



HAL
open science

Beneficial reuse of dam fine sediments as clinker raw material

A. Fauré, C. Coudray, B. Anger, I. Moulin, H. Colina, L. Izoret, F. Théry, A. Smith

► **To cite this version:**

A. Fauré, C. Coudray, B. Anger, I. Moulin, H. Colina, et al.. Beneficial reuse of dam fine sediments as clinker raw material. *Construction and Building Materials*, 2019, 218, pp.365-384. 10.1016/j.conbuildmat.2019.05.047 . hal-02321680

HAL Id: hal-02321680

<https://unilim.hal.science/hal-02321680v1>

Submitted on 25 Oct 2021

HAL is a multi-disciplinary open access archive for the deposit and dissemination of scientific research documents, whether they are published or not. The documents may come from teaching and research institutions in France or abroad, or from public or private research centers.

L'archive ouverte pluridisciplinaire **HAL**, est destinée au dépôt et à la diffusion de documents scientifiques de niveau recherche, publiés ou non, émanant des établissements d'enseignement et de recherche français ou étrangers, des laboratoires publics ou privés.



Distributed under a Creative Commons Attribution - NonCommercial 4.0 International License

Beneficial reuse of dam fine sediments as clinker raw material

A. Faure^{1,*}, C. Coudray², B. Anger², I. Moulin¹, H. Colina³, F. Théry², A. Smith⁴

¹ LERM, SETEC Group, F-13631, Arles, France

² EDF Lab Les Renardières, F-77818 Moret-sur-Loing, France

³ ATILH, F-92974, Paris-La-Défense, France

⁴ ENSIL-ENSCI, Limoges University, CNRS, IRCER, UMR 7315, F-87068, Limoges, France

* Corresponding author. E-mail addresses: antoine.faure@lerm.setec.fr (A. Faure),

coryse.coudray@edf.fr (C. Coudray), baptiste.anger@edf.fr (B. Anger),

isabelle.moulin@lerm.setec.fr (I. Moulin), h.colina@atilh.fr (H. Colina), francois.thery@edf.fr (F.

Théry), agnes.smith@unilim.fr (A. Smith)

Abstract

The accumulation of fine sediments (< 200 μm) occurs in hydroelectric dams due to watershed erosion and solid transport. A rigorous and sustainable sediment management is required. Although most of these materials are transferred into the watercourse downstream, a significant quantity might have to be managed as on-land waste in the future. Considering that sediments contain silica, alumina, calcia and iron oxide as main chemical constituents, they could be useful candidate raw materials in the cement industry for the manufacture of clinker. This work concerns sediments from French dams. Whatever their origin, each sediment is suitable for a beneficial reuse as silico-aluminous raw material for clinker production. The characteristics of the raw sediments can lead to specific microstructures in the clinkers. However, clinker characteristics can still be controlled by adjusting raw mix proportions, maintaining a rather high sediment content in the mix (between 10 and 15 wt%).

Keywords

Dam fine sediment, Clinkering reactions, Portland cement industry, Valorization

Highlights

- 7 dam sediments from different French regions are suitable for clinker production
- Clinkers produced using 10 to 15% of sediment are similar to industrial ones
- Special features (polymorphisms and phase ratios) can be induced by sediments
- Key-criteria: Grain size, silica ratio and minor elements (Mg, Na, K) in sediments composition

33 1. Introduction

34 In France, the annual volume of dredged material is estimated at 50 Mm³ [1]. More than 90 %
35 of this come from marine and estuarian dredging operations. The remaining fraction is attributed to
36 continental extraction (waterways and dams). Although the total volume of removed sediment from
37 dams can slightly vary from one year to the next, the order of magnitude is several tens of
38 thousands of cubic meters. Erosion of rocks and soils at the watershed level generates solid particles
39 that are transported by watercourses. Dam construction leads to a local reduction of the water
40 velocity. Schleiss *et al.* [2] estimated that between 0.5 and 1.0% of the reservoir capacity is lost
41 each year in the world because of sediment accumulation. A segregation occurs between the coarse
42 particles (gravels and sands) that deposit at the reservoir entrance and the fine particles (silts and
43 clay) that can remain in suspension. Further transport of these particles yields a final accumulation
44 close to the dam construction [3]. Nowadays, most of the solid particles are transferred from the
45 reservoir upstream to the watercourse downstream ensuring the ecological and sedimentary
46 continuity. However, technical or environmental reasons could constrain the hydroelectric dam
47 operator to an on-land management of these materials. According to the European Directive
48 2008/98/CE [4], sediments extracted from reservoirs become waste. Following the waste
49 management hierarchy, beneficial reuse solutions prevail over disposal options. With this in mind,
50 coarse and fine particles need to be clearly distinguished. According to Owens *et al.* [5], the limit
51 can be set at 63 μm , *i.e.* the transition from silt to sand class. Particles greater than 63 μm are not a
52 critical issue since they are commonly reused as sand or aggregate. By contrast, the beneficial reuse
53 of fine sediments, *i.e.* particles smaller than 63 μm , is more challenging since no recycling solution
54 is implemented.

55 In the literature, several reuse options for fine sediments were considered such as (i)
56 construction of functional soils [6-7], (ii) sub-base layers in road or pavement construction [8-10],
57 (iii) raw material for traditional ceramic bricks manufacturing [11-13] and (iv) partial replacement
58 of sand in concrete production [14-17]. Beneficial reuse of fine sediment as a raw material to
59 produce clinker was also investigated by different authors [18-20]. Aouad *et al.* [18] worked on a
60 contaminated sediment from a waterway in Northern France. They obtained a satisfying clinker by
61 introducing this sediment with a mass ratio of 39.1 wt%. The product reactivity was confirmed both
62 by calorimetry and compressive strength tests on final cement pastes. Dalton *et al.* [19] studied one
63 sedimentary resource sampled in an US marine harbor. The finest fraction was selected (< 300 μm).
64 Tests were performed both at the lab and industrial pilot scales. Although the obtained products
65 could be described as clinkers, some biases were induced by the unadjusted thermal treatments, *e.g.*

66 no quenching and insufficient sintering temperature. Finally, Anger *et al.* [20] investigated three
67 different sediments from French hydroelectric reservoirs considering a reuse in cement industry as a
68 replacement for clay in clinker manufacture. Microstructural analyses of the produced clinkers
69 showed that all the studied sediments could be successfully recycled into clinker production.

70 In parallel to the sediment accumulation issue and the need to find some sustainable beneficial
71 reuse solutions, clinker production in cement industry requires an adequate mix of CaO (lime), SiO₂
72 (silica), Al₂O₃ (alumina) and Fe₂O₃ (iron oxide). These essential elements are traditionally brought
73 to the raw meal by limestone, for calcium, and by clay rocks for the silico-aluminous content.
74 During the clinkering process, a temperature of 1450 °C is reached and lime combines with the
75 three other main oxides to form the usual anhydrous phases, namely alite C₃S, belite C₂S, calcium
76 aluminate C₃A and calcium alumino-ferrite C₄AF – also written C₂(A,F)¹. Along with CO₂
77 emissions, the consumption of large volumes of natural resources is often described as an
78 environmental issue for the cement industry [21-22]. Knowing that (i) 1.7 t of raw materials are
79 required per ton of clinker [23] and (ii) 12.5 Mt of clinker were produced in France in 2015 [24],
80 the amount of consumed resources to produce clinker can be estimated at 21.3 Mt per year (fuels
81 not considered). Therefore, the replacement of non-renewable geological resources by sediments as
82 alternative raw materials seems relevant. A positive side effect can be pointed out since the
83 valorization contributes to the reduction of waste disposal. Due to the chemical composition
84 similarity between the traditional raw materials used in the cement industry and the fine sediments
85 extracted from hydroelectric reservoirs, this replacement could be technically promising. Moreover,
86 large quantities of sediment could potentially be reused, which makes the cement industry a
87 relevant option for dredged material valorization. Also, it can be noticed that cement plants are
88 quite solicited to incorporate alternative raw materials into the meal. Besides, the literature presents
89 the valorization of various types of waste in the cement industry: wastes from construction and
90 demolition operations [25-28], the metal industry [29-31], extractive activities [32] and residues
91 from household waste incineration [33-34].

92 Based on literature results and previous studies, this paper investigates and compares a
93 significant number of sediment resources from French reservoirs, namely seven, as alternative raw
94 materials. The objective is to take into account the pedological and geological variability from a
95 watershed to another that directly influences the characteristics of the particles generated by erosion
96 and accumulated in reservoirs. The effect of sediment characteristics has been examined, especially
97 by looking at the relation between the phase polymorphism and the characteristics of the sediment
98 introduced into the clinker raw meal. Also, compared to previous studies, a scale change is operated

¹ In cementitious notation, A, C, F, H and S refer respectively to Al₂O₃, CaO, Fe₂O₃, H₂O and SiO₂.

99 with the production and characterization of mortars prepared with Portland cement **originating** from
100 clinker produced with sediments.

101 **2. Materials and methods**

102 *2.1 Pretreatment of raw materials*

103 Seven sediments were investigated. They came from four different French regions: four
104 sediments from the Alps named ALP1, ALP2, ALP3 and ALP4, one from Brittany labelled BRT1,
105 one from the **North-Eastern part** of France called EST1 and a last one close to the Mediterranean
106 Sea referenced as MED1. Locations, labels and allotted colors are given in Figure 1. According to
107 the reservoir context and the water level, fine sediments were either collected by a grab from a
108 barge or with a mechanical or manual shovel. Sealed plastic containers were used for transport. For
109 each sediment, a first preparation step consisted **of air-drying** associated with homogenization.
110 Drying was carried out at 40 °C. Afterwards, the compact blocks formed during drying were de-
111 agglomerated using a jaw crusher. It was then checked that 100 % of each sediment could pass
112 through a 200 µm sieve. Sediments were then considered as “*pretreated materials*”. They were
113 stored at 40 °C until their use.

114 Concerning the rocks extracted from quarries for clinker production, the initial materials were
115 also pre-treated through coarse crushing. For lab experiments, they were finely ground using a
116 planetary ball mill until the crushed materials could be sieved **through a 125 µm mesh**. These
117 materials were kept at 105 °C. For the synthesis of clinker, the calcareous rock, referenced as LIM1,
118 was mixed together with a silico-aluminous material. In this respect, two clay resources namely
119 CLY1 and CLY2 were used for comparison and were partially or totally **substituted** by sediments in
120 raw meal formulations.

121 In the following sections, “*raw materials*” will refer to the “*pretreated materials*”.

122 *2.2 Raw materials characterizations*

123 • *Physical properties*

124 Particle size distributions of the raw materials were analyzed by laser diffraction using a
125 MALVERN INSTRUMENTS Mastersize 2000 device. The suspensions used for analyses were
126 prepared by mixing 2 g of powder with 50 mL of deionized water, followed by ultrasonic dispersion
127 for two minutes. Results are presented **in** Figure 2 and Table 1. According to Owen’s criteria [5],
128 most sediments can be considered as fine since the particle size is **less** than 63 µm. The only
129 exception is EST1 since 18.6 vol% is between 63 µm and 2 mm. Regarding the quarried materials,
130 their particle size distributions fulfill the requirements for their use as raw materials in clinker
131 production.

132 Densities were assessed by helium pycnometry (MICROMERITICS AccuPyc 1330
133 equipment). Specific surface areas (SSA) were estimated by two different methods: (i) the
134 Brunauer-Emmett-Teller (BET) technique [35] and (ii) the Blaine method. BET SSA measurements
135 were performed with gaseous N₂ on a MICROMERITICS Tristar II apparatus. SSA measurements
136 were preceded by a degassing step at 120 °C for 15 hours. Blaine SSA determinations were carried
137 out according to the NF EN 196-6 standard [36] with an instrument from CONTROLAB Company.
138 Blaine protocol consists in measuring the time required for the transfer of a known air volume
139 through a compacted powder bed. This duration is related to specific surface area and fineness. SSA
140 and pycnometry results are given in Table 2. For lime and most clays, the densities are close to the
141 values of the constituents, except for BRT1 and EST1. This difference is due to the presence of
142 organic matter as witnessed by thermal analysis (see *Mineralogical properties* subsection).
143 Concerning the specific surface area, the values are quite dependent on the technique [37]. Blaine
144 SSA values are lower than BET SSA values. This difference can be attributed to the surface
145 roughness and porosity of the particles. BET corresponds to N₂ forming a single monolayer over the
146 surface of the exposed material while the Blaine technique relies on a gas going through a
147 compacted powder.

- *Chemical properties*

149 Elemental compositions of materials were obtained by X-Ray fluorescence (XRF). Fused
150 beads were prepared for XRF analysis using a melting agent that contained lithium tetraborate
151 (99.5 wt%) and lithium iodide (0.5 wt%). 1 g of the analyzed sample was mixed with 10 g of
152 melting agent (1:10 mass ratio) in order to prepare the bead. A PANalytical Zetium device was used
153 to carry out the elemental composition measurements operating with a 1 kW generator and a Rh
154 anode. The elemental chemical composition of each raw material is presented in Table 3. For all
155 clay minerals, the main oxides are SiO₂, Al₂O₃ and CaO. The compositions have been plotted in a
156 Rankin's diagram (see Figure 3). The four alpine sediments and BRT1 are located in the same
157 region on the diagram, slightly different from the CLY1 and CLY2 location. EST1 and MED1 are
158 different since they contain respectively slightly less alumina and more lime than the other
159 sediments.

- *Mineralogical properties*

161 Mineralogical compositions were obtained by X-Ray Diffraction (XRD). Two types of
162 investigations were performed: powder analysis and clay species identification. Both were
163 performed on a BRUKER D8 Advance device mounted on a Bragg-Brentano geometry θ - θ . The
164 apparatus was equipped with a copper anticathode ($\lambda = 1.5406 \text{ \AA}$), a high speed LynxEye XE
165 detector and operated at 40 kV and 40 mA. For powder analyses, measurements were made
166 between 3 and 70 °2 θ , with a 0.012 °2 θ step and a time per step of 0.6 s. Crystalline phases were

167 identified using the BRUKER DIFFRACPlus EVA software and the ICDD PDF4+ database. To
168 perform the semi-quantitative XRD analyses, zincite (ZnO) was added to the sample (10 % by
169 mass). XRD quantifications were carried out by **the Rietveld method** on a BRUKER TOPAS
170 software. Concerning the distinct identification of clay minerals and their semi-quantification, a
171 preferential orientation of the clay minerals in the sample according to the 001 plan was needed in
172 order to increase the intensity of the basal X-ray reflexions. To do so, a suspension was prepared
173 from fine sediment: wet sieving (40 μm mesh) and centrifugation (8000 revolutions per minute –
174 30 min). The supernatant was **extracted with a pipette** and placed on a glass slide. In order to make
175 possible identification according to d-spacing, three different treatments were performed: natural
176 air-drying at room temperature, polyalcohol atmosphere (adapted **to** swelling clays) and thermal
177 treatment at 490 °C (differentiation between kaolinite and chlorite). Angles between 3 and 35 $^{\circ}2\theta$
178 were explored with a step size of 0.008 $^{\circ}2\theta$ and a time per step of 0.84 s. Clay species were semi-
179 quantified using the relative peak intensities according to the technique described by Holtzapffel
180 [38]. Results of powders and clay semi-quantifications are presented in Table 4.

181 CLY1 and CLY2 present the highest percentage of quartz, which is in accordance with the
182 chemical analysis. The sediments contain quartz (between 17 and 35 wt%), clay minerals (between
183 26 and 36 wt%) and carbonated phases (between 26 and 46 wt%). MED1, a calcareous sediment,
184 contains the highest percentage of carbonates. In the four alpine sediments and EST1, the clay
185 minerals are **mostly illite and some chlorite**. CLY1 and CLY2 contain kaolinite **and some illite**.
186 MED1 and BRT1 contain illite, chlorite and kaolinite. Whatever the nature of the silico-aluminous
187 materials, alkaline ions are present, either potassium in illite and microcline, or sodium in albite.

188 Thermal behaviors of raw materials were analysed by thermogravimetric analysis (TGA)
189 coupled with differential thermal analysis (DTA). Measurements were carried out on a SETARAM
190 Setsys 16/18 thermobalance, using calcined alumina as inert reference. The reference and the
191 analysed materials were placed in platinum crucibles. TGA and DTA were followed in the 30-
192 1000 °C range with a heating ramp of 5 °C/min. Mass loss for each raw material is given in Table 5
193 with the corresponding temperature range and the associated phenomenon. The sediments present
194 greater mass losses than CLY1 or CLY2. This is explained by both the presence of carbonates
195 (Table 4) and organic matter (OM). Organic matter content is analysed for the fine sediments by
196 loss on ignition according to NF EN 12880 protocol [39], *i.e.* a calcination operation in a muffle
197 electric furnace at 550 °C for 2 hours. 2 g of material were used each time. Organic matter contents
198 are given in Table 6. The OM content has influence upon the density (see Table 2): BRT1 and
199 EST1 which present the lowest densities have the highest OM.

