

# Additive manufacturing in construction requires reliable high fidelity models.

## Modelling and Simulation of Shotcrete 3D Printing

*K. Kutscher, M. Geier, M. Krafczyk, Institute for computational modeling in civil engineering, TU Braunschweig*

### In Short

- Thixotropy modeling with cumulant LBM
- Simulation of rheological behavior of fresh concrete
- Simulation of multiphase turbulent jet

This project is concerned with the simulation of additive manufacturing processes in civil engineering as being developed in the TRR 277. More specifically we focus on the modelling of the automated shotcrete process used in large scale printing of concrete structures. Its future development depends heavily on the understanding and control of the flow patterns in the jet used for the deposition of the materials. This jet is a complex turbulent three phase flow comprised of liquid cement, solid aggregates and ambient air. The air may not only interact with the fluid and solid components of the concrete during the deposition but can become a permanent part of it by forming voids. The distribution of the aggregates, the voids and the adhesion to previously deposited layers is a function of the spatial distribution of the different components of the jet and their kinetic energy at the time of impact. Any attempt to optimize this process will depend on an in-depth understanding of the physical behavior of the jet. The high ejection velocity leads to a phenomenon called atomization in which the jet breaks up in many small fragments that deposit individually. An atomizing jet spreads laterally and may lead to an inhomogeneous distribution of the material components and their impact velocity with obvious implications on the quality of the result. However, direct measurement of component densities and their impact velocities are apparently difficult. Hence, we aim at determining such data numerically.

The project is structured into two work packages. In the first work package, we will calibrate and validate the rheological model for concrete based on Roussel [4]. The model will be adapted for our massively parallel simulation framework VirtualFluids based on the cumulant lattice Boltzmann method [2]. Experimental reference data is provided by our project partners of TRR277 project A04 (i.e. the

group of Prof. Dirk Lowke TU-Braunschweig). In order to validate the numerical accuracy of the so obtained model, we performed empirical convergence analysis by repeating simulations at four different resolutions from which we compute the order of convergence and the Grid Convergence Index. The research resulted in the development of a novel numerical method to alter the viscosity of fluid which has recently been published [1]. In the second work package, the conservative Allen-Cahn phase field equation in velocity/pressure formulation [3] will be applied to the simulation of the turbulent shotcrete jet at realistic density ratios between concrete and air.

### WWW

<https://amc-trr277.de/projects/project-area-b/focus-area-b-03/>

### More Information

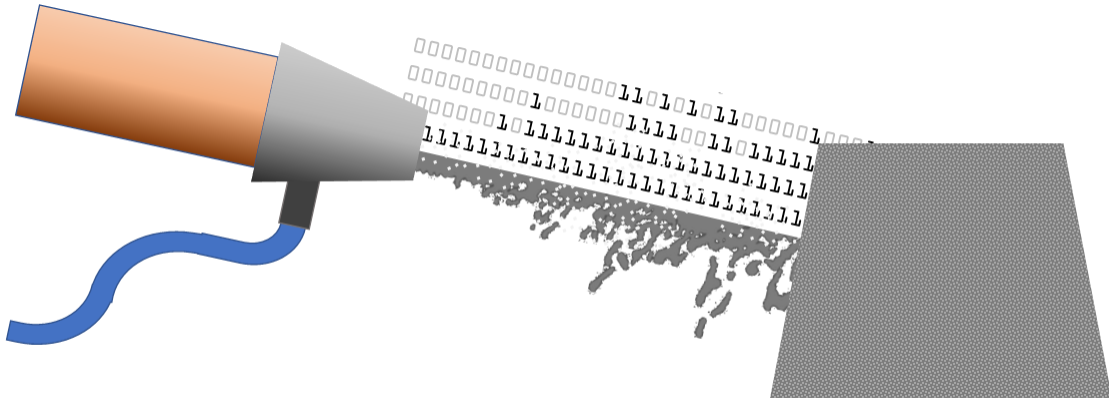
- [1] Geier, M., Kutscher, K., Krafczyk, M. (2021). A Direct Effective Viscosity Approach for Modeling and Simulating Bingham Fluids with the Cumulant Lattice Boltzmann Method. *Open Journal of Fluid Dynamics*, 11(01), 34. doi: 10.4236/ojfd.2021.111003
- [2] Kutscher, K., Geier, M., & Krafczyk, M. (2019). Multiscale simulation of turbulent flow interacting with porous media based on a massively parallel implementation of the cumulant lattice Boltzmann method. *Computers & Fluids*, 193, 103733. doi:10.1016/j.compfluid.2018.02.009
- [3] Geier, M., Fakhari, A., Lee, T. (2015). "Conservative phase-field lattice Boltzmann model for interface tracking equation." *Physical Review E* 91.6: 063309. doi:10.1103/PhysRevE.91.063309
- [4] Roussel, N. (2006). A thixotropy model for fresh fluid concretes: theory, validation and applications. *Cement and concrete research*, 36(10), 1797-1806.

