

Investigation of the compressive strength of CFRP wrapped nylon fiber reinforced concrete cylinders

Soumya Suhreed Das¹ and Rupak Mutsuddy²

¹*Department of Civil Engineering,
Stamford University Bangladesh, Dhaka, Bangladesh*

²*Department of Civil Engineering,
Bangladesh University of Engineering and Technology, Dhaka, Bangladesh*

Received 05 September 2021

Abstract

Nylon fibers are found to increase the mechanical properties of structural concrete when introduced into the concrete matrix by partially replacing fine aggregates. Since Nylon fibers are cheap waste materials, properly controlling their percentage into the matrix results in higher strength as well as cost control. This study discusses the compressive strength of nylon fiber induced concrete cylinders by wrapping them with 200gsm carbon fiber sheets as well as records the failure pattern. This is done by comparing the compressive strength of control specimens with sets of cylinders which are induced with nylon fiber and wrapped around with zero, one and three layers of CFRP laminates. It also discusses on several tensile tests carried out on CFRP strips which can be used as a measure to check hardener bond strengths in field. For that purpose, five coupons were prepared for flat tensile test and another five for overlap splice tensile test, stress-strain data were recorded; and the tests followed the guidelines stated in ACI code.

© 2021 Institution of Engineers, Bangladesh. All rights reserved.

Keywords: CFRP, flat tensile test, overlap splice test, bond strength, laminates.

1. Introduction

Retrofitting materials are used for strengthening an existing structural member, or repairing a member which has already lost its service capacity. Jacketing and plate bonding techniques, NSM FRP bars or strips, textile reinforcing using glass, aramid, polyethylene and carbon fiber fabrics etc. are famous retrofitting measures available for concrete members. Among these, Carbon Fiber Reinforced Polymer (CFRP) sheets are extensively used for their relatively cheaper expense and easy application. CFRP sheets can be attached to any concrete surface with minimal priming, and lesser amount of maintenance or supervision is required. The bond strength and mixing of saturants play a vital role in this process as well as the curing period for both priming and hardening are relatively short. If the compressive force that can be sustained by substrate concrete members when subjected to carbon fiber laminates can be

predicted beforehand, then the structures can be overloaded beyond the actual concrete compressive strength. Also, if the members are subjected to tensile forces; measuring the fiber bond strength under tensile loading similar predictions can be made. American Concrete Institute (ACI 440.3R) has explicit guidelines for FRPs intended for retrofitting and strengthening of concrete members. Subsection L.2 and L.3 are dedicated directly for the test methods of flat tensile test and overlap splice tensile test specimens. Test specifications, coupon size, preparation guideline of wet layup materials etc are clearly indicated there. (Hou and Ruiz 2000) tested strength properties of woven CFRP T300/914 under different strain rate. Their results indicated linear elastic properties in both [0] and [90] directions. Under tension, the specimens remained virtually linear elastic up to failure, and Plastic deformation occurred before total failure in compression tests. Tensile tests on $[\pm 45]$ specimens gave non-linear stress strain curves. Studies were also conducted with tensile and lap splice properties of CFRP sheets under varying temperature range (Cree et al. 2015), and CFRP bars as well (Aly et al. 2006). Tab materials for tensile testing of CFRP laminates were also determined using combination of digital image correlation and acoustic emission techniques (Tabrizi et al. 2019). On the other hand, FRP confinement of concrete cylinders were undertaken and compressive strengths were determined by various researchers (Benzaid et al. 2010), and idealization for design oriented stress strain curve were also conducted (Lam and Teng 2003) (Ozbakkaloglu et al. 2013).

