

**Monolithic (unshaped) refractory products - Part 4:
Determination of consistency of castables (ISO 1927-
4:2012)**

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NATIONAL FOREWORD

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| Standard on jõustunud sellekohase teate avaldamisega EVS Teatajas. | This standard has been endorsed with a notification published in the official bulletin of the Estonian Centre for Standardisation. |
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ICS 81.080

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English Version

**Monolithic (unshaped) refractory products - Part 4:
Determination of consistency of castables (ISO 1927-4:2012)**

Produits réfractaires monolithiques (non façonnés) - Partie
4: Détermination de la consistance des bétons (ISO 1927-
4:2012)

Ungeformte (monolithische) feuerfeste Erzeugnisse - Teil 4:
Bestimmung der Konsistenz von Feuerbetonen (ISO 1927-
4:2012)

This European Standard was approved by CEN on 30 November 2012.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
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Foreword

This document (EN ISO 1927-4:2012) has been prepared by Technical Committee ISO/TC 33 "Refractories" in collaboration with Technical Committee CEN/TC 187 "Refractory products and materials" the secretariat of which is held by BSI.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by June 2013, and conflicting national standards shall be withdrawn at the latest by June 2013.

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Endorsement notice

The text of ISO 1927-4:2012 has been approved by CEN as a EN ISO 1927-4:2012 without any modification.

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Monolithic (unshaped) refractory products —

Part 4: Determination of consistency of castables

1 Scope

This part of ISO 1927 describes methods for the determination and measurement of the consistency of dense and insulating castables as defined in ISO 1927-1. It is applicable to all types of dense regular castables, dense deflocculated castables and insulating castables to determine the liquid addition necessary for preparing test pieces according to ISO 1927-5.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 1927-1, *Monolithic (unshaped) refractory products — Part 1: Introduction and classification*

ISO 1927-5:2012, *Monolithic (unshaped) refractory products — Part 5: Preparation and treatment of test pieces*

3 Principle

The amount of water used in a castable mix for preparing test pieces has a significant influence on the test results. Excess water can reduce strength, increase shrinkage, and can cause sedimentation. Insufficient moisture can give voids due to poor compaction, with subsequent lower density and strength.

This part of ISO 1927 describes three different methods for determining the consistency according to the type of material:

- a) determination of the consistency of insulating castables containing significant amounts of light-weight aggregates such as vermiculite or perlite which would be destroyed by intensive mixing; such products are normally installed by pouring, rodding, tamping;
- b) determination of the consistency of all types of vibratable castables;
- c) determination of the consistency of self-flowing castables.

To obtain reproducible results, the following factors are closely controlled:

- wet mixing time;
- batch size, which is chosen for the required number of determinations (e.g. if determination of working time is required), and is also related to mixer pan size or bowl;
- mixer pan size adapted to batch weight to have at least 50 % and a maximum of 75 % volume loading by the dry batch;
- temperature (of the water, castable and mix and ambient temperature), of 18 °C to 22 °C for consistency and working time determination;
- quantity of water addition used in the test which is rapidly affected when the dry volume loading of the mixer pan drops below 50 % of the total dry capacity, due to the increased metal surface to be wetted;