

TITLE OF THE INVENTION

**CALCIUM FERROALUMINATE COMPOUND, CEMENT ADMIXTURE
AND PROCESS FOR PRODUCING SAME, AND CEMENT COMPOSITION**

5 BACKGROUND OF THE INVENTION

FIELD OF THE INVENTION

[0001]

The present invention relates primarily to a cement
admixture and a cement composition used in the civil
10 engineering and construction fields.

DESCRIPTION OF THE PRIOR ART

[0002]

Calcium aluminoferrite has been well known as a CaO-
15 Al_2O_3 - Fe_2O_3 based compound used for cement admixtures.
The calcium aluminoferrite known so far in the art
includes $4\text{CaO}\cdot\text{Al}_2\text{O}_3\cdot\text{Fe}_2\text{O}_3$ (C_4AF), $6\text{CaO}\cdot 2\text{Al}_2\text{O}_3\cdot\text{Fe}_2\text{O}_3$ ($\text{C}_6\text{A}_2\text{F}$),
and $6\text{CaO}\cdot\text{Al}_2\text{O}_3\cdot 2\text{Fe}_2\text{O}_3$ (C_6AF_2).

[0003]

20 These calcium aluminoferrites have a crystal
structure of $2\text{CaO}\cdot\text{Fe}_2\text{O}_3$ (C_2F) that is a sort of calcium
ferrite. In short, they keep a C_2F crystal structure
although a large amount of Al_2O_3 is solid-solubilized in
 C_2F , and take a variety of $\text{Al}_2\text{O}_3/\text{Fe}_2\text{O}_3$ molar ratios in
25 terms of composition. The C_2F crystal structure is an
orthorhombic system where $a=5.32\text{\AA}$, $b=14.48\text{\AA}$ and $c=5.51\text{\AA}$
with a unit lattice volume of $424.95\text{\AA}^3$.

[0004]

On the other hand, $\text{CaO} \cdot 2\text{Al}_2\text{O}_3$ (CA_2) has been known as a sort of calcium aluminate. The crystal structure of CA_2 is a monoclinic system where $a=12.89\text{\AA}$, $b=8.88\text{\AA}$ and $c=5.45\text{\AA}$ with a unit lattice volume of $596.41\text{\AA}^3$.

5 [0005]

Thus, C_2F and CA_2 have quite different crystal structures, and never until now is any compound with a Fe_2O_3 component solid-solubilized in CA_2 known in the art.
[0006]

10 By the way, there has recently been mounting demand for improvements in the durability of concrete structures in the civil engineering and construction fields.
[0007]

One factor of degradation of concrete structures is
15 damage caused by salt where reinforcing bars (rebars) corrode visibly in the presence of chloride ions, and to hold back that damage, there is a method for imparting resistance to penetration of chloride ions to concrete structures.

20 [0008]

In order to keep chloride ions from penetrating into a concrete structure thereby imparting resistance to penetration of chloride ions to it, there is a method of reducing water/cement ratios known in the art (see Non-
25 Patent Publication 1). However, the method of reducing water/cement ratios is not only detrimental to workability but may also provide no drastic measure.
[0009]

There has also been a method of using a cement admixture composed mainly of $\text{CaO} \cdot 2\text{Al}_2\text{O}_3$ and gypsum and further containing an inorganic chloride for the purpose of imparting early strength to cement concrete and preventing corrosion of rebars (see Patent Publication 1).
[0010]

In addition, there has been a method of using a cement admixture containing calcium aluminate having a $\text{CaO}/\text{Al}_2\text{O}_3$ molar ratio of 0.3 to 0.7 and a Blaine's specific surface area of 2,000 to 6,000 cm^2/g thereby making sure good resistance to penetration of chloride ions and preventing temperature cracking of mass concrete (see Patent Publication 2). A problem with this cement admixture is, however, that a rapid-hardening feature appears in high-temperature environments with detrimental to the workability of cement concrete mixed with it. For instance, the rapid-hardening feature would not only appear in regions where high temperatures prevail and Chloride Attack and acidic degradation are accelerated such as Okinawa at home and Singapore abroad, but it has also emerged through numerous studies made by the inventors that the resistance to penetration of chloride ions is not fully exerted. Thus, there is still expectation of the development of a rustproofing technology that works more effectively in high-temperature environments where the diffusion speed of corrosive components is high and corrosion reactions are accelerated.

[0011]

On the other hand, cement compositions mixed with finely pulverized, quenched, granulated blast-furnace slag and pozzolan substances have been known to make
5 improvements in the resistance to penetration of chloride ions. Why they inhibit the penetration of chloride ions is that the Al component in the finely pulverized, quenched, granulated blast-furnace slag contributes to chemical fixation, or electrical absorption, of chloride
10 ions. Referring here to reductions of calcium hydroxide in hardened cement, the pozzolan substances would appear to reduce voids of a few tens to a few hundred of micrometers that are otherwise formed in the case where calcium hydroxide is leached out in seawater. However,
15 the reactions of finely pulverized, quenched, granulated blast-furnace slag and pozzolan substances tend to take place over an extended period of time, impeding the development of initial strength, and giving rise to a problem that as they are immersed in seawater in an early
20 material age, it causes the resistance to penetration of chloride ions to go down, resulting in degradation of concrete. In order to improve durability, viz., seawater resistance, it is thus required to accelerate reactions in hardened cement, thereby reducing penetration of
25 chloride ions under the action of seawater from an early material age.

[0012]

On the other hand, there has also been a method for

adding nitrites or the like proposed for the purpose of prevention rusting of rebars (see Patent Publications 3 and 4). However, the nitrites have been found to have no effect on acid resistance at all.

5

Listing of the Prior Arts

Patent Publications

[0013]

Patent Publication 1: JP(A) 47-035020

10 Patent Publication 2: JP(A) 2005-104828

Patent Publication 3: JP(A) 53-003423

Patent Publication 4: JP(A) 01-103970

Non-Patent Publications

[0014]

15 Non-Patent Publication 1: "Durability Series for Concrete Structures, Chloride Attack (I)" edited by K. Kishitani, N. Nishizawa, etc., Gihodobook, pp. 34-37, May 1986

SUMMARY OF THE INVENTION

20 [0015]

Providing a solution to such problems as described above, the present invention has for its purpose the provision of a cement admixture that can impart good rustproofness to rebars in hardened cement concrete even
25 in high-temperature environments, has resistance to penetration of chloride ions entering from the outside into the hardened cement concrete, keeps the hardened cement concrete from getting porous because of less

leaching of Ca ions out of the hardened cement concrete, and has a self-recovery capability enabling cracks to be recovered on their own, its manufacturing method, and a cement composition containing that cement admixture.

5 [0016]

To achieve the aforesaid object, the present invention is embodied as follows.

