



Standard Specification for Concrete Brick¹

This standard is issued under the fixed designation C 55; 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 This specification covers concrete brick and similar solid units (see Note 3) intended for use in structural masonry or facing for buildings and other structures, and are made from portland cement, water, and suitable mineral aggregates with or without the inclusion of other materials.

1.2 The text of this standard references notes and footnotes which provide explanatory material. These notes and footnotes (excluding those in tables and figures) shall not be considered as requirements of the standard.

1.3 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.

NOTE 1—Concrete brick covered by this specification are made from lightweight or normal weight aggregates, or both.

NOTE 2—When particular features are desired, such as weight classification, high compressive strength, surface textures for appearance or bond, finish, color, fire resistance, insulation, acoustical properties, or other special features, such properties should be specified separately by the purchaser. Local suppliers should be consulted as to the availability of concrete brick having the desired features.

2. Referenced Documents

2.1 ASTM Standards:

C 33 Specification for Concrete Aggregates²

C 140 Test Methods for Sampling and Testing Concrete Masonry Units and Related Units³

C 150 Specification for Portland Cement⁴

C 207 Specification for Hydrated Lime for Masonry Purposes⁴

C 331 Specification for Lightweight Aggregates for Concrete Masonry Units²

C 426 Test Method for Drying Shrinkage of Concrete Masonry Units³

C 595 Specification for Blended Hydraulic Cements⁴

C 618 Specification for Coal Fly Ash and Raw or Calcined Natural Pozzolan for Use as a Mineral Admixture in Portland Cement Concrete²

C 989 Specification for Ground Granulated Blast Furnace Slag for Use in Concrete and Mortars²

C 1157 Performance Specification for Hydraulic Cement⁴

C 1209 Terminology of Concrete Masonry Units and Related Units³

C 1232 Terminology of Masonry³

3. Terminology

3.1 Terminology defined in Terminology C 1209 and Terminology C 1232 shall apply for this specification.

4. Classification

4.1 *Grades*—Concrete brick manufactured in accordance with this specification shall conform to two grades as follows:

4.1.1 *Grade N*—For use as architectural veneer and facing units in exterior walls and for use where high strength and resistance to moisture penetration and severe frost action are desired.

4.1.2 *Grade S*—For general use where moderate strength and resistance to frost action and moisture penetration are required.

NOTE 3—The requirements for Grades N and S concrete brick are also applicable to solid concrete veneer and facing units larger than brick size, such as split block.

5. Materials and Manufacture

5.1 *Cementitious Materials*—Materials shall conform to the following applicable specifications:

5.1.1 *Portland Cement*—Specification C 150.

5.1.2 *Blended Hydraulic Cements*—Specification C 595.

5.1.3 *Hydraulic Cement*—Specification C 1157.

5.1.4 *Hydrated Lime, Type S*—Specification C 207.

5.1.5 *Ground Granulated Blast Furnace Slag*—Specification C 989.

5.1.6 *Pozzolans*—Specification C 618.

5.2 *Aggregates*—Aggregates shall conform to the following specifications, except that grading requirements shall not necessarily apply:

5.2.1 *Normal Weight Aggregates*—Specification C 33.

¹ This specification is under the jurisdiction of ASTM Committee C15 on Manufactured Masonry Units and is the direct responsibility of Subcommittee C15.03 on Concrete Masonry Units and Related Units.

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² *Annual Book of ASTM Standards*, Vol 04.02.

³ *Annual Book of ASTM Standards*, Vol 04.05.

⁴ *Annual Book of ASTM Standards*, Vol 04.01.

5.2.2 Lightweight Aggregates—Specification C 331.

5.3 *Other Constituents*—Air-entraining agents, coloring pigments, integral water repellents, finely ground silica, and other constituents shall be previously established as suitable for use in concrete masonry units and shall conform to applicable ASTM standards or shall be shown by test or experience not to be detrimental to the durability of the concrete masonry units or any material customarily used in masonry construction.

6. Physical Requirements

6.1 At the time of delivery to the purchaser, units shall conform to the physical requirements prescribed in Table 1.

6.2 At the time of delivery to the purchaser, the total linear drying shrinkage of units shall not exceed 0.065 % when tested in accordance with Test Method C 426.

NOTE 4—The purchaser is the public body or authority, association, corporation, partnership, or individual entering into a contract or agreement to purchase or install, or both, concrete brick. The time of delivery to the purchaser is FOB plant when the purchaser or the purchaser's agent transports the concrete brick, or at the time unloaded at the worksite if the manufacturer or the manufacturer's agent transports the concrete brick.

