Cross-Laminated Timber: Potential & Challenges for the Construction Industry

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NW Construction Consumer Council Annual Conference
Lynnwood Convention Center
Composite Materials & Engineering Center
70-year track record in wood composites R&D

Core Competencies:

• Wood composite materials development and manufacturing
• Testing (IAS accredited)
• Design codes and standards
Research & Commercialization

Nondestructive testing, lumber and veneer grading, decay detection

Metriguard joins Raute
Research & Commercialization

Wood composites – product and process development

GLOBAL FIBERGLASS SOLUTIONS
Zero-waste, circular solutions for industrial fiberglass waste
100m diameter turbine at 15 rpm = 175 mph!
Research & Commercialization

Nelson Treehouse - Animal Planet's Treehouse Masters
Cross-Laminated Timber

What is it and why the excitement?

Cross-Laminated Timber (CLT) is an engineered wood composite made from lumber that forms large plates. The plates can be made quite thick (7 laminations or more), which make it viable for buildings of 10 stories or higher.

Source: Structurlam Products Ltd.
Uses of CLT

✓ Walls
✓ Floors
✓ Roofs
✓ Mats

Opportunities

✓ Mid-rise construction
✓ Schools (rapid construction over summer)
✓ Modular (can withstand handling and transportation loads)
Evolution

- Europe led the way approximately 3 decades ago
- In North America, Canada was the first to adopt
- Progress in US is a bit slower
Who manufactures CLT in North America?

- Structurlam Products Ltd., Penticton, BC  CANADA
- Nordic Structures, Quebec  CANADA
- StructureCraft Builders, Abbotsford, BC  CANADA
- DR Johnson, Riddle, OR
- Smartlam Technology Group, Columbia Falls, MT
- Katerra, Spokane, WA  (opens 2019)
- Vaagen Timbers, Colville, WA  (opens 2019)
Albina Yard (Portland, OR)

First building in US made from domestically-produced CLT.
Brock Commons Tallwood House, UBC

Great illustration of hybrid construction – 17 stories of mass timber above concrete podium, two concrete stair cores and steel roof
WSU Brelsford Visitor Center
WSU Brelsford Visitor Center
WSU PACCAR Environmental Technology Building
Code Acceptance

- **Progress**
  - CLT Handbook (joint effort with Canadians)
  - 2015 National timber design standard (NDS)
    - CLT member
    - Connections
    - Fire

- **Challenges**
  - Seismic design coefficients (FEMA 695 study)
  - Prescriptive fire design provisions (ICC Ad Hoc Committee)
  - Floor vibration and acoustics
Manufacturing

- **Progress**
  - Voluntary Product Standard
    ANSI/APA PRG 320
  - Research and testing facilities
  - New plant start-ups in US

- **Challenges**
  - Evolving supply chain
  - Limited availability/competition within 500 miles of metro markets
  - Linking engineering design software with digital manufacturing software
Professional Practice

- **Progress**
  - Low-rise and mid-rise design and engineering methods
  - Potential for rapid construction times

- **Challenges**
  - Time to permit
  - Cost estimation
  - Construction workforce training
  - Education: detailing for durability; field modification; protecting CLT from weather during construction
## Summary

<table>
<thead>
<tr>
<th>Pro</th>
<th>Con</th>
</tr>
</thead>
<tbody>
<tr>
<td>Low carbon footprint</td>
<td>Availability (and initial purchase price)</td>
</tr>
<tr>
<td>Potential savings in construction time and cost</td>
<td>Extra design and permitting costs (in short term)</td>
</tr>
<tr>
<td>Biophilic response (people respond well to it)</td>
<td>Design issues need to be resolved before digital manufacturing</td>
</tr>
<tr>
<td>Beauty and aesthetics</td>
<td>Potential issues with labor unions</td>
</tr>
<tr>
<td>Reduced onsite wastes</td>
<td>Supply chain not fully developed</td>
</tr>
<tr>
<td>Potential for modular construction</td>
<td>Seismic and fire design issues need to be resolved</td>
</tr>
</tbody>
</table>
Mass timber

Source: Gartner hype cycle
CLT Research & Education at WSU
Self-Centering Rocking Walls

- NSF-sponsored collaboration with Colorado School of Mines, Colorado State Univ, Univ of Washington, Washington State University, Lehigh University, Univ of Nevada
- Initial concepts tested at WSU
- 2-story building tested at shake table at UC San Diego
Inter-Panel Fuses for Shear Walls

- Collaboration with Katerra and WSU
- Fuse dissipates seismic energy
- Concept tested in laboratory and at UC San Diego
Design Methodologies for Seismic and PBD

• Design methodology and performance of tall CLT buildings – development of modeling and acceptance procedures for *performance based design (PBD)*.