200 2.3 Clinker synthesis

201 • Formulation strategy

202 From the chemical composition of each raw material (i.e. quarried rocks, sediments; see Table
203 3), clinker raw meals were formulated applying the empirical moduli used in the cement industry.
204 These moduli correspond to ratios between the main oxides and they are used to target raw meals
205 with the correct stoichiometry. The three most common parameters - named Lime Saturation Factor
206 (LSF), Silica Ratio (SR) and Alumina Ratio (AR) - are given in Equations 1, 2 and 3, respectively
207 [40].

$$\text{LSF} = \frac{\% \text{CaO}}{2.80 \times \% \text{SiO}_2 + 1.20 \times \% \text{Al}_2\text{O}_3 + 0.65 \times \% \text{Fe}_2\text{O}_3} \times 100 \quad \text{Eq. 1}$$

$$\text{SR} = \frac{\% \text{SiO}_2}{\% \text{Al}_2\text{O}_3 + \% \text{Fe}_2\text{O}_3} \quad \text{Eq. 2}$$

$$\text{AR} = \frac{\% \text{Al}_2\text{O}_3}{\% \text{Fe}_2\text{O}_3} \quad \text{Eq. 3}$$

208 Each of them is supposed to control one or several characteristics of the final clinker. LSF
209 ensures the right stoichiometry between calcium oxide and the three other main chemical
210 components. Theoretically, if the target for LSF is between 92 to 98, a right balance is found
211 between providing enough CaO to complete the clinkering reaction and limiting the free
212 (uncombined) lime content [39]. Working on German industrial clinkers, Locher noticed that the
213 LSF range is actually wider (90 to 104) [41]. Concerning the Silica Ratio, it helps to fix the relative
214 proportion between silicate phases, C₃S and C₂S, and the aluminate ones, that is to say C₃A and
215 C₄AF. Aluminate phases are commonly liquid at high temperature (above 1300 °C) and they both
216 form the interstitial phase. Thus, SR operates also as a relevant index for the liquid phase content
217 during the clinkering process. Suitable clinker SR is in the range 2.0 to 3.0 [40] but a more
218 restrictive and optimized domain can be given: 2.4 to 2.6 [42]. Finally, AR controls the relative
219 mass contents in the interstitial phases between the iron-free mineral C₃A and the only clinker phase
220 that contains iron, i.e. C₄AF. A large [40] and a narrow [42] range can be identified for the Alumina
221 Ratio, [1.0 ; 4.0] and [1.5 ; 1.8] respectively.

222 Two different formulation strategies were considered. The first one consisted in maximizing
223 the dam sediment content with a total replacement of the clay fraction by this alternative raw
224 material. These mixes were called “binary mixes”. As the limestone is relatively pure, it can be
225 considered that the whole silico-aluminous fraction is brought to the meal by the material coming
226 from the dredging operation. Using only two different constituents, the chemical adjustment
227 possibilities for the raw meal are limited to one compositional parameter. LSF was chosen since
228 combination of lime is the most critical factor. A LSF value of 97 was targeted yielding the

229 formulation of *binary mixes* (Table 7). It can be observed that CLY1 and CLY2 contents in binary
230 mixes were lower than every sediment mass ratios, whatever the origin. It can be explained by the
231 higher CaO content of the dredged materials compared to the quarried clay rocks. As a
232 consequence, sediments replaced on one hand the whole silica, alumina and iron oxide supply and,
233 on the other hand, a fraction of limestone. That is why the most calcareous sediment, *i.e.* MED1,
234 showed the highest substitution level in binary preparations with 34.81 wt%. As replacement
235 percentages are relatively high, the effect of sediment on clinker properties is supposed to be
236 exacerbated. SR and AR were not adjusted in these formulations. It explains why some of the
237 theoretical SR and AR values could be **outside** of the usual ranges. None of the SR was in the
238 optimum range [2.4 ; 2.6]. In most cases, they were lower – due to the high alumina content –
239 except for EST1 and CLY2 rock. Depending on the alumina-to-iron ratio of each sediment, AR of
240 binary mixes could also be higher, *e.g.* MED1-Bin, or lower, *e.g.* BRT1-Bin and EST1-Bin, than
241 the supposed optimum domain.

242 The second formulation strategy consisted in using CLY1 or CLY2 plus a sediment as a
243 silico-aluminous bearer. In other words, a clay rock from a quarry is partially substituted and
244 complemented by an alternative dredged material (Table 8). As three components were introduced
245 into each mix ("*ternary mix*"), it allowed the adjustment of another compositional parameter. The
246 second most important one, SR, was chosen and a value of 2.4 was targeted. To reach this value, the
247 adequate complementing clay had to be selected, that is to say the aluminous CLY1 for EST-Ter
248 and the siliceous CLY-2 for all the other meals (SR < 2.4 in binary). In addition to ternary mixes
249 with sediment, a reference mix – named CLY-Ter – was also studied with both CLY1 and CLY2 as
250 silico-aluminous sources. After resolving the equations, clinker raw meal formulations were
251 obtained and are presented in Table 8. Compared to binary mixes, sediment contents were
252 diminished to values **less** than 20 %, except for ALP4-Ter. These mass ratios ranging from 10.78 to
253 18.43 wt% are closer to what is actually observed concerning the use of alternative materials **in a**
254 **cement plant**. With respect to **the ALP4-Ter case**, the calculated AR was already rather close to 2.4
255 in the binary mix ALP4-Bin (2.32). It justifies why **the ALP4 content** was kept relatively high, even
256 in ternary meal. Regarding the last compositional parameter, which was not intentionally adjusted,
257 it can be noticed that the transition from binary to ternary mix tended to buffer AR too. Indeed, all
258 the calculated AR were located in the optimum range for ternary meals.

259 • *Lab clinker preparation*

260 Clinkers were prepared at the lab scale. To do so, powdered raw materials were initially dried
261 at 105 °C until reaching a constant mass. Then, 100 g of raw meal were prepared according to the
262 mass contents obtained by calculation and presented in Tables 7 and 8 for binary and ternary raw
263 meals, respectively. Dried powders were homogenized using a three-dimensional **Turbula mill** for

264 one hour. In a rotary kiln of a cement plant, clinker nodulization results from both the rotative
265 movement and the presence of a liquid phase. Using a static electric lab furnace, nodulization is
266 impossible. To overcome this laboratory issue, a granulation step was added to the process in
267 analogy to what is done in the industrial semi-dry plants. In the literature, other authors suggested
268 this methodology to ensure the shaping of raw meal and an intimate homogenization of the particles
269 at the lab scale [25;43]. Granules with diameters from 5 to 10 mm were obtained using a water-to-
270 powder ratio of 0.22. Afterwards, free water was fully evaporated in an oven at 100 °C. Pellets were
271 then sintered in a bottom lift furnace using a Pt-Rh crucible. After a residence period of 45 min at
272 the clinkering temperature of 1450 °C, clinker granules were air-quenched. This rapid cooling
273 methodology was necessary to make sure that C₃S formed at 1450 °C would not decompose into
274 C₂S and calcium oxide, a reverse reaction that occurs **if slow cooling is used**.

275 2.4 Anhydrous clinker characterization

276 Several analyses and characterizations were performed on lab clinkers. The first one consisted
277 in assessing the success of lime combination with the other oxides to synthesize the four usual
278 phases, **two silicates (C₂S, C₃S) and two aluminates (C₃A, C₄AF)**. The usual experimental technique
279 is based on an acidic titration of the remaining uncombined lime in the clinkering product, also
280 known as “free lime”, after a selective chemical attack by ethylene glycol. This method was first
281 suggested by Schlöpfer and Bukowski in 1933 [44]. After grinding, 1 g of clinker is stirred in
282 ethylene glycol heated at 70 °C. This specific attack transforms free lime into calcium glycolate,
283 (CaCH₂O)₂. After vacuum filtration, calcium glycolate is titrated with HCl 0,1 mol.L⁻¹ and the end-
284 point is detected with bromocresol green indicator. The acidic titration reaction is given in
285 Equation 4.



286 The upper limit which is usually **accepted** for free lime content is 2 wt%, even if proportions
287 between 2 and 3 % can be **tolerated** [42]. Due to the formulation step with the LSF adjustment, **the**
288 **free lime** content is theoretically supposed to be correct. However, depending on the raw material
289 properties, free lime content might differ from the expected values.

290 Clinker chemical analyses were performed by XRF with a protocol similar to what was
291 described for the elemental analysis of raw materials. NF EN 197-1 [45] set two different chemical
292 limits for Portland clinker – referenced as “K” in the standard – when used **as a component** of
293 Portland cement. These restrictions and the typical composition range for Portland clinker
294 according to Baroghel-Bouny [46] are given in Table 9. Knowing the main oxide contents, Bogue
295 defined in 1929 a numerical method to estimate the potential phase composition. Four equations,
296 one for each crystalline phase, were suggested and are given in Equations 5 to 8.

$$C_4AF = 3.0432 Fe_2O_3 \quad \text{Eq. 5}$$

$$C_3A = 2.6504 Al_2O_3 - 1.6920 Fe_2O_3 \quad \text{Eq. 6}$$

$$C_2S = -3.0710 CaO + 8.6024 SiO_2 + 5.0683 Al_2O_3 + 1.0785 Fe_2O_3 \quad \text{Eq. 7}$$

$$C_3S = 4.0710 CaO - 7.6024 SiO_2 - 6.7187 Al_2O_3 - 1.4297 Fe_2O_3 \quad \text{Eq. 8}$$

297 These equations were employed on lab clinkers with a correction for CaO: the lime proportion was
298 subtracted from the total CaO content.

299 Clinker XRD analyses were carried out following the same experimental methodology as
300 the one used for bulk raw materials. In addition to the crystalline phase identification in the
301 complete diffraction diagram, several specific windows were selected for the determination of C₃S,
302 C₂S and C₃A polymorphs according to literature. Concerning tricalcium silicate, two angle ranges
303 were examined: 36.0 to 38.0 °2θ and 55.5 to 57.5 °2θ [47]. Regarding dicalcium silicate forms, both
304 30.5 to 32.0 °2θ and 32.7 to 33.6 °2θ areas were studied [48-49]. For tricalcium aluminate, two
305 other windows were taken into account: between 18.0 and 22.5 °2θ and from 47.0 to 48.0 °2θ [49-
306 50].

307 2.5 Fresh and hardened state behaviors

308 Concerning the clinker referenced as ALP1-Ter, standard tests from the cement industry
309 were performed pursue more deeply the demonstration of the beneficial reuse potential of dam
310 sediment in clinker manufacture. A cement equivalent to a CEM I made with clinker ALP1-Ter was
311 compared to an industrial CEM I 52.5N Portland cement (named hereafter Control CEM I) for all
312 the experiments. Both cements were prepared in order to reach an identical SO₃ content (2.6 wt%)
313 and the same Blaine fineness (3600 cm²/g) after clinker and gypsum co-grinding. The chemical
314 composition and the potential phase contents of the Control CEM I are shown in Table 10.

315 First, the setting times (initial and final) were measured with a Vicat apparatus after the
316 assessment of the water-to-cement ratio (w/c) to reach normal consistency according to NF EN 196-
317 3 [51]. The evaluation of standard consistency and required water content gives information on the
318 fresh state workability of the hydraulic binder. Several parameters come into play: cement fineness,
319 solid particle flocculation and hydration kinetics (consistency modification due to paste stiffening)
320 [52]. Then, strength tests were performed on mortar in agreement with NF EN 196-1 [53]. Flexural
321 and compressive strengths were measured on prismatic samples after curing times of 2, 7 and
322 28 days. The aim of this test was to determine the strength class of ALP1-Ter cement according to
323 NF EN 197-1 [45] with (i) the compressive strength reached after 28 days (32.5, 42.5 or 52.5 MPa)
324 and (ii) the early-age strength development (normal N or rapid R). Another parameter that was

325 investigated is the cement heat of hydration. This test was performed by the semi-adiabatic
326 technique given in NF EN 196-9 [54]. In this methodology, a mortar incorporating the tested
327 cement is made and cast in a semi-adiabatic cell. The temperature evolution is followed for 120 h
328 and compared to the temperature of an “inert” mortar (for which hydration is complete). The
329 cumulative hydration at a given time t, labelled Q(t), can be calculated according to Equation 9.

$$Q(t) = \frac{C_{Tot}}{m_c} \times \theta_t + \frac{1}{m_c} \times \int_0^t \alpha \theta_t \cdot dt \quad \text{Eq. 9}$$

330 In Equation 9, C_{Tot} refers to the heat capacity of the complete calorimeter ($J.K^{-1}$), m_c corresponds to
331 the cement mass contained in the mortar sample (g), t is attributed to the hydration time (h), α is a
332 coefficient related to the specific heat loss of the calorimeter and θ_t indicates the difference of
333 temperature between the tested sample and the reference inert mortar at time t. The last investigated
334 parameter is the shrinkage of mortar in a controlled drying atmosphere (20 °C and 50 % RH)
335 according to NF P15-433 [55]. In these conditions, a large part of the total shrinkage is explained by
336 drying shrinkage: evaporation of pore water through the surfaces. In addition to dimensional
337 variations, mass evolution was also followed for 28 days.

338 3. Results and discussion

339 The measured clinker properties are presented in three sections. Section 3.1 refers to the
340 clinkers obtained with binary mixes; limestone was blended with a unique silico-aluminous material
341 which was either a quarried clay (CLY1 or CLY2) or a dredged sediment. Section 3.2 focuses on
342 ternary mixes in which silica, alumina and iron oxide are introduced by an adequate blend of one
343 sediment and one clay rock traditionally used by cement plants. The last section summarizes both
344 approaches and establishes some relationships between the initial sediment properties and the final
345 clinker characteristics.

346 3.1 Binary clinkers

347 • Anhydrous clinker characteristics

348 The first important parameter that should be considered is the achievement of lime
349 combination reactions. It was assessed by measuring the remaining free lime in clinker that is the
350 calcium oxide that was not found in the cementitious phases. Results for binary clinkers are given in
351 Figure 4a. Chemical compositions of binary clinkers are given in Table 11. Bogue calculations were
352 used to estimate the potential phase proportions for C_3S , C_2S , C_3A and C_4AF . These values are
353 summarized in Table 11 as well. Using the LSF adjustment, most clinkers present a free lime
354 content below the threshold of 2 wt% and a relatively high C_3S/C_2S ratio. EST1-Bin is different
355 since its lime percentage is 3.62 wt% and the C_3S content is the lowest. This can be correlated with
356 its particle size distribution (see Figure 2 and Table 1) showing the presence of > 100 μm particles

357 that could be quartz. The presence of large quartz particles is known to promote the formation of
358 significant quantities of C₂S to the detriment of C₃S.

359 The full diffraction diagrams shown in Figure 5 confirm the presence of the four typical
360 crystalline phases of clinker and show some low intensity peaks for calcium oxide resulting from
361 the presence of free lime traces. Figure 5 does not show any complementary phase. To investigate
362 in greater details the effect of sediment introduction on the clinkering reactions, it was decided to
363 identify not only which of the four main phases were present, but also their polymorphism. The
364 cases of alite, belite and tricalcium aluminate cases are examined. Concerning C₃S, two XRD
365 windows were selected allowing allotropes identification. The corresponding diagrams are given in
366 Figures 6a and 6b. The identified C₃S polymorphs are M₃ when sediments are added, while the
367 usual M₁ polymorphs are formed in CLY1-Bin and CLY2-Bin. As shown in Figure 7 it is related to
368 the MgO content of the sediment according to the empirical diagram from Maki et Goto (1982)
369 [56]. Higher MgO content increases the probability of formation of M₃. MgO comes from dolomite
370 and is also present in the trioctahedral sheets of illite, in the trioctahedral sheets of chlorite and in
371 the brucite sheets of chlorite (see Table 4). Figure 8 shows the C₂S polymorphs present in the
372 different binary mixes. Typical β-C₂S are formed when CLY1, CLY2 and MED1 are used (most
373 common form in clinkers; Figure 8a). However, the high temperature α-belite is stabilized for the
374 other clinkers (Figure 8b). Since clinker preparation protocols are equivalent, the only explanation
375 is a stabilization by Na supplied by the Na-feldspars like albite (no feldspar is usually present in
376 industrial rocks). Concerning C₃A, Figure 9 shows that the typical cubic C₃A phase is formed in
377 CLY1-Bin, CLY2-Bin and MED1-Bin. Orthorhombic C₃A is identified for all the other clinkers.
378 Again, the greater the Na content, the more likely is the stabilization of the orthorhombic form of
379 C₃A.

