Utilization of Brine Sludge in Manufacturing of Fly Ash Bricks

[1]Suryansh Singh, [2]Maaz Allah Khan, [3]Vipin Kumar Yadav, [4]Akash Singh Yadav, [5]Upendra Sharan
[1]Student, [2]Assistant Professor, [3]Student, [4]Student, [5]Student
Dr. Shakuntala Misra National Rehabilitation University, Lucknow Lucknow, Uttar Pradesh, India

Abstract - **The Indian car industry has risen as a 'dawn segment' in the Indian economy with a yearly creation of 23.37 million vehicles in 2014-15. Indeed, even it is a worth including industry, it has a few ecological effects causing area and water contamination with lethality. Profluent slop squander the executives turns into a major issue these days. Aside from built landfills, rest of the strategies for dumping, drives ground water tainting and there by other financial effects. In the present examination, an endeavor has been made to use the car ETP slime (dry) in creation of development materials, which is delivered from Goodbye MOTARS, PUNE. Salt water muck is a mechanical waste created in chloral antacid industry. The created saline solution ooze squander is dumped into landfills and contains barium Sulfate, calcium carbonate, magnesium hydroxide, Sodium chloride, earth, and lethal components like chromium, zinc, copper, and Vanadium, in this manner representing an ecological danger. Subsequently, there is a pressing need to change over dangerous saline solution slop squander into its non-lethal structure. The present innovation along these lines plans to accomplish complete usage of this salt water ooze for making functionalized saline solution muck material helpful for an expansive application range.**

keywords - **Modern Waste, Reusing, Squander The board**

INTRODUCTION

The advancement of nano and non-dangerous materials have pulled in extraordinary consideration of material researchers because of their interesting attributes, empowering amalgamation of multifunctional materials and tending to the difficulties of Taking care of issue of usage of poisonous and non-harmful modern squanders for making esteem included materials helpful for expansive application range. Salt water ooze is a mechanical waste created in the chloralkali business. The chloralkali procedure is the principle procedure for assembling of acidic pop and chlorine creation everywhere throughout the world. In India an aggregate of very nearly 36 chloralkali plants are in operational structure. Saline solution mud age is around 30 kg for each ton scathing soft drink in India, which is more than twofold the universal normal. To accomplish all out use of this brackish water slime, no procedures have been created to date. In the chloralkali business, the creation of NaOH and chlorine is completed by the electrolysis of refined saline solution arrangement, for example 30% sodium chloride arrangement, and the procedure of cleaning of sullied brackish water arrangement includes evacuation of Sulfate and chloride salts of magnesium and potassium. Evacuation of Sulfate species is done by including barium carbonate, which is costly and prompts the age of lethal saline solution slop squander containing barium sulfate. Further evacuation of chloride species is done by adding Sodium carbonate prompting the age of brackish water slime containing calcium carbonate and magnesium hydroxide. The created salt water slop squander is dumped into landfills, which contains barium Sulfate, calcium carbonate, magnesium hydroxide, Sodium chloride, dirt and poisonous components like chromium, Zinc, copper and Vanadium, along these lines presenting natural risk. In this manner, there is a dire need to give a procedure which changes over lethal salt water ooze squander into non-poisonous structure. Brackish water muck has been used for making low worth things like blocks and paver squares utilizing regular concrete and fly debris. Be that as it may, the downsides of the refered to process are that the saline solution ooze has been utilized related to concrete and fly debris for making just paver squares and blocks with just 35%, for example insignificant usage, of saline solution ooze. In this manner, the issue of use of 65% saline solution slime despite everything remains. Further, the harmful components present in the brackish water slime have just been balanced out in concrete framework without shaping any concoction linkages with the lethal components. One more object of the present creation is to give a procedure which uses light capacity of microwave in order to empower concurrent and Synergistic compound responses among the different particles of the reactants, specifically brackish water muck, fly debris, Sodium hydroxide, ethylene glycol, cetyl trimethyl ammonium bromide, and water prompting multifunctional capacity of the created materials. Goodbye Engines Restricted is India's biggest vehicle organization, with merged incomes of 42.04 billion out of 2014-2015.Tata Engine's quality cuts over the length and broadness of India. More than 8 billion Goodbye vehicles employ on Indian streets. In vehicle industry by utilizing different procedures and activities and expends enormous nature of water and creates amazingly contaminating waste effluents. The measure of waste water created from ETP is 2.7 MGD. While treating the wastewater discharged from car ventures enormous volume of slop is created. Because of absence of removal techniques, this muck is causing parcel of ecological issues. Indian development enterprises are running low on development materials.

