly Ash (A)	08-0632	24.9	0.086	2.46	0.000	12.8	2.09	1.53	0.019	0.432	0.286	0.477	48.4	1.14	94.7
3/08 Fly Ash (B)	08-0632	24.8	0.085	2.44	0.000	12.8	2.03	1.49	0.017	0.419	0.286	0.450	47.9	1.14	93.8

		F	CI	PO4
3/08 Cement (A)	08-0630	<0.200	<0.200	<0.200
3/08 Cement (B)	08-0630	<0.200	<0.200	<0.200
3/08 Slag (A)	08-0631	<0.200	<0.200	<0.200
3/08 Slag (B)	08-0631	<0.200	<0.200	<0.200
3/08 Fly Ash (A)	08-0632	<0.200	<0.200	0.380
3/08 Fly Ash (B)	08-0632	<0.200	<0.200	0.370

										LOD	LOI
						110°C			750°C	<u>(wt%)</u>	<u>(wt%)</u>
				Dry	Total	Wet Wt	Dry Wt	Dry	Total		
Sample ID	Lab ID	Empty (g)	<u>Full (g)</u>	<u>110°C (g)</u>	Solid	<u>(g)</u>	<u>(g)</u>	<u>750°C (g)</u>	Solid		
3/08 Cement (A)	08-0630	44.8822	45.8919	45.8897	99.782%	1.0097	1.008	45.8814	98.960%	0.200	1.05
3/08 Cement (B)	08-0630	44.8358	45.9705	45.9684	99.815%	1.1347	1.133	45.9584	98.934%		
3/08 Slag (A)	08-0631	43.9814	44.9903	44.9902	99.990%	1.0089	1.009	44.9901	99.980%	0.057	0.134
3/08 Slag (B)	08-0631	43.2951	44.3440	44.3429	99.895%	1.0489	1.048	44.3428	99.886%		
3/08 Fly Ash (A)	08-0632	45.1545	46.1879	46.1863	99.845%	1.0334	1.032	46.1408	95.442%	0.125	4.54
3/08 Fly Ash (B)	08-0632	44.9127	45.9603	45.9593	99.905%	1.0476	1.047	45.9129	95.475%		

			Cement						
	Cement A	Cememt B	Ave	Slag A	Slag B	Slag Ave	Fly Ash A	Fly Ash B	Fly Ash Ave
	wt%	wt%	wt%	wt%	wt%	wt%	wt%	wt%	wt%
CaO	64.4	64.4	64.4	35.8	36.7	36.3	2.4	2.4	2.4
MgO	1.19	1.2	1.2	13.3	12.9	13.1	1.5	1.5	1.5
AI2O3	5.25	5.1	5.2	7.8	8.1	8.0	24.9	24.8	24.9
Fe2O3	3.72	3.9	3.8	0.3	0.3	0.3	12.8	12.8	12.8
SiO2	19.2	19.7	19.5	39.8	39.2	39.5	48.4	47.9	48.2
TOTAL	93.76	94.3	94.0	97.0	97.2	97.1	90.1	89.4	89.8

	Normalized						
	10:45:45	25c:75fa	25c:75s	38s:62fa	Cement	Siay	CIASS F FIY ASI
CaO	24.9	10.2	15 1	15.8	68 5	37.3	27
MgO	7.0	19.2	40.1	6.2	1.2	13.5	1 7
	16.7	1.0	7.5	0.2	1.2	13.5	1.7
A1203	10.7	22.2	7.5	20.3	5.5	8.2	21.1
rezus	7.0	11.8	1.3	9.0	4.1	0.3	14.3
SIUZ	44.5	45.4	35.7	48.7	20.7	40.7	53.6
Total	100.0	100.0	100.0	100.0	100.0	100.0	100.0
C+M/A+S	0.520	0.307	1.285	0.319	2.66	1.04	0.05
C+M/S+A+F	0.467	0.261	1.248	0.282	2.30	1.03	0.05
C/A+S	0.406	0.284	1.043	0.230	2.61	0.76	0.03







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