WSDOT Errata to FOP for AASHTO T 255

Total Evaporable Moisture Content of Aggregate by Drying

WAQTC FOP for AASHTO T 255 has been adopted by WSDOT with the following changes:

Sample Preparation

TABLE 1 Sample Sizes for Moisture Content of Aggregate – *Shall conform to the following nominal maximum size definition and include the note below.*

*For Aggregate, the nominal maximum size sieve is the largest standard sieve opening listed in the applicable specification upon which more than 1-percent of the material by weight is permitted to be retained. For concrete aggregate, the nominal maximum size sieve is the smallest standard sieve opening through which the entire amount of aggregate is permitted to pass.

Note: For an aggregate specification having a generally unrestrictive gradation (i.e., wide range of permissible upper sizes), where the source consistently fully passes a screen substantially smaller than the maximum specified size, the nominal maximum size, for the purpose of defining sampling and test specimen size requirements may be adjusted to the screen, found by experience to retain no more than 5 percent of the materials.

TOTAL EVAPORABLE MOISTURE CONTENT OF AGGREGATE BY DRYING FOP FOR AASHTO T 255

Scope

This procedure covers the determination of moisture content of aggregate in accordance with AASHTO T 255-25. It may also be used for other construction materials.

Overview

Moisture content is determined by comparing the wet mass of a sample and the mass of the sample after drying to constant mass. The term constant mass is used to define when a sample is dry.

Constant mass – the state at which a mass does not change more than a given percent, after additional drying for a defined time interval, at a required temperature.

Apparatus

- Balance or scale: Capacity sufficient for the principal sample mass, readable to 0.1 percent of sample mass or to 0.1 g, meeting the requirements of AASHTO M 231.
- Containers: clean, dry, and capable of being sealed
- Suitable drying containers
- Microwave safe container with ventilated lids
- Heat source: thermostatically controlled, capable of maintaining 110 ± 5°C (230 ± 9°F).
  - Forced draft oven (preferred)
  - Ventilated oven
  - Convection oven
- Heat source, uncontrolled, for use when allowed by the agency, which will not alter the material being dried, and when close control of the temperature is not required.
  - Infrared heater, hot plate, fry pan, or any other device/method allowed by the agency
  - Microwave oven (900 watts minimum)
- Hot pads or gloves
- Utensils such as spoons

Sample Preparation

Obtain a representative sample according to the FOP for AASHTO R 90 in its existing condition. If necessary, reduce to moisture content sample size according to the FOP for AASHTO R 76.

The moisture content sample size is based on Table 1 or other information that may be specified by the agency.

TABLE 1
Sample Sizes for Moisture Content of Aggregate

Nominal Maximum Size* mm (in.)	Minimum Sample Mass g (lb)
150 (6)	50,000 (110)
100 (4)	25,000 (55)
90 (3 1/2)	16,000 (35)
75 (3)	13,000 (29)
63 (2 1/2)	10,000 (22)
50 (2)	8000 (18)
37.5 (1 1/2)	6000 (13)
25.0 (1)	4000 (9)
19.0 (3/4)	3000 (7)
12.5 (1/2)	2000 (4)
9.5 (3/8)	1500 (3.3)
4.75 (No. 4)	500 (1.1)

* One sieve larger than the first sieve to retain more than 10 percent of the material using an agency specified set of sieves based on cumulative percent retained. Where large gaps in specification sieves exist, intermediate sieve(s) may be inserted to determine nominal maximum size.

Immediately seal or cover moisture content samples to prevent any change in moisture content or follow the steps in "Procedure."

Procedure

Determine all sample masses to the nearest 0.1 percent of the sample mass or 0.1 g.

When determining the mass of hot samples or containers or both, place and tare a buffer between the sample container and the balance. This will eliminate damage to or interference with the operation of the balance or scale.

1. Determine and record the mass of the container (and lid for microwave drying).
2. Place the wet sample in the container.
3. Determine and record the total mass of the container and wet sample.

   a. For oven(s), hot plates, infrared heaters, etc.: Spread the sample in the container.
   b. For microwave oven: Heap sample in the container; cover with ventilated lid.
4. Subtract the container mass determined in Step 1 from the mass of the container and sample determined in Step 3 and record the wet mass of the sample (M_W).
5. Place the sample in one of the following drying apparatuses:
   a. Controlled heat source (oven): at 110 ±5°C (230 ±9°F).
   b. Uncontrolled heat source (Hot plate, infrared heater, or other heat sources as allowed by the agency): Stir frequently to avoid localized overheating.
6. Dry until the sample appears moisture free.
7. Determine mass of sample and container.
8. Subtract the container mass determined in Step 1 from the mass of the container and sample determined in Step 7 and record the mass of the sample.
9. Return sample and container to the heat source for the additional time interval.
   a. Controlled (oven): 30 minutes
   b. Uncontrolled (Hot plate, infrared heater, or other heat sources as allowed by the agency): 10 minutes
   c. Uncontrolled (Microwave oven): 2 minutes

Caution: Some minerals in the sample may cause the aggregate to overheat, crack and explode, altering the aggregate gradation.