Various other properties of members-either cylindrical or rectangular in shape was investigated by researchers. In a study, iso grid cylindrical shells were fabricated and wrapped with CFRP and their static compression test was checked against the numerical ones using FEM approach (Sakata and Ben 2012). Some researchers investigated on both static and dynamic properties of CFRP epoxy laminates to check the effects against blast loading and other high impact loads (Zhang et al. 2016). They investigated the application of a CFRP wrapped unidirectionally over a wide range of strain set. Confinement of brick masonry columns with CFRP laminates also suggested strong increase of substrate ultimate load, stiffness and ductility (Corradi et al. 2007). They utilized mono directionally wrapped CFRP sheets on 24 clay solid brick columns to determine the effects of FRP reinforcement systems where two widely diffused types of masonry columns having differing square cross-sections were tested for compression. But there are lesser studies on cost effective field testing of supplied CFRP laminates and plates where they can be used without overstressing the substrate concrete. Since the effectiveness of any bonded FRP system is dependent on the soundness and tensile strength of both the substrate and the FRP system, as well as there are fewer investigations to prescribe tensile and compressive strength of FRP sheets numerically, a prior assessment of the tensile and compressive strength of the supplied FRP system beforehand of application is required to avoid unwanted cases of overloading in site.

Discrete fibers such as Nylon (polyamide 6.6), are found to increasing durability of the concrete in deleterious environment with the presence of supplementary cementitious materials (Samrose and Mutsuddy 2019). Introducing nylon fibers in concrete matrix at certain ratio increases compressive, split tensile and flexural strength (Ali et al.). (Brugo et al. 2017) tried to interleave fibers into CFRP laminates and could efficiently control rate of delamination and crack propagation. This study has made an attempt to monitor the strength response of Nylon fiber induced concrete while subjected to CFRP lamination as well as measuring the bond strength of CFRP fabric laminates

2. Specimen preparation

The impregnated epoxy or hardener (locally known as saturant), which is an important latex for retrofitting the yielded frames with CFRP, needs to be tested for bond strength before field

application. Two types of tests were chosen for monitoring the supplied resins bond strength—flat tension test and overlap splice tensile test. Five coupons were prepared for flat tensile test and five others were prepared for overlap splice test. The supplied CFRP material has the following specifications besides the technical advantage of high strength, flexibility, non-corrosiveness, high alkalinity and lightweight.

Table 1
Properties of the supplied CFRP material

Color	Black
Woven	Unidirectional
Areal weight	200g/m ²
Fiber content	100%
Dry fiber tensile strength	5800 MPa
Composite Tensile Strength	4000 MPa
E Modulus	240 GPa
Thickness	0.111mm
Elongation at break	1.60%
Density	1.8 g/cm ³
Length / roll	100m
Width Package	60cm

For flat tensile test's laboratory preparation of wet layup materials, guidelines prescribed in ACI 440.3R section L.2 was rigorously followed. It consisted of a plastic sheet placed on a smooth, flat horizontal surface and resin was coated onto the film. The FRP fabric or sheet material was placed into the resin and additional resin was overcoated. This process was repeated for multiple plies with the help of a grooved roller used to work out trapped air. A second plastic sheet was placed over the assembly. Using the flat edge of a small paddle, excess resin was forcibly pushed out of the laminate with a screeding action in the fiber direction. The laminate was cured without removing the plastic. The sample size was 25mm wide and 12 inches long with three consecutive FRP straps with splayed resin. After a sample sandwich of FRP prepared, it was undergone for trial run in a universal testing machine. The ultimate load and stress were recorded in the dial gauge.

Also, for overlap splice tension test, ACI 440.3R's section L3 guidelines was used. The sample preparation process is same as of flat tensile test, except an overlap splice of 25mm was made between consecutive samples. Probable failure modes found in research are (source: ACI 440.3R)-

- Delamination/debond—The failure is a generally clean separation at the overlap interface.
- Tension failure—Specimen fails outside of overlap splice at representative single laminate strength and not within or adjacent to either of the grips.
- Splitting—Specimen fails along entire length, leaving portions of overlap bond intact.
- Tab failure—A significant proportion of failures within one specimen width of the tab should be cause to re-examine the tab material and configuration, gripping method and adhesive, and to make necessary adjustments to promote failure within gage length of specimen.

The test followed the testing procedure described on ASTM C39/C39M-20 (C09 Committee n.d.) guidelines for testing of cylinder compressive strength. For the purpose of monitoring the post yield and pre-yield behavior of 28-day old concrete cylinders; testing was done by wrapping the cylinders with CFRP. Four sets of cylinders were present: one set contains no presence nylon fiber in concrete matrix, one set with nylon fiber present and no layer of

CFRP wrapping, one set having nylon fiber present and one layer of wrapping and the final set has three layers of CFRP laminates. After monitoring the conditions of NFRC cylinders after they reached their capacity, need for impregnating them with resin and mono layer fiber was assessed to observe if their post-yield behavior could be modified. The w/c ratio was kept 0.42. The local sand used was kept 43.3 kg/cft and stone chips used was 44.64kg/cft. Measured slump was found to be 4.5 inches (true slump).