- (1) A calcium ferroaluminate compound, comprising a $\text{CaO-Al}_2\text{O}_3\text{-Fe}_2\text{O}_3$ system, and having a Fe_2O_3 content of 0.5
10 to 15 % by mass and a $\text{CaO}\cdot 2\text{Al}_2\text{O}_3$ structure.
- (2) A cement admixture, characterized by containing a calcium ferroaluminate as recited in (1), wherein the $\text{CaO}/\text{Al}_2\text{O}_3$ molar ratio ranges from 0.15 to 0.7.
- (3) A cement admixture as recited in (2), which has a
15 fineness of 2,000 to 7,000 cm^2/g as represented in terms of a Blaine's specific surface area value.
- (4) A cement admixture as recited in (2) or (3), which further contains a potentially hydraulic substance and/or a pozzolan substance.
- 20 (5) A cement admixture as recited in (4), wherein said potentially hydraulic substance and/or said pozzolan substance contain one or two or more selected from the group consisting of finely pulverized, quenched, granulated blast-furnace slag, fly ash, silica fume,
25 metakaolin, incinerated pulp sludge ash, incinerated sewage sludge ash, and waste glass powder.
- (6) A cement admixture as recited in (4) or (5), wherein said calcium ferroaluminate and said potentially

hydraulic substance and/or said pozzolan substance are blended together in a blending proportion of 10/1 to 1/10 by mass.

- (7) A method for manufacturing a cement admixture, characterized in that a CaO-containing raw material, an Al_2O_3 -containing raw material and an iron-containing raw material are blended together such that a $\text{CaO}/\text{Al}_2\text{O}_3$ molar ratio ranges from 0.15 to 0.7 and an Fe_2O_3 content ranges from 0.5% to 15% by mass, and heat treated at $1,400^\circ\text{C}$ to $1,600^\circ\text{C}$ inclusive to obtain a clinker, and said clinker is pulverized down to a Blaine's specific surface area value ranging from 2,000 to 7,000 cm^2/g .
- (8) A cement composition, which contains cement and a cement admixture as recited in any one of (1) to (6).

ADVANTAGES OF THE INVENTION

[0017]

The inventive cement admixture has some considerable advantages: it makes sure sufficient work times even in high-temperature environments, ensures a good rustproofing feature (rustproofness) combined with resistance to penetration of chloride ions entering from the outside, and keeps the hardened cement concrete from becoming porous due to less leaching of Ca ions out of it.

BRIEF DESCRIPTION OF THE DRAWINGS

[0018]

Fig. 1 is an XRD diagram for calcium ferrite and calcium aluminoferrite.

Fig. 2 is an XRD diagram for calcium ferroaluminate and calcium aluminate.

5

BEST MODE FOR CARRYING OUT THE INVENTION

[0019]

The present invention will now be explained in greater details.

10 It is to be noted that unless otherwise specified, the "part(s)" and "%" are given on a mass basis.

It is also to be noted that the "cement concrete" referred herein is a generic term for cement pastes, cement mortars, and concretes.

15 [0020]

Through numerous experiments, the inventors have found that the Fe_2O_3 component can be solid-solubilized in CA_2 , and revealed that this solid solution still keeps the CA_2 structure intact, providing a compound quite different from calcium aluminoferrites such as C_4AF , $\text{C}_6\text{A}_2\text{F}$, and C_6AF_2 in terms of composition and crystal structure. The compound having Fe_2O_3 solid-solubilized in CA_2 while keeping the crystal structure of CA_2 intact is called the calcium ferroaluminate.

25 [0021]

The calcium ferroaluminate compound (hereinafter referred to as the CFA compound) used herein is a generic term for compounds composed primarily of CaO , Al_2O_3 and

Fe_2O_3 and obtained by mixing together raw materials containing calcia, alumina, ferrite, etc. and firing the resultant mixture in a kiln, fusing it in an electric furnace or otherwise heat treating it.

5 Referring here to the composition of the CFA compound, it has a $\text{CaO}/\text{Al}_2\text{O}_3$ molar ratio of 0.15 to 0.7 and a Fe_2O_3 content of 0.5 to 15%. More preferably, the $\text{CaO}/\text{Al}_2\text{O}_3$ molar ratio should be 0.4 to 0.6. At less than 0.15, no sufficient resistance to penetration of chloride ions may
10 often be obtained, and at greater than 0.7, on the contrary, the rapid-hardening feature may often appear, failing to make sure pot life. The Fe_2O_3 content of the CFA compound should be preferably 0.5 to 15%, more preferably 1 to 12%, and most preferably 3 to 10%. At
15 less than 0.5%, there may often a lot of unreacted aluminum oxide remaining upon heat treatment, which does not only make the formation reaction of calcium ferroaluminate unlikely to keep on going but also gives rise to rapid-hardening features in high-temperature
20 environments, ending up with a lowering of workability and a worsening of resistance to penetration of chloride ions. At greater than 15%, on the contrary, the effect on keeping the reaction on going efficiently levels off, and the resistance to penetration of chloride ions tends
25 to go worse too.

[0022]

The fineness of the CFA compound should be preferably 2,000 to 7,000 cm^2/g , more preferably 3,000 to 6,000

cm²/g, and most preferably 4,000 to 5,000 cm²/g as represented in terms of the Blaine's specific area value (hereinafter called the Blaine's value). If the CFA compound is in coarse particle form, no sufficient
5 resistance to penetration of chloride ions may often be obtained, and if the CFA compound in powder form finer than 7,000 cm²/g, there may often be the rapid-hardening feature appearing, resulting in a failure to make sure pot life.

10 [0023]

The raw materials used to prepare the CFA compound will now be explained.

By way of example but not by way of limitation, the CaO-containing raw material includes quick lime (CaO),
15 hydrated lime (Ca(OH)₂) and limestone (CaCO₃), all commercially available as industrial materials.

By way of example but not by way of limitation, the Al₂O₃-containing raw material includes Al₂O₃, aluminum hydroxide and bauxite, all commercially available as
20 industrial materials, among which bauxite is more desirable because of containing both Al₂O₃ and Fe₂O₃.

By way of example but not by way of limitation, the iron-containing raw material includes Fe₂O₃ obtained from the pulverization, processing and refinement of iron ore,
25 and Fe₂O₃ obtained through the recovery and refinement of waste hydrochloric acid upon steel scrubbing, all commercially available as industrial materials. FeO, Fe₃O₄, and even pure iron, if heat treated in an

oxidizing atmosphere, may be used too.

These iron-containing raw materials may be used in combination with, for instance, SiO_2 and R_2O (R is an alkaline metal) without detrimental to the object of the invention.

[0024]

The CFA compound may be obtained by mixing together the CaO -containing raw material, the Al_2O_3 -containing raw material, the iron-containing raw material, etc., and firing the resultant mixture in a kiln, fusing it in an electric furnace or otherwise heat treating it. Although depending on the blend of the raw materials, the heat-treatment temperature should be preferably 1,400 to 1,600°C inclusive, and more preferably 1,450 to 1,550°C inclusive. At lower than 1,400°C, it is less likely that the reaction involved keeps on going efficiently, leaving some Al_2O_3 unreacted and rendering it impossible to obtain calcium ferroaluminate. At higher than 1,600°C, on the contrary, it is often likely that the raw materials may stick up, rendering operation difficult and giving rise to a worsening of energy efficiency.

[0025]

In the present invention, the CFA compound having a $\text{CaO}/\text{Al}_2\text{O}_3$ molar ratio of 0.15 to 0.7 and a Fe_2O_3 content of 0.5 to 20% may be used in combination with the potentially hydraulic substance and/or pozzolan substance for the purpose of maintaining sufficient rustproofness, resistance to penetration of chloride ions and the effect

on keeping Ca ions from leaching, enhancing initial strength, and improving the self-recovery capability.

