Contents

1 Introduction **17**

1.1 European forests in the 21st century 17

1.2 Hardwoods in the building industry 19

1.3 Glued laminated timber 20

1.3.1 Characterization of mechanical properties of glulam according to EN 14080 22

1.3.2 Towards standardization of hardwood GLT 23

1.3.3 The example of softwoods: strength models 24

1.4 Objectives 25

1.5 Scope 26

1.6 Outline and overview 26

2 State of the art **27**

2.1 General remarks 27

2.2 A look at the variation in wood: sources of uncertainty 27

2.3 General statistical concepts and methods for the analysis of wood properties 30

2.3.1 Weibull theory of weakest link 30

2.3.2 Order statistics and extreme value theory 31

2.3.3 Survival analysis 31

2.4 Probabilistic methods for the simulation of correlated variables . . . 33

2.4.1 Simulation of correlated normally distributed variables . . . 33
2.4.2 Simulation of correlated non-normally distributed variables 34
2.4.3 Autoregressive models 34
2.5 Models for the simulation of material properties along boards . . . 36
2.5.1 Predictor-based stochastic models 38
2.5.2 Pure stochastic models 40
2.5.3 Simulation of KAR values along the boards 47
2.6 Probabilistic strength models for glulam beams 48
2.6.1 Model by Foschi and Barrett (1980) 48
2.6.2 Karlsruher Rechenmodel 49
2.6.3 PROLAM model 50
2.6.4 Karlsruher Rechenmodel (latest implementation) 51
2.6.5 Model by Fink (2014) 52
2.6.6 Model by Kandler et al. (2018) 53

3 Materials **55**
3.1 General remarks 55
3.2 Dataset A: Material used for the study of within board variation . . 56
3.2.1 Segmentation of boards 57
3.2.2 Grain deviation 58
3.2.3 Knot-related variables 58
3.2.4 Dynamic modulus of elasticity measurements 58
3.3 Dataset B: Glulam experimental data: Gamiz 59
3.3.1 Mechanical properties of boards 60
3.3.2 Mechanical properties of glulam beams 61
3.3.3 Distribution of board lengths in glulam 62
3.4 Dataset C: FCBA experimental campaign 62
3.4.1 Mechanical properties of boards and finger-joints 62
3.4.2 Mechanical properties of glulam beams 63

4 Analysis of knots in oak boards **65**

4.1 General Remarks 65

4.2 Knot area ratios (KAR) 66

4.2.1 Digitally reconstructing the 3D knot geometry of boards . . 67

4.2.2 Comparison of different KAR definitions 68

4.2.3 KAR distributions 72

4.3 Length of clear wood segments 77

4.3.1 Definition of clear wood length 77

4.3.2 Clear wood length analysis 78

4.4 Final remarks 79

5 Variation of mechanical properties in oak boards **81**

5.1 General 81

5.2 Description of the experimental campaign 82

5.2.1 Variation of modulus of elasticity along board 82

5.2.2 Multiple tensile strength measurements 83

5.2.3 Density measurements along boards 85

5.3 Density variation within boards 86

5.4 Modulus of elasticity 88

5.4.1 Processing of measured data 88

5.4.2 Global and local moduli of elasticity 88

5.4.3 Correlation of MOE with density and KAR 93

5.4.4 Normalization of the measured MOE data 94

5.4.5 Transformation of normalized MOE to stationary data . . . 98

5.4.6 Serial correlation of localized MOE measurements 99

5.5 Tensile strength 104

5.5.1 Fracture behavior and global tensile strength 105

5.5.2 Local tensile strength 106

5.5.3 Relationship between tensile strength and MOE 107

5.5.4 Estimation of the intra-board tensile strength distribution . . 109

5.6 Regression models for MOE and $f_{t,0}$ . . . 117
5.7 Summary and discussion . . . 120

6 Simulation of mechanical properties along oak boards 123
6.1 General remarks . . . 123
6.2 Simulation of global properties of boards . . . 124
6.3 Localized modulus of elasticity . . . 125
6.3.1 Determination of order and parameters of the stationary AR process . . . 127
6.3.2 Model for the simulation of MOE profiles . . . 128
6.3.3 Example of simulations of MOE profiles along boards . . . 129
6.3.4 Consideration of different board lengths . . . 133
6.4 Localized tensile strength . . . 134
6.4.1 Model for the simulation of tensile strength profiles . . . 135
6.4.2 Simulation examples of tensile strength profiles along boards 136
6.4.3 Simulation of length effect for tensile strength . . . 137
6.4.4 Correlation of MOE and tensile strength at global level . . . 141
6.5 Localized compressive strength . . . 142
6.6 Discussion . . . 142

7 Finite element model for the prediction of bending strength in glulam beams 145
7.1 General remarks . . . 145
7.2 Input parameters . . . 146
7.2.1 Configuration files and hashing of parameters . . . 148
7.3 Finite element model . . . 148
7.3.1 Geometry and build-up characteristics . . . 151
7.3.2 Material properties . . . 152
7.3.3 Material assignment and meshing . . . 157
7.3.4 Boundary conditions . . . 159
7.3.5 Solver configuration . . . 160

7.4 Typical solution and post-processing of results . . . 161
7.4.1 General failure behavior . . . 161
7.4.2 Data extraction from the FE model . . . 163
7.4.3 Definition of bending failure . . . 163
7.5 Discussion . . . 164

8 Model calibration and parametric analysis 165
8.1 General remarks . . . 165
8.2 Studied configurations . . . 166
8.2.1 Dataset B . . . 166
8.2.2 Dataset C . . . 167
8.3 Analysis of stiffness results . . . 168
8.3.1 Stiffness results of dataset B . . . 168
8.3.2 Stiffness results of dataset C . . . 169
8.4 Calibration of fracture energy . . . 169
8.4.1 Calibration of fracture energies with dataset B . . . 170
8.4.2 Application of fitted energy values to dataset C . . . 173
8.5 Parametric analysis . . . 174
8.5.1 Effect of tensile strength distribution . . . 174
8.5.2 Effect of length of boards . . . 176
8.5.3 Effect of tensile strength of finger-joints . . . 179
8.6 Discussion . . . 185

9 Conclusions and outlook 187
9.1 Conclusions . . . 187
9.2 Outlook . . . 189

References 191

List of Symbols 203

Appendix A Variation of MOE along boards 209

Appendix B Analysis of MOE normalization method **217**

Appendix C Testing of the user-defined material in a one-element problem 219

Appendix D Input parameters used in the strength model **221**

D.1 Parameters used for the strength model with dataset B 221

D.2 Parameters used for the strength model with dataset C 222

Appendix E Reordering of vectors to maintain global correlation **223**