Fig. 1. Preparation of flat tensile and overlap splice coupons.



Fig. 2. Testing of flat tensile and overlap splice tension test coupons.



Fig. 3. CFRP Laminate wrapped cylinders ready for curing period.

Mold shapes used for cylinders were 4" x 8", and the mix ratio was maintained 1:1.5:3 for cement, local sand and stone chips. Nylon fibers were induced in the concrete matrix to prevent early age micro cracking (Khan and Ali 2016) and develop fatigue resistance (Lee et al. 2005); i.e. durability. These nylon fibers were slightly lighter than water (specific gravity 1.14) and the fiber content chosen was 0.1%. To ensure proper workability, conplast SP-337 superplasticisers were used according to recommended dosage.

Table 2
Load vs deflection scenario of loaded flat tensile coupons

Sample number	Maximum load sustained (kN)	Maximum deflection (mm)
01	32.2	15.36
02	31.98	15
03	33.29	15.36
04	29.42	14.62
05	27.27	17.06

Table 3
Load vs deflection scenario of loaded overlap splice tensile coupons

Sample number	Maximum load sustained (kN)	Maximum deflection (mm)
01	2.31	50.87
02	24.67	17.26
03	33.3	21.93
04	38.05	19.07
05	1.21	35.78

After 28day curing, the cylinders were taken out of water bath and surface dried. Nodules, protrusions, etc. if found, was cleared. Fabric was cut with heavy duty scissors having splits of 13 inches width and 8 inches height. The usage of dull or worn cutting implements was avoided to prevent fiber weakening or fraying. Prior to placing the fabric, concrete cylinders were primed with FSE302 (Primer Epoxy) by spraying, brushing or rolling and waited until the resin is slightly tacky.

The package of CFRP contained two primer mixes (A & B-designated FSE302) and two impregnated epoxy mixes (FSE 322). Both were mixed with a ratio of 2:1 for three minutes until the color is even. Then when the primer has dried off, the impregnated epoxy was pasted

over the primer. The drying period by primer is usually six hours, then the hardener was mixed and applied.

After 28 days and a curing period for setting of the hardener, the cylinders were tested in UTM for compressive strength. Cylinder sets were designated as following:

Concrete cylinders with no nylon fiber presence and no CFRP laminates = 0F0

Concrete cylinders with 0.1% nylon fiber and no CFRP laminates = 0F0.1

Concrete cylinders with 0.1% nylon fiber and one layer of CFRP laminates = 1F0.1

Concrete cylinders with 0.1% nylon fiber and three layers of CFRP laminates = 3F0.1

3. Findings on Tensile and Compression tests

3.1 Tensile test coupons

For five tensile test specimens, the corresponding recorded load vs deflection scenario is provided in Table 2. and for five overlap splice tensile test specimens, the corresponding recorded load vs deflection data is provided in Table 3. The load deflection data for these coupons registered from UTM was plotted in graph and following observations were made:

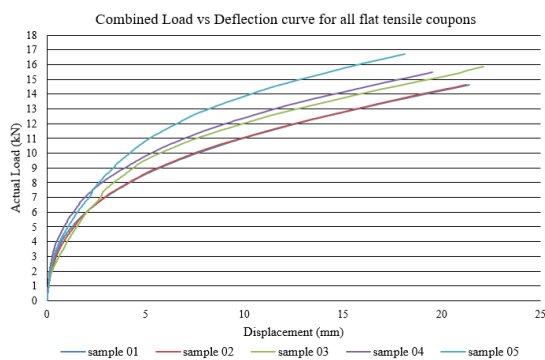


Fig. 4. Combined load vs deflection curve for all flat tensile coupons.