Specifically but not exclusively, the potentially hydraulic substance and/or pozzolan substance used herein
5 include finely pulverized, quenched, granulated blast-furnace slag, fly ash, silica fume, metakaolin, incinerated pulp sludge ash, incinerated sewage sludge ash, and waste glass powder. In order to make further enhancement of the aforesaid effects, finely pulverized,
10 quenched, granulated blast-furnace slag, fly ash, silica fume, and metakaolin is preferred.

[0026]

Specifically but not exclusively, the proportion of the CFA compound blended with the potentially hydraulic
15 substance and/or pozzolan substance should be preferably 10/1 to 1/10 by mass, and more preferably 5/1 to 1/5 by mass.

If the blending proportion of the CFA compound to the pozzolan substance (potentially hydraulic substance) is
20 set in the aforesaid range, the sufficient rustproofness, the resistance to penetration of chloride ions, the effect on inhibition of leaching of Ca ions, and the self-recovery capability are much more improved than the CFA compound is used alone.

25 [0027]

The cement used herein includes a variety of Portland cements such as normal Portland cement, high-early strength Portland cement, super-early strength Portland

cement, low-heat Portland cement and moderate-heat Portland cement; a variety of mixed cements of those Portland cements with blast-furnace slag, fly ash or silica; filler cements mixed with limestone powders,
5 finely pulverized, cooled-down blast-furnace slag; and Portland cements such as environmentally friendly cements (eco-cements) produced using incinerated municipal garbage ash, and incinerated sewage sludge ash as the raw material, which may be used alone or two or more.

10 [0028]

Specifically but not exclusively, when only the calcium ferroaluminate compound is used as the cement admixture, the amount of the cement admixture is preferably 1 to 15 parts, and more preferably 2 to 12
15 parts per 100 parts of the cement composition composed of cement and the cement admixture. As the amount of the cement admixture used is smaller, it may often provide none of the sufficient rustproofness, the resistance to penetration of chloride ions and the effect on prevention
20 of leaching of Ca ions, and excessive use may often cause the rapid-hardening feature to appear, failing to make sure sufficient pot life. When the calcium ferroaluminate compound and the potentially hydraulic substance and/or pozzolan substance are used as the
25 cement admixture, the cement admixture is used in an amount of preferably 1 to 50 parts, and more preferably 5 to 30 parts per 100 parts of the cement composition made up of cement and the cement admixture. As the amount of

the cement admixture used is smaller, it may often provide none of the sufficient rustproofness, the resistance to penetration of chloride ions and the effect on prevention of leaching of Ca ions, and excessive use
5 may often cause the rapid-hardening feature to appear, failing to make sure sufficient pot life.

[0029]

In the present invention, cement is blended with the cement admixture or the CFA compound into a cement
10 composition.

[0030]

In the cement composition of the invention, the water/binder ratio should be preferably 25 to 70%, and more preferably 30 to 65%. A smaller amount of water may
15 often cause a lowering of pump delivery or workability, shrinkage or the like, and too much water may often render the ability to develop strength lower. The "binder" herein refers to the cement and CFA compound combined.

20 [0031]

In the cement admixture or cement composition of the invention, the respective materials may be mixed on site or may have been partly or wholly mixed together.

[0032]

25 In the present invention, the cement and cement admixture as well as fine aggregates such as sand and coarse aggregates such as gravel may be used in combination with one or two or more in the group

consisting of expanding materials, rapid-hardening mortar-accelerators, water-reducing agents, AE water-reducing agents, AE water-reducing agents, high-performance water-reducing agents, high-performance AE
5 water-reducing agents, defoamers, thickeners, conventional rustproofing agents, antifreezers, shrinkage-reducing agents, hardening modifiers, clay minerals such as bentonite, anion exchangers such as hydrotalcite, slag such as finely pulverized, quenched,
10 granulated blast-furnace slag and finely pulverized, cooled-down blast-furnace slag and admixture materials such as finely pulverized limestone without substantial detrimental to the object of the invention.

[0033]

15 The mixing apparatus used may be any one of exiting mixers such as tilting mixers, omini mixers, Henschel mixers, V-type mixers, and Nauta mixers.

[0034]

More specifically but not exclusively, the present
20 invention will now be explained with reference to inventive and comparative examples.

EXAMPLES

[0035]

25 Identification of the compound's crystal structure

Synthesized were calcium ferrite (C_2F), calcium aluminoferrites (C_4AF , C_6A_2F , C_6AF_2), calcium ferroaluminate and calcium alluminate (CA_2).

Shown in Fig. 1 are XRD diagrams for calcium ferrite (C_2F) and calcium aluminoferrites (C_4AF , C_6A_2F , C_6AF_2), from which it is found that these compounds have the same crystal structure.

5 Shown in Fig. 2, on the other hand, are XRD diagrams for calcium ferroaluminate and calcium aluminate (CA_2), from which it can be seen that in the calcium ferroaluminate, Fe_2O_3 is solid-solubilized while keeping the CA_2 structure intact. It can also be seen that as Fe_2O_3
10 exceeds 15%, there is no solid solubilization taking place, resulting in precipitation of magnetite. It has thus been demonstrated that the calcium ferroaluminate is a compound quite different from calcium aluminoferrite that is a $CaO-Al_2O_3-Fe_2O_3$ system compound known so far in
15 the art.

[0036]

Experimental Example 1

Primary reagent calcium carbonate and primary reagent aluminum oxide were blended together in such molar ratios
20 as set out in Table 1 on an oxide basis, and primary reagent iron oxide was blended to the mixture in such Fe_2O_3 contents as set out in Table 1 for firing of the resulting mixture in an electric furnace. A blend having a CaO/Al_2O_3 molar ratio of 0.7, a blend having a CaO/Al_2O_3
25 molar ratio of 0.6, a blend having a CaO/Al_2O_3 molar ratio of 0.4, and a blend having a CaO/Al_2O_3 molar ratio of 0.15 were fired at 1,400°C, 1,450°C, 1,500°C, and 1,550°C, respectively, for 3 hours, and then cooled down

for synthesis. The samples were all adjusted to a Blaine's value of 4,000 cm²/g. For the purpose of comparison, a sample which was free of iron oxide, a sample which contained SiO₂, and a sample which contained R₂O were likewise synthesized. Whether or not there were unreacted matters were estimated by means of X-ray diffraction. The results are set out in Table 1.

[0037]

Estimation by X-ray diffraction

Cross × indicates that the diffraction peak for unreacted matters (aluminum oxide) was clearly identified; triangle Δ indicates that there is a little peak identified; and circle ○ indicates that no peak was identified.

