



Designation: C1693 – 11 (Reapproved 2025)

Standard Specification for Autoclaved Aerated Concrete (AAC)¹

This standard is issued under the fixed designation C1693; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This specification covers autoclaved aerated concrete (AAC), a cementitious product based on calcium silicate hydrates in which low density is attained by the inclusion of an agent resulting in macroscopic voids, and in which curing is carried out using high-pressure steam.

1.2 The raw materials used in the production of autoclaved aerated concrete are portland cement or blended cements, quartz sand, water, lime, gypsum or anhydrite, and an agent resulting in macroscopic voids. The quartz sand used as a raw material may be replaced by a siliceous fine aggregate other than sand, and usually is ground to a fine powder before use. Fly ash may be used as a sand replacement. The batched raw materials are mixed thoroughly together to form a slurry. The slurry is cast into steel molds. Due to the chemical reactions that take place within the slurry, the volume expands. After setting, and before hardening, the mass is machine cut into units of various sizes. The units then are steam-cured under pressure in autoclaves where the material is transformed into a hard calcium silicate.

1.3 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.4 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use. See Section 6, 7, and 8.*

1.5 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

¹ This specification is under the jurisdiction of ASTM Committee C27 on Precast Concrete Products and is the direct responsibility of Subcommittee C27.60 on Precast Autoclaved Aerated Concrete.

Current edition approved Nov. 15, 2025. Published January 2026. Originally approved in 2009. Last previous edition approved in 2017 as C1693 – 11(2017). DOI: 10.1520/C1693-11R25.

2. Referenced Documents

2.1 ASTM Standards:²

- C22/C22M Specification for Gypsum
- C33/C33M Specification for Concrete Aggregates
- C39/C39M Test Method for Compressive Strength of Cylindrical Concrete Specimens
- C144 Specification for Aggregate for Masonry Mortar
- C150/C150M Specification for Portland Cement
- C332 Specification for Lightweight Aggregates for Insulating Concrete
- C595/C595M Specification for Blended Hydraulic Cements
- C618 Specification for Coal Ash and Raw or Calcined Natural Pozzolan for Use in Concrete
- C1692 Practice for Construction and Testing of Autoclaved Aerated Concrete (AAC) Masonry
- E4 Practices for Force Calibration and Verification of Testing Machines
- E575 Practice for Reporting Data from Structural Tests of Building Constructions, Elements, Connections, and Assemblies

3. Classification

3.1 AAC units manufactured in accordance with this specification are classified according to their strength class.

4. Materials and Manufacture

4.1 *Raw Materials*—Materials shall conform to the following applicable specifications:

- 4.1.1 *Portland Cement*, Specification C150/C150M.
- 4.1.2 *Blended Cements*, Specification C595/C595M.
- 4.1.3 *Pozzolan*, Specification C618.
- 4.1.4 *Gypsum*, Specification C22/C22M.
- 4.1.5 *Aggregates*, Specifications C33/C33M, C144, or C332.

5. Physical Requirements

5.1 *Compressive Strength*—The compressive strength shall be determined according to Section 6 and shall conform to the requirements of Table 1.

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at www.astm.org/contact. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

TABLE 1 Physical Requirements^A

Strength Class	Compressive Strength, psi (MPa) min	Nominal Dry Bulk Density, lb/ft ³ (kg/m ³)	Density Limits, lb/ft ³ (kg/m ³)	
			Lower Limit >	Upper Limit ≤
AAC-2	290 (2.0)	25 (400)	22 (350)	28 (450)
AAC-3	435 (3.0)	31 (500)	28 (450)	34 (550)
		37 (600)	34 (550)	41 (650)
AAC-4	580 (4.0)	31 (500)	28 (450)	34 (550)
		37 (600)	34 (550)	41 (650)
AAC-5	725 (5.0)	37 (600)	34 (550)	41 (650)
		44 (700)	41 (650)	47 (750)
AAC-6	870 (6.0)	37 (600)	35 (550)	41 (650)
		44 (700)	41 (650)	47 (750)

^A The average drying shrinkage requirement of all strength classes is ≤0.02 %.

5.2 Dry Bulk Density—The dry bulk density shall be determined according to Section 7 and shall conform to the requirements of Table 1.

5.3 Drying Shrinkage—The drying shrinkage shall be determined in accordance with Section 8, and shall conform to the requirements of Table 1.

5.4 Modulus of Elasticity—If required, the modulus of elasticity shall be determined in accordance with Section 9.

6. Determination of Compressive Strength

6.1 Apparatus:

6.1.1 Testing Machine—The testing machine shall conform to the requirements prescribed in Practice E4. The machine shall be equipped with two steel bearing blocks one of which is a spherically seated block that will transmit load to the upper surface of the specimen, and the other a plane rigid block on which the specimen will rest.

6.2 Test Specimens:

6.2.1 Three cube specimens of 4 in. (100 mm) edge length shall be tested in an air dried condition (5 to 15 % by mass moisture content). If the samples have to be dried before testing to reach that moisture content, they shall be stored at a temperature not exceeding 158°F (70°C).

6.2.2 A minimum of three specimens shall be tested. Whenever possible, one specimen shall be obtained from the upper third of the product, one from the middle, and one from the lower third, determined in the direction of the rising of the mass during manufacture. Otherwise, the position of the cubes and information regarding the rise shall be reported. The direction of the rise shall be noted on all specimens. This is shown in Fig. 1.

6.2.3 Loadbearing surfaces of the specimen shall be plane within 0.0035 in. (0.09 mm) per 4 in. (100 mm). This can be achieved by grinding, milling, or capping. When capping, a gypsum plaster compound shall be used.

6.3 Procedure:

6.3.1 The specimen shall be placed in the testing machine and the load applied perpendicular to the direction of rise during manufacture.

6.3.2 Speed of Testing—Apply the load up to one half of the expected maximum load at a convenient rate, after which adjust the controls of the machine as required to give a uniform

rate of travel of the moving head such that the remaining load is applied in not less than one nor more than two minutes.

6.3.3 Calculate the compressive strength of each specimen as follows:

$$\text{Compressive strength, } f = \frac{P}{A} \quad (1)$$

where:

f = compressive strength of the specimen, psi (or Pa),
 P = maximum load, lbf (or N), indicated by the testing machine, and
 A = gross cross-sectional area of the specimen, in.² (mm²).

6.4 The compressive strength shall be reported to the nearest 10 psi (69 kPa) for each specimen and as the average for three specimens.

7. Determination of Moisture Content and Bulk Density

7.1 Apparatus:

7.1.1 Balance—shall be sensitive within 0.5 % of the mass of the specimen.

7.2 Test Specimens—Three test specimens, as described in 8.2, shall be used for calculating the bulk density.

7.3 Procedure:

7.3.1 Determine the mass of the specimens, and then dry them in a ventilated oven at 212 to 230°F (100 to 110°C) for not less than 24 h, and until two successive determinations of mass at intervals of 2 h show an increment of loss not greater than 0.2 % of the last previously determined mass of the specimen.

7.3.2 Calculate the moisture content of each specimen as follows:

$$\text{Moisture Content } \%, MC = (A - B)/B \times 100 \quad (2)$$

where:

MC = moisture content, %,
 A = sampled mass of specimen, lb (kg), and
 B to = dry mass of specimen, lb (kg).

7.3.2.1 Report the average moisture content of all of the specimens as the moisture content of the lot.

7.3.3 Determine the dimensions of the test specimens with a caliper gauge. Measure the width and height at the ends and in the middle of the length of the specimen. Measure the length