

TABLE OF CONTENTS

Certificate	i
Declaration by the Candidate	ii
Copyright Transfer Certificate	iii
Dedication	iv
Acknowledgement	v-ix
Table of Contents	xi-xvi
List of Figures	xvii-xxiii
List of Tables	xxv-xxix
Abbreviations	xxxi-xxxiv
Abstract	xxxv-xxxix

1 INTRODUCTION 1-23

1.1 Preface	1
1.2 History of WMA	4
1.3 Classification of WMA Technologies.....	6
1.3.1 Foaming Technology	6
1.3.2 Organic Additives	7
1.3.3 Chemical Agents.....	8
1.4 Benefits and Drawbacks of WMA	9
1.5 Problem Statement and Gaps	11
1.6 Key Research Queries	13
1.7 Aim.....	14
1.8 Objectives and Tasks.....	14
1.9 Scope of the Present Study.....	16
1.10 Organization of the Thesis	20

2 LITERATURE REVIEW 25-115

2.1 Preface	25
2.2 Introduction to WMA.....	32
2.3 Concept of Mix Design	39

2.3.1	Material Selection	40
2.3.2	Aggregate Gradation	41
2.3.3	Additional Additives	41
2.3.4	Curing and Conditioning Process	42
2.3.5	Mixing and Compaction Temperature	42
	2.3.5.1 Review of Methodologies used for the Estimation of Production Temperatures.....	43
2.4	Discussion on Mix Parameters	50
2.4.1	Workability	50
2.4.2	Optimum Binder Content and Volumetric Analysis	57
2.5	Morphological, Chemical, and Physical Characteristics.....	59
2.5.1	Morphology of WMA Binders.....	59
2.5.2	Chemical Characteristics of WMA Binders.....	62
2.5.3	Physical Properties of WMA Binders	65
2.6	Performance of WMA Binders and Mixtures	67
2.6.1	Resistance to Rutting Potential	67
2.6.2	Fatigue Resistance.....	76
2.6.3	Resistance to Moisture Damage.....	85
2.7	Field Survey	92
2.7.1	Summary of Field Survey	100
2.8	Interaction of WMA with Different Materials	101
2.9	Environmental and Economic Survey	105
2.10	Life Cycle Assessment.....	105
2.10.1	Greenhouse Gas Emissions	107
2.11	Energy Consumption and Economic Benefits	110
2.12	Summary	113

3 MATERIALS AND METHODOLOGY117-186

3.1	Preface	117
3.2	Materials Used.....	118
3.2.1	Asphalt Binders.....	118
3.2.2	Aggregates	118
3.2.3	Warm Mix Additives	120
3.2.4	Preparation of WMA Binders	123
3.2.5	Ageing Condition.....	125
	3.2.5.1 Ageing of Asphalt Binders.....	126

3.2.5.2	Ageing of Asphalt Mixtures.....	128
3.3	Experimental Framework	131
3.4	Methodology	134
3.4.1	Basic Characterization of Asphalt Binder.....	134
3.4.1.1	Scanning Electron Microscopy	134
3.4.1.1.1	Discussion on SEM Observations.....	136
3.4.1.2	Fourier Transform Infrared Spectroscopy (FTIR)	143
3.4.1.2.1	Discussion on FTIR Spectral Analysis	146
3.4.1.3	Penetration Value.....	151
3.4.1.4	Softening Point.....	151
3.4.1.5	Viscosity Value.....	151
3.4.1.6	High-Temperature Performance Grade (PG)	152
3.4.1.7	Discussion on the Basic Properties of Asphalt Binders	154
3.4.1.7.1	Effect of WMA Technologies on the Penetration Value	154
3.4.1.7.2	Effect of WMA Technologies on the Softening Point.....	155
3.4.1.7.3	Effect of WMA Technologies on the Viscosity Value	157
3.4.1.7.4	Effect of WMA technologies on the high temperature PG	158
3.4.1.8	Correlations between the Basic Properties of Asphalt Binders.....	160
3.4.2	Determination of Production Temperatures.....	163
3.4.3	Phase I – Characterization of Asphalt Binders	169
3.4.3.1	Frequency Sweep	169
3.4.3.2	Multiple Stress Creep and Recovery (MSCR)	170
3.4.3.3	Linear Amplitude Sweep Test (LAST).....	171
3.4.3.4	Bond Strength and Bond Strength Ratio.....	172
3.4.4	Phase II – Characterization of Asphalt Mixtures	175
3.4.4.1	Mix Design.....	175
3.4.4.2	Cyclic Compression Test (CCT).....	178
3.4.4.3	Indirect Tensile Cracking Test.....	180
3.4.4.4	Moisture Resistance	181
3.4.4.4.1	Boiling Water Test.....	181
3.4.4.4.2	Retained Marshall Stability (RMS)	182
3.4.4.4.3	Modified Lottman Test	184
3.5	Summary	185