[0038]

Table 1

Ex. No.	CaO/Al ₂ O ₃ Molar Ratio	Fe ₂ O ₃ (%)	Identification by
			XRD
1-1	0.15	0.5	○
20 1-2	0.15	1	○
1-3	0.15	3	○
1-4	0.15	10	○
1-5	0.15	12	○
1-6	0.15	15	○
25 1-7	0.4	0.5	○
1-8	0.4	1	○
1-9	0.4	3	○
1-10	0.4	10	○

			18	
	1-11	0.4	12	○
	1-12	0.4	15	○
	1-13	0.6	0.5	○
	1-14	0.6	1	○
5	1-15	0.6	3	○
	1-16	0.6	10	○
	1-17	0.6	12	○
	1-18	0.6	15	○
	1-19	0.7	0.5	○
10	1-20	0.7	1	○
	1-21	0.7	3	○
	1-22	0.7	10	○
	1-23	0.7	12	○
	1-24	0.7	15	○
15	1-25	0.15	0	×
	1-26	0.4	0	×
	1-27	0.6	0	×
	1-28	0.7	0	△
	1-29	0.4	3*	×
20	1-30	0.4	3**	×

*: Silicon oxide was added instead of iron oxide.

** : Instead of iron oxide, sodium carbonate was added in an amount of 3% as calculated on a Na₂O basis.

[0039]

25 From Table 1, it is found that the incorporation of iron enables the CFA compounds to be synthesized without leaving some alumina unreacted yet with high energy efficiency.

Referring here to the iron-free samples, the diffraction peak for unreacted aluminum oxide disappeared by firing the sample having a $\text{CaO}/\text{Al}_2\text{O}_3$ molar ratio of 0.7 at 1,500°C or higher, the sample having a $\text{CaO}/\text{Al}_2\text{O}_3$ molar ratio of 0.6 at 1,550°C or higher, the sample having a $\text{CaO}/\text{Al}_2\text{O}_3$ molar ratio of 0.4 at 1,600°C or higher, and the sample having a $\text{CaO}/\text{Al}_2\text{O}_3$ molar ratio of 0.15 at 1,650°C or higher.

[0040]

10 Experimental Example 2

The CFA compounds set out in Table 2 were each blended with cement in an amount of 7 parts per 100 parts of cement and the CFA compound to prepare a cement composition, and a mortar sample having a water/binder ratio of 0.5 was prepared according to JIS R 5201. This mortar sample was measured in terms of hardening time, rustproofness, compressive strength, depth of penetration of chlorides, leaching of Ca ions and resistance to sulfate attack. The results are also set out in Table 2. Note here that the tests were carried out in an environment of 30°C.

[0041]

CAF Compounds

CFA Compound A

25 Primary reagent calcium carbonate and primary reagent aluminum oxide were blended together in a given proportion, and primary reagent iron oxide was further blended with the mixture in such a way as to provide a

Fe₂O₃ content of 3%. As in Experimental Example 1, the blend was fired at 1,550°C in an electric furnace, and cooled down for synthesis. The CaO/Al₂O₃ molar ratio was 0.1, and the Blaine's value was 4,000 cm²/g.

5 CFA Compound B

Experiment No. 1-3; the CaO/Al₂O₃ molar ratio was 0.15, the Fe₂O₃ content was 3%, and the Blaine's value was 4,000 cm²/g.

CFA Compound C

10 Experiment No. 1-9; the CaO/Al₂O₃ molar ratio was 0.4, the Fe₂O₃ content was 3%, and the Blaine's value was 4,000 cm²/g.

CFA Compound D

15 Experiment No. 1-15; the CaO/Al₂O₃ molar ratio was 0.6, the Fe₂O₃ content was 3%, and the Blaine's value was 4,000 cm²/g.

CFA Compound E

20 Experiment No. 1-21; the CaO/Al₂O₃ molar ratio was 0.7, the Fe₂O₃ content was 3%, and the Blaine's value was 4,000 cm²/g.

CFA Compound F

25 This compound was synthesized by firing at 1,400°C in an electric furnace, and cooling down; the CaO/Al₂O₃ molar ratio was 0.9, the Fe₂O₃ content was 3%, and the Blaine's value was 4,000 cm²/g.

CFA Compound G

Experiment No. 1-26; the CaO/Al₂O₃ molar ratio was 0.4, and the Blaine's value was 4,000 cm²/g.

CFA Compound H

Experiment No. 1-29; the $\text{CaO}/\text{Al}_2\text{O}_3$ molar ratio was 0.4, the SiO_2 content was 3%, and the Blaine's value was 4,000 cm^2/g .

5 CFA Compound I

Experiment No. 1-30; the $\text{CaO}/\text{Al}_2\text{O}_3$ molar ratio was 0.4, the Na_2O content was 3%, and the Blaine's value was 4,000 cm^2/g .

Cement

10 Commercially available normal Portland cement

Fine Aggregate

Standard sand used according to JIS R 5201

Water

Tap Water

15 [0042]

Estimations

For the hardening time, when hardening came to an end was measured according to JIS R 5201.

For the rustproofing effect (rustproofness), there
20 was accelerated testing performed in which chloride ions were incorporated as intrinsic chloride ions in a mortar sample at a concentration of 10 kg/m^3 , and a round steel rebar was placed in it for heated aging at 50°C. No
rusting of the rebar was estimated to be good; rusting of
25 the rebar within an area of 1/10 acceptable; and rusting of the rebar beyond an area of 1/10 unacceptable.

For the compressive strength, the compressive strength of the sample was measured after the lapse of

one day and 28 days according to JIS R 5201.

For the depth of penetration of chlorides, the resistance to penetration of chloride ions was estimated. More specifically, a columnar mortar sample of 10 cm ϕ ×20
 5 cm was aged in water of 30°C until a material age of 28 days. After the sample was immersed in pseudo-seawater that was a brine of 30°C having a salt concentration of 3.5% for 12 weeks, the depth of penetration of chlorides was measured. A portion in section of the mortar sample
 10 that did not turned brown in the fluorosceine-silver nitrate method was regarded as the depth of penetration of chlorides, and 8 measurements taken by slide calipers were averaged.

For the leaching of Ca ions, a mortar sample of 4×4×
 15 16 cm was immersed in 10-liter pure water for 28 days to measure the concentration of Ca ions dissolved in a liquid phase.

For the resistance to sulfate attack, a mortar sample of 4×4×16 cm was immersed in a 10% Na₂SO₄ solution for
 20 25 weeks to measure the expansion coefficient.

[0043]

Table 2

Ex. No.	CFA Compounds	Hardening Time (min.)	Rustproof- ness	Compressive Strength (N/mm ²)	
				1 day	28 days
25 2-1	-	180	Unacceptable	12.7	53
2-2	A	180	Acceptable	10.5	48
2-3	B	165	Good	10.3	53

	2-4	C	150	Good	10.5	55
	2-5	D	95	Good	10.5	55
	2-6	E	60	Good	10.8	54
	2-7	F	3	*	*	*
5	2-8	G	30	Good	5.7	49
	2-9	H	40	Unacceptable	4.3	42
	2-10	I	**	**	**	**

	Ex.	Depth of	Leaching of	Resistance to	Remarks
10	No.	Penetration	Ca Ions	Sulfate Attack	
		of Chlorides (mm)	(mg/l)	(%)	
	2-1	20	130	0.18	Comparative
	2-2	14	106	0.10	Comparative
	2-3	9	41	0.07	Inventive
15	2-4	2	40	0.01	Inventive
	2-5	3	42	0.02	Inventive
	2-6	5	44	0.02	Inventive
	2-7	*	*	*	Comparative
	2-8	17	103	0.10	Comparative
20	2-9	16	99	0.12	Comparative
	2-10	**	**	**	Comparative

No cement admixture was used in Experiment No. 2-1.

