IPS CORPORATION®

PRODUCT BULLETIN – SPECIFICATIONS

WELD-ON 810 A & B

A REACTIVE HIGH-STRENGTH ADHESIVE
FOR JOINING PVC AND CPVC PLASTICS

GENERAL DESCRIPTION:

Weld-On 810 is a white, thick syrupy, two component reactive, high strength plastic resin adhesive.

PRODUCT USES:

Weld-On 810 was specially formulated for joining, fabricating and repairing large size PVC and CPVC pipe and fittings. It can also be used for joining PVC or CPVC to other materials such as metals, concrete and clay, or to join dissimilar plastics, such as fiberglass reinforced polyester (FRP), ABS, acrylic and polycarbonate. Weld-On 810 is unexcelled for joining very large sizes of PVC pipe and fittings, where fits are loose enougk to have gaps;. It is not recommended for joints with interference fits. It provides excellent adhesion in peel, tensile or sheer applications with PVC and CPVC— withstands very high pressure.

- Fills gaps too large for solvent cement to fill.
- Allows time for careful workmanship in fabricating, joining or repair of very large diameter pipe and fittings. It is ideal for installing large saddles or valve connections.
- Although it hardens to a rigid plastic, it is tough enough to resist substantial impact.
- Forms superior bonds between PVC and other materials e.g., plastics and non-plastics to cast iron, galvanized, aluminum, concrete or clay pipe or fittings.
- For joints subjected to chemical exposure, prior evaluation with regards to the specific chemical, concentration, temperature and pressure involved, must be made.

DIRECTIONS FOR USE:

1. Assemble materials for the job - Weld-On 810 A & B, mixing sticks, applicator (spatula or stiff brush), sandpaper, clean wiping cloths, cleaning solvent and gloves.
2. Prepare joints by sanding to roughen mating surfaces. Wipe surfaces clean with a dry rag or with solvent cleaner. Do not soften with solvent cleaner.
3. With pre-measured Weld-On kit, add Catalyst B (small container) to Resin A (large container). Mix thoroughly and apply to each mating surface. Pot life and working time is about 30 minutes at 75°F.
4. Assemble parts and allow squeeze out to remain as a filler.
5. Do not disturb joint for at least 2 hours at 70°F. Warmer weather will shorten pot life and cure time. Colder weather will increase time for both.
6. When joining CPVC for service temperatures over 150°F, please contact IPS Corporation for more information.

Please Note: After mixing Component A (Base Resin) with Component B (Catalyst), Weld-On 8.10 is ready to be applied to the mating surfaces. Pot life of the mixture is about 30 minutes at 75°F. Working time is often shorter than the pot life because the resin surface air dries to form a thin skin during application. The resin layer cures initially to a hard gel in about 2 hours and reaches near ultimate strength in 24 hours at 70°F. The cured layer is a tough, chemical and water resistant plastic. Note: Cure will be faster in warmer weather. slower in cold weather.

REPAIR WITH WELD-ON 810:

Weld-On 810 has had considerable field history in the repair of leaks. We have had many reports of very satisfactory results. All lab test repairs provided leak-free service at full rated pressure for 5 weeks without failure. Pressure was then increased to burst pressure of the pipe, but the repairs did not fail. From these results we would expect that field repairs should provide durable, leak-free service, depending on the quality of the repairs.

Here are suggestions for making repairs with Weld-On 810: (1) Have materials ready, sufficient quantity of Weld-On 810; a clean stick for mixing; a spatula or stiff brush for applying Weld-on 810; fiberglass* cloth mat cut to desirable size or strip for wrapping; sandpaper or emery, clean dry rags, gloves for protection. (2) Turn off water pressure; dry off the area of bond and abrade it well with sandpaper and wipe clean. (3) Mix Weld-On 810 as a pre-measured kit. Add small bottle of "B" to larger container of "A" and mix thoroughly. (4) Apply a generous coat of Weld-On 810 to leak and surrounding area. (5) Apply Weld-On 810 to mating surface of cloth and wrap around leak area. Some adhesive should squeeze up through cloth. (6) Apply an additional coat of Weld-On 810 to the top surface. (7) Allow to cure a minimum of 4 hours at 75°F. Overnight or 24 hours cure would be more desirable before re-pressurizing the systems.