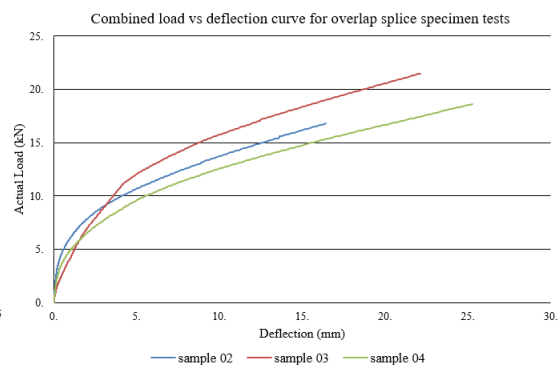


Fig. 5. Combined load vs deflection curve for all overlap splice tensile coupons.

From the registered load deflection data, it is evident that all of the samples showed nonlinear ductile characteristics under static increasing load. Sample 01 and 05 of overlap splice tensile coupons did a slip failure, so their load-deflection characteristics were not included in the graph.

Table 4
Failure criterion of flat tensile and overlap splice coupons

Flat tensile coupon 01:	Side splitting
Flat tensile coupon 02:	Side splitting
Flat tensile coupon 03:	Side splitting
Flat tensile coupon 04:	Side splitting
Flat tensile coupon 05:	Side splitting
Overlap splice coupon 01:	Plastic response after debonding starts, no splice failure, shear among layers and slip
Overlap splice coupon 02:	gradual crack development along plastic layer, tear of plastic and bursting of side
Overlap splice coupon 03:	tear of plastic, bursting of side with explosive sound, lap splice unharmed
Overlap splice coupon 04:	complete failure, splitting of plastic cover, debonding and total disintegration of layers
Overlap splice coupon 05:	cover splitting

Loads were multiplied with correction factor for to obtain actual load-deflection statistics. Average ultimate load was found out to be 30.82 kN, and all specimens showed almost similar yielding characteristics. Code specified minimum bond strength 5.5 MPa, where for sample strength, (1inch width = 25.4mm, 2mm thick) becomes 606 MPa, so sample sustains in required strength. And for overlap splice coupons it was found that coupons failed due to debonding between lateres, while splice region was unyielded. Also, it can be seen that since average strength of overlap splice samples is 19.91 kN, and cross section area beaing the same as flat tensile coupons, the debonding stress is 391 MPa which is greater than code specified minimum code strength. Failure criterion of all samples is summarized below:



Fig. 6(a). Typical failure Pattern of Flat tensile coupons.



Fig. 6(b). Typical failure pattern of Overlap splice tensile coupons.

3.2 Compression test of cylinders

The normal concrete cylinders yielded after reaching estimated crushing strength. Wrapping the cylinders with CFRP layers increase the yield strength to a high magnitude (almost 3/4 times). At first the 800kN capacity machine was used for testing the cylinders with FRP layers, but since increasing CFRP layers induces large crushing strength within the cylinders, for those with multiple layers of CFRP was shifted to a 2000kN capacity machine. Attaching one layer of FRP initiates heavy confining stress which increases the resistance against compression several times, while attaching three layers shifts concrete behavior from brittle to large ductile attitude. The cylinders start to sustain extremely high loads before coming down to collapse with high splitting sound. The corresponding capacities of different cylinders are stated below:

Table 5
Average compressive strengths sustained by cylinder sets in accordance with presence of CFRP layers

Cylinder labels	Sample number	Ultimate capacities (MPa)	Average compressive strength (MPa)
0F0	01	20.66	20.13
	02	19.47	
	03	20.26	
0F0.1	01	22.22	24.19
	02	25.92	
	03	24.44	
1F0.1	01	61.72	58.92
	02	60.49	
	03	54.56	
3F0.1	01	98.38	114.92
	02	119.24	
	03	127.14	