• New performance based design guidelines for CLT – justification for reducing PBD acceptance criteria for buildings under 6 stories and do not have torsional irregularity.
CLT Supply Chain Analysis

Market Demand

Building Design

Production Capacity

CLT Requirements

Resource Needs
Project Components

#1
City of Seattle Building Codes
  ↓
CLT Volume Requirements
  ↓
CLT Use Factors

#2
7PP and NEEA
  ↓
Market Assessment
  ↓
CLT Techno-Economic Analysis
  ↓
Supply Chain Analysis

#3
Lumber Mill Database
  ↓
Lumber Assessment
## Building Archetypes

<table>
<thead>
<tr>
<th>Building Archetype Details</th>
<th>Low-Rise (1-6)</th>
<th>Mid-Rise (7-12)</th>
<th>High-Rise (13-20)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Building Height (stories)</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Construction Type</td>
<td>platform</td>
<td>balloon frame</td>
<td>hybrid system</td>
</tr>
<tr>
<td>Lateral Loads</td>
<td>CLT</td>
<td>CLT</td>
<td>concrete core</td>
</tr>
<tr>
<td>Gravity System</td>
<td>CLT</td>
<td>CLT</td>
<td>CLT</td>
</tr>
</tbody>
</table>
### Average CLT Use Factor (ft³/ft²)

<table>
<thead>
<tr>
<th>Footprint Range (ft²)</th>
<th>Low-Rise (1-6)</th>
<th>Mid-Rise (7-12)</th>
<th>High-Rise (13-20)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1,000 – 10,000</td>
<td>0.71</td>
<td>0.88</td>
<td>0.57</td>
</tr>
<tr>
<td>20,000 – 50,000</td>
<td>0.69</td>
<td>0.88</td>
<td>0.57</td>
</tr>
<tr>
<td>60,000 – 100,000</td>
<td>0.69</td>
<td>0.88</td>
<td>0.57</td>
</tr>
</tbody>
</table>

- Design of each archetype was reduced into a CLT use factor
- CLT Use Factor = \( \text{ft}^3 \) of CLT / \( \text{ft}^2 \) of building
- For each footprint, CLT use factor increases with increasing building height up to 12 stories from lateral load demands
- CLT use factor is smallest for high-rise buildings; CLT is assumed to carry no lateral load
- Low-rise CLT use factor range = 0.62 to 0.88
- Mid-rise CLT use factor range = 0.80 to 0.96
Capital Costs

<table>
<thead>
<tr>
<th>Department</th>
<th>Large Scale Cost (MM$)</th>
<th>Small Scale (MM$)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Lumber Preparation</td>
<td>$3.0</td>
<td>$2.1</td>
</tr>
<tr>
<td>Finger Jointing</td>
<td>$2.7</td>
<td>$2.7</td>
</tr>
<tr>
<td>Lay Up/Resin Application</td>
<td>$1.9</td>
<td>$1.4</td>
</tr>
<tr>
<td>Press</td>
<td>$2.4</td>
<td>$1.5</td>
</tr>
<tr>
<td>Panel Finishing</td>
<td>$6.6</td>
<td>$5.8</td>
</tr>
<tr>
<td><strong>Total Direct Costs</strong></td>
<td><strong>$51.9</strong></td>
<td><strong>$42.1</strong></td>
</tr>
<tr>
<td><strong>Total Capital Investment</strong></td>
<td><strong>$80.6</strong></td>
<td><strong>$64.6</strong></td>
</tr>
</tbody>
</table>

- Large Scale = 3.1 MM ft³/year
- Small Scale = 1.8 MM ft³/year
Estimated Production Costs

Sensitivity of CLT MSP from base case cost of $15.2/ft^3

Lumber Price (-30%: 0%: 30%)
TDEC (-30%: 0%: 30%)
Real Discount Rate (5%: 10%: 15%)
Maintenance (4%: 6%: 8% FCI)
Labor (-20%: 0%: 20%)
Material Loss (5%: 15%: 25%)
Electricity Rate (-50%: 0%: 50%)
Haul Distance (50: 100: 150 miles)
Natural Gas Rate (-50%: 0%: 50%)

Change in MSP of CLT ($/ft^3)
Example CLT Facility to Spokane and Boise Markets
R&D and Testing Services for New CLT Plants
Education

- Teach over 170 students per year in civil engr, const mgmt, architecture
- Timber design textbook used by over 70 colleges
- Partner with Simpson Strong-Tie on education symposium
How do universities figure into your value propositions?

Universities can...
• Educate future design and construction professionals
• Provide R&D services (leverage your resources)
• Participate in relevant codes and standards development

How to activate industry/university collaborations:
• Identify universities that have design and construction programs
• Offer guest lectures and teaching samples
• Sponsor research
• Offer scholarships and internships
• Sponsor student design competitions
Questions?

cmec.wsu.edu