

Table S1. Chemical composition of the raw materials

Sample	Chemical Composition (wt%)									
	CaO	Al ₂ O ₃	SiO ₂	Fe ₂ O ₃	SO ₃	MgO	K ₂ O	CO ₂	H ₂ O	LOI
OPC	65.24	5.07	20.55	3.47	1.46	1.22	0.99	-	-	2.0
Kaolinite	-	20.9	71.7	-	-	-	-	-	7.4	-
Limestone	55.44	-	1	-	-	-	-	43.56	-	-