Observing the compressive strengths of different layers of wraps and presence of nylon fibers, it can be seen that when nylon fiber was introduced into the mix, the average compressive

strength of cylinders rose from 20.13 MPa to 24.19 MPa, indicating 1.20 times rise of average strength. After the nylon fiber induced cylinders were wrapped with CFRP, this rise was significantly visible. Wrapping cylinders with a single layer of FRP yields average strength of 58.92 MPa and cylinders with three layers of wrap is 114.92 MPa. So, wrapping a cylinder with one layer of CFRP increases the average strength of NFRC 2.44 times and with three layers the strength increment is almost 4.75 times. Cylinders starts to intake large number of loads due before failure due to their heightened stress absorbing capacity due to heavy confining strength provided by FRP plastics. From the graph provided below, it can be seen that for two layers the average compressive strength becomes around 85 psi, which is 3.5 times enhancement of the strength provided by no CFRP layers, and 1.44 times increment from one-layer CFRP. Adding another layer yields 1.35 times strength enhancement. So, it can be seen that adding one single layer of CFRP enhances the concrete strength hugely, and for practical purposes, to retrofit a concrete member under compressive stress or to strengthen an already performing concrete member under service loading, one layer of CFRP with surface priming and added hardener is recommended.

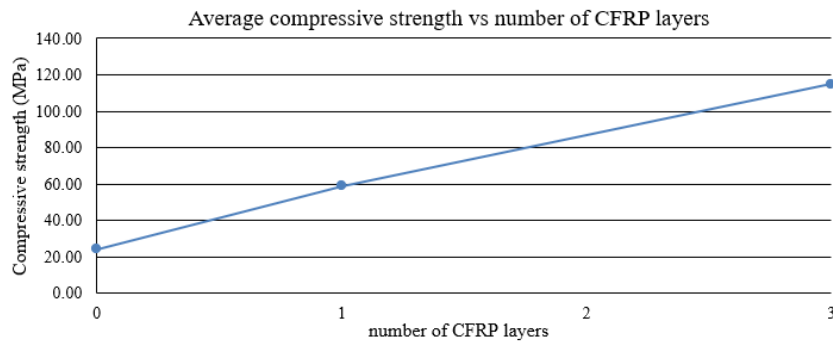


Fig. 7. Average compressive strength vs number of CFRP layers.

By observing the failure patterns, it can be seen that with increasing layers of FRP wrapped around the cylinders, the failure pattern shifts from splitting or shear/crushing failure to debonding of FRP layers by barreling effect then crushing. This type of failures that happen in those which are confined by CFRP layers, are mainly instigated by hoop tension stress that is caused by the wrapping CFRP layers in the negative direction by preventing the cylinders to collapse and assisting it to sustain a larger load. This hoop can be concentrated at the central zone of the cylinder specimens. The width of the hoop section determines the concrete section that remains attached with the inside face of delaminated CFRP. Summarizing the failure shapes yields the Table 6 is prepared.

Table 6

Failure types of concrete cylinders induced with nylon fiber and wrapped with various CFRP layers

Cylinder Designation	Failure Type
0F0.1 Sample 01	Shear failure
0F0.1 Sample 02	Side fracture at bottom
0F0.1 Sample 03	Cone and Shear
1F0.1 Sample 01	Debonding of laminate
1F0.1 Sample 02	Explosive or bursting of concrete
1F0.1 Sample 03	Crushing of concrete with delamination of fiber sheets from surface
3F0.1 Sample 01	Debonding from fiber sheets
3F0.1 Sample 02	Detachment of fiber laminates from primed concrete surface in the maximum hoop stress region
3F0.1 Sample 03	Detachment of fiber laminates from primed concrete surface in the maximum hoop stress region



(a) (b) (c)
Fig. 8. Sample control cylinders (consecutive failure types: (a) shear (b) side fracture at bottom (c) cone and shear).



(a) (b) (c)
Fig. 9. Cylinders wrapped with one layer of CFRP (a) (debonding of laminate) (b) explosive (c) crushing of concrete and fiber debonding.



Fig. 10. Failure pattern of cylinders wrapped in three layers.

4. Conclusion

The study results show a constant rise in the capacity of nylon fiber cylinders after introducing layers of CFRP fabric wrappings around it. Introducing one layer of CFRP showed a steep rise, and the rate of gain was slow with additional layers of laminates. It can be said that if a fourth layer was introduced, the rate would not vary much from the third one and failure would have been a complete debonding failure. Finally, a guideline for field test of CFRP bond strength of hardeners was completed by performing tensile tests and overlap splice tensile tests. The specimens which satisfied the prescribed behavior in ACI codes were accepted and those which did not rejected. By performing these tests, users of CFRP can be ensured of their material quality before applying it on their structural members.