*: No sample could not be prepared because of rapid-hardening.

25 **: The sample was set in about 4 minutes because its fluidity dropped.

For the rustproofness, no rusting of the rebar was estimated to be good; rusting of the rebar within an area of 1/10 acceptable; and rusting of the rebar beyond an area of 1/10

unacceptable.

[0044]

As can be seen from Table 2, if CFA compounds B, C, D and E having a $\text{CaO}/\text{Al}_2\text{O}_3$ molar ratio of 0.15 to 0.7 and containing iron (Fe_2O_3) are used as the cement admixture (Experiment Nos. 2-3 to 2-6), sufficient work time could be ensured even in high-temperature environments in particular, and the rustproofing effect and the resistance to penetration of chloride ions could be maintained much more, not only with prevention of a lowering of initial strength but also with improvements in the effect on inhibition of leaching of Ca ions and the resistance to sulfate attack, sharply contrast to Experiment No. 2-1 where no CFA compound was used. In particular, CFA compounds C and D having a $\text{CaO}/\text{Al}_2\text{O}_3$ molar ratio of 0.4 to 0.6 would be preferable. The use of CFA compound A containing iron but having a $\text{CaO}/\text{Al}_2\text{O}_3$ molar ratio of 0.1 (Experiment No. 2-2), and compound G having a $\text{CaO}/\text{Al}_2\text{O}_3$ molar ratio of 0.4 but containing no iron (compound G is conveniently classified as the CFA compound in Table 2, although it belongs to the CA compound) (Experiment No. 2-8) resulted in a lowering of the resistance to penetration of chloride ions because of an insufficient effect on inhibition of leaching of Ca ions. The use of CFA compound F having a $\text{CaO}/\text{Al}_2\text{O}_3$ molar ratio of 0.9 (Experiment No. 2-7) made it impossible to ensure pot life due to rapid hardening.

The use of compound H containing SiO_2 instead of Fe_2O_3

(compound H is conveniently classified as the CFA compound in Table 2, although it does not belong to the CFA compound) (Experiment No. 2-9) made the rustproofing effect poor, gave rise to a lowering of initial strength, and failed to obtain sufficient resistance to penetration of chloride ions and sufficient effects on inhibition of leaching of Ca ions with a lowering of resistance to sulfate attack.

The use of compound I containing Na_2O instead of Fe_2O_3 (compound I is conveniently classified as the CFA compound in Table 2, although it does not belong to the CFA compound) (Experiment No. 2-9) results in a lowering of fluidity within a short period of time leading to early setting of the cement composition.

[0045]

Experimental Example 3

Experimental Example 2 was repeated with the exception of combined use of the CFA compound that was synthesized by blending together primary reagent calcium carbonate and primary reagent aluminum oxide in a $\text{CaO}/\text{Al}_2\text{O}_3$ molar ratio of 0.4, blending the mixture with primary reagent iron oxide in such a way as to provide the contents of Fe_2O_3 set out in Table 3, and firing the blend in an electric furnace as in Example 1, followed by cooling down. The results are also set out in Table 3.

[0046]

Table 3

	Ex.	Fe ₂ O ₃	Hardening	Rustproof-	Compressive	
	No.	(%)	Time (min.)	ness	Strength (N/mm ²)	
					1 day	28 days
5	2-8	0	30	Good	5.7	49
	3-1	0.5	90	Good	9.0	51
	3-2	1	120	Good	10.5	53
	2-4	3	150	Good	10.5	55
	3-3	5	170	Good	10.5	53
10	3-4	7	180	Good	10.5	55
	3-5	10	190	Good	10.8	54
	3-6	15	190	Good	10.6	52
	3-7	20	190	Acceptable	9.8	47

15	Ex.	Depth of	Leaching of	Resistance to	Remarks
	No.	Penetration	Ca Ions	Sulfate Attack	
		of Chlorides (mm)	(mg/l)	(%)	
	2-8	17	103	0.10	Comparative
	3-1	6	44	0.08	Inventive
20	3-2	4	43	0.05	Inventive
	2-4	2	40	0.01	Inventive
	3-3	3	42	0.02	Inventive
	3-4	2	40	0.01	Inventive
	3-5	4	44	0.02	Inventive
25	3-6	5	43	0.02	Inventive
	3-7	11	99	0.02	Comparative

[0047]

As can be seen from Table 3, if the CFA compounds

containing iron in an amount of 0.5 to 15% by mass are used as the cement admixture (Experiment Nos. 3-1 to 3-6), sufficient work times could be ensured even in high-temperature environments in particular, and the

5 rustproofing effect and the resistance to penetration of chloride ions could be maintained much more, not only with prevention of a lowering of initial strength, but also with improvements in the effect on inhibition of leaching of Ca ions and the resistance to sulfate attack,

10 sharply contrast to Experiment No. 2-8 where the iron-free CA compound was used. The use of the CFA compound containing iron in an amount of 20% by mass (Experiment No. 3-7) failed to obtain sufficient resistance to penetration of chloride ions and sufficient effects on

15 inhibition of leaching of Ca ions.

[0048]

Experimental Example 4

Experimental Example 2 was repeated with the exception of using CFA compound D whose fineness is set

20 out in Table 4. The results are also set out in Table 4.

[0049]

Table 4

Ex. No.	Fineness of the CFA compound (cm ² /g)	Rustproof-ness	Compressive Strength (28 days) (N/mm ²)
25 4-1	2,000	Acceptable	51
4-2	3,000	Good	53
2-5	4,000	Good	55
4-3	5,000	Good	55

4-4	6,000	Good	55
4-5	7,000	Good	54

Ex. No.	Depth of Penetration	Leaching of Ca Ions	Resistance to Sulfate Attack	Remarks
	of Chlorides (mm)	(mg/l)	(%)	
4-1	5	60	0.10	Inventive
4-2	3	49	0.04	Inventive
2-5	3	42	0.02	Inventive
4-3	2	45	0.02	Inventive
4-4	3	44	0.02	Inventive
4-5	7	51	0.04	Inventive

For rustproofness, no rusting of the rebar was estimated to be good; rusting of the rebar within an area of 1/10 acceptable; and rusting of the rebar beyond an area of 1/10 unacceptable. [0050]

As can be seen from Table 4, if the fineness of the CFA compound is adjusted for the cement admixture, the rustproofing effect (rustproofness) and the resistance to penetration of chloride ions could then be maintained much more, not only with prevention of a lowering of strength, but also with improvements in the effect on inhibition of leaching of Ca ions and the resistance to sulfate attack. The fineness of the CFA compound would be preferably 2,000 to 7,000 cm^2/g , more preferably 3,000 to 6,000 cm^2/g , and most preferably 4,000 to 5,000 cm^2/g . [0051]

Experimental Example 5

Experimental Example 2 was repeated with the exception that CFA compound D was used in the amounts set out in Table 5. For the purpose of comparison, similar
 5 experimentation was carried out using conventional rustproofing materials. The results are also set out in Table 5.