4 MIXING AND COMPACTION TEMPERATURES OF ASPHALT MIXTURES..... 187-234

4.1	Preface	187
4.2	Experimental Plan	190
4.2.1	Different Approaches for Determining Mixing and Compaction Temperatures .	191
4.2.2	Background, Need, and Development of Workability Prototype	191
4.2.2.1	Estimation of Workability.....	195
4.2.2.2	Challenges and Refinement in the Workability Setup	198
4.2.2.3	Feasibility and Validation of Fabricated Workability Setup.....	199
4.2.2.4	Assessment of Production Temperatures	199
4.2.3	Mix Design.....	201
4.2.3.1	Validation of Production Temperatures	201
4.2.3.1.1	Coating Ability of Asphalt Mixtures	202
4.2.3.1.2	Compactability Test.....	206
4.3	Results and Discussion.....	207
4.3.1	RV Approach	207
4.3.2	DSR Approach	211
4.3.3	Discussion on Workability Characteristics	214
4.3.4	Production Temperatures from Workability Approach	221
4.3.5	Discussion on Coating Ability	226
4.3.6	Discussion on Compactability	228
4.3.7	Selection of Optimum WMA Additive Dosage	230
4.4	Summary	233

5 CHARACTERIZATION OF ASPHALT BINDERS 235-291

5.1	Preface	235
5.2	Ageing Behavior of WMA Binders	237
5.3	Discussion on the Master Curve.....	244
5.4	Rutting Performance	249
5.4.1	Application of Arrhenius Equation	258
5.5	Fatigue Performance	265
5.5.1	Stress-Strain Response of Asphalt Binders.....	267
5.5.2	Fatigue Life of Asphalt Binders.....	274
5.6	Moisture Resistance	280
5.7	Summary	289

6 CHARACTERIZATION OF ASPHALT MIXTURES 293-331

6.1	Preface	293
6.2	Rutting Performance	295
6.3	Fatigue Performance	300
6.3.1	Discussion on FE and FI of WMA mixtures.....	304
6.3.2	Discrepancies between FE and FI.....	306
6.4	Moisture Resistance	308
6.4.1	Discussion on Boiling Water Test	309
6.4.2	Discussion on Retained Marshall Stability	311
6.4.3	Indirect Tensile Strength and Tensile Strength Ratio	312
6.5	Correlation Analysis.....	315
6.5.1	Correlating Rutting Performance	316
6.5.1.1	Limiting Values of Rutting Test Parameters.....	318
6.5.2	Correlating Fatigue Performance	321
6.5.2.1	Limiting Values of Fatigue Test Parameters.....	323
6.5.3	Correlating Moisture Performance.....	325
6.5.3.1	Limiting Value of BSR	328
6.6	Summary	329

7 ECONOMIC AND ENVIRONMENTAL IMPACT OF WMA TECHNOLOGIES..... 333-371

7.1	Preface	333
7.2	Experimental Approach.....	336
7.2.1	Environmental Life Cycle Assessment (ELCA)	336
7.2.2	Calculation of Energy Consumption and GHG Emissions	337
7.3	Results and Discussion.....	341
7.3.1	Energy Consumption and Cost Savings.....	341
7.3.2	Maximum Bearable Cost of WMA Additives	354
7.3.3	Greenhouse Gas Emissions.....	359
7.4	Summary	369

8 RANKING OF WARM MIX ASPHALT ADDITIVES 373-392

8.1	Preface	373
8.2	Ranking Approach.....	374
8.3	Results and Discussion.....	378
8.4	Summary	391

9 CONCLUSIONS AND RECOMMENDATIONS393-402

9.1	Preface	393
9.2	Conclusions	393
9.2.1	Material Characterization.....	394
9.2.2	Production Temperatures of Asphalt Mixtures	394
9.2.3	Performance of Asphalt Binders	395
9.2.4	Performance of Asphalt Mixtures	396
9.2.5	Economic and Environmental Burdens.....	398
9.2.6	Ranking of WMA Additives	399
9.3	Contribution of the Study	400
9.4	Limitations of the Study.....	401
9.5	Applications of the Research Output	401
9.6	Future Recommendations.....	402

LIST OF PUBLICATIONS403-405**REFERENCES.....407-464**