



Duraweld-60

2 Part Epoxy

Gel Viscosity

Description:

Duraweld-60 is a solvent free two-part gel epoxy binder for concrete, steel reinforcement and anchor embedding.

It bonds cured concrete to fresh concrete. It is not affected by dampness on fresh concrete. Mixed to concrete gray in color and will have an open time of 30 to 40 minutes + or - @ 75° F on average. Heat will accelerate the set and cold weather will slow the setting time. Product has the viscosity of a gel for vertical uses and can be extended with dry silica sand to make a stiff non sag mortar.

Uses:

This product is used as a structural adhesive which can be used on hardened concrete to bond fresh concrete.* It is also able to embed steel into concrete. This product can accept up to 3 parts of silica sand which can be used as a chemical resistant coating; repair mortar for vertical forms; machinery pads and many other uses. Gels are able to be applied to overhead surfaces with less sagging.

Limitations:

*Use on hardened concrete of minimum of 14 days old.

Keep cool before mixing as heat will increase the setting times. On hot days it is best to cool units in a cool water bath prior to use . Do not use when temperatures fall below 40° F. Epoxy must be still tacky for bond. If material becomes hard, remove instead of re-coating. Do not use when ambient temperature is expected to fall below 40° F.

Note: *Cold weather can stop the thermo-setting properties of all epoxies and can limit or stop the hardening process.*

When used to embed rebar, the hole should be dust free and never be bigger than one quarter (1/4) inch of the bar diameter.

Installation:

Only apply to a clean non-dusting substrate. Mix part A with Part B in equal proportions until the color becomes completely uniform. Apply a generous coat to fully cover the whole surface. It is best to use a stiff brush and/or tooling trowel to apply gels.

Mix only amounts to be used in the allotted time. Discard if it becomes too stiff to apply.

Apply to both surfaces when jointing steel, wood or concrete-like materials. For rebar and anchors, blow holes clean with compressed air. Dip steel in the epoxy mix and hammer into place with a twisting motion.

On floor overlays it can accept 3 to 5 parts of silica by volume depending on thickness. Applications over floors should be applied in one direction avoiding air pockets by squeegee or roller. A neat bonding coat on substrate can ease the installation for easier spreading. This product can be used to stop moisture from coming to the surface in slabs and walls, but caution should be used to assess each individual case. High hydrostatic pressures may require a different approach.

Packaging:

2 and 4 Gal. kits in each case, (A + B)

Compliance:

Bond: ASTM C-882, Type III, Grade 3, Class B & C
1900 in 48 hours (dry), 1800 psi in 14 days (wet cured)

Compressive: ASTM D-695, 4500 psi in 24 hours ,
6700 psi in 7 days. @ 75°

Tensile: ASTM -638, 2350 psi in 14 days

Flexural: ASTM D-790, 3000 psi in 14 days.

Water absorption: Less than 0.5%

Tack Free: 2-4 hours at 75° F


Coverage: Up to 100 Sq./Ft. per gallon @ 15 mills,
(depending surface profile)

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Duraweld-60

LO-Mod.

Mixing and applying:

Mix part A with Part B in equal proportions until it completely becomes one uniform color. Apply a generous coat to fully cover all of the bonded area. It can be applied to steel and as a reinforcement for additional protection. Mix only amounts to be used in the allotted time before it becomes difficult to apply. Apply to both surfaces if they are going to be jointed together.

Anchoring Bolts & Dowels:

Hole should be at least 1/4 inch larger diameter than the anchor and full depth. Blow holes clean and apply epoxy to dowel and fill the hole. Insert into hole, making sure hole is filled evenly to the surface.

As structural bonding agent:

Apply to the area to be bonded by brush or roller, making sure all of the surfaces are evenly coated.

When joining steel plates, apply mixed epoxy to both sides of the surfaces to be bonded. Bond concrete or metal parts before epoxy hardens.

Coverage: As a Bonding Agent:

Over Smooth Surfaces: 100 Sq./Ft. per gallon

Over Rough Surfaces: 60-Sq./Ft. per gallon

Where to Use:

- ◆ Non-Sag applications and overhead (supported)
- ◆ Structural bonding adhesive for hardened to fresh concrete.
- ◆ Corrosive resistant protective coatings.
- ◆ Bolt and anchor grouting.
- ◆ Base plate epoxy mortars.
- ◆ Machine bases and many other uses.

Extend with fine silica for grouting:

Can be mixed to up to 3 parts of dry silica sand by volume. (grouting)

1to1 Mix: covers approximately 12.8 Sq./Ft. at 1/8 inch

Safety and Clean-up:

Keep away from fire hazards and ignition sources, do not smoke while handling. Use eye and skin protection and avoid inhalation of fumes. Use gloves and suitable respirator in well ventilated areas. Clean tools and equipment with Lacquer thinner or Acetone. Request a copy of product MSDS Data for additional information for safe handling of this product.. Dispose as solid waste following local and federal laws.

Warranty: When product is used according to directions and when properly used, warranty is limited to one year after product is supplied to the purchaser in the original container. Refund of the purchase price only if deemed defective at manufacture. This product is intended for industrial professional use by competent tradesmen. with sufficient knowledge and experience on use and proper handling of these products. The purchaser agrees to assume all responsibility for installation, product selection, application, job warranties, use, transport and disposal of product. Builders Construction Products shall not be liable to the purchaser or any third party for costs of labor or direct or indirect and incidental or consequential damages related to the use or suitability of this product. No other warranties are implied. Responsible disposal of used products and packaging is the responsibility of the purchaser and or user. Disclaimer clause; while we try to publish the most accurate information we reserve the right to correct mistypes and incorrect statements as they are discovered. If at any time you have doubts about the contents of any of our literature, you are encouraged to contact us.

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