380 • *Hardened state properties*

381 Differences can be observed at 2 or 7 days (Figure 10). This can be attributed to differences
382 in clinker reactivity, in mass percentage of each phase, in the gypsum quantity or in the fineness
383 after grinding. Nevertheless, all the samples show suitable strengths after 28 days. The important
384 increase between young age and 28 days for samples using sediments might be linked to the
385 formation of the C₂S α-polymorph which is delayed (compared to C₃S) but which is also known to
386 be a highly reactive belite polymorph.

387 *3.2 Ternary clinkers*

388 • *Anhydrous clinker characteristics*

389 A study, which was similar to the investigations on binary clinkers, was also carried out on
390 clinkers obtained from ternary meals. Free lime contents were evaluated and results are reported in
391 Figure 4b. The diagram presented in Figure 4b demonstrates that all the clinkering products

392 exhibited a free lime content **less** than the typical limit of 2 wt%, or slightly higher for ALP4-Ter.
393 Hence, it can be said that the clinkering reaction were relatively successful. Combination of lime
394 with the three other oxides was efficient. Interesting observations come from the comparison of the
395 free lime content between binary and ternary mix for a same **sediment source**. The most remarkable
396 example is **the EST1 sample**, since free lime content was reduced from 3.62 wt% for the binary
397 clinker to 1.70 wt% for EST1-Ter. This improved raw meal burnability can be explained by the
398 **decrease** of the sediment fraction in the meal, from 26.27 % to 10.78 %, and its **substitution** by an
399 aluminous clay rock (CLY1) that increased the melt content. A high liquid phase proportion
400 facilitates the combination of lime, especially the transition from C₂S to C₃S. Melt acts as a medium
401 for Ca²⁺ ion diffusion [40]. Although the EST1 content was maintained at a relatively high level
402 (> 10 wt%), the negative effect of coarse PSD and high silica ratio were fully corrected using an
403 appropriate industrial clay from **the cement industry**. This good result **for a ternary blend** was
404 obtained only by mix adjustment and without any modification of the clinkering process,
405 particularly the burning time. Contrary **to the EST1 sediment**, all the other resources – MED1,
406 BRT1 and alpine materials – were complemented by a clay rock CLY2 with a high silica ratio. Due
407 to the reduction of the liquid phase fraction, ternary mixes were in most cases harder to burn than
408 for binary mixes. Free lime contents increased although they still **remained in a satisfactory range**.

409 After the **successful assessment of lime combination**, chemical compositions of ternary
410 clinkers were determined, and analyses are presented in Table 12 along with potential mineralogical
411 compositions which were calculated according to Bogue calculations. Table 12 shows that the
412 chemical composition tends to be more uniform from **one clinker to another** due to the simultaneous
413 use of one dam sediment and one quarried clay, which allows a good adjustment of the chemical
414 parameters. For instance, **the** SiO₂ content was increased for all the clinkers prepared by
415 incorporating a sediment with low SR, *i.e.* ALP1, ALP2, ALP3, ALP4, BRT1 and MED1, in
416 comparison to the binary clinkers. Chemical compositions comply with the typical range as defined
417 by [46]. Moreover, the ternary clinkers satisfied both criteria concerning **the** MgO content and the
418 ratio between lime and silica as defined in NF EN 197-1. In parallel, the mineralogical
419 compositions according to Bogue calculations were also stabilized due to SR adjustment during the
420 mix formulation step. The ratio between silicate and aluminate phases was relatively constant
421 between all the ternary clinkers, with an interstitial phase (C₃A and C₄AF) that **accounted** for 18.5
422 to 20.3 wt%. It should be noticed that only three components were used to obtain homogeneous and
423 well-proportioned clinkers (Table 8). The adjustment could even be better, particularly **by** setting
424 the alumina ratio, *i.e.* controlling the composition of the liquid phase. **Depending on** the expected
425 clinker, iron oxide or alumina – often in the form of bauxite – can be added to the raw meal.

426 Since adequate ratios between crystalline phases were demonstrated for ternary clinker,
427 attention was then focused on the polymorphs. Specific XRD windows allowing alite identification
428 are shown in Figure 11. First, in Figure 11a, the presence or absence of the diffraction peak located
429 at $36.7^\circ 2\theta$ helps in discriminating which samples contain alite with **the** M_3 allotrope and which
430 ones are free from this monoclinic form. It can be observed that all the ternary samples prepared
431 with sediment do contain M_3 - C_3S . In contrast, CLY-Ter clinker did not present the typical reflection
432 peak at $36.7^\circ 2\theta$. This observation for the reference CLY-Ter clinker was not very surprising since
433 the binary clinkers prepared with the individual quarried clays did not initially present M_3 -alite.
434 Considering, as a second step, the 55.5 to $57.5^\circ 2\theta$ window in Figure 11b, it can be mentioned that
435 the control lab clinker CLY-Ter presented the expected characteristic pattern of M_1 - C_3S . Regarding
436 the clinkers produced with sediment in ternary **blends**, it should be noticed that a broad double peak
437 can now be distinguished between 56.2 and $56.7^\circ 2\theta$. This pattern could be interpreted as a
438 coexistence of M_1 and M_3 polymorphs. Compared to the binary clinkers, a relevant evolution to
439 consider is the relatively equal intensity between the peak at 36.4 (M_1) and the peak at 36.6 (M_3).
440 Intensities were almost equivalent for all the ternary clinker whereas the M_3 peak was clearly the
441 strongest in binary clinkers produced with sediment (Figure 6). To sum up, the main conclusion
442 concerning alite polymorphism during the transition from binary to ternary mix was a distinct
443 increase of monoclinic M_1 - C_3S proportion and, in parallel, a relative **decrease** of M_3 - C_3S . The
444 **decrease** of sediment content and its replacement by clay low in magnesium oxide reduces the
445 quantity of incorporated magnesium that acts as a stabilizing agent **in the** M_3 form due to
446 substitutions in crystal lattice.

447 Concerning C_2S polymorphism, the same windows as for binary clinkers were chosen for
448 ternary products. These selected angle ranges are presented in Figure 12. Figure 12a, which focuses
449 on the angle range 30.5 to $32.0^\circ 2\theta$, shows similar diffraction patterns for all the studied clinkers,
450 except for ALP4-Ter. The common feature is an association of two close peaks: a first one just
451 below $31.0^\circ 2\theta$ and another one at $31.6^\circ 2\theta$. This combination is typical of the β - C_2S **phase**, which
452 is industrially the most frequent polymorph. With a moderate level of stabilizing agents and a
453 **moderate** to rapid cooling rate, β -belite is the obtained form of C_2S . Theoretically, this polymorph is
454 metastable at room temperature and should be transformed into the unreactive orthorhombic γ - C_2S .
455 However, due to chemical stabilizers and/or the size of crystallites [40], this transition to **the** γ -form
456 does not occur. In ternary clinkers, it should also be noticed that no peak could be observed at
457 $33^\circ 2\theta$ contrary to **observations for binary clinkers** observations. It means that the high temperature
458 α - C_2S **form** was no longer contained in clinkers from ternary blends, except for ALP4-Ter. This
459 observation can be explained by the reduction in alkali content, especially Na_2O which is known to
460 promote **the** α -form when combined with rapid cooling [57]. Thus, considering the results for

461 binary and ternary blends, it is clear that the sediment content in clinker raw meal may modify the
462 polymorphism of C₂S. High replacement ratios are likely to preserve high temperature forms
463 whereas a mix with a reduced amount of alternative raw material would favor the cooling
464 transformations towards α'_H , α'_L and the traditional β -form. Even if most sediments – MED1
465 excluded – tend to add stabilizers for high temperature belite, all these polymorphs are supposed to
466 present a hydraulic reactivity. The unreactive γ was never observed, neither the typical “dusting”
467 phenomenon due to the 13 % volume change when crystals evolve from monoclinic- β to
468 orthorhombic- γ .

469 During the binary clinkers characterization, it was shown that C₃A was the third phase with
470 a polymorphism affected by sediment addition. Crystallographic changes of this mineral were also
471 investigated for ternary mixes, using the usual 47.0 to 48.0 °2 θ angle range. This portion of XRD
472 patterns is given for each ternary clinker in Figure 13. The main comment that can be made on
473 Figure 13 is the prevalence of the 47.8 °2 θ peak for all the ternary clinkers, except for ALP4-Ter. It
474 means that the cubic polymorph, that is to say the undistorted lattice form, was dominant. This
475 result can be explained by a reduced amount of sodium impurities provided by sediment and
476 contained in Na-feldspars and, to a lesser extent, in clay minerals.

477 • *Fresh and hardened state properties on mortar*

478 It was previously shown that ternary clinkers did not show any particular feature in
479 comparison to the binary ones. Furthermore, the characteristics were rather homogenous from one
480 ternary clinker to another due to a more precise adjustment of the raw meal chemistry, except for
481 ALP4-Ter. Thus, it was decided to investigate more deeply one clinker formulation. For its greater
482 availability, ALP1-Ter was selected. Several standard tests, on the mortar and in the fresh state,
483 were carried out on a Portland cement produced with fine-grained sediment, yielding results which
484 were never observed before in literature. The properties of ALP1-Ter cement were compared (i) to
485 the cement standards when available and (ii) to the hydration characteristics of an industrial
486 Portland cement, considered as reference in the experimentation. As a reminder, both cements were
487 prepared to obtain a similar Blaine fineness (3600 cm²/g) and identical SO₃ contents (2.6 wt%).

488 First and foremost, setting times were measured after establishing the water-to-binder ratio
489 which yields standard consistency. Results are given in Table 13. Since the production in the
490 laboratory of ALP1-Ter lab cement was limited (2 kg), the number of possible w/c trials to reach
491 standard consistency was reduced. It explains why there is no strict value given in Table 13.
492 According to the accomplished tests, it can be said that w/c ratio of ALP1-Ter cement at standard
493 consistency was slightly lower than 0.245. In comparison, the reference CEM I presented a w/c
494 ratio of 0.260. According to Zhang [58], standard consistency generally lies in the range 0.24 to
495 0.30. Thus, the studied ALP1-Ter cement required a rather low water amount while maintaining an

496 interesting workability. Concerning setting times, it can be mentioned that the initial setting time is
497 30 minutes shorter for ALP1-Ter cement compared to the control sample. This observation could be
498 explained by the difference in C₃A content which plays a main role in early reactivity. According to
499 the NF EN 197-1 standard [45], a 52.5 strength class cement must exhibit an initial setting time
500 **greater** than 45 min. This condition was satisfied by ALP1-Ter and by the reference cement as well.
501 Regarding the final setting times, they are similar from one cement to another (around 3 hours).
502 According to Siddiqi [59], a final setting time **less** than 10 h should be recommended for any
503 binder. Again, this requirement was fulfilled by ALP1-Ter cement. Therefore, a hydraulic reactivity
504 was demonstrated by the alternative **laboratory cement**. Short setting times **ensure rapid hardening**
505 **and quick strength** development.

506 The heat generated by ALP1-Ter cement hydration was followed for 120 h **using** semi-
507 adiabatic calorimetry and compared to the Portland cement made with **an industrial clinker**.
508 Cumulative heats of hydration for both cements are presented in Figure 14. After 120 h, the
509 cumulative heat of hydration is stabilized for both Portland binders. Mortar manufactured with
510 ALP1-Ter cement generated 413 J/g, which was 8.7 % higher than the control CEM I (380 J/g).
511 Each clinker phase **exhibits a very** different heat of hydration. Two of them mainly participate in
512 total heat generation: C₃A (1000 to 1200 J/g) and C₃S (500 to 525 J/g) [60]. Therefore, the higher
513 content in tricalcium aluminate of the **laboratory clinker** could explain the **greater** heat generated
514 during its hydration compared to the control sample, especially at the very beginning of setting.
515 Although the total heat generated by ALP1-Ter cement was rather high, it is still tolerable for a
516 CEM I binder. For different reasons (thermal cracking risks and delayed ettringite formation), a
517 limitation of heat of hydration might be required. ALP1 sediment could still be valorized using
518 supplementary cementitious materials in addition to ALP1-Ter or adjusting the raw meal to
519 **synthesize** less C₃A.

520 Mortar compressive strength with ALP1-Ter cement was assessed after 2, 7 and 28 days in
521 standard conditions. Results are given in Figure 15 and Table 14 and compared to the industrial
522 reference CEM I. **After** 28 days, ALP1-Ter cement presented a compressive strength of 57.9 MPa.
523 According to the strength value after a curing time of 2 days (< 30 MPa), ALP1-Ter cement can be
524 classified as a 52.5N binder. It can be noticed that at any curing time, compressive strengths of the
525 **laboratory** cement made with sediment were higher than the reference Portland cement. ALP1-Ter
526 cement showed **a high** reactivity and strength gain at the earliest ages (2 and 7 days). The maximum
527 compressive strength difference between the tested cement and the control sample was observed
528 **after** 7 days (17.3 % higher). In contrast, this discrepancy tended to diminish **at a later age**, *i.e.*
529 28 days. The described strength development is rather consistent with the semi-adiabatic

530 calorimeter results and relatively short setting times. In summary, mechanical performances of the
531 Portland cement prepared with 11.4 wt% of sediment were fully acceptable.

532 Dimensional and mass variations of mortars stored in a cabinet with controlled atmosphere
533 were assessed during 28 days (Figure 16). Mortar shrinkage with ALP1-Ter cement was stabilized
534 after 21 days at 390 $\mu\text{m/m}$ (Figure 16a). This value is low compared to the reference Portland
535 cement (500 $\mu\text{m/m}$). Generally speaking, the lower the shrinkage, the more performant the cement.
536 Shrinkage limits are no longer given in cement standards. However, the withdrawn NF P15-301
537 standard set a maximum limit at 1000 $\mu\text{m/m}$ for a cement that reaches 55 MPa after 28 days. This
538 criterion is respected for ALP1-Ter cement and the reference one as well. Moreover, studying 8
539 different industrial CEM I cements, Massazza observed that shrinkage in the same conditions lies in
540 a range from 329 to 461 $\mu\text{m/m}$ [61], which is similar to the manufactured ALP1-Ter mortar. Blaine
541 fineness is often presented as a key-explanation for drying shrinkage. However, in this study, Blaine
542 fineness was kept constant in order to avoid this bias. Therefore, the small difference in shrinkage
543 between the ALP1-Ter mortar and the control one can mainly be attributed to the progress of the
544 hydration reaction that was greater for the laboratory ALP1-Ter sample in an equivalent time. More
545 water participated in hydration reactions compared to the other sample, meaning less water is
546 available for evaporation in the porous system. To complete dimensional interpretations, it can be
547 observed in Figure 16b that whatever the drying time, mass loss was lower for ALP1-Ter mortar
548 compared to the control CEM I. This result is consistent with dimensional variations, since mass
549 loss and shrinkage are both related to the evaporated water quantity. To sum up, it can be said that
550 ALP1-Ter shrinkage is absolutely satisfying.

551 As a conclusion of this result part concerning the “advanced” experiments related to ALP1-
552 Ter cement, it can be said that this alternative binder fulfilled all the tested requirements either in a
553 fresh or a hardened state.

554 3.3 Link between sediment properties and clinker characteristics

555 It's interesting to represent the different mineralogical compositions in a framework, as
556 proposed by Haurine *et al.* in 2016 [13] in order to classify the sediments according to their interest
557 in being used in the tile and brick industry. In the present work, we have chosen a representation
558 that highlights the presence of alkaline ions which are known to play a significant role during
559 sintering. The poles are the following: (1) clay minerals and microcline since they contain
560 potassium (especially illite as shown in Table 4 and microcline), (2) albite which can supply sodium
561 during sintering, and (3) quartz. All sediments are quite distinct from CLY1 and CLY2. Thus a
562 chemical and a mineralogical framework to predict the effect of sediment addition on clinker

563 characteristics can be proposed (Figure 17). From Figure 17a, the following points can be
564 underlined:

- 565 - The greater the CaO content, the greater amount of sediment can be used in the raw meal.
- 566 - When the quantity of SiO₂ increases, the burnability decreases.
- 567 - The interstitial phase is abundant when the composition is enriched with alumina.

568 Figure 17b presents the mineral compositions of the sediments in a mineralogical framework. One
569 pole corresponds to K rich phases, a second pole to Na rich phases and the last pole to quartz. If the
570 composition contains a significant amount of albite, then orthorhombic C₃A and α-C₂S are present
571 in the clinker. These frameworks are simplified and obviously they need to be completed with
572 similar studies on a variety of sediments. Nevertheless, they could be a useful decision support tool
573 for a cement company to decide if a sediment could be incorporated into a raw meal as it is or if it
574 needs to be mixed with other sources of raw materials.

