

# Repair Stick Steel



fast cure  
steel-filled  
NSF approval, can be used in drinking water aereas

It is particularly suited for the fast and high-strength repair and bonding of metal parts and for the patching and sealing of cracks, holes, and leaks in machine parts, tanks and pipelines, containers, pumps and housings, balcony railings, banisters, and torn-out threads.

The WEICON Repair Stick Steel can be used in machine and system construction, in tank construction and apparatus engineering, in the foods, cosmetic and pharmaceutical industries and in many other applications.

ISSA: 75.530.15/01

IMPA: 81 29 25/26

## Technical data

Composition	Epoxy resin and steel fillers, putty
Pot life at 25 g material and at +20 °C	4 Min.
Density of the mixture	2,0 g/cm <sup>3</sup>
Processing temperature	+10 bis +35 °C
Curing temperature	+6 bis +40 °C
Colour after curing	dark-grey
Gap covering power to maximum	15 mm
Handling strength (35% strength/+20 °C) after	10 Min.
Capable of bearing mechanical loads(50% strength/+2	1 h
Final strength (100%) at +20 °C after	24 h
Pressure (DIN 53281-83)	80 N/mm <sup>2</sup>
Shore hardness D	75
Average tensile shear strength after 7 days	
ac. to DIN 53283	4,1 (Steel sandblasted) N/mm <sup>2</sup>
Temperature resistance	-50 bis +120 (kurzz. +150) °C

## Pretreatment of the surface

To ensure a perfect bond, the surfaces to be joined must be clean and dry (e.g., clean and degrease using WEICON Surface Cleaner). Smooth surfaces should be roughened, e.g. by sandblasting.

## Processing

WEICON Repair-Sticks cover gaps of max. 15 mm per procedure. The pot life given is for a material quantity of 25 g at room temperature. If larger quantities are used, the curing time will be faster due to the

typical reaction heat of epoxy resins (exothermic reaction).

Similarly, higher ambient temperatures shorten the cure time (as a rule of thumb, every +10°C increase above room temperature will halve working and curing time). Temperatures below +16°C will extend working and curing times considerably, while below about +5°C, no reaction will take place at all.

## Storage

When kept at a constant room temperature of about +20°C and unopened in dry conditions, WEICON Repair Sticks will keep for at least 18 months.

Avoid direct sunlight.

## Note

Any product specifications and recommendations given herein must not be seen as guaranteed product characteristics. They are based on our laboratory tests and on practical experience. Since individual application conditions are beyond our knowledge, control and responsibility, this information is provided without any obligation. We do warrant the continuously high quality of our products being free from defects in accordance with and subject to our General Sales Conditions. However, own adequate laboratory and practical tests to find out if the product in question meets the requested properties are recommended. A claim cannot be derived from them. The user bears the only responsibility for non-appropriate or other than specified applications.

## Health and Safety

When using WEICON products, the physical, safety technical, toxicological and ecological data and regulations in our EC safety data sheets ([www.weicon.com](http://www.weicon.com)) must be observed.

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