BRINE SLUDGE

1.Present Situation

There are around 36,000 perilous waste creating ventures in India which produce 6.2 million tons out of which land usable unsafe waste is about 2.7 million tons (44%), Incinerable Dangerous waste is about 0.4 million tons (7 %) and recyclable risky waste is about 3.1 million tons (49 %). Aimless and informal removal of squanders in the past has brought about a few locales in the nation to turn out to be earth debased. There are 141 dangerous waste dumpsites that have been essentially distinguished in 14 States/UTs out of which 88 basically contaminated areas are as of now recognized. Gujarat (about 29%), Maharashtra (about 25%) and Andhra Pradesh (about 9%) are the main three HW creating States. From there on, Chhattisgarh (about 5%), Rajasthan, West Bengal and Tamil Nadu (around 4 %) are seen as significant generators of HW. These seven States together, are producing around 80 % of nation's complete HW. Around 64 Basic Perilous Waste Transportation, Stockpiling and Removal Destinations (TSDFs) have been recognized in different States/UTs out of which 35 locales have been informed. 25 TSDFs are operational and 9 TSDFs are under development. According to the National Stock of Unsafe Waste Creating Businesses, all out waste taking care of limits of TSDFs is about 1.5 MTA and there is a shortage of about 1.2 MTA for land usable squanders and about 0.9 MTA for Incinerable squanders.

2.Sludge Generation

Organically degradable and non-degradable natural and inorganic toxins existing in the wastewater in dissolvable, colloidal or suspended structure are expelled by number of techniques in squander water treatment plants. The suspended solids and a portion of the broke up solids that are available in the wastewater just as the ones which are included or refined by wastewater forms are isolated as settle capable solids In this way, muck is the solids, fluid or semisolids residuals (concentrated contaminants) produced as a side-effect of waste water treatment. Generally slop contains 0.25-12 % solids by weight, contingent on the activities and the procedures utilized Slime treatment/removal speaks to 50 % of the capital and operational expenses of wastewater treatment plant. As referenced over, the profluent treatment plant comprises of physical, synthetic and organic unit, every unit creating various sorts of muck. The sheltered removal of these kinds of squanders has gotten a significant consideration lately to ensure nature.

3. Related Works

Oil ooze was unsafe slime containing high measure of hydrocarbons. The oil ooze contains oil, water and inorganic material. The significant constituents of the slop are SiO_2, CaO, Al_2O_3 and Fe_2O_3. The outcome shows that, the nature of block slop is superior to the standard blocks because of shading and less fuel of terminating. Compressive quality outcomes demonstrated the Dirt: Sand: Water (SS) and Soil: Sand: Slime (SSS) block delivered 16.45MPa and 16.02MPa individually higher than business block with 9.06MPa. All blocks consented to all necessities agreeing Indian standard. The vast majority of the metals (Mn, Cr, Sb, Ni, Co, and Hg) are radiated during terminating. By utilizing this muck, it will lessen the prerequisite of water and fuel in block make and could be one of the removal strategies for the dangerous slime. As per Jayesh kumar Pitroda [10]. Blend proportioning was directed to discover ideal water to solidify proportion, slop to solidify proportion and concrete substitution rate. The set slop execution was estimated by compressive quality and porous porosity. The ideal proportion of water to solidify was found at 0.45 and concrete to slop of 8. Rice husk debris (RHA) was included at 5, 10 and 15 % concrete substitution. 5 % RHA showed the best execution with respect to unconfined compressive of 24.9 N/mm2. The quality was better than the slime concrete of 19.2 N/mm2. Penetrable porosity has opposite relationship with quality at water to solidify proportion of 0.4. Anyway at water to solidify proportion of 0.45, the relationship indicated distinctive pattern where increment in porosity cause increment in quality. Porosity was found to increment with expanding RHA content. The surface morphology of hardened concrete with voids was seen as in the scope of 10 to 15μm for 15 % RHA. Stone muck was another slime that concentrated by Rajgor et al. [11] to be utilized in mud blocks. Changing rates of stone muck 10%, 20%, 30%, 40%, half and 60% were joined in the mud blocks. All examples were terminated at 1050ºC. The outcomes for compressive quality are 2.11MPa to 4.2MPa and water assimilation proportion is from 8% to 12%.