[0052]

Conventional Rustproofing Materials

10 I: Commercially available lithium nitrite

II: Commercially available nitrite-type hydrocalumite

[0053]

Table 5

15	Ex. No.	CFA Compound D (parts)	Rustproofness	Compressive Strength (28 days) (N/mm ²)
	2-1	0	Unacceptable	53
	5-1	1	Acceptable	53
	5-2	2	Good	54
	5-3	3	Good	55
20	5-4	5	Good	55
	2-5	7	Good	55
	5-5	10	Good	55
	5-6	12	Good	54
	5-7	15	Good	53
25	5-8	*I10	Acceptable	39
	5-9	*II10	Acceptable	34

Ex. No.	Depth of Penetration	Leaching of Ca Ions (mm) (mg/l)	Resistance to Sulfate Attack (%)	Remarks	
	of Chlorides	(mm)	(mg/l)	(%)	
	2-1	20	130	0.18	Comparative
5	5-1	10	84	0.10	Inventive
	5-2	7	55	0.10	Inventive
	5-3	5	49	0.07	Inventive
	5-4	4	46	0.03	Inventive
	2-5	3	42	0.02	Inventive
10	5-5	3	45	0.02	Inventive
	5-6	5	51	0.02	Inventive
	5-7	7	59	0.02	Inventive
	5-8	14	119	0.16	Comparative
	5-9	17	128	0.17	Comparative

15 The amount of the CFA compound is given by parts per 100 parts of the cement composition composed of cement and the CFA compound.

In Experiment No. 2-1, there was no cement admixture used.

*: Convention rustproofing material is used.

20 For rustproofness, no rusting of the rebar is estimated to be good; rusting of the rebar within an area of 1/10 acceptable; and rusting of the rebar beyond an area of 1/10 unacceptable.
[0054]

25 As can be seen from Table 5, if the amount of the CFA compound used is adjusted for the cement admixture, the rustproofing effect (rustproofness) and the resistance to penetration of chloride ions could then be maintained much more, not only with prevention of a lowering of

strength, but also with improvements in the effect on inhibition of leaching of Ca ions and the resistance to sulfate attack.

From Table 5, it is found that when only the calcium ferroaluminate compound is used as the cement admixture, it should be used in an amount of preferably 1 to 15 parts, and more preferably 2 to 12 parts per 100 parts of the cement composition composed of cement and the cement admixture.

[0055]

Experimental Example 6

The CFA compounds having such varying $\text{CaO}/\text{Al}_2\text{O}_3$ molar ratios as set out in Table 6 were mixed with the potentially hydraulic substance and/or pozzolan substance I at a mass ratio of 1/2 into cement admixtures. This cement admixture was used with cement to prepare a cement composition containing 21 parts of the cement admixture per 100 parts of the cement composition, and a mortar sample having a water/binder ratio of 0.5 was prepared according to JIS R 5201. This mortar sample was measured in terms of rustproofness, compressive strength, depth of penetration of chlorides, leaching of Ca ions and self-recovery capability. The results are also set out in Table 6.

[0056]

Potentially Hydraulic Substance and/or Pozzolan Substance I

Finely pulverized, quenched, granulated blast-furnace

slag commercially available in the art and having a
Blaine's value of 4,000 cm²/g

[0057]

Estimation of Self-Recovery Capability

5 There was a mortar sample of 10×10×40 cm prepared
with which 6-mm nylon fibers were mixed in an amount of
0.15% by mass, and a 0.3 mm-wide crack was introduced by
bending stress in it. After the sample was immersed in
pseudo-seawater for 180 days, the crack width was
10 measured. Double circle © indicates that the crack was
fully closed up; circle ○ indicates that the crack width
narrowed down to 0.1 mm or less; triangle △ indicates
that the crack width narrowed down to about 0.2 mm, and
cross × indicates that the crack width did not narrow at
15 all or, conversely, it widened.

[0058]

Table 6

	Ex.	CFA Compound	Rustproof-	Compressive Strength (N/mm ²)	
	No.		ness	1 day	28 days
20	2-1	-	Unacceptable	12.7	53
	6-1	A	Acceptable	12.8	52
	6-2	B	Good	13.0	56
	6-3	C	Good	14.1	59
	6-4	D	Good	15.0	59
25	6-5	E	Good	14.5	58
	6-6	F	*	*	*

Ex. No.	Depth of Penetration	Leaching of Ca Ions (mm) (mg/l)	Self-Recovery Capability	Remarks
2-1	20	130	×	Comparative
5 6-1	12	100	×	Comparative
6-2	7	36	△	Inventive
6-3	2	37	○	Inventive
6-4	1	35	⊙	Inventive
6-5	3	39	○	Inventive
10 6-6	*	*	*	Comparative

In Experiment No. 2-1, there was no cement admixture used.

*: No sample could be prepared due to rapid hardening.

[0059]

As can be seen from Table 6, if CFA compound B, C, D, and E of the invention having a $\text{CaO}/\text{Al}_2\text{O}_3$ molar ratio of 0.15 to 0.7 is used in combination with the potentially hydraulic substance and/or pozzolan substance (Experiment Nos. 6-2 to 6-5), the rustproofing effect (rustproofness) and the resistance to penetration of chloride ions could then be improved not only with an increased initial strength but also with improvements in the effect on inhibition of leaching of Ca ions as well as the self-recovery capability, sharp contrast to the comparative example where both are not used (Experiment No. 2-1).

CFA compounds C and D having a $\text{CaO}/\text{Al}_2\text{O}_3$ molar ratio of 0.4 to 0.6 would be particularly preferred. With CFA compound A having a $\text{CaO}/\text{Al}_2\text{O}_3$ molar ratio of 0.1 (Experiment No. 6-1), both the resistance to penetration

of chloride ions and the effect on inhibition of leaching of Ca ions remained insufficient with a lowering of the self-recovery capability, and with CFA compound F having CaO/Al₂O₃ molar ratio of 0.9 (Experiment No. 6-6), pot
5 life was not ensured because of rapid hardening.

[0060]

Experimental Example 7

Experimental Example 6 was repeated with the exception of using the CFA compounds set out in Table 7
10 with varying Fe₂O₃ contents in combination with the potentially hydraulic substance and/or pozzolan substance I. The results are also set out in Table 7.

[0061]

CFA Compounds

15 CFA Compound J

Primary reagent calcium carbonate and primary reagent aluminum oxide were blended together in a given proportion with addition of primary reagent iron oxide in a Fe₂O₃ content of 0.5%. Then, the mixture was fired at
20 1,450°C in an electric furnace, and finally cooled down for synthesis. The CaO/Al₂O₃ molar ratio was 0.6, and the Blaine's value was 4,000 cm²/g.

CFA Compound K

Primary reagent calcium carbonate and primary reagent
25 aluminum oxide were blended together in a given proportion with addition of primary reagent iron oxide in a Fe₂O₃ content of 1%. Then, the mixture was fired at 1,450°C in an electric furnace, and finally cooled down

for synthesis. The $\text{CaO}/\text{Al}_2\text{O}_3$ molar ratio was 0.6, and the Blaine's value was $4,000 \text{ cm}^2/\text{g}$.