575 4. Conclusions

576 Beneficial reuse of waste as alternative raw materials for industry is a challenging, but
577 necessary, objective for the future. Concerning the cement industry, large amounts of natural
578 geological resources are consumed each year to manufacture clinker, component of concrete which
579 is the most widely used construction material. In parallel, great amounts of fine-grained sediment
580 might have to be dredged from French reservoirs in the future. In this context, an industrial ecology
581 approach could be implemented in order to introduce dam sediments into clinker raw meals,
582 reducing at the same time waste disposal and the extraction of quarried rock. Compared to previous
583 studies which were “case-specific”, this paper aimed to take into account the soils and geological
584 variations from one French region to another, working simultaneously on 7 sediments from
585 different locations. The essential conclusions are listed below:

- 586 - In terms of chemical composition, all the studied sediment resources contain SiO₂, Al₂O₃
587 and CaO as the main oxides but with various concentrations. A direct relationship can be
588 made with the mineralogical phases, *e.g.* CaO is carried by carbonates (primarily calcite)
589 while silica is contained in quartz, phyllosilicates and feldspars. Additional minor elements
590 can also be indicated, especially for alpine sediments, like Mg (illite, chlorite and dolomite)
591 and alkalis (feldspars and illite).
- 592 - Very high sediment replacement ratios (from 25 to 35 wt%) are reached in the total clay
593 substitution strategy, called binary mixes. This approach is challenging since the adjustment
594 of the composition is restricted to the lime saturation factor. According to the identified
595 crystalline phases, the products can be considered as “Portland” clinkers. In several cases,
596 special features are observed due to sediment introduction (lime combination success,

597 interstitial phase content, polymorphism). The impact of dredged materials on clinkering
598 reactions was never described with such details previously in literature.

599 - Considering the clinker obtained with ternary meals, it can be said that a replacement of 10
600 to 15 wt% of the usual raw material by any of the sediments does not significantly impact
601 the clinker properties, even the phase polymorphism. After gypsum addition, a CEM I
602 52.5N cement can be obtained, with a high hydraulic reactivity and no constraint in terms of
603 fresh state workability and shrinkage. To sum up, fine-grained sediments can be reused in
604 clinker raw meal to produce any type of clinker.

605 Due to the significant number of investigated sediments, this study provides a solid foundation for
606 future work and in particular to test with an industrial pilot scheme. Moreover, additional practical
607 aspects must be considered such as full-scale drying after dredging operation and transport
608 conditions. It should also be noticed that durability tests are a legitimate extension of this work,
609 particularly the sensitivity to chemical attacks, according to the desired cement type and the
610 expected application.

611 **Acknowledgements**

612 The National Association of Technical Research (ANRT) is sincerely acknowledged for its
613 financial support. Additionally, the authors would like to thank the interns from ENSIL-ENSCI
614 Engineering school who were involved for several weeks in this project. Their experimental work
615 was sincerely appreciated.

- [1] Ministry of Ecology, Energy, Sustainable Development and Territorial Planning, Circulaire du 04/07/08 relative à la procédure concernant la gestion des sédiments lors de travaux ou d'opérations impliquant des dragages ou vurages maritimes et fluviaux, Official Bulletin of MEEDDAT n° 2008/15, 2008.
- [2] A.J. Schleiss, M.J. Franca, C. Juez, G. De Cesare, Reservoir sedimentation, *J. Hydraul. Res.* 54 (2016) 595-614. doi:10.1080/00221686.2016.1225320.
- [3] S. Munir, Role of sediment transport in operation and maintenance of supply and demand based on irrigation canals, CRC Press, Boca Raton, 2011.
- [4] Directive 2008/98/EC of the European Parliament and of the Council of 19 November 2008 on waste and repealing certain Directives, O. J. L 312-3, 2008.
- [5] P.N. Owens, R.J. Batalla, A.J. Collins, B. Gomez, D.M. Hicks, A.J. Horowitz, G.M. Kondolf, M. Marden, M.J. Page, D.H. Peacock, E.L. Petticrew, W. Salomons, N.A. Trustrum, Fine-grained sediment in river systems: environmental significance and management issues, *River Res. Appl.* 21 (2005) 693-717. doi:10.1002/rra/878.
- [6] C. Sheehan, J. Harrington, J.D. Murphy, A technical assessment of topsoil production from dredged material, *Resour. Conserv. Recy.* 54 (2010) 1377-1385. doi:10.1016/j.resconrec.2010.05.012.
- [7] G. Fourvel, L. Vidal-Beaudet, A. Le Bocq, V. Brochier, F. Théry, D. Landry, T. Kumarasamy, P. Cannavo, Early structural stability of fine dam sediment in soil construction, *J. Soils Sediments.* 18 (2018) 1-17. doi:10.1007/s11368-018-1926-2.
- [8] V. Dubois, N.E. Abriak, R. Zentar, G. Ballivy, The use of marine sediments as a pavement base material, *Waste Manage.* 29 (2009) 774-782. doi:10.1016/j.wasman.2008.05.004.
- [9] S. Kamali, F. Bernard, N. E. Abriak, P. Degrugilliers, Marine dredged sediments as new materials resource for road construction, *Waste Manage.* 28 (2008) 919-928. doi:10.1016/j.wasman.2007.03.027.
- [10] M. Le Guern, T.A. Dang, M. Boutouil, Implementation and experimental monitoring of a subgrade road layer based on treated marine sediments, *J. Soils Sediments.* 17 (2017) 1815-1822. doi:10.1007/s11368-017-1652-1.
- [11] K. Hamer, V. Karius, Brick production with dredged harbour sediments. An industrial scale experiment, *Waste Manage.* 22 (2001) 521-530. doi:10.1016/S0956-053X(01)00048-4.
- [12] A. Mezencevova, N.N. Yeboah, S.E. Burns, L.F. Kahn, K.E. Kurtis, Utilization of Savannah Harbor river sediment as the primary raw material in production of fired brick, *J. Environ. Manage.* 113 (2012) 128-136. doi:10.1016/j.envman.2012.08.030.

- [13] F. Haurine, I. Cojan, M.-A. Bruneaux, Development of an industrial mineralogical framework to evaluate mixtures from reservoir sediments for recovery by the heavy clay industry: Application to the Durance system (France), *Appl. Clay Sci.* 132 (2016) 508-517. doi:10.1016/j.clay.2016.07.022.
- [14] J. Limeira, M. Etxeberria, M. Agulló, D. Molina, Mechanical and durability properties of concrete made with dredged marine sand, *Constr. Build. Mater.* 25 (2011) 4165-4174. doi:10.1016/j.conbuildmat.2011.04.053.
- [15] N. Junakova, J. Junak, M. Balintova, Reservoir sediment as a secondary raw material in concrete production, *Clean Technol. Environ.* 17 (2014) 1161-1169. doi:10.1007/s10098-015-0943-8.
- [16] J. Couvidat, M. Benzaazoua, V. Chatain, A. Bouamrane, H. Bouzahzah, Feasibility of the reuse of total and processed contaminated marine sediments as fine aggregates in cemented mortars, *Constr. Build. Mater.* 112 (2016) 892-902. doi:10.1016/j.conbuildmat.2016.02.186.
- [17] P. Ozer-Erdogan, H. Merve Basar, I. Erden, L. Tolun, Beneficial use of marine dredged materials as a fine aggregate in ready-mixed concrete: Turkey example, *Constr. Build. Mater.* 124 (2016) 690-704. doi:10.1016/j.conbuildmat.2016.07.144.
- [18] G. Aouad, A. Laboudigue, N. Gineys, N.E. Abriak, Dredged sediments used as a novel supply of raw material to produce cement clinker, *Cement and Concrete Composites.* 34 (2012) 788-793. doi:10.1016/j.cemconcomp.2012.02.008.
- [19] J.L. Dalton, K.H. Gardner, T.P. Seager, M.L. Weimer, J.C.M. Spear, B.J. Magee, Properties of Portland cement made from contaminated sediments, *Resour. Conserv. Recy.* 41 (2004) 227-241. doi:10.1016/j.resconrec.2003.10.003.
- [20] B. Anger, I. Moulin, J.-P. Commène, F. Théry, D. Levacher, Fine-grained reservoir sediments: an interesting alternative raw material for Portland cement clinker production, *Eur. J. Environ. Civ. En.*, (2017) 1-14. doi:10.1080/19648189.2017.1327890.
- [21] C. Meyer, The greening of the concrete industry, *Cement Concrete Comp.* 31 (2009) 601-605. doi:10.1016/j.cemconcomp.2008.12.010.
- [22] T. Gao, L. Shen, M. Shen, L. Liu, F. Chen, Analysis of material flow and consumption in cement production process, *J. Clean. Prod.* 112 (2016) 553-565. doi:10.1016/j.clepro.2015.08.054.
- [23] H.G. van Oss, A.C. Padovani, Cement Manufacture and the Environment. Part II: Environmental Challenges and Opportunities, *J. Ind. Ecol.* 7 (2003) 93-126. doi:10.1162/108819803766729212.
- [24] Cimbéton, Infociments 2016. L'essentiel, 2016.

- [25] J. Schoon, L. Van der Heyden, P. Eloy, E.B. Gaigneux, K. De Buysser, I. Van Driessche, N. De Belie, Waste fibre cement: An interesting alternative raw material for a sustainable Portland clinker production, *Constr. Build. Mater.* 36 (2012) 391-403. doi:10.1016/j.conbuildmat.2012.04.095.
- [26] J. Schoon, K. De Buysser, I. Van Driessche, N. De Belie, Feasibility study on the use of cellular concrete as alternative raw material for Portland clinker production, *Constr. Build. Mater.* 48 (2013) 725-733. doi:10.1016/j.conbuildmat.2013.07.083.
- [27] M. De Schepper, K. De Buysser, I. Van Driessche, N. De Belie, The regeneration of cement out of Completely Recyclable Concrete: Clinker production evaluation, *Constr. Build. Mater.* 38 (2013) 1001-1009. doi:10.1016/j.conbuildmat.2012.09.061.
- [28] C. Diliberto, A. Lecomte, J.-M. Mechling, L. Izoret, A. Smith, Valorisation of recycled concrete sands in cement raw meal for cement production, *Mater. Struct.* 50 (2017). doi:10.1617/s1152-7-017-0996-8.
- [29] G. Bernardo, M. Marroccoli, M. Nobili, A. Telesca, G. Valenti, The use of oil well-derived drilling waste and electric arc furnace slag as alternative raw materials in clinker production, *Resour. Conserv. Recy.* 52 (2007) 95-102. doi:10.1016/j.resconrec.2007.02.004.
- [30] P.E. Tsakiridis, P. Oustadakis, S. Agatzini-Leonardou, Black Dross Leached Residue: An Alternative Raw Material for Portland Cement Clinker, *Waste Biomass Valori.* 5 (2014) 973-983. doi:10.1007/s12649-014-9313-8.
- [31] R.I. Iacobescu, G.N. Angelopoulos, P.T. Jones, B. Blanpain, Y. Pontikes, Ladle metallurgy stainless steel slag as a raw material in Ordinary Portland Cement production: a possibility for industrial symbiosis, *J. Clean. Prod.* 112 (2016) 872-881. doi:10.1016/j.jclepro.2015.06.006.
- [32] M.Y. Hassaan, Basalt rock as an alternative raw material in Portland cement manufacture, *Mater. Lett.* 50 (2001) 172-178. doi:10.1016/S0167-577X(01)00220-8.
- [33] N. Saikia, S. Kato, T. Kojima, Production of cement clinkers from municipal solid waste incineration (MSWI) fly ash, *Waste Manage.* 27 (2007) 1178-1189. doi:10.1016/j.wasman.2006.06.004.
- [34] J.R. Pan, C. Huang, J.-J. Kuo, S.-H. Lin, Recycling MSWI bottom and fly ash as raw materials for Portland cement, *Waste Manage.* 28 (2008) 1113-1118. doi:10.1016/j.wasman.2007.04.009.
- [35] S. Brunauer, P.H. Emmett, E. Teller, Adsorption of gases in multimolecular layers, *J. Am. Chem. Soc.* 60 (1938) 309-319. doi: 10.1021/ja01269a023.
- [36] AFNOR, NF EN 196-6. Methods of testing cements - Part 6: Determination of fineness, 2012.
- [37] E.C. Arvaniti, M.C.G. Juenger, S.A. Bernal, J. Duchesne, L. Courard, S. Leroy, J.L. Provis, A. Klemm, N. De Belie, Determination of particle size, surface area, and shape of supplementary

cementitious materials by different techniques, *Materials and Structures*. 48 (2015) 3687-3701.

- [38] T. Holtzapffel, *Les minéraux argileux. Préparation. Analyse diffractométrique et détermination*, Société Géologique du Nord, Villeneuve d'Ascq, 1985.
- [39] AFNOR, NF EN 12880. *Caractérisation des boues - Détermination du résidu sec et de la teneur en eau*, 2000.
- [40] H.F.W. Taylor, *Cement Chemistry*, Academic Press, Londres, 1990.
- [41] F.W. Locher, *Cement: Principles of production and use*, Verlag Bau+Technik, Düsseldorf, 2006.
- [42] G. Moir, *Cements*, in: J. Newman, B.S. Choo (Eds.), *Advanced Concrete Technology*, Butterworth-Heinemann, Oxford, 2003, pp. 1/1-1/45.
- [43] V. Michaud-Poupardin, R. Suderman, *Sulfates in high SO₃/alkali clinker. Their dissolution kinetics and their influence on concrete workability and durability*, in: K. Scrivener, J. Skalny (Eds.), *International RILEM Workshop on Internal Sulfate Attack and Delayed Ettringite Formation*, RILEM Publications, Bagneux, 2002, pp. 28-40.
- [44] P. Schläpfer, R. Bukowski, *Untersuchungen über die Bestimmung des freien Kalkes und des Kalziumhydroxydes in Zement-klinkern, Zementen, Schlacken und abgebundenen hydraulischen Mörteln*, Eidgenössische Materialprüfungsanstalt an der E.T.H. in Zürich. 63.
- [45] AFNOR, NF EN 197-1. *Cement - Part 1: Composition, specifications and conformity criteria for common cements*, 2012.
- [46] V. Baroghel-Bouny, *Caractérisation microstructurale et hydrique des pâtes de ciment et des bétons ordinaires et à très hautes performances*, PhD thesis: Ecole Nationale des Ponts et Chaussées. 1994.
- [47] H. Li, W. Xu, X. Yang, J. Wu, *Preparation of Portland cement with sugar filter mud as lime-based raw material*, *J. Clean. Prod.* 66 (2014) 107-112. doi:10.1016/j.jclepro.2013.11.003.
- [48] K. Morsli, A.G. De la Torre, J.M. Cuberos, M. Zahir, M.Á. García, *Preparación y caracterización de cementos belíticos blancos activados con dopantes alcalinos*, *Mater. Construcc.* 59 (2009) 19-29. doi:10.3983/mc.2009.44307.
- [49] P.E. Stutzman, *Guide for X-Ray Powder Diffraction Analysis of Portland Cement and Clinker*, National Institute of Standards and Technology, Gaithersburg, 1996.
- [50] A.P. Kirchheim, V. Fernández-Altable, P.J.M. Monteiro, D.C.C. Dal Molin et I. Casanova, *Analysis of cubic and orthorhombic C3A hydration in presence of gypsum and lime*, *J. Mater. Sci.* 44 (2009) 2038-2045. doi:10.1007/s10853-009-3292-3.
- [51] AFNOR, NF EN 196-3. *Methods of testing cements. Part 3 - Determination of setting times*

and soundness, 2017.

- [52] L. Struble, Hydraulic Cements-Physical Properties, in: J.F. Lamond, J.H. Pielert (Eds.), Significance of Tests and Properties of Concrete & Concrete-Making Materials, ASTM International, West Conshohocken, 2006, pp. 435-449.
- [53] AFNOR, NF EN 196-1. Methods of testing cement - Part 1: Determination of strength, 2016.
- [54] AFNOR, NF EN 196-9. Methods of testing cement - Part 9: Heat of hydration - Semi-adiabatic method, 2010.
- [55] AFNOR, NF P15-433. Methods of testing cement: Determination of shrinkage and swelling, 1994.
- [56] I. Maki, K. Goto, Factors influencing the phase constitution of alite in Portland cement clinker, Cement Concrete Res. 12 (1982) 301-308. doi:10.1016/0008-8846(82)90078-3.
- [57] A. Gies, D. Knöfel, Influence of alkalis on the composition of belite-rich cement clinkers and the technological properties of the resulting cements, Cement Concrete Res. 16 (1986) 411-422. doi:10.1016/0008-8846(86)90117-1.
- [58] H. Zhang, Building materials in civil engineering, Woodhead Publishing, Cambridge, 2011.
- [59] Z. A. Siddiqi, Concrete Structure: Part II, second ed., Help Civil Engineering Publisher, Lahore, 2012.
- [60] P. Acker, Prise et durcissement des bétons - Les effets thermomécaniques. C2235 V2, Techniques de l'Ingénieur, Saint-Denis, 1998.
- [61] F. Massazza, Pozzolana and Pozzolanic Cements, in: P.C. Hewlett (Ed.), Lea's Chemistry of Cement and Concrete, Butterworth-Heinemann, Oxford, 2004, pp. 471-635.