TABLE 2
Methods of Drying

Heat Source	Specific Instructions	Drying intervals to achieve constant mass (minutes)
Controlled:		
Forced Draft Oven (preferred), Ventilated Oven, or Convection Oven	110 ±5°C (230 ±9°F)	30
Uncontrolled:		
Hot plate, Infrared heater, or any other device/method allowed by the agency	Stir frequently	10
Microwave	Heap sample and cover with ventilated lid	2

10. Determine mass of sample and container.
11. Subtract the container mass determined in Step 1 from the mass of the container and sample determined in Step 10 and record.

12. Determine percent change by subtracting the new mass determination (M_n) from the previous mass determination (M_p), dividing by the previous mass determination (M_p), and multiplying by 100.
13. Continue drying, performing Steps 9 through 12, until there is less than a 0.10 percent change after additional drying time.
14. Constant mass has been achieved; sample is defined as dry.
15. Allow the sample and container to cool. Determine and record the total mass.
16. Subtract the container mass determined in Step 1 from the mass of the container and sample determined in Step 15 and record the dry mass of the sample (M_D).
17. Determine and record percent moisture (w) by subtracting the final dry mass determination (M_D) from the initial wet mass determination (M_W), dividing by the final dry mass determination (M_D), and multiplying` by 100.

Calculation

Constant Mass:

Calculate constant mass using the following formula:

$$\%\ Change = \frac{M_p - M_n}{M_p} \times 100$$

where:

M_p = previous mass measurement

M_n = new mass measurement

Example:

Mass of container:	1232.1 g
Mass of container after first drying cycle:	2637.2 g
Mass, M_p, of possibly dry sample:	2637.2 g - 1232.1 g = 1405.1 g
Mass of container and sample after second drying cycle:	2634.1 g
Mass, M_n, of sample:	2634.1 g - 1232.1 g = 1402.0 g

$$\%\ Change = \frac{1405.1\ \text{g} - 1402.0\ \text{g}}{1405.1\ \text{g}} \times 100 = 0.22\%$$

0.22 percent is not less than 0.10 percent, so continue drying

Mass of container and sample after third drying cycle: 2633.0 g

Mass, M_n, of sample: 2633.0 g - 1232.1 g = 1400.9 g

$$\% \, Change = \frac{1402.0 \text{ g} - 1400.9 \text{ g}}{1402.0 \text{ g}} \times 100 = 0.08\%$$

0.08 percent is less than 0.10 percent, so constant mass has been reached.

Moisture Content:

Calculate the moisture content, w, as a percent, using the following formula:

$$w = \frac{M_W - M_D}{M_D} \times 100$$

where:

w = moisture content, percent

M_W = wet mass

M_D = dry mass

Example:

Mass of container: 1232.1 g

Mass of container and wet sample: 2764.7 g

Mass, M_W, of wet sample: 2764.7 g - 1232.1 g = 1532.6 g

Mass of container and dry sample (COOLED): 2633.5 g

Mass, M_D, of dry sample: 2633.5 g - 1232.1 g = 1401.4 g

$$w = \frac{1532.6 \text{ g} - 1401.4 \text{ g}}{1401.4 \text{ g}} \times 100 = \frac{131.7 \text{ g}}{1401.4 \text{ g}} = 9.40\% \text{ report } 9.4\%$$

Report

- On forms approved by the agency
- Sample ID
- M_W, wet mass
- M_D, dry mass
- Moisture content to the nearest 0.1 percent

AGGREGATE WAQTC FOP AASHTO T 255 (25)

PERFORMANCE EXAM CHECKLIST

TOTAL MOISTURE CONTENT OF AGGREGATE BY DRYING

FOP FOR AASHTO T 255

Participant Name _____ Exam Date _____

Record the symbols "P" for passing or "F" for failing on each step of the checklist.

Procedure Element	**Trial 1**	**Trial 2**
1. Representative sample of appropriate mass obtained?	_____	_____
2. Mass of container determined to 0.1 percent or 0.1 g?	_____	_____
3. Sample placed in container and wet mass determined to 0.1 percent or 0.1 g?	_____	_____
4. Test sample mass conforms to the required mass?	_____	_____
5. Loss of moisture avoided prior to mass determination?	_____	_____
6. Sample dried by a suitable heat source?	_____	_____
7. If aggregate heated by means other than a temperature controlled oven, is sample stirred to avoid localized overheating?	_____	_____
8. If heated in a microwave, heaped and covered with a ventilated lid?	_____	_____
9. Is aggregate heated for the additional, specified time?	_____	_____
a. Forced draft, ventilated, convection ovens – 30 minutes		
b. Microwave – 2 minutes		
c. Other – 10 minutes		
10. Mass of sample and container determined?	_____	_____
11. Constant mass checked at drying intervals. Final interval showing less than 0.10 percent loss?	_____	_____
12. Sample cooled before dry mass determination to 0.1 percent or 0.1 g?	_____	_____
13. Calculations performed properly, and results reported to the nearest 0.1 percent?	_____	_____

Comments: First attempt: Pass_____Fail_____ Second attempt: Pass_____Fail_____

Examiner Signature _____ **WAQTC #:**_____

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