

**PORTLAND LIMESTONE CEMENT CONFORMING TO
 ASTM C595/C595M-21 TYPE IL (7.2), SCG Bangkok Thailand**

Physical properties	Unit	Specification	Test Results	Test Method
Air content of mortar	%	12 Max	8.3	ASTM C 185
Autoclave expansion	%	0.80 Max	0.03	ASTM C151/C151M
Blaine	cm ² /g	A	4100	ASTM C 204
Mass density	g/cm ³	A	3.14	ASTM C 188
Heat of Hydration	J/g(cal/g)	**	301	ASTM C1702
Mortar Bar Expansion *	%	< 0.020	0.004	ASTM C1038
Sulfate Resistance	%	0.10 Max ***	0.07	ASTM C1012
Compressive Strength				
3 days	PSI/MPa	1890 (13.0)	5190 (35.8)	ASTM C 109/C109M
7 days		2900 (20.0)	5920 (40.8)	
28 days		3620 (25.0)	7230 (49.8)	
Time of setting (Vicat)				
Initial set	Minutes	45 Min	120	ASTM C 191
Final set		420 Max	190	
Retained content on				
.+Sieve 45µm	%	10.0 Max	2.1	ASTM C 430
Chemical properties				
MgO	%	A	1.0	ASTM C114
SO ₃	%	3.0 Max*	2.9	
Loss on ignition (LOI)	%	10 Max	4.8	
Insoluble Residue	%	A	Mill Cert-0.20	
Limestone in cement	%	5.0-15.0	7.2	
CaCO ₂ in Limestone	%	70 or >	93.79	
SiO ₂	%	A	20.0	
Al ₂ O ₃	%	A	4.5	
Fe ₂ O ₃	%	A	2.9	
CaO	%	A	67.4	
K ₂ O	%	A	0.56	
Na ₂ O	%	A	0.15	
R ₂ O (Total alkalis)	%	A	0.52	
Chloride content	%	A	0.05	

Remark:

This cement meets ASTM C595 and AASHTO M240 Specification for Type IL Portland Limestone Cement.

A = Not applicable.

** = Default table maximum may be exceeded if C1038/C1038M limit is met.*

*** = Meets 3d Moderate Heat – MH*

****=Meets 180d Moderate Sulfate – MS*

February 22, 2026



Daniel K. Paaaina III

Chemist