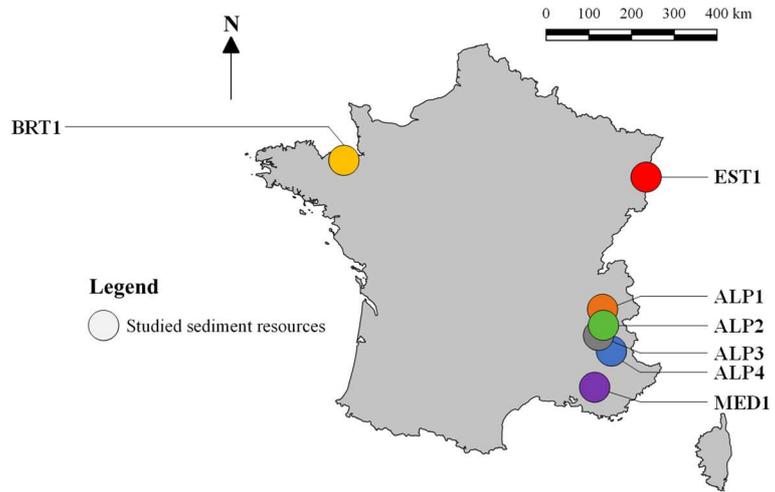
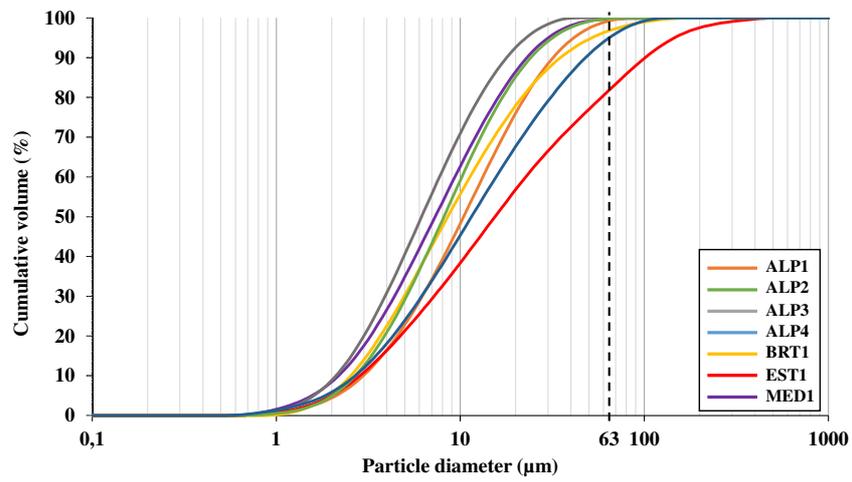
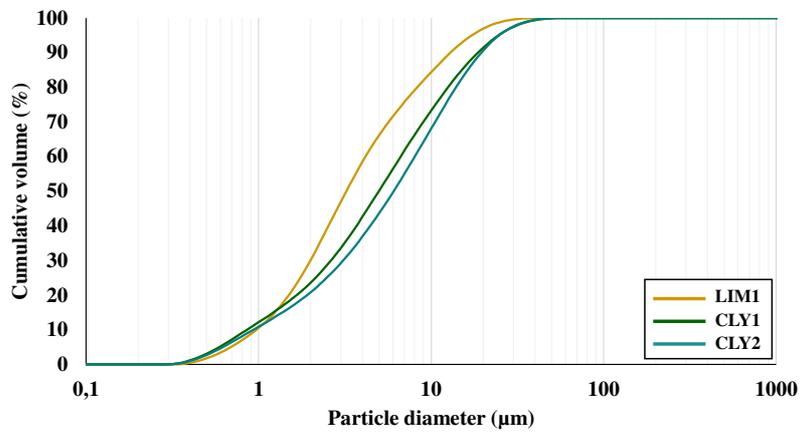


Figure 1 - Location of dam sediments on the French territory and corresponding abbreviations.



(a)



(b)

Figure 2 - Particle size distributions of the raw sediments (a) and the quarried materials (b).

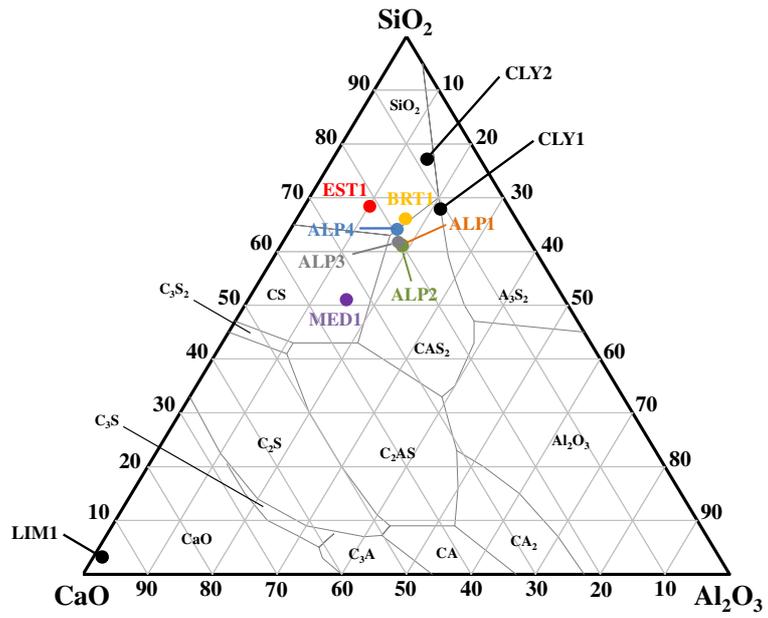
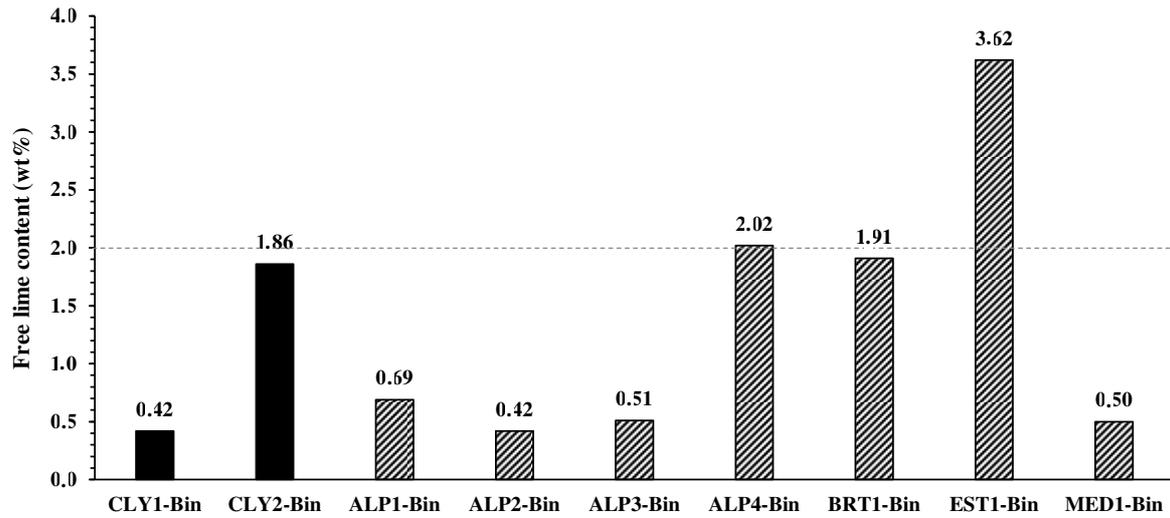
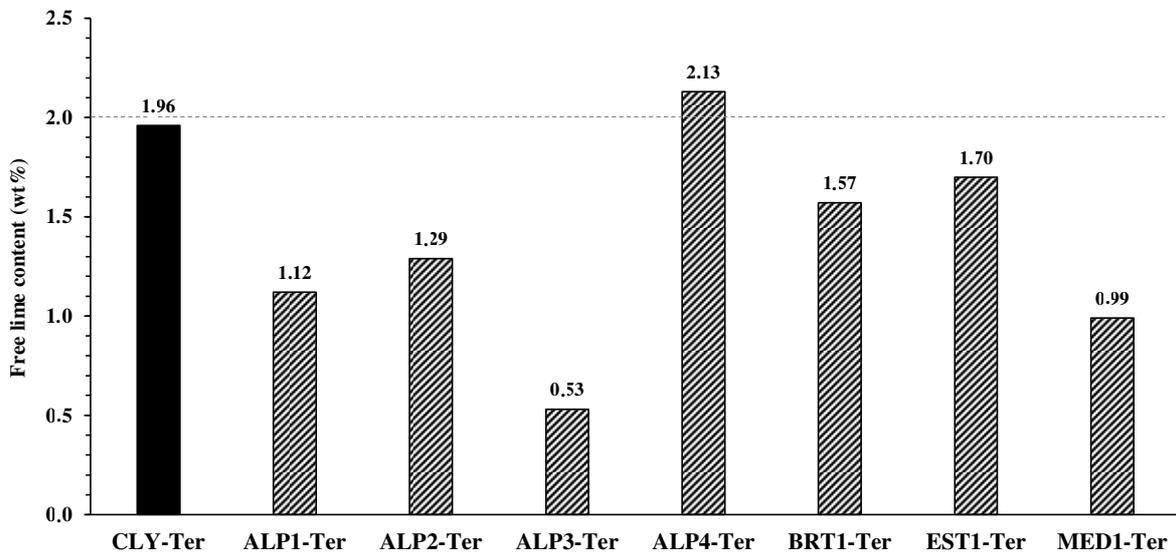


Figure 3 - Raw material locations in Rankin's diagram.



(a)



(b)

Figure 4 - Free lime contents of clinkers from (a) binary and (b) ternary mixes.

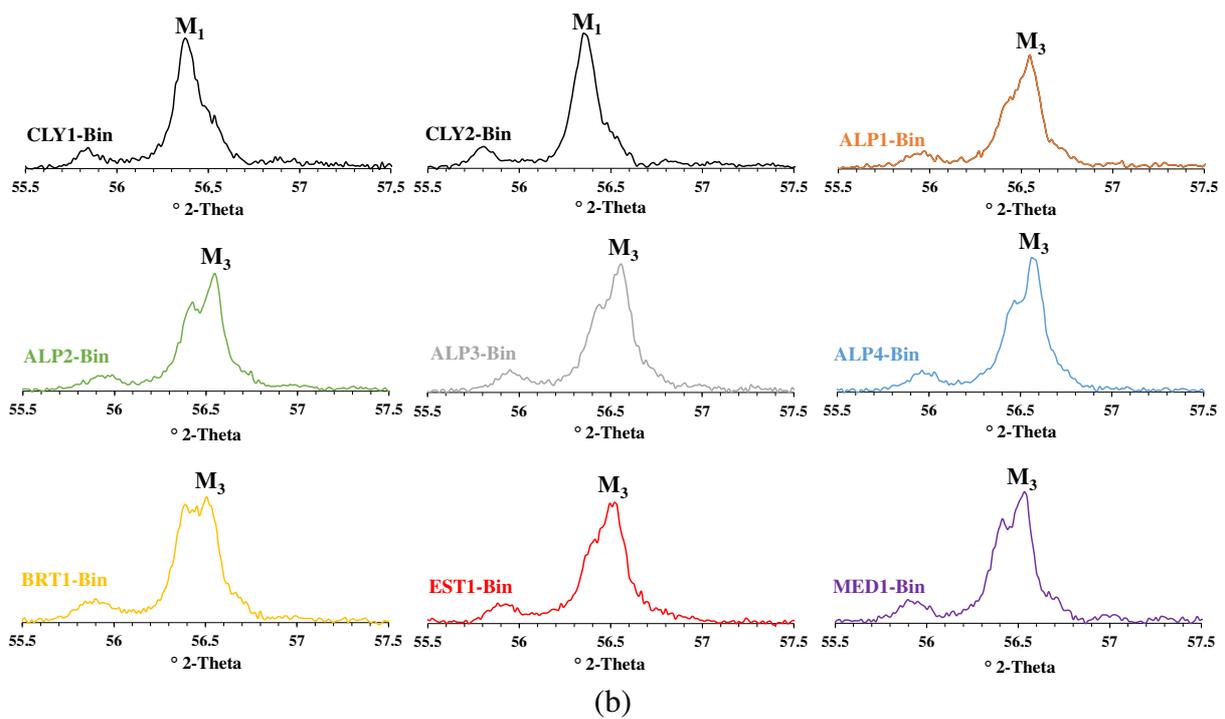
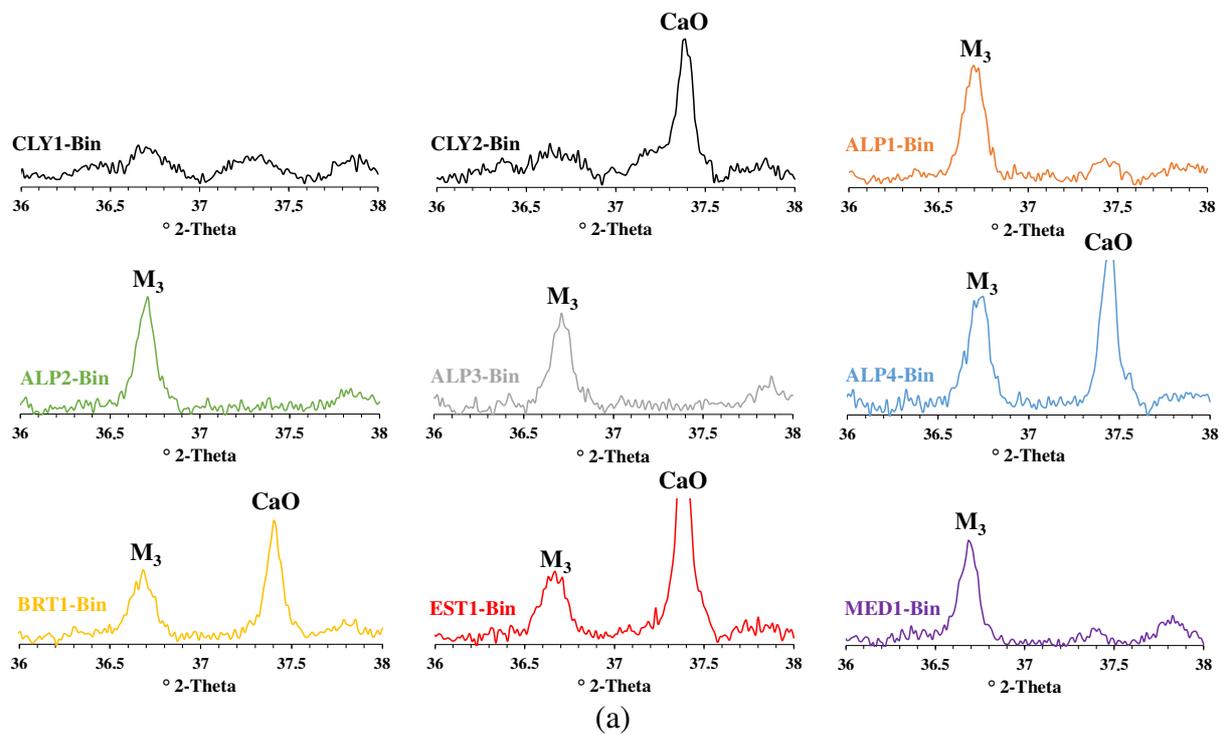


Figure 6 - Identification of C_3S polymorphism of binary clinkers in the 36.0 to 38.0 $^{\circ}2\theta$ window (a) and in the 55.5 to 57.5 $^{\circ}2\theta$ window (b). M_1 and M_3 are two alite polymorphs.

