



845™ 2-PART REACTIVE ADHESIVE

Weld-On® 845™ is a tan*, low VOC, 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 140 °F / 60 °C). *Adhesive may have slight color change after cure.

Specially formulated for joining, fabricating and repairing PVC and CPVC pipe and fittings. It can also be used for bonding fiberglass, ABS, acrylic, FRP (fiberglass-reinforced plastic), concrete and other materials to themselves or to dissimilar materials.

- Applicable for joining very large sizes of plastic pipe and fittings with loose gaps.
- Excellent for fabrication of fittings, joining saddles to pipe, and repairing cracks or leaky pipe valves and fittings.
- Provides strong adhesion in peel, tensile or sheer applications.
- Not recommended for joints with interference fit or use on Ceramic, PTFE, Silicone, Polypropylene, Polyethylene and other Polyolefins.

PRODUCT SPECIFICATIONS

Adhesive usage	For joining, fabricating and repairing PVC and CPVC pipe and fittings. Also applicable for bonding fiberglass, ABS, acrylic, FRP (fiberglass-reinforced plastic), concrete and other materials to themselves or to dissimilar materials.
Color	Tan (pink when cured)
Resin	Acrylic
Approximate coverage	1.5 sq. ft. per 43 mL cartridge 15 sq. ft. per 400 mL cartridge <small>*Based on laboratory evaluation @ 20 mil thickness. This data is for reference only. Actual coverage may vary.</small>
Performance Specification	SCAQMD Rule 1168/316A
Brookfield Viscosity	Minimum 400,000 cps @ 73° ± 3.6°F
Specific Gravity	Component A: 1.089 ± 0.04 Component B: 1.327 ± 0.04
VOC Emissions	< 50 g/L
Shelf Life	1 Year (unopened cartridge) <small>Refrigerated storage is recommended.</small>
LEED Compliant	Credit can be earned per LEED® (Leadership in Energy and Environmental Design), IEQ Credit 4.1

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.
- Remove the cap/plug from the cartridge nozzle. Clear any obstructions inside the nozzle openings with a probe.
- Insert cartridge into the dispensing gun. Dispense a small amount of adhesive to make 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 inch of the adhesive prior to use.
- Once dispensed, the adhesive pot life is about 8 to 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 1 to 2 hours and reaches near ultimate strength in 24 hours at 70 °F (21 °C). Cure will be faster in warm weather, slower in cold weather.

⚠ WARNING: Cancer -www.P65Warnings.ca.gov

SPECIAL PRECAUTION

This product is designed to be used by expert people at their own risk. Installers must verify for themselves that they can make satisfactory joints under different conditions. It is strongly recommended that the installer review this product datasheet, application video, and instructions on the label prior to installation.

Please refer to the current safety data sheet for additional information on safety precautions, first aid, storage, handling, transport and disposal.

Storage temperature: 50 °F (10 °C) and 80 °F (27 °C). Keep away from heat sources, sunlight and humidity.

Please refer to the website for full terms and conditions.