References

- ACI 440.3R-04 Guide Test Methods for Fiber-Reinforced Polymers (FRPs) for Reinforcing or Strengthening Concrete Structures. Page 30-36.
- Ali, A., Aijaz, A., Arsalan, M. "a study on nylon fibre reinforced concrete by partial replacement of cement with metakaolin: a literature review." *International Research Journal of Engineering and Technology (IRJET)* Volume: 05 Issue: 03 | Mar-2018 05(03), 3 ISSN: 2395-0072.
- Aly, R., Benmokrane, B., and Ebead, U. (2006). "Tensile Lap Splicing of Bundled CFRP Reinforcing Bars in Concrete." *Journal of Composites for Construction, American Society of Civil Engineers*, 10(4), 287–294.
- Benzaid, R., Mesbah, H., and Chikh, N. E. (2010). "FRP-confined Concrete Cylinders: Axial Compression Experiments and Strength Model." *Journal of Reinforced Plastics and Composites, SAGE Publications Ltd STM*, 29(16), 2469–2488.
- Brugo, T., Minak, G., Zucchelli, A., Yan, X. T., Belcari, J., Saghafi, H., and Palazzetti, R. (2017). "Study on Mode I fatigue behaviour of Nylon 6,6 nano reinforced CFRP laminates." *Composite Structures*, 164, 51–57.
- C09 Committee. (n.d.). Test Method for Compressive Strength of Cylindrical Concrete Specimens. ASTM International.
- Corradi, M., Grazini, A., and Borri, A. (2007). "Confinement of brick masonry columns with CFRP materials." *Composites Science and Technology*, 67(9), 1772–1783.
- Cree, D., Gamaniouk, T., Loong, M. L., and Green, M. F. (2015). "Tensile and Lap-Splice Shear Strength Properties of CFRP Composites at High Temperatures." *Journal of Composites for Construction, American Society of Civil Engineers*, 19(2), 04014043.
- Hou, J. P., and Ruiz, C. (2000). "Measurement of the properties of woven CFRP T300/914 at different strain rates." *Composites Science and Technology*, 60(15), 2829–2834.
- Khan, M., and Ali, M. (2016). "Use of glass and nylon fibers in concrete for controlling early age micro cracking in bridge decks." *Construction and Building Materials*, 125, 800–808.
- Lam, L., and Teng, J. G. (2003). "Design-oriented stress–strain model for FRP-confined concrete." *Construction and Building Materials, Fibre-reinforced polymer composites in construction*, 17(6), 471–489.
- Lee, S. J., Rust, J. P., Hamouda, H., Kim, Y. R., and Borden, R. H. (2005). "Fatigue Cracking Resistance of Fiber-Reinforced Asphalt Concrete." *Textile Research Journal, SAGE Publications Ltd STM*, 75(2), 123–128.
- Ozbakkaloglu, T., Lim, J. C., and Vincent, T. (2013). "FRP-confined concrete in circular sections: Review and assessment of stress–strain models." *Engineering Structures*, 49, 1068–1088.
- Sakata, K., and Ben, G. (2012). "Fabrication method and compressive properties of CFRP isogrid cylindrical shells." *Advanced Composite Materials, Taylor & Francis*, 21(5–6), 445–457.
- Samrose, S., and Mutsuddy, R. (2019). durability of nylon fiber reinforcement concrete. Conference: International Conference on Disaster Risk Management, March 2019
- Tabrizi, I. E., Khan, R. M. A., Massarwa, E., Zanjani, J. S. M., Ali, H. Q., Demir, E., and Yildiz, M. (2019). "Determining tab material for tensile test of CFRP laminates with combined usage of digital image correlation and acoustic emission techniques." *Composites Part A: Applied Science and Manufacturing*, 127, 105623.
- Zhang, X., Hao, H., Shi, Y., Cui, J., and Zhang, X. (2016). "Static and dynamic material properties of CFRP/epoxy laminates." *Construction and Building Materials*, 114, 638–649.