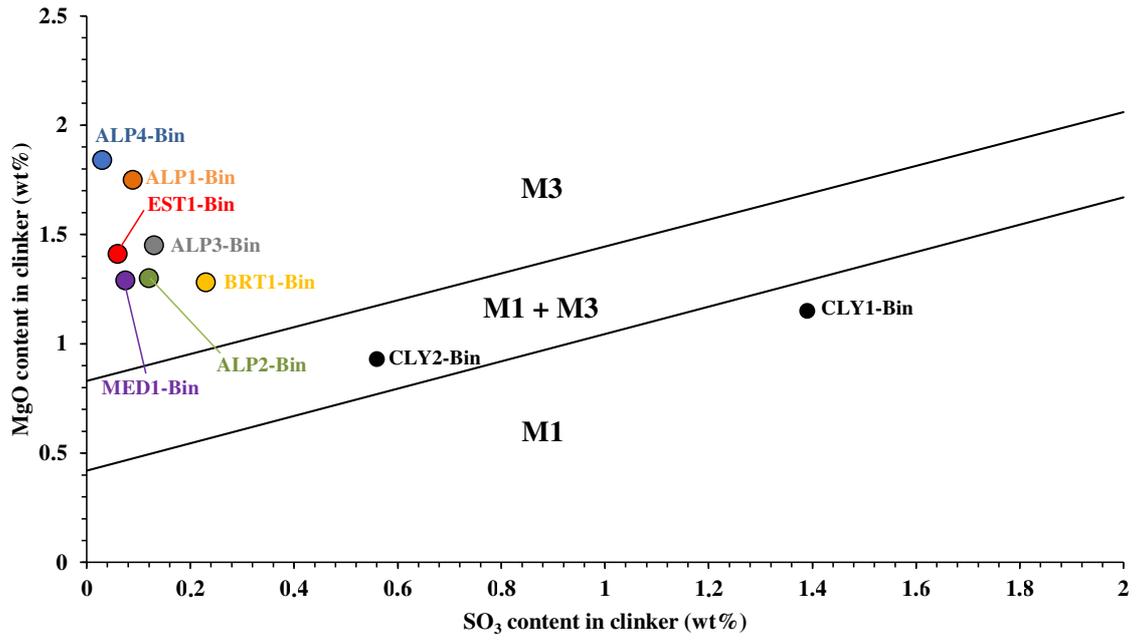
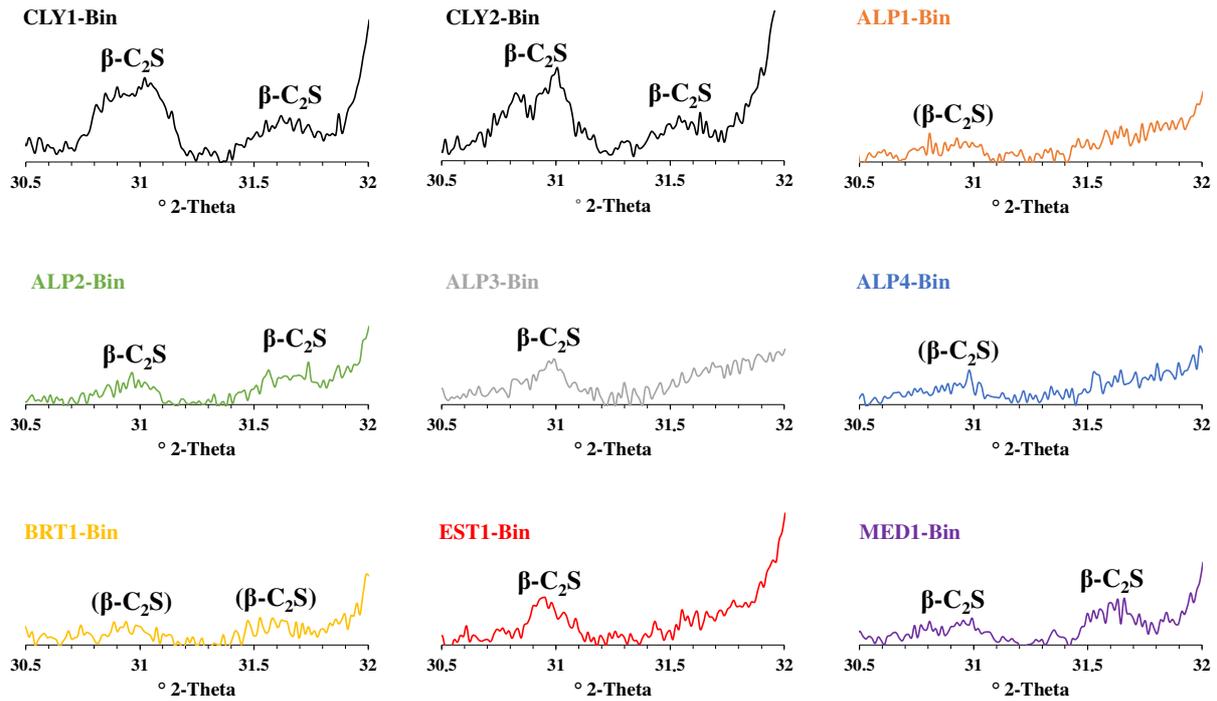
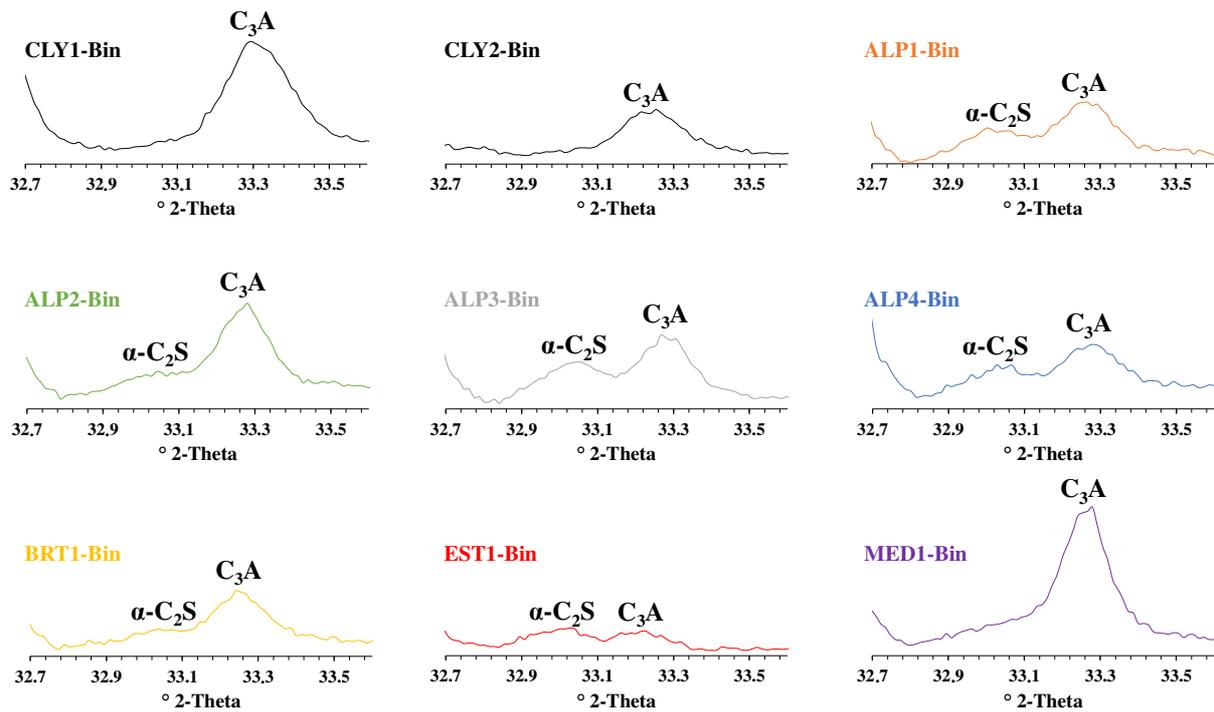


Figure 7 - Relationship between MgO/SO₃ content on polymorphic transformations of alite and location of binary lab clinkers (adapted from [56]).



(a)



(b)

Figure 8 - Identification of C_2S polymorphism of binary clinkers in the 30.5 to 32.0 °2θ window (a) and in the 32.7 to 33.6 °2θ window (b).

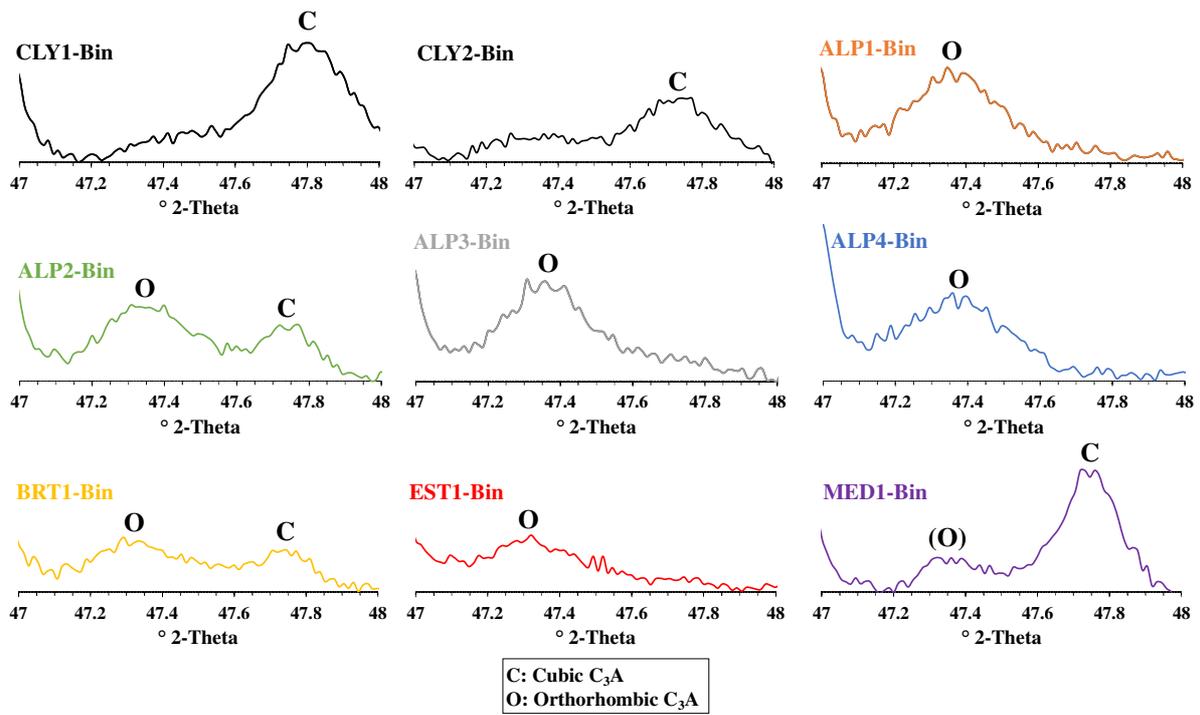


Figure 9 - Identification of C₃A polymorphism of binary clinkers in the 47.0 to 48.0 °2θ window.

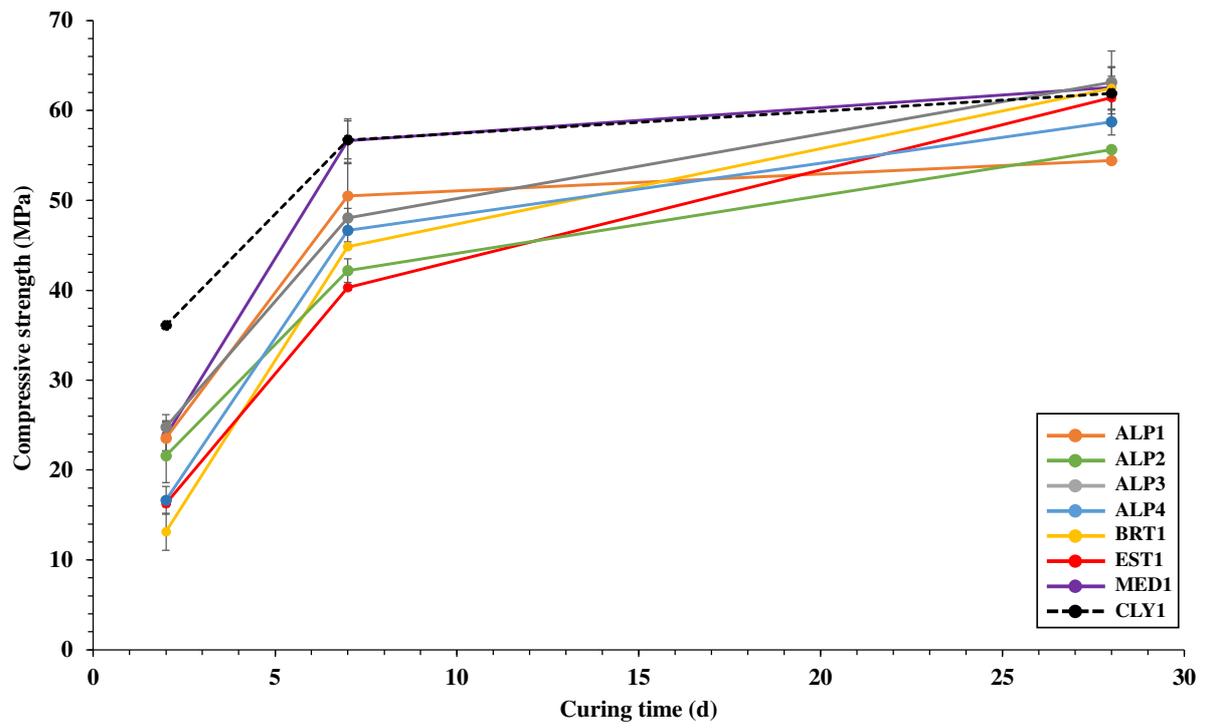
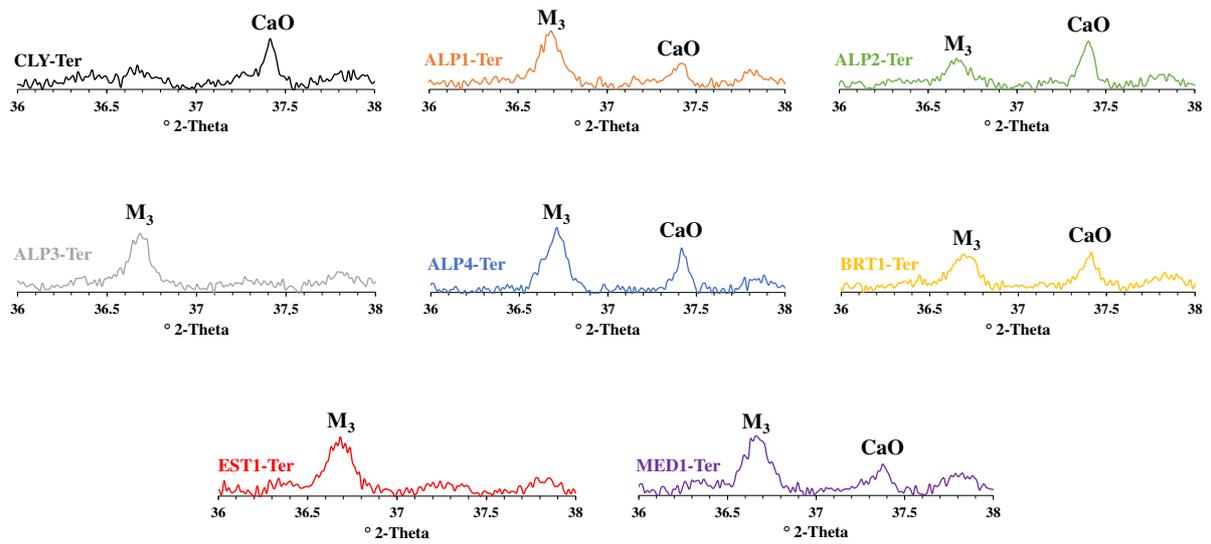
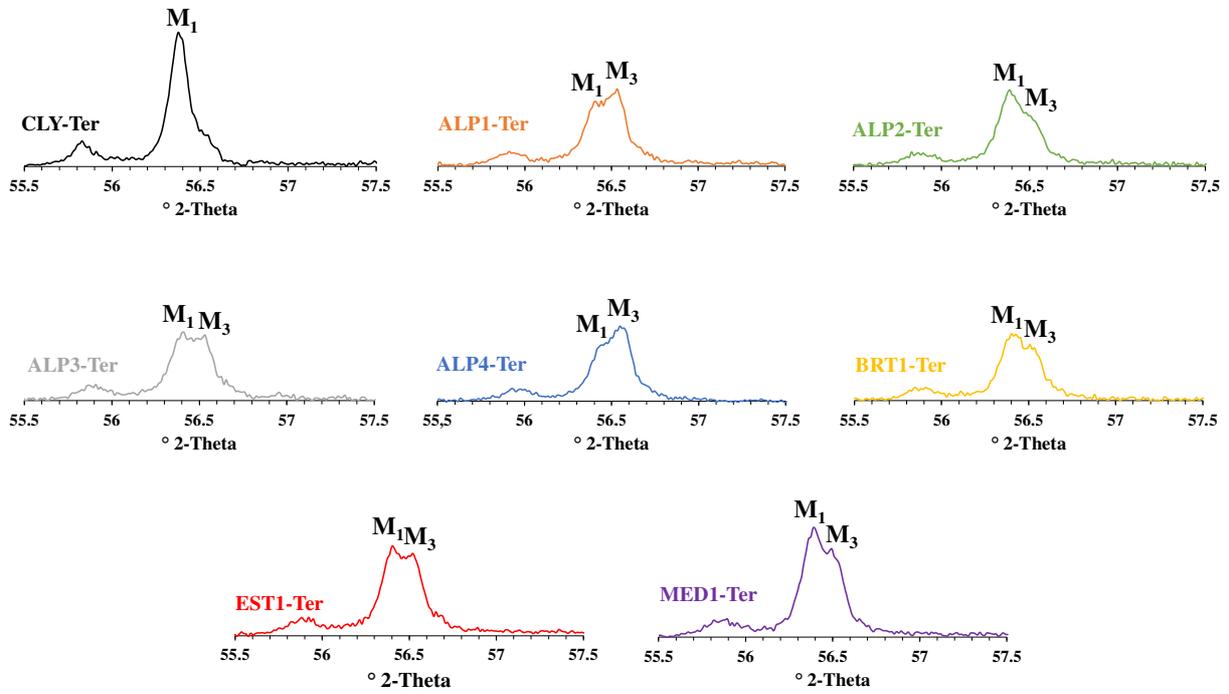


Figure 10 - Compressive strength on cement pastes produced from binary clinkers.