* Good results were obtained with Weld-On 810 without fiberglass cloth, but fiberglass cloth is recommend for added structural strength.

AVAILABILITY:

This product is available in 1/4 pint, pint, quart and gallon two part pre-measured, plastic container kits.

STORAGE/SHELF LIFE:

When both components are stored between 45°F and 75°F, 1 year shelf life can be expected.

SHIPPING:

Shipping Information for Liter and Above: DOT Hazard Class: 3. DOT Shipping Name: Adhesive.
Identification Number: UN 1133. Packaging Group: II. Label Required: Flammable Liquid.

Shipping Information for Less than One Liter:

DOT Shipping Name: Consumer Commodity. DOT Hazard Class: ORM-D.

SAFETY PRECAUTIONS:

This product is a flammable solvent cement. It is considered a hazardous material. In conformance with the Federal Hazardous Substances Labeling Act, the following hazards and precautions are given. Purchasers who may repackage this product must also conform to all local, state and federal labeling, safety and other regulations.

DANGER - FLAMMABLE - VAPOR HARMFUL
MAY BE HARMFUL IF SWALLOWED - MAY IRRITATE SKIN OR EYES

Keep out of the reach of children. Do not take internally. Keep away from heat, spark, open flame and other sources of ignition. Keep container closed when not in use. Store in the shade between 45°F and 75°F. Use only with adequate ventilation. Avoid breathing vapors. Atmospheric levels should be maintained below established threshold limit values. See Section II of MSDS. If airborne concentrations exceed limits, use a supplied air respirator. Do not use a chemical cartridge respirator. For emergencies and other conditions where short term exposure may be exceeded, use an approved positive pressure self-contained breathing apparatus. In confined areas, use a positive pressure self-contained breathing apparatus (SCBS). Avoid contact with skin, eyes and clothing. May cause eye injury. Protective equipment such as gloves, safety goggles and impervious apron should be used. Carefully read Material Safety Data Sheet and follow all precautions. Contents Comp. A: Methyl Methacrylate Monomer (80-62-6). Contents Comp. B: Methyl Ethyl Ketone (78-93-3) and Benzoyl Peroxide (94-36-0). Do not use this product for other than intended use.

FIRST AID:

Inhalation: If ill effects from inhalation, remove to fresh air. If not breathing, give artificial respiration. If breathing is difficult, give oxygen. Call physician.

Eye Contact: Flush with plenty of water for 15 minutes and call a physician.

Skin Contact: Wash skin with plenty of soap and water for at least 15 minutes. If irritation develops, get medical attention.

Ingestion: If swallowed give 1 to 2 glasses of water or milk. Do not induce vomiting. Contact physician immediately.

"Title III Section 313 Supplier Notification": This product contains toxic chemicals subject to the reporting requirements of Section 313 of the Emergency Planning and Community Right-to-Know Act of 1986 and of 40CFR372. This information must be included in all MSDSs that are copied and distributed for this material.

QUALITY ASSURANCE:

Every batch of this product is checked to assure that consistent quality is maintained. An infrared absorption curve is recorded for each batch to ensure that this product was properly formulated. Samples are taken from all batches and kept for a period of at least one year. A batch identification code is stamped on each can.

IMPORTANT NOTE:

This product is intended for use by skilled individuals at their own risk. These suggestions and data are based on information we believe to be reliable. Users should verify by test that this product, as well as these methods, are suited to their application. Since specific use, materials and handling are not controlled by IPS, our warranty is limited to the replacement of defective IPS product.

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