### Project Partners

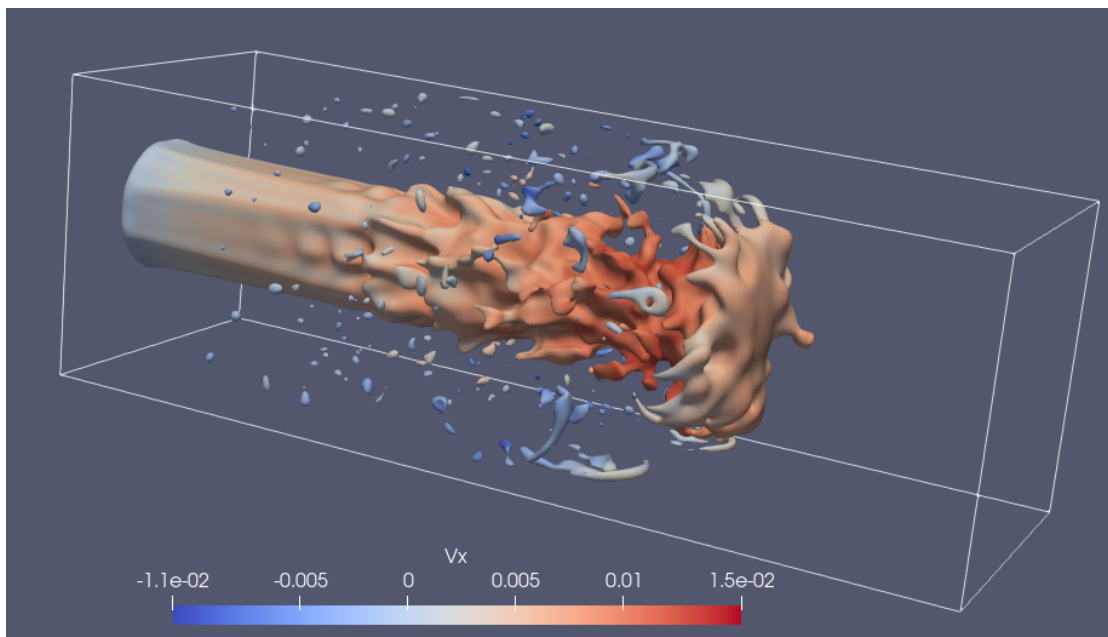
TRR277 project A04 (i.e. the group of Prof. Dirk Lowke TU-Braunschweig)

### Funding

DFG SFB/Transregio TRR 277



**Figure 1:** The final goal of the project is the numerical simulation of the atomizing jet including solid particles, the comparison to experiment from A04 and the construction of a simplified surrogate model describing the distribution of different phases and their kinetic energy in the jet.



**Figure 2:** The overall flow structure in liquid jet breakup with density ratio  $\frac{\rho_h}{\rho_l} = 24.6$ .