CFA Compound L

Primary reagent calcium carbonate and primary reagent
5 aluminum oxide were blended together in a given
proportion with addition of primary reagent iron oxide in
a Fe_2O_3 content of 7%. Then, the mixture was fired at
1,450°C in an electric furnace, and finally cooled down
for synthesis. The $\text{CaO}/\text{Al}_2\text{O}_3$ molar ratio was 0.6, and the
10 Blaine's value was $4,000 \text{ cm}^2/\text{g}$.

CFA Compound M

Primary reagent calcium carbonate and primary reagent
aluminum oxide were blended together in a given
proportion with addition of primary reagent iron oxide in
15 a Fe_2O_3 content of 10%. Then, the mixture was fired at
1,450°C in an electric furnace, and finally cooled down
for synthesis. The $\text{CaO}/\text{Al}_2\text{O}_3$ molar ratio was 0.6, and the
Blaine's value was $4,000 \text{ cm}^2/\text{g}$.

CFA Compound N

20 Primary reagent calcium carbonate and primary reagent
aluminum oxide were blended together in a given
proportion with addition of primary reagent iron oxide in
a Fe_2O_3 content of 20%. Then, the mixture was fired at
1,450°C in an electric furnace, and finally cooled down
25 for synthesis. The $\text{CaO}/\text{Al}_2\text{O}_3$ molar ratio was 0.6, and the
Blaine's value was $4,000 \text{ cm}^2/\text{g}$.

CFA Compound O

Primary reagent calcium carbonate and primary reagent

aluminum oxide were blended together in a given proportion. Then, the mixture was fired at 1,450°C in an electric furnace in the absence of Fe_2O_3 , and finally cooled down for synthesis. The $\text{CaO}/\text{Al}_2\text{O}_3$ molar ratio was 0.6, and the Blaine's value was 4,000 cm^2/g .

[0062]

Table 7

Ex. No.	CFA Compound	Rustproof-	Compressive Strength (N/mm^2)		
			ness	1 day	28 days
10	2-1	-	Unacceptable	12.7	53
	7-1	J	Acceptable	12.7	53
	7-2	K	Good	15.0	55
	6-4	D	Good	15.0	59
	7-3	L	Good	15.0	55
15	7-4	M	Good	14.4	54
	7-5	N	Good	13.9	54
	7-6	O	Acceptable	7.5	50

	Ex. No.	Depth of Penetration	Leaching of Ca Ions	Self-Recovery Capability	Remarks
20		of Chlorides (mm)	(mg/l)		
	2-1	20	130	×	Comparative
	7-1	6	49	○	Inventive
	7-2	2	45	◎	Inventive
25	6-4	1	35	◎	Inventive
	7-3	2	43	◎	Inventive
	7-4	3	48	◎	Inventive
	7-5	4	52	◎	Inventive

7-6	8	62	Δ	Comparative
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In Experiment No. 2-1, there was no cement admixture used.

[0063]

As can be seen from Table 7, if CFA compound D, J, K,
 5 L, M, N, and O having a Fe_2O_3 content of 0.5 to 20% is
 used in combination with the potentially hydraulic
 substance and/or pozzolan substance (Experiment Nos. 6-4
 and 7-1 to 7-5), the rustproofing effect (rustproofness)
 and the resistance to penetration of chloride ions could
 10 then be improved not only with an increased initial
 strength but also with improvements in the effect on
 inhibition of leaching of Ca ions as well as the self-
 recovery capability. When CFA compound O having a Fe_2O_3
 content of 0 (this compound is conveniently classified as
 15 the CFA compound in Table 7, although it belongs to the
 CA compound) was used in combination with the potentially
 hydraulic substance and/or pozzolan substance (Experiment
 No. 7-6), the initial strength went down.

[0064]

20 Experimental Example 8

Experimental Example 6 was repeated with the
 exception of using CFA compound D whose finenesses are
 set out in Table 8 in combination with the potentially
 hydraulic substance and/or pozzolan substance I. The
 25 results are also set out in Table 8.

[0065]

Table 8

Ex. No.	CFA Compound Fineness (cm ² /g)	Rustproof-ness	Compressive Strength (N/mm ²)	
			1 day	28 days
	8-1 2,000	Acceptable	12.7	55
5	8-2 3,000	Good	14.0	57
	6-4 4,000	Good	15.0	59
	8-3 5,000	Good	14.9	60
	8-4 6,000	Good	15.0	59
	8-5 7,000	Good	14.4	58

10

Ex. No.	Depth of Penetration (mm)	Leaching of Ca Ions (mg/l)	Self-Recovery Capability	Remarks
	8-1 5	46	○	Inventive
15	8-2 2	44	○	Inventive
	6-4 1	35	◎	Inventive
	8-3 1	40	◎	Inventive
	8-4 2	39	◎	Inventive
	8-5 4	48	○	Inventive

20 [0066]

As can be seen from Table 8, if the fineness of the CFA compound is adjusted, then the rustproofing effect (rustproofness) and the resistance to penetration of chloride ions could then be maintained not only with prevention of a lowering of strength but also with improvements in the effect on inhibition of leaching of Ca ions as well as the self-recovery capability. The fineness of the CFA compound would be preferably 2,000 to

25

7,000 cm²/g, more preferably 3,000 to 6,000 cm²/g, and most preferably 4,000 to 5,000 cm²/g.

[0067]

Experimental Example 6 was repeated with the exception of using CFA compound D in combination with the potentially hydraulic substances and/or pozzolan substances (hereinafter called the pozzolan substances for short). The results are also set out in Table 9.

[0068]

10 Pozzolan Substances

Pozzolan Substance II

Commercially available silica fume having a BET specific surface area of 20 m²/g

Pozzolan Substance III

15 Commercially available fly ash having a Blaine's value of 4,000 cm²/g

Pozzolan Substance IV

Commercially available metakaolin having a BET specific of 10 m²/g

20 Pozzolan Substance V

Commercially available incinerated pulp sludge ash having a Blaine's value of 4,000 cm²/g

Pozzolan Substance VI

25 Commercially available incinerated sewage sludge ash having a Blaine's value of 9,000 cm²/g

Pozzolan Substance VII

Commercially available water glass powders having a Blaine's value of 4,000 cm²/g

Pozzolan Substance VIII

Mixture of 50 parts of Pozzolan Substance I and Pozzolan Substance II having a Blaine's value of 10,000 cm²/g
[0069]

5

Table 9

Ex. No.	Pozzolan Substance	Rustproof-ness	Compressive Strength (N/mm ²)	
			1 day	28 days
	6-4 I	Good	15.0	59
	9-1 II	Good	15.2	57
10	9-2 III	Good	14.5	54
	9-3 IV	Good	14.9	57
	9-4 V	Good	13.5	54
	9-5 VI	Good	12.8	53
	9-6 VII	Good	12.7	53
15	9-7 VIII	Good	14.8	56

	Ex. No.	Depth of Penetration	Leaching of Ca Ions	Self-Recovery Capability	Remarks
		of Chlorides (mm)	(mg/l)		
20	6-4	1	35	⊙	Inventive
	9-1	2	42	⊙	Inventive
	9-2	3	50	⊙	Inventive
	9-3	2	48	⊙	Inventive
	9-4	4	56	○	Inventive
25	9-5	5	62	○	Inventive
	9-6	5	60	○	Inventive
	9-5	2	40	⊙	Inventive

[0070]

As can be seen from Table 9, even with any pozzolan substances, the rustproofing effect (rustproofness) and the resistance to penetration of chloride ions could be maintained not only with prevention of a lowering of strength but also with improvements in the effect on inhibition of leaching of Ca ions as well as the self-recovery capability. In particular, finely pulverized, quenched, granulated blast-furnace slag (pozzolan substance I), silica fume (pozzolan substance II), fly ash (pozzolan substance III), and metakaolin (pozzolan substance IV) would preferably be used.