MATERIAL & METHOD

Raw Materials

1.Brine Sludge.

The example of brackish water slop acquired from Dahej, Gujarat, was dried at 100 ± 2◦C for 48 hrs, cooled to surrounding temperature, and investigated for different substance constituents by X-beam fluorescence (XRF) spectroscopy (model: S8, make: Bruker, German) and according to the test strategies recommended in the standard [15]. The aftereffects of physical and substance investigation of slop are given in Table 1. The muck was antacid in character as showed by its pH and was ground in a ball plant to a fineness of 85% going through 150 micron IS strainer.

2.Fly Ash

The fly ash sample (procured from Dahej, Gujarat) was evaluated for chemical composition by XRF.

3. Physical and chemical analysis of brine sludge and fly ash.

(A)Physical Parameter

S.no.	Properties	Brine sludge	Fly ash
1.	Color	Light Grey	Grayish black
2.	Physical state at room		

	temperature	Semi-solid	Solid
3.	pH	12	10.5
4.	Bulk density, g/cc	2.52	2.35

(B)Chemical properties,%

S.no.	Properties	Brine sludge	Fly ash
1.	SiO2	9.16	62.51
2.	Al2O3 + Fe2O3	5.22	26.88
3.	CaO	9.32	2.20
4.	MgO	7.65	0.92
5.	BaO	40.03	_
6.	SO3	12.32	1.80
7.	Cl	5.30	_
8.	Na2O	4.80	0.40
9.	K2O	0.31	0.57
10.	Cr2O3	_	0.04
11.	ZnO	0.03	0.02
12.	CuO	0.05	0.01
13.	V2O5	0.01	_
14.	LOI	5.8	4.65

The mineralogical conduct of fly debris was cultivated utilizing Xray diffraction strategy (XRD, Rigaku D-Max 2200). The consequences of XRF investigation (Table 1) show that fly debris predominantly comprises of SiO_2 (62.51%) and Al_2O_3 + Fe_2O_3 (26.88%), together with auxiliary measures of CaO, SO_3, and MgO. This shows the fly debris utilized right now Type F (as per IS 3812-2003) [16]. The lime reactivity of fly debris decided according to standard test strategy referenced in IS 1727 [17]was seen as 4.5N/mm2.The test was ground in a ball plant to a fineness of explicit surface zone of 310m2/kg. the nearness of quartz as major crystalline stage alongside little amount of mullite, hematite, and magnetite.

Concrete. Normal Portland concrete (OPC) of substance structure (%) SiO_2: 23.4, Al_2O_3: 3.39, Fe_2O_3: 4.2, CaO: 63.42, MgO: 3.21, SO_3: 1.8 and misfortune on ignition0.45%, physical properties explicit gravity: 3.1, adequacy: 1.5 mm, fineness: 330m2/kg blaine, setting time (minutes) starting: 155 and last: 213, and compressive quality: 28MPa (3 days), 39MPa (7 days), and 49.5MPa (28 days) was utilized for this examination.

Aggregates The physical and mechanical properties of fine total (passing 4.75 micron IS sifter) and coarse total (particles passing 10 micron IS strainer and held over 4.75 micron IS strainer) tried according to IS 2386 [18] are exhibited in Table 2.

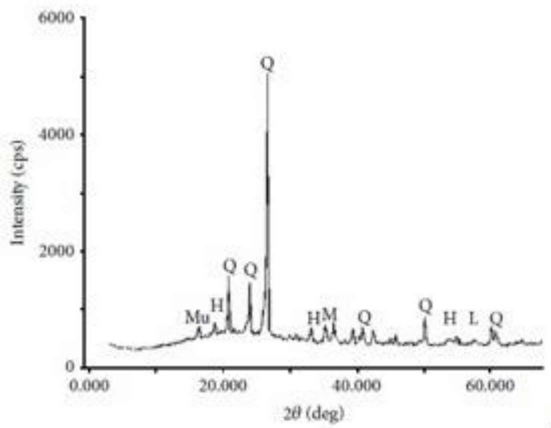


Figure 1: XRD of fly ash sample (Q: quartz,Mu:mullite, H: hematite, M: magnetite, and L: lime).