(a)



(b)

Figure 11 - Identification of C₃S polymorphism of ternary clinkers in the 36 to 38 °2θ window

(a) and in the 55.5 to 57.5 °2θ window (b). M₁ and M₃ are two alite polymorphs.

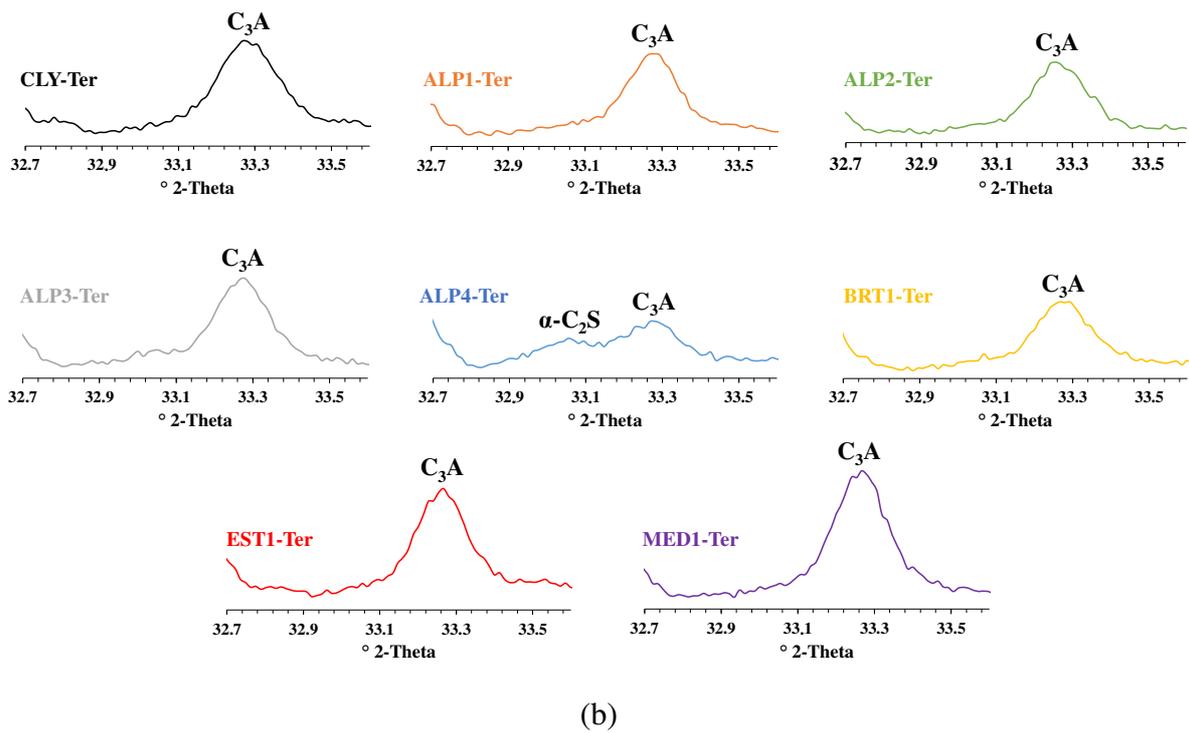
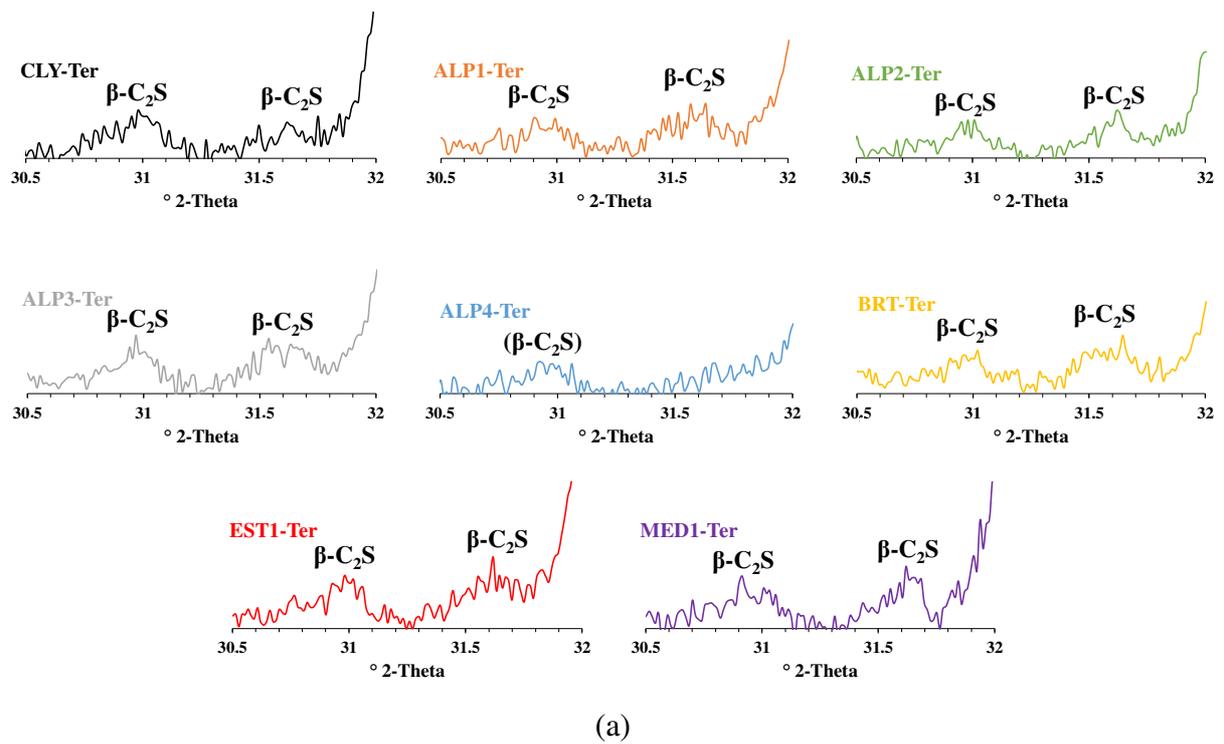


Figure 12 - Identification of C_2S polymorphism of ternary clinkers in the 32.7 to 33.6 $^{\circ}2\theta$ window (a) and in the 32.7 to 33.6 $^{\circ}2\theta$ window (b).

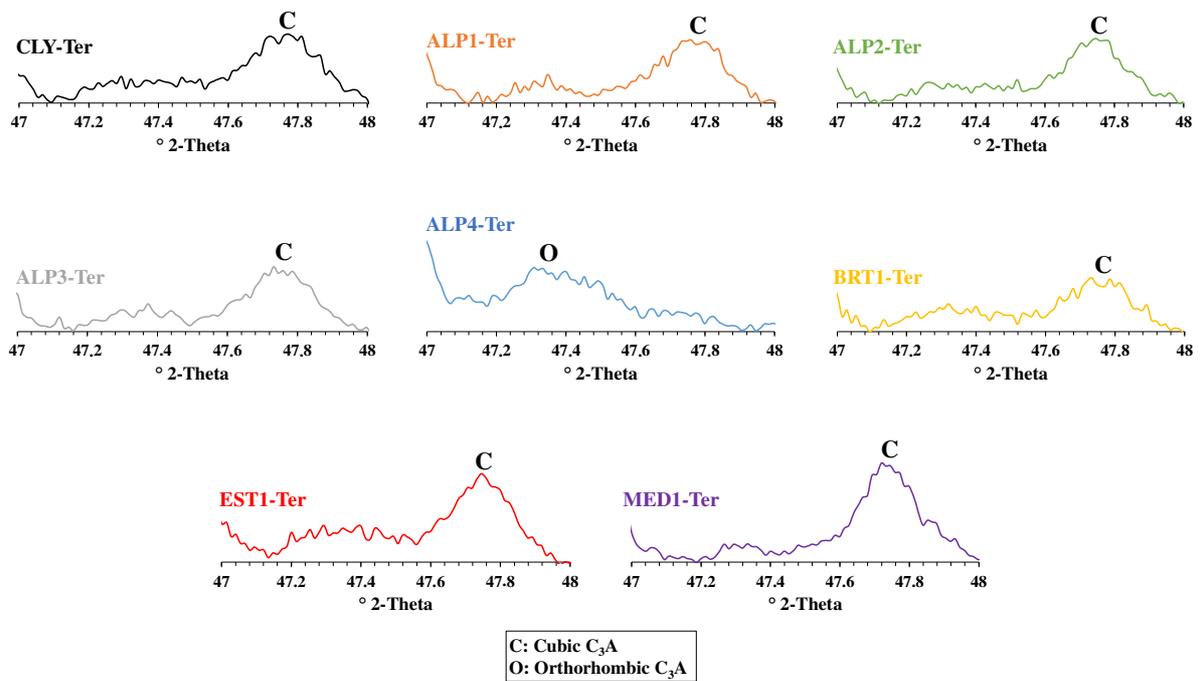


Figure 13 - Identification of C_3A polymorphism of ternary clinkers in the 47.0 to 48.0 $^{\circ}2\theta$ window

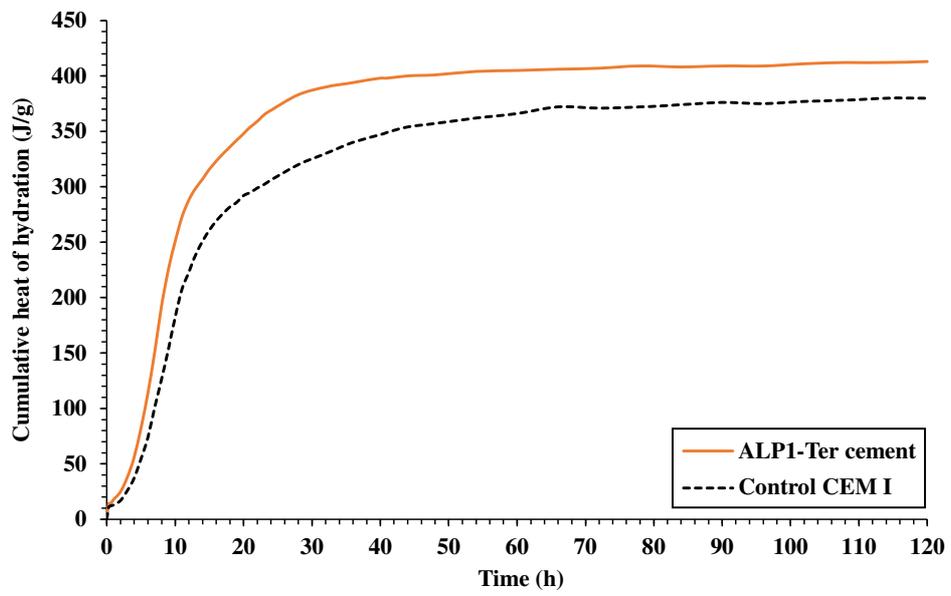


Figure 14 - Cumulative heat of hydration of ALP1-Ter cement and control CEM I.

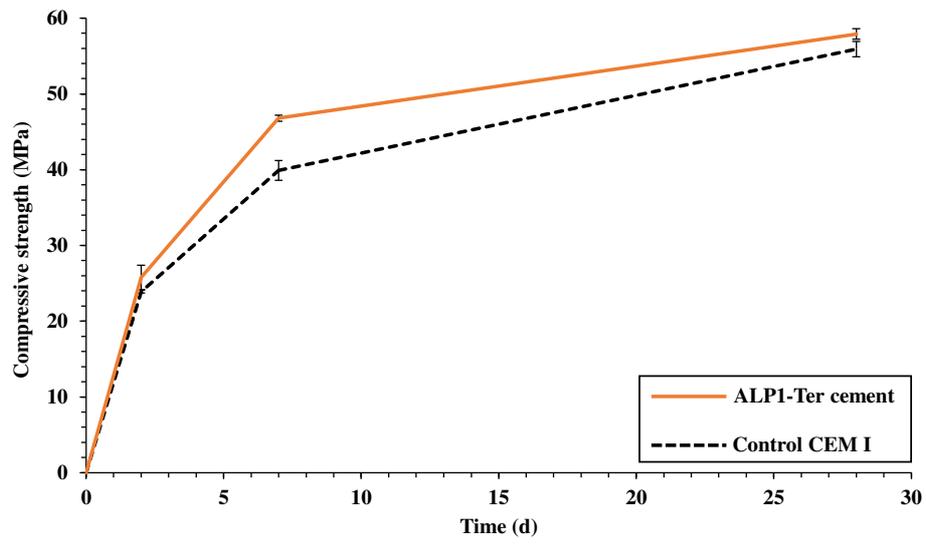
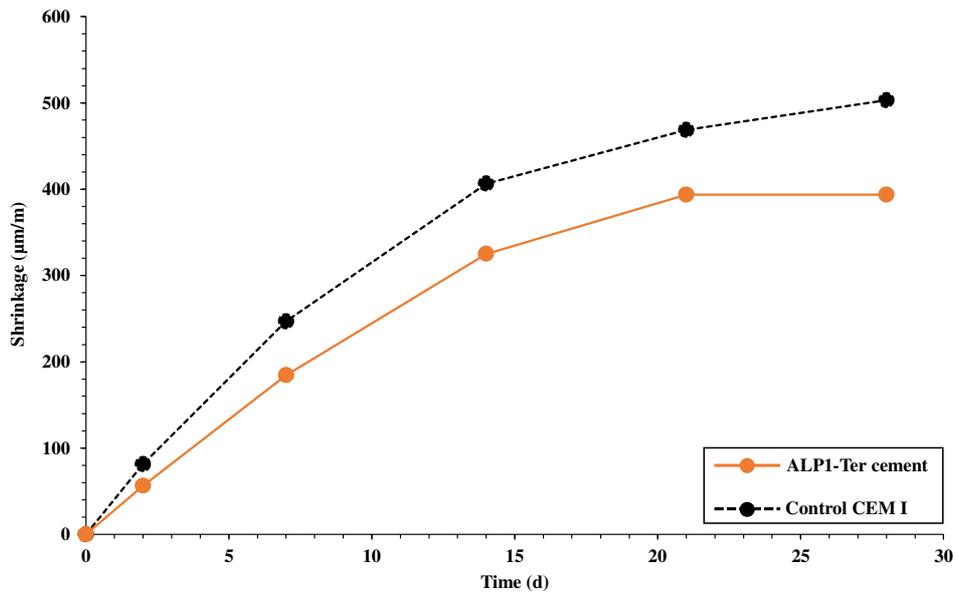
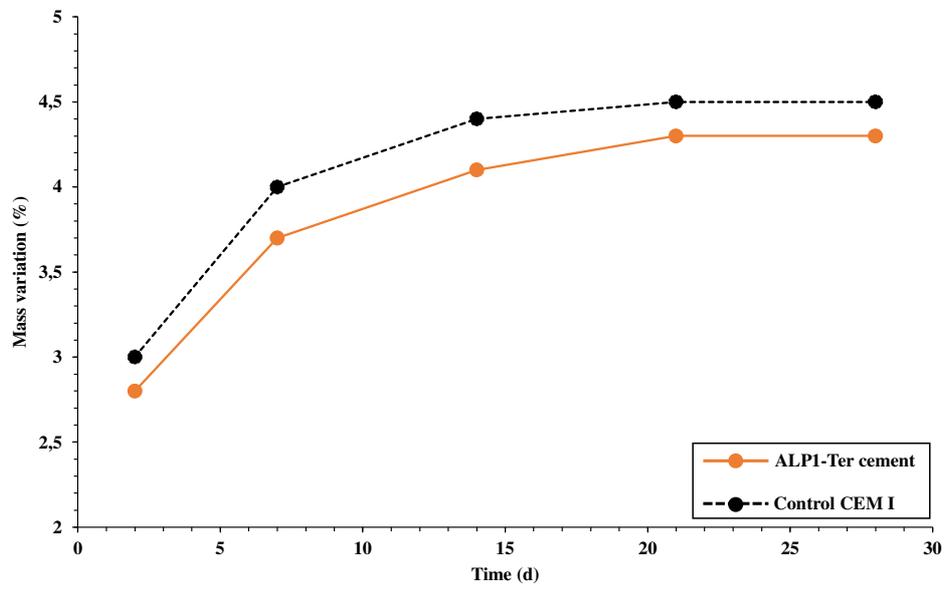


Figure 15 - Compressive strength of standard NF EN 196-1 mortars prepared with ALP1-Ter cement and with the control CEM I.



