

**GENERAL DESCRIPTION:**

WELD-ON® 845™ is a tan (pink when cured), low VOC emission, high viscosity, two-component (4 to 1 mix ratio), high strength, reactive adhesive used for bonding a variety of materials. It has fast cure time, is impact resistant, can be used underwater and once cured, withstands very high pressure and large temperature range (-30°F / -35°C to 200°F / 93°C). **Not recommended for use on Ceramic, PTFE, Silicone, Polypropylene, Polyethylene and other Polyolefin's.**

APPLICATION:

WELD-ON 845 is specially formulated for joining, fabricating and repairing PVC and CPVC pipe and fittings. It can also be used on Fiberglass, ABS, Acrylic, FRP (fiberglass-reinforced plastic), metals, concrete and other materials to themselves or to dissimilar materials. WELD-ON 845 is outstanding for joining very large sizes of plastic pipe and fittings with loose gaps. It also provides strong adhesion in peel, tensile or sheer applications. Excellent for fabrication of fittings, joining saddles to pipe, and repairing cracks or leaky pipe valves and fittings. This product is not recommended for joints with interference fit.

AVAILABILITY:

This product is available in 50ml cartridge (net content: 43ml) and 400ml cartridge. Each cartridge size requires a dispensing gun and mixing tips. A starter kit is also available and consists of 2 - 50ml cartridges, 1 - dispensing gun and 6 - mixing tips. For detailed information on containers and applicators, see our current Price List.

STANDARDS AND CERTIFICATION LISTINGS:

- Meets SCAQMD Rule 1168/316A
- Compliant with LEED® (Leadership in Energy and Environmental Design). When using this WELD-ON low VOC product, credit can be claimed for LEED Green Building Rating System - Indoor Environmental Quality.

SPECIFICATIONS:

COLOR:	Tan (pink when cured)
RESIN:	Acrylic
SPECIFIC GRAVITY:	Component A = 1.089 ± 0.040 & Component B = 1.327 ± 0.040
BROOKFIELD VISCOSITY:	Minimum 400,000 cps @ 73°F ± 3.6°F
APPROXIMATE COVERAGE:	1.5 sq. ft. per 50 ml cartridge* 15 sq. ft. per 400 ml cartridge*

* Based on laboratory evaluation @ 20 mil thickness. This data is for reference only. Actual coverage may vary.

DIRECTIONS FOR USE:

- Always wear safety glasses and polyethylene gloves. Use this product at room temperature.
- Wipe joining surfaces clean with a dry rag and/or with solvent cleaner. Do not soften surfaces with the solvent cleaner.
- Open valves at the cartridge nozzle. Clear any obstructions inside the valve openings with a probe. Close valves.
- Insert cartridge into the dispensing gun. Open valves. Dispense a small amount of adhesive making sure that both components flow freely from the cartridge nozzle.
- Attach a mixing tip and dispense approximately 1 to 2 inches to ensure both components of the adhesive are completely mixed before use. Note: the adhesive inside the mixing tip may cure if the tip is left on the cartridge for a prolonged duration without additional use. In this case, keep the mixing tip on the cartridge. When you are ready to dispense the adhesive again, replace the mixing tip. Dispense and discard the first few inches of the adhesive prior to use.
- Once dispensed, the adhesive pot life is about 10 minutes at 75°F (23°C). Working time is often shorter than the pot life. The adhesive initially cures to a hard gel in 30 minutes and reaches near ultimate strength in 2 hours at 70°F (21°C). Cure will be faster in warm weather, slower in cold weather.

SHELF LIFE & STORAGE:

1 year in unopened cartridge when stored between 50°F (10°C) and 70°F (21°C). Keep away from sources of heat, sunlight and moisture. Refrigerator storage is recommended.

QUALITY ASSURANCE:

WELD-ON 845 is carefully evaluated to assure that consistent high quality is maintained. Fourier transform infrared spectroscopy, gas chromatography, and additional in depth testing ensures each batch is manufactured to exacting standards. A batch identification code is stamped on each can and assures traceability of all materials and processes used in manufacturing this product.

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. Installers should verify for themselves that they can make satisfactory joints under varying conditions. Toward this end, it is highly desirable that they receive personal instruction from trained instructors or competent, experienced installers. Contact Weld-On or your supplier for additional information or instructions.

Refer to the current WELD-ON 845™ GHS Safety Data Sheet for additional safety precautions, first-aid, handling, storage and transportation information.

WARRANTY:

Weld-On warrants that all new Weld-On products shall be of good quality and free from defects in material and workmanship for the shelf life as indicated on the product. If any Weld-On product becomes defective, or fails to conform to our written limited warranty under normal use and storage conditions, then Weld-On will, without charge, replace the nonconforming product. However, this limited warranty shall not extend to, nor shall Weld-On be responsible for, damages or loss resulting from accident, misuse, negligent use, improper application, or incorporation of Weld-On products into other products. In addition, any repackaging of Weld-On products also shall void the limited warranty. Weld-On shall not be responsible for, nor does this limited warranty extend to, consequential damage, or incidental damage or expense, including without limitation, injury to persons or property or loss of use. Please refer to our standard Weld-On Limited Warranty for additional provisions.

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