4.Chemical Sludge:
The synthetic slime which is utilized right now gathered from the Car business situated at Pimpri, Pune.
5.Ordinary Portland Concrete:
OPC of evaluation 53 was utilized right now was purchased from a neighborhood Seller.

RESULT AND DISCUSSIONS

1.Properties of Cement-Fly Ash-Brine Sludge Binder:
The assurance of compressive quality gives a proportion of the coupling quality of concrete to the waste (brackish water slime and fly debris) and is one of the significant records to assess the nature of the hardened item for application in development materials. The deliberate 3-day, 7-day, 14-day, and 28-day compressive quality and different properties of the concrete fly debris saline solution muck folios are abridged in Table 6. From the test outcomes, it tends to be seen that the properties of folios are influenced by the concrete/fly debris/muck proportions. The blend creation B2 has nearly lower benefits of setting time and adequacy than the blend structures B1, B3, B4, and B5. Information shows that the compressive quality expanded with the expansion in hydration period in all arrangements and most extreme quality was accomplished for the blend creation B2. It is additionally seen that the compressive quality of folio examples diminished with an expansion in the centralization of saline solution ooze at same relieving age. The wonder is much increasingly unfavorable when the slop content in examples is half or past it. For example, the compressive qualities of B2 folio are 14.5%, 6.8%, 34.6%, and 51.2% higher than B1, B3, B4, and B5 folios, individually, at 28 years old days.
The improvement in the quality of folios with relieving period is because of the hydration of Portland concrete and the pozzolanic response of fly debris. The high extents of silica, alumina, and iron oxide in concrete and the response of metastable silicate present in fly debris with Ca2+ particles lead to the development of calcium silicates and aluminates which tie the whole mass together delivering a cemented framework. Likewise the high pH in the grid brings about the precipitation of metal particles as metal hydroxides (adjustment). The concrete framework typifies these hydroxides and makes them stable (cementing). This gives both substance dependability and physical robustness to the treated waste. , the fuse of fine fly debris particles into the folios ends up being ideal from multiple points of view. The fly debris particles fill into the inside voids and slim channel to diminish the quantity of enormous pores in the network. They additionally adsorb metal particles on their surface. These marvels of filling and adsorption are capacity of the rates of the fly debris utilized, to such an extent that the more the fly debris particles are included, the more viable their job becomes. Consequently, the compressive quality of B3 cover is higher than that of B1 and further increments as the fly debris content builds (B2 fastener) at all the ages.

2. Water Absorption and Porosity of Cement-Fly Ash-Brine Sludge Binders:
The water ingestion and porosity are key components for estimation of solidarity and sturdiness of the folios. The examples of blend arrangements B1, B2, B3, B4, and B5 restored for 28 days were dried at 42 ± 2◦C and afterward inundated in water to quantify their water assimilation and porosity after various submersion periods. The temperature of the water was kept up at 25 ± 2◦C. The impact of drenching in water on the water ingestion and porosity of fasteners B1 B5 are appeared in Figures 2 and 3, separately. It tends to be seen from the figures that water assimilation and porosity of all folios expanded with an expansion in the submersion time frame however turned out to be around direct following 7 days of inundation in water and positioned in the streaming request: B5 > B4 > B1 > B3 > B2. These outcomes plainly show the nonattendance of draining in all structures which is credited to the topping off of pores in the fastener lattice with the hydration items that cause the folio particles to coordinate with one another.
Paver Blocks:
The 28-day cured cement concrete paver blocks of M30 grade were tested for various physical properties as shown in Figure 4. It was observed that the compressive strength (C.S.) as well as flexural strength (F.S.) decreased and water absorption (W.A.) increased when the amount of brine sludge in the blocks increased from P2 to P4 as compared to the control mix P1. However, the properties of mix P2 and P3 conformed to the minimum limits of M30 grade paver. blocks laid down in the standard [22]. On the other hand, mix P4 failed to pass the minimum strength criterion for M30 grade paver blocks. On the basis of properties

of blocks and consideration for maximum utilization of brine sludge (35%), the mix composition P3 was optimized. These blocks can be used in building premises, public gardens/parks, and so forth.