(a)



(b)

Figure 16 – Mortar shrinkage (a) and mortar mass variation (b) versus time for ALP1-Ter cement and control CEM I.

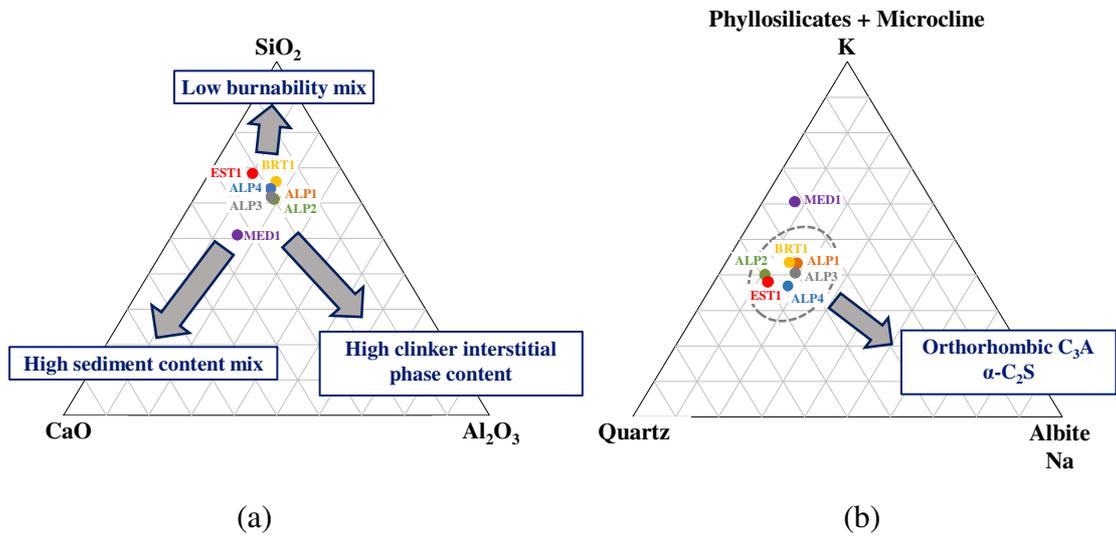


Figure 17 - Proposition of a chemical (a) and mineralogical (b) framework to predict the influence of sediments introduction in clinker manufacture.

	LIM1	CLY1	CLY2	ALP1	ALP3	ALP2	ALP4	BRT1	EST1	MED1
d_{v10} (μm)	1.1	1.0	1.0	3.3	2.4	3.0	3.0	2.5	3.2	2.2
d_{v50} (μm)	3.6	5.6	6.8	11.7	6.9	9.1	12.9	8.6	17.3	7.3
d_{v90} (μm)	14.5	21.0	21.9	35.8	20.0	27.1	53.8	35.0	113.4	23.0
Clay fraction (vol%) < 4 μm	30.1	23.6	20.8	16.5	30.9	20.9	18.1	22.5	16.4	26.6
Silt fraction (vol%) 4 μm - 63 μm	69.9	76.4	79.2	82.7	69.1	78.9	76.6	74.2	65.0	73.1
Sand fraction (vol%) 63 μm – 2 mm	0.0	0.0	0.0	0.8	0.0	0.2	5.3	3.3	18.6	0.3

Table 1 – 10th, 50th and 90th percentiles of sediments particle size distributions and volumic distribution of clay, silt and sand fractions.

	LIM1	CLY1	CLY2	ALP1	ALP2	ALP3	ALP4	BRT1	EST1	MED1
Density (g.cm⁻³)	2.74	2.66	2.75	2.79	2.81	2.70	2.79	2.55	2.59	2.67
BET SSA (m².g⁻¹)	4.1	47.1	28.3	5.9	7.0	11.7	5.2	17.9	7.8	16.8
Blaine SSA (cm².g⁻¹)	5852	6377	6154	5741	10502	12498	7547	7132	4931	12069

Table 2 - Density and specific surface areas of raw materials.

wt%	LIM1	CLY1	CLY2	ALP1	ALP2	ALP3	ALP4	BRT1	EST1	MED1
SiO₂	1.79	50.65	61.22	43.52	44.51	42.76	46.95	46.96	49.63	35.04
Al₂O₃	0.76	16.07	11.63	13.40	13.70	12.38	11.58	11.97	7.41	10.46
Fe₂O₃	1.28	5.95	4.82	5.63	5.81	5.22	5.09	5.79	3.07	3.90
CaO	52.71	7.79	6.43	14.18	14.64	14.09	13.78	12.13	15.64	23.14
MgO	0.48	1.64	1.14	2.87	1.83	1.84	3.03	1.72	2.10	1.56
TiO₂	0.02	0.90	0.92	0.60	0.70	0.68	0.56	0.64	0.39	0.48
MnO	0.04	0.03	0.02	0.10	0.16	0.15	0.11	0.05	0.06	0.08
P₂O₅	0.06	0.10	0.05	0.16	0.19	0.17	0.14	0.29	0.13	0.10
SrO	0.03	0.02	0.02	0.05	0.08	0.06	0.05	0.08	0.04	0.07
Na₂O	0.00	0.13	0.06	0.91	0.65	0.83	0.94	0.75	0.70	0.27
K₂O	0.13	3.15	2.24	2.69	2.18	2.50	2.32	2.08	1.58	1.81
SO₃	0.10	1.07	1.27	0.17	0.36	0.28	0.08	0.30	0.11	0.34
LOI	42.54	12.35	10.09	15.60	15.06	18.92	15.28	17.05	19.02	22.72
Total	99.94	99.85	99.91	99.88	99.87	99.88	99.91	99.81	99.88	99.97

Table 3 - Chemical composition of raw materials.

wt%	LIM1	CLY1	CLY2	ALP1	ALP2	ALP3	ALP4	BRT1	EST1	MED1
<i>Silico aluminous phases</i>										
Quartz	1	45	59	29	35	28	30	31	32	17
Clay minerals	-	28	22	29	23	21	22	27	21	31
Albite	-	-	1	12	7	12	12	11	8	4
Microcline	-	3	2	2	5	7	3	5	3	2
<i>Carbonated phases</i>										
Calcite	98	20	15	23	29	30	25	18	28	43
Dolomite	1	-	-	5	1	2	8	-	8	3
Aragonite	-	-	-	-	-	-	-	8	-	-
<i>Mineral phases that contain sulfur</i>										
Pyrite	-	3	4	-	-	-	-	-	-	-
Gypsum	-	1	1	-	-	-	-	-	-	-
<i>Detailed clay mineral compositions</i>										
Illite	-	41	45	62	54	55	68	24	63	45
Chlorite	-	-	-		46	45	32	36	37	25
Kaolinite	-	59	55	38	-	-	-	40	-	30

Table 4 - Mineral composition of raw materials.

Temperature range (°C)	Attributed phenomenon	Mass loss (wt%)									
		LIM1	CLY1	CLY2	ALP1	ALP2	ALP3	ALP4	BRT1	EST1	MED1
105-150	Remaining adsorbed water evaporation and organic matter oxidation	0.1	0.7	0.4	1.1	0.8	1.2	0.8	5.3	3.8	1.5
450-650	Phyllosilicates dehydroxylation – Dolomite decomposition	0.4	1.2	0.9	2.5	2.2	3.1	1.7	4.1	2.8	3.1
650-850	Calcite decomposition	12.9	2.5	2.0	11.4	10.2	17.1	10.5	6.9	10.5	17.1
850-1000	Ending of phyllosilicates degradation	0.0	0.1	0.0	0.2	0.1	0.1	0.2	0.1	0.2	0.1
105-1000	Total mass loss	13.4	4.5	3.3	15.2	13.3	13.9	13.2	16.4	17.3	21.8

Table 5 - TGA for the raw materials between 105 and 1000 °C and associated phenomena.

	LIM1	CLY1	CLY2	ALP1	ALP2	ALP3	ALP4	BRT1	EST1	MED1
Organic matter (wt%)	n.d.	n.d.	n.d.	3.2	3.2	3.9	3.0	8.7	5.6	4.8

Note: n.d. = not determined

Table 6 - Organic matter content of raw materials.

Meal reference	Limestone (wt%)	Silico-aluminous raw material (wt%)									SR	AR
		CLY1	CLY2	ALP1	ALP2	ALP3	ALP4	BRT1	EST1	MED1		
CLY1-Bin	76.70	23.30									1.97	1.83
CLY2-Bin	79.24		20.76								2.81	1.50
ALP1-Bin	72.70			27.30							1.97	1.71
ALP2-Bin	72.13				27.87						2.07	1.68
ALP3-Bin	73.12					26.88					1.97	1.70
ALP4-Bin	73.82						26.18				2.32	1.58
BRT1-Bin	74.20							25.80			2.21	1.49
EST1-Bin	73.73								26.27		3.37	1.43
MED1-Bin	65.19									34.81	2.11	1.89

Table 7 - Composition of binary clinker meals (LSF = 97).

Meal reference	Limestone (wt%)	Silico-aluminous raw material (wt%)									AR
		CLY1	CLY2	ALP1	ALP2	ALP3	ALP4	BRT1	EST1	MED1	
CLY-Ter	78.18	9.67	12.14								1.65
EST1-Ter	75.48	13.74							10.78		1.69
ALP1-Ter	76.50		12.06	11.44							1.59
ALP2-Ter	75.72		10.48		13.79						1.60
ALP3-Ter	76.70		12.14			11.16					1.59
ALP4-Ter	74.84		3.90				21.25				1.56
BRT1-Ter	76.04		7.60					16.36			1.50
MED1-Ter	71.80		9.77							18.43	1.71

Table 8 - Composition of ternary clinker meals (LSF = 97 and SR = 2.4).

Usual composition range in wt% (according to [46])				NF EN 197-1 requirements [45]	
SiO ₂	Al ₂ O ₃	Fe ₂ O ₃	CaO	CaO/SiO ₂	MgO
19-25	2-9	1-5	62-67	> 2.0	< 5.0

Table 9 - Chemical requirements for Portland clinker.

wt%	Control CEM I
SiO₂	19.94
Al₂O₃	5.33
Fe₂O₃	4.21
CaO	65.74
MgO	0.69
TiO₂	0.31
MnO	0.04
P₂O₅	0.07
SrO	0.08
Na₂O	0.09
K₂O	0.41
SO₃	2.69
LOI	0.26
Total	99.86
<i>Mineralogical composition according to Bogue calculations</i>	
C₃S	70.9
C₂S	5.2
C₃A	7.2
C₄AF	13.1

Table 10 - Chemical and mineralogical composition of the control CEM I used as reference in the standard cement tests.

Clinker	CLY1-Bin	CLY2-Bin	ALP1-Bin	ALP2-Bin	ALP3-Bin	ALP4-Bin	BRT1-Bin	EST1-Bin	MED1-Bin
SiO ₂	20.02	21.45	20.61	20.72	20.98	20.93	20.21	22.61	20.82
Al ₂ O ₃	6.58	4.85	6.53	6.40	6.58	5.69	5.67	4.06	6,56
Fe ₂ O ₃	3.64	3.02	3.79	3.79	3.69	3.77	3.93	2.83	3.51
CaO	65.20	67.86	65.23	65.89	65.56	66.50	66.75	66.21	66.32
MgO	1.15	0.93	1.75	1.30	1.45	1.84	1.28	1.41	1.29
TiO ₂	0.32	0.35	0.34	0.31	0.35	0.19	0.31	0.15	0.28
MnO	0.03	0.04	0.10	0.14	0.11	0.10	0.06	0.10	0.10
P ₂ O ₅	0.11	0.10	0.13	0.15	0.13	0.11	0.20	0.14	0.11
SrO	0.05	0.05	0.06	0.07	0.07	0.06	0.07	0.06	0.07
Na ₂ O	0.14	0.08	0.41	0.28	0.37	0.35	0.35	0.29	0.16
K ₂ O	1.17	0.44	0.34	0.26	0.50	0.23	0.27	0.21	0.33
SO ₃	1.39	0.56	0.09	0.12	0.13	0.03	0.23	0.06	0.08
LOI	0.14	0.20	0.52	0.50	0.02	0.12	0.58	1.84	0.33
Total	99.94	99.93	99.90	99.93	99.94	99.92	99.91	99.97	99.96
<i>NF EN 197-1 chemical requirements on clinker</i>									
%MgO	< 5 wt%								
%CaO / %SiO ₂	3.3	3.2	3.2	3.2	3.1	3.2	3.3	2.9	3.2
<i>Mineralogical compositions according to Bogue calculations</i>									
C ₃ S	62.1	68.77	56.8	60.6	55.8	59.8	66.6	51.6	60.6
C ₂ S	10.6	9.70	16.3	13.7	18.0	14.9	7.7	25.9	14.0
C ₃ A	11.3	7.74	10.9	10.6	11.2	8.7	8.4	6.0	11.5
C ₄ AF	11.1	9.19	11.5	11.5	11.2	11.5	12.0	8.6	10.7

Table 11 - Chemical and mineralogical compositions of binary clinkers.

Clinker	CLY-Ter	ALP1-Ter	ALP2-Ter	ALP3-Ter	ALP4-Ter	BRT1-Ter	EST1-Ter	MED1-Ter
SiO₂	20.40	20.61	20.74	21.78	20.95	21.12	20.94	21.14
Al₂O₃	5.40	5.86	5.62	5.64	5.54	5.85	6.01	5.73
Fe₂O₃	3.14	3.29	3.23	3.26	3.41	3.54	3.18	3.16
CaO	68.29	67.20	67.68	66.25	67.11	66.61	66.59	67.16
MgO	1.02	1.24	1.06	1.21	1.68	1.19	1.23	1.14
TiO₂	0.30	0.32	0.33	0.31	0.21	0.33	0.28	0.28
MnO	0.02	0.07	0.08	0.09	0.09	0.07	0.08	0.09
P₂O₅	0.10	0.08	0.11	0.11	0.12	0.13	0.09	0.09
SrO	0.05	0.05	0.05	0.06	0.06	0.06	0.05	0.06
Na₂O	0.11	0.17	0.12	0.18	0.31	0.17	0.19	0.13
K₂O	0.42	0.43	0.35	0.38	0.20	0.40	0.55	0.36
SO₃	0.55	0.47	0.30	0.33	0.06	0.41	0.63	0.36
LOI	0.18	0.16	0.30	0.32	0.23	0.10	0.14	0.26
Total	99.98	99.95	99.97	99.92	99.97	99.98	99.96	99.96
Mineralogical compositions according to Bogue calculations								
C₃S	74.27	68.3	70.2	59.4	63.2	59.8	60.0	65.6
C₂S	2.52	7.6	6.5	17.6	12.4	15.4	14.8	11.1
C₃A	9.00	10.0	9.4	9.4	8.9	9.5	10.5	9.8
C₄AF	9.55	10.0	9.8	9.9	10.4	10.8	9.7	9.6

Table 12 - Chemical and mineralogical compositions of ternary clinkers.

	ALP1-Ter cement	Control CEM I
w/c at standard consistency	< 0.245	0.260
Initial setting time (min)	95	125
Final setting time (min)	180	185

Table 13 - Setting times of ALP1-Ter cement and the control CEM I.

Curing time (d)	ALP1-Ter cement		Control CEM I	
	Flexural strength	Compressive strength	Flexural strength	Compressive strength
2	4.9	25.8	5.0	23.9
7	7.4	46.8	7.6	39.9
28	8.3	57.9	8.6	57.9

Table 14 - Flexural and compressive strength values for standard NF EN 196-1 mortar prepared with ALP1-Ter cement and control CEM I.