[0071]

Experimental Example 10

Experimental example 6 was repeated with the exception that CFA compound D and pozzolan substance I were blended together in the proportions set out in Table 10 into cement admixtures.

[0072]

Table 10

20	Ex. CFA compound/pozzolan		Rustproof	Compressive
	No. substance (mass ratio)		ness	Strength (N/mm ²)
	2-1	0/0	Unacceptable	53
	10-2	1/20	Acceptable	54
	10-3	1/10	Good	56
25	10-4	1/5	Good	55
	6-4	1/2	Good	59
	10-5	2/1	Good	54
	10-6	5/1	Good	54

10-7	10/1	Good	52
10-8	20/1	Acceptable	51
10-9	1/0	Acceptable	54

5	Ex. No.	Depth of Penetration	Leaching of Ca Ions	Self-Recovery Capability	Remarks
		of Chlorides (mm)	(mg/l)		
	2-1	20	130	×	Comparative
	10-2	20	30	△	Inventive
10	10-3	9	37	○	Inventive
	10-4	4	42	◎	Inventive
	6-4	1	35	◎	Inventive
	10-5	2	50	◎	Inventive
	10-6	3	50	◎	Inventive
15	10-7	7	52	○	Inventive
	10-8	15	90	○	Inventive
	10-9	3	42	×	Comparative

In Experiment No. 2-1, there was no cement admixture used.

[0073]

20 As can be seen from Table 10, if the blending proportion of the CFA compound to the pozzolan substance is set at 1/20 to 20/1 by mass, then the rustproofing effect (rustproofness) and the resistance to penetration of chloride ions could be maintained not only with

25 prevention of a lowering of strength but also with improvements in the effect on inhibition of leaching of Ca ions as well as the self-recovery capability. The aforesaid blending proportion would be preferably 1/10 to

10/1 by mass, and more preferably 1/5 to 5/1 by mass.

[0074]

Experimental Example 11

Experimental Example 6 was repeated with the
 5 exception that CFA compound D was used to prepare cement
 admixtures (CFA compound D plus pozzolan substance I) in
 the amounts set out in Table 11. For the purpose of
 comparison, similar experiments were carried out using
 conventional rustproofing materials. The results are
 10 also set out in Table 11.

[0075]

Table 11

	Ex. No.	Cement	Rustproof	Compressive Strength
		Admixture (parts)	ness	(N/mm ²)
15	2-1	0	Unacceptable	53
	11-1	1	Acceptable	53
	11-2	3	Good	54
	11-3	5	Good	55
	11-4	7	Good	55
20	11-5	10	Good	55
	11-6	15	Good	55
	6-4	21	Good	59
	11-7	30	Good	53
	11-8	50	Acceptable	53
25	11-9	**X10	Acceptable	39
	11-10	**Y10	Acceptable	34

Ex. No.	Depth of Penetration	Leaching of Ca Ions	Self-Recovery Capability	Remarks	
<u>of Chlorides (mm) (mg/l)</u>					
5	2-1	20	130	×	Comparative
	11-1	11	84	○	Inventive
	11-2	5	55	○	Inventive
	11-3	3	49	◎	Inventive
	11-4	2	47	◎	Inventive
10	11-5	2	43	◎	Inventive
	11-6	2	41	◎	Inventive
	6-4	1	35	◎	Inventive
	11-7	8	59	◎	Inventive
	11-8	10	61	○	Inventive
15	11-9	14	119	×	Inventive
	11-10	17	128	×	Comparative

The cement admixture was used in an amount (part) per 100 parts of the cement composition made up of cement plus the cement admixture.

20 **: The conventional rustproofing materials were used. No rusting of the rebar is estimated to be good; rusting of the rebar within an area of 1/10 acceptable; and rusting of the rebar beyond an area of 1/10 unacceptable.

[0076]

25 As can be seen from Table 11, if the amount of the cement admixture used is adjusted, then the rustproofing effect (rustproofness) and the resistance to penetration of chloride ions could be maintained not only with prevention of a lowering of strength but also with

improvements in the effect on inhibition of leaching of Ca ions as well as the self-recovery capability.

From Table 11, it could be found that when the CFA compound and the pozzolan substance are used as the cement admixture, the amount of the cement admixture used would preferably range 1 to 50 parts, and more preferably 5 to 30 parts per 100 parts of the cement composition made up of cement and the cement admixture.

10 APPLICABILITY TO THE INDUSTRY

[0077]

The use of the inventive cement admixture could ensure sufficient work times even in high-temperature environments, and make sure good rustproofness and resistance to penetration of chloride ions combined with the effect on inhibition of leaching of Ca ions and resistance to sulfate attack; so it may be well compatible with a wide range of applications inclusive mainly of water-use structures, water tanks, floor slab concrete, etc. in seawaters and rivers in the civil engineering and construction fields.

WHAT IS CLAIMED IS:

[1] A calcium ferroaluminate compound, comprising a $\text{CaO-Al}_2\text{O}_3\text{-Fe}_2\text{O}_3$ system, and having a Fe_2O_3 content of 0.5 to 15 % by mass and a $\text{CaO}\cdot 2\text{Al}_2\text{O}_3$ structure.

[2] A cement admixture, characterized by containing a calcium ferroaluminate as recited in claim 1, wherein a $\text{CaO/Al}_2\text{O}_3$ molar ratio ranges from 0.15 to 0.7.

[3] A cement admixture as recited in claim 2, which has a fineness of 2,000 to 7,000 cm^2/g as represented in terms of a Blaine's specific surface area value.

[4] A cement admixture as recited in claim 2, which further contains a potentially hydraulic substance and/or a pozzolan substance.

[5] A cement admixture as recited in claim 4, wherein said potentially hydraulic substance and/or said pozzolan substance contain one or two or more selected from the group consisting of finely pulverized, quenched, granulated blast-furnace slag, fly ash, silica fume, metakaolin, incinerated pulp sludge ash, incinerated sewage sludge ash, and waste glass powder.

[6] A cement admixture as recited in claim 4, wherein said calcium ferroaluminate and said potentially hydraulic substance and/or said pozzolan substance are blended together in a blending proportion of 10/1 to 1/10 by mass.

[7] A method for manufacturing a cement admixture, characterized in that a CaO -containing raw material, an

Al₂O₃-containing raw material and an iron-containing raw material are blended together such that a CaO/Al₂O₃ molar ratio ranges from 0.15 to 0.7 and an Fe₂O₃ content ranges from 0.5% to 15% by mass, and heat treated at 1,400°C to
5 1,600°C inclusive to obtain a clinker, and said clinker is pulverized down to a Blaine's specific surface area value ranging from 2,000 to 7,000 cm²/g.

[8] A cement composition which contains cement and a cement admixture as recited in any one of claims 1 to 6.