Figure 2: Effect of immersion period on the water absorption of sludge-fly ash-cement binders.

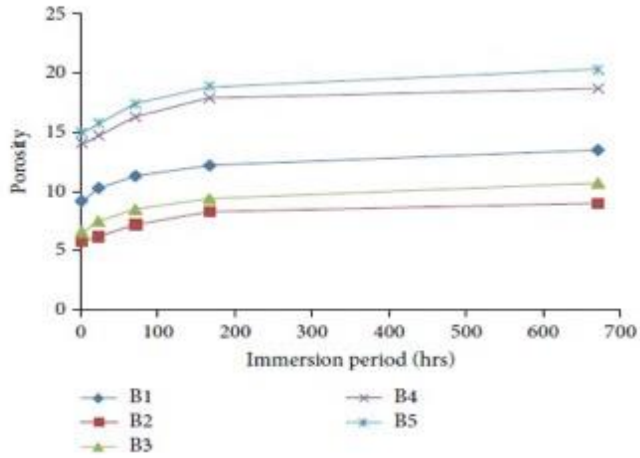
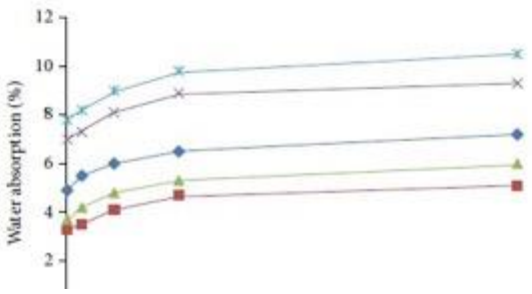


Figure 3: Effect of water immersion period on the porosity of sludge-fly ash-cement binders.



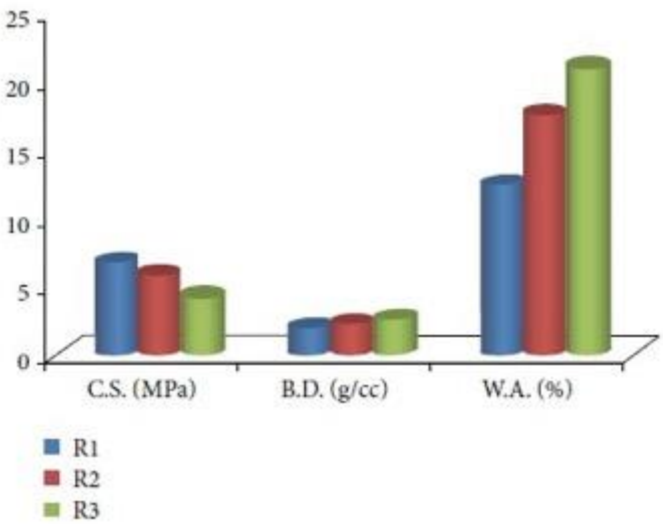


Figure 5: Properties of bricks

Bricks:

The properties of concrete fly ... ng 20, 25, and 30% salt water slop assigned as R1, R2, and ... essive quality (C.S.) of blocks diminished and water assimilation expanded (W.A.) with increment in the saline solution slop focus. The compressive quality of blend R3 is a lot of lower than R1 and R2 blends and doesn't satisfy the base quality necessity of class 5 blocks indicated in IS 12894 . A slight upgrade in the mass thickness (B.D) of blocks was seen with expanded extent of salt water slop. The drying shrinkage of the R1, R2, and R3 assigned blocks tried according to the technique depicted in IS 4139 [24] existed in the most extreme indicated estimation of 0.15 percent.The properties of the concrete fly debris salt water sludgebricks are practically identical with the blocks arranged from fly debris concrete cover and different squanders [25, 26]. The photos of paver squares and blocks are appeared in Figure .