7. Dimensions and Permissible Variations

7.1 No overall dimension (width, height, and length) shall differ by more than $\pm \frac{1}{8}$ in. (3.2 mm) from the specified standard dimensions.

NOTE 5—Standard dimensions of concrete brick are the manufacturer's designated dimensions. Nominal dimensions of modular size concrete brick are equal to the standard dimensions plus the thickness of one mortar joint. Nominal dimensions of nonmodular size concrete brick usually exceed the standard dimensions by $\frac{1}{8}$ to $\frac{1}{4}$ in. (3.2 to 6.4 mm).

7.2 *Coring*—Unless otherwise specified, brick shall be either solid or cored at the option of the seller. The net cross-sectional area of cored brick in any plane parallel to the surface containing the cores shall be at least 75 % of the gross cross-sectional area measure in the same plane. No part of any hole shall be less than $\frac{3}{4}$ in. (19.1 mm) from any edge of the brick.

8. Finish and Appearance

8.1 All units shall be sound and free of cracks or other defects that interfere with the proper placement of the units or significantly impair the strength or permanence of the construction. Minor cracks incidental to the usual method of manufacture or minor chipping resulting from customary methods of handling in shipment and delivery are not grounds for rejection.

8.2 Where units are to be used in exposed wall construction, the face or faces that are to be exposed shall not show chips or

cracks not otherwise permitted or other imperfections when viewed from a distance of not less than 20 ft (6.1 m) under diffused lighting.

8.2.1 Five percent of a shipment containing chips, not larger than $\frac{1}{2}$ in. (12.7 mm) in any dimension, or cracks not wider than 0.02 in. (0.5 mm) and not longer than 25 % of the nominal height of the unit is permitted.

8.3 The color and texture shall be specified by the purchaser. The finished surfaces that will be exposed in place shall conform to an approved sample consisting of not less than four units, representing the range of texture and color permitted.

9. Methods of Sampling and Testing

9.1 The purchaser or authorized representative shall be accorded proper facilities to inspect and sample the concrete brick at the place of manufacture from the lots ready for delivery. At least 10 days shall be allowed for completion of the test.

9.2 Sample and test concrete brick in accordance with Test Methods C 140 and Test Method C 426, when applicable.

9.3 Total linear drying shrinkage shall be based on tests of concrete brick made with the same materials, concrete mix design, manufacturing process, and curing method, conducted in accordance with Test Method C 426 not more than 24 months prior to delivery.

10. Compliance

10.1 If a sample fails to conform to the specified requirements, the manufacturer shall be permitted to remove units from the shipment. A new sample shall be selected by the purchaser from remaining units from the shipment with a similar configuration and dimension and tested at the expense of the manufacturer. If the second sample meets the specified requirements, the remaining portion of the shipment represented by the sample meets the specified requirements. If the second sample fails to meet the specified requirements, the remaining portion of the shipment represented by the sample fails to meet the specified requirements.

NOTE 6—Unless otherwise specified in the purchase order, the costs of tests is typically borne as follows: (1) if the results of the tests show that the units do not conform to the requirements of this specification, the cost is typically borne by the seller; (2) if the results of the tests show that the units conform to the specification requirements, the cost is typically borne by the purchaser.

11. Keywords

11.1 absorption; architectural veneer; compressive strength; concrete brick; concrete masonry units; facing units; linear shrinkage; portland cement

TABLE 1 Strength and Absorption Requirements

Grade	Compressive Strength, min, psi (MPa) (Concrete Brick Tested Flatwise) Average Gross Area		Water Absorption, max, lb/ft ³ (Average of 3 Units)		
	Average of 3 Units	Individual Unit	Weight Classification—Oven Dry Weight of Concrete, lb/ft ³ (kg/m ³)		
			Lightweight less than 105 (1680)	Medium Weight less than 125 to 105 (2000 to 1680)	Normal Weight 125 (2000) or more
N	3500 (24.1)	3000 (20.7)	15 (240)	13 (208)	10 (160)
S	2500 (17.3)	2000 (13.8)	18 (288)	15 (240)	13 (208)

SUMMARY OF CHANGES

Committee C15 has identified the location of selected changes to this standard since C 55-01a that may impact the use of this standard.

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| (1) Portland cement was changed to hydraulic cement in 1.1. | 2 and 5 to identify it as a permissible cementitious material to |
| (2) C 989 for blast furnace slag cement was added to Sections | use in the production of concrete brick. |

Committee C15 has identified the location of selected changes to this standard since C 55-01 was published in the 2001 *Annual Book of ASTM Standards*, Vol 04.05.

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| (1) In Section 5 on Materials and Manufacture, Specification C 1157 was removed from Paragraph 5.1.2 to its own para- | graph and identified as hydraulic cement rather than blended cement. |
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