

# Investigation and Performance Improvement of Hot Mix Asphalt Concrete Containing EAF Slag

N. Hosseiniadeh, M. J. Rezaei, and S. M. Hosseini

**Abstract**—Over one million tons of electric arc furnace slag (EAF) wastes per year is produced just in Moharakoh Steel Company of Isfahan (MSC). According to large number of steel making factories all around the world, in recent years many researches have been done to minimize environmental impacts of these wastes by using them again in production of different materials like recycled structural concrete or hot mix asphalt concrete (HMAC). In this research EAF slag wastes which were produced by Moharakoh Steel Company (MSC) in Iran, were applied to produce an environmental friendly HMAC. Marshall stability and flow tests, indirect tensile strength test and resistance to moisture damage test were performed on specimens. Results showed that by optimizing combined gradation of HMAC mixtures containing EAF slags as fine aggregate and crushed stone as medium and coarse aggregate a relatively moisture resistant mixture with significant increase in Marshall stability and indirect tensile strength can be gained preserving asphalt cement content in same ratio and flow test result almost the same.

**Index Terms**—Electric arc furnace slag, asphalt concrete, hot mix, marshall test, indirect tensile strength, moisture damage.

## I. INTRODUCTION

The mineral aggregate in hot mix asphalt concrete (HMAC), including fine and coarse aggregate contain almost 90 percent in total volume of the HMAC. These aggregate work like the structural skeleton of the pavement and therefore have a significant influence on properties of pavements [1].

In recent years many researches have been performed to investigate influences of applying different waste materials as aggregate on performance of HMAC. Blast furnace slag and electric arc furnace slag are two of these waste materials which are produced in large amounts by steel making factories all over the world.

Marco Pasero and Nicola Baldo's in their research in 2009 on application of EAF slags in HMAC tested four HMAC mixtures which two of them contained EAF slag aggregate with maximum size of 15mm and in 2010 tested four HMAC mixtures which three of them contained EAF slags with maximum aggregate size of 10mm. Both experiments have verified that the use of waste material from steel production in the lithic skeleton of asphalt is a technically satisfactory option that fulfils the spirit of the "Zero Waste" target, that

the iron and steel industry has been aiming for in the last decade [2], [3].

Perviz Ahmedzadeh and Bunk Sengut in 2008 investigated performance of HMAC containing blast furnace slags as coarse aggregate. Results showed that applying blast furnace slag as coarse aggregate, increases Marshall stability and indirect tensile strength of HMAC and decreases flow test results [4].

From the technical viewpoint as mentioned before these slags possess physical, chemical and mechanical properties of HMAC and also from the ecological viewpoint, fewer areas are required for storing EAF slags and thus fewer environmental impacts there will be. Less amount of natural aggregate will be used in the road construction because of their replacement with slags and there is also potential risk of groundwater pollution by elution. On the other hand there is economical viewpoint which considers preparation costs of steel slags, necessity for accurate quality control and stricter environmental protection and decreasing maintenance of the road pavement including steel slags. These considerations are enough to make these slags highly suitable as an alternative replacement for natural aggregate in HMAC [3].

Because of their high resistance to polishing, steel slags including EAF slags are mostly used in surface layers of road pavements [5] however, another application of these slags is in road base and base course layers of flexible pavements which are not in direct contact with the vehicle tires and so the surface roughness of the slag grains contributes mainly to creating high internal friction, which is useful for increasing the mechanical stability of the bituminous mix.

The study described here was aimed at investigating and improving the performance of a wider range of HMAC mixtures containing EAF slag and crushed stone which can be briefed in more varied mixed aggregate gradation checking all possible mix designs. Marshall stability and flow test, indirect tensile strength (ITS) and resistance to moisture damage tests were performed on each specimen and results were compared with the corresponding traditional, natural solutions.

## II. EXPERIMENTAL PROCEDURES

### A. Materials

60/70 type asphalt cement was used in this study. The asphalt cement was procured from Jey Asphalt Cement Factory in Isfahan. Table I gives a summary of the results for some tests performed on the asphalt cement ordered by our research unit in MSC.

Crushed stone (CS) aggregate was procured from a stone mine near Isfahan and electric arc furnace slag produced in

Manuscript received November 29, 2014; revised February 27, 2015.

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