(a)

(A)Paver blocks

(b)

Leachability Study:

The lethal trademark filtering strategy (' ... and adjustment of metal particles present in the hydrated item. The drainir ... les utilizing the ASTM extraction D3987-85 technique. The example was ... ugh a number 6 sifter (0.333 cm) and held on a number 16 strainer (0.119 cm). From that point, 10g of test was added to 160mL of water and pH of arrangement was kept steady at 5.0 ± 0.2 by including acidic corrosive (1 N). The examples were vivaciously unsettled (170 RPM) on a shaker for 24 hrs. At that point, a 10mL example was taken and sifted through a 0.45 μm film channel paper. The measure of metals filtered was dictated by estimating their focus utilizing inductively coupled plasma optical emanation spectroscopy (ICP-OES, model: Wonder XP). The leachates were investigated in triplicate and normal estimations of the metal particles are accounted for in Table 7.The outcomes were contrasted and the cutoff points for release of toxins at inland surface water referenced in Indian standard IS 10500 [28].The results obviously uncovered that the metal particles tried are firmly bound and held into the material structure and don't promptly filter from that point .The convergence of drained metals is very lower than the cutoff points determined in Indian standard with the exception of iron metal.

Metal ion	**Concentration of metal ions determined by ICP-OES (mg/L)**	**IS 10500-2012 discharge limit of metal ions at inland surface water (mg/L)**
Vanadium	0.12	0.2
Zinc	1.72	5.0
Copper	2.03	3.0
Iron	3.20	3.0

(A)Different Proportion of Trial Mix:

TABLE I

PROPORTION OF SAMPLE

	Sludge	Cement	Sand	Fly Ash	Lime	$CaCl_2$
M-1 %	10	40	17	30	2	1
M-2 %	20	40	17	20	2	1
M-3 %	30	40	17	10	2	1

B.Compressive Strength of Sample:

Fig.3. an and Fig.3. b shows the compressive quality of the blocks tested.The expansion of slime is in less add up to different constituents expanded the compressive quality of blocks. Indeed, even so,the expansion of slime is more in rate brought about decrease of compressive quality. Be that as it may, slop being better than soils itself, it additionally may fill the voids inside the dirt causing decrease in void space along these lines making blocks denser. Henceforth, the filler activity of muck should expand the compressive quality of blocks. The watched changes in quality ought to clearly be the entirety of these two impacts. Filler activity is prevailing when rate slop included is under 5%. Further expansion of ooze consumes the space just by pushing the coarse sand particles in the dirt separated. This will bring about decrease in the grinding between sand particles which contribute fundamentally to the compressive quality of blocks. Along these lines, decrease in compressive quality is normal at higher rates of ooze.

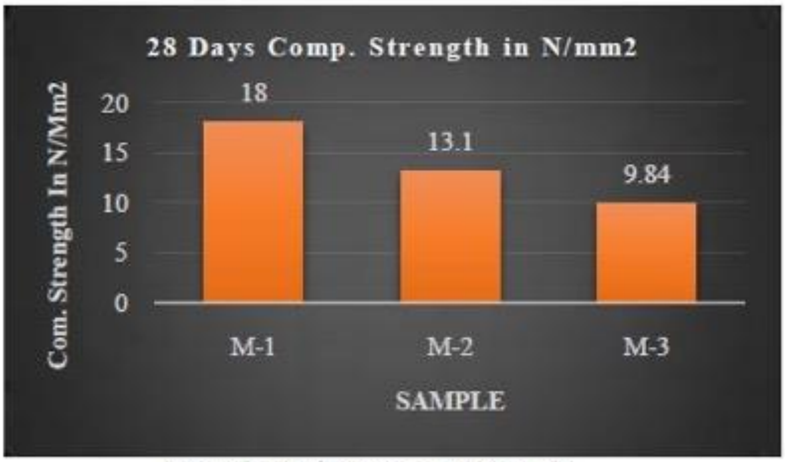


Fig.3.b 28 days Com. Strength

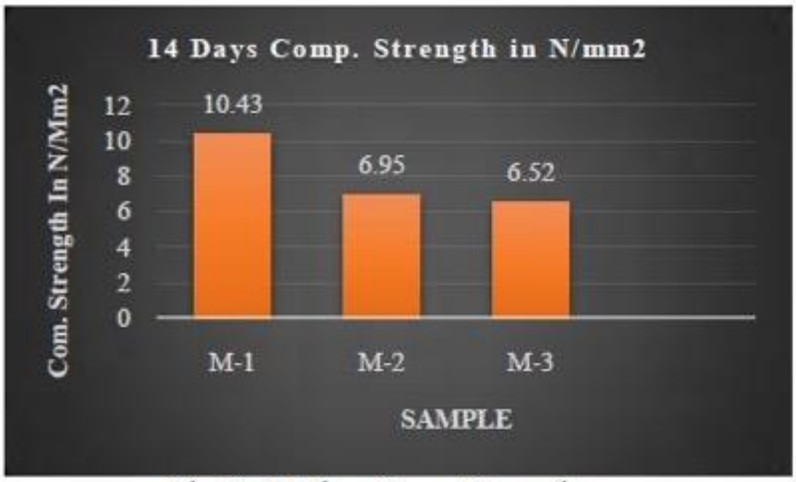


Fig.3.a 14 days Com. Strength

Water Absorption:

Impact of slop on water adsorption is appeared in Fig.4. This shows water adsorption of blend is inside the standard worth. Anyway the water ingestion ought to be under 20% by weight.

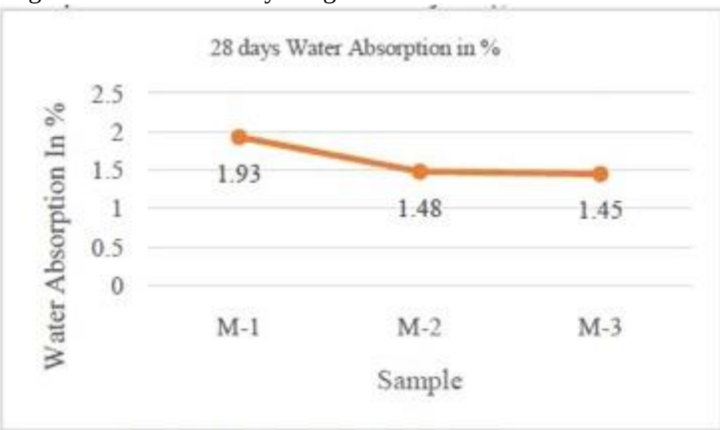


Fig.4 28 days Water Absorption

CONCLUSION

The work exhibited that it was doable to utilize a modern brackish water muck squander (IBSW) as a sorbent that can be utilized in the wet vent gas desulfurization process. Right now, impacts of temperature, pH, blending speed, strong to-fluid proportion (m/v), molecule size, and corrosive fixation were concentrated so as to decide the disintegration energy of IBSW. It was discovered that the disintegration pace of IBSW expanded with increment in corrosive focus, temperature, and mixing pace, and it diminished with an expansion in strong to-fluid proportion (m/v), molecule size, and pH. An initiation vitality of 7.195 kJ/mol was acquired; this shows item layer dispersion was the rate-restricting advance. The ends came to right now dependent on the trial program executed right now, constrained on both the tried materials and the testing methods utilized:

From the above investigation the accompanying ends can be drawn.

(1) The saline solution muck can be used for making development materials in concrete fly debris brackish water ooze folio, solid clearing squares, and blocks.

(2) The compressive quality expanded with the expansion in hydration period in all arrangements and most extreme quality was accomplished for the blend sythesis B2 contained 20% ooze, 30% fly debris, and half concrete.

(3) The fine particles of fly debris assume a significant job in filling pores and inner holes in the framework to produce a conservative structure with decreased water assimilation and porosity.

(4) The properties of paver squares and blocks agreed to the prerequisite of Indian measures. The outcomes show that salt water ooze up to 25 and 35% can be used for making paver squares and blocks, separately.

(5) The hydration items, that is, calcium silicates and aluminates, tie the whole mass together delivering a set grid and immobilize the disintegrated metal particles into it by their ensuing adsorption and precipitation.

(6) The leachability contemplates affirm that the metals and polluting influences in the muck are significantly fixed in the hardened item.

(7) The usage of salt water muck in development materials empowers the removal of a lot of slime while devouring lesser measures of solidifying materials than up until now conceivable.

 Vehicle emanating treatment plant muck can be a fruitful fractional substitute for block.

 From the compressive quality investigation was discovered The quality of blocks diminished with increment in slop focus.

 Water adsorption results additionally demonstrated that slop have less water ingestion power.

 The blocks with slime didn't have any impact of blossoming.

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