

**GENERAL DESCRIPTION:**

WELD-ON® DUIT™ 425™ is a blue, low VOC emission, medium bodied, extremely fast setting, very high strength PVC solvent cement for all PVC electrical duct and conduit with interference fit through 8 inch (200 mm) diameter. Can be used with or without primer. Check your local code requirements.

**APPLICATION:**

WELD-ON DUIT 425 is for use on all PVC power and communication duct, conduit and any non-pressure PVC application. It can be used on rigid and flexible pipe and fittings.

**AVAILABILITY:**

This product is available in pint (473 ml), quart (946 ml) and gallon (3.785 l) metal cans. For detailed information on containers and applicators, see our current Price List.

**STANDARDS:**

- Meets SCAQMD Rule 1168/316A.
- Meets ASTM D2564.
- Meets National Electrical Manufacturers Association (NEMA) TC-2, TC-6 and TC-8.
- 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
- Suitable for use with PVC conduit and fittings that meet Underwriters Laboratories UL-651.

**SPECIFICATIONS:**

COLOR:	Blue
RESIN:	PVC
SPECIFIC GRAVITY:	0.926 @ 23°C (73°F)
BROOKFIELD VISCOSITY:	Minimum 500 cP @ 73° ± 2°F (23° ± 1°C)

**SHELF LIFE:**

3 years in tightly sealed containers. The date code of manufacture is stamped on the bottom of the container. Stability of the product is limited by the evaporation of the solvent when the container is opened. Evaporation of solvent will cause the cement to thicken and reduce its effectiveness. Adding of thinners to change viscosity is not recommended and may significantly change the properties of the cement.

**QUALITY ASSURANCE:**

WELD-ON DUIT 425 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 solvent cement.

**SPECIAL PRECAUTION:**

WELD-ON solvent cements must never be used in PVC piping systems using or being tested by compressed air or gases; including air-over-water booster.

Do not use a dry granular calcium hypochlorite as a disinfecting material for water purification in potable water piping systems. The introduction of granules or pellets of calcium hypochlorite with PVC solvent cements and primers (including their vapors) may result in a violent chemical reaction if a water solution is not used. It is advisable to purify lines by pumping chlorinated water into the piping system – this solution will be nonvolatile. Furthermore, dry granular calcium hypochlorite should not be stored or used near solvent cements and primers.

This product is intended for use by skilled individuals at their own risk. Installers should verify for themselves that they can make satisfactory joints under varying conditions. Detailed directions on making solvent cemented joints are printed on the container label. It is highly recommended that the installer review the instructions supplied by the pipe and fitting manufacturer.

**Refer to the current WELD-ON DUIT™ 425™ Safety Data Sheet for additional safety precautions, first-aid, handling, storage and transportation information.**

**WARRANTY:**

Weld-On Adhesives, Inc., warrants to all original purchasers of Weld-On products that all new Weld-On products shall be of good quality and free from defects in material and workmanship for the product's shelf life. If any Weld-On product becomes defective, or fails to conform to this written limited warranty under normal use and storage conditions, and if the original purchaser complies with the terms of this limited warranty, then Weld-On will, without charge, replace the nonconforming product.

This limited warranty shall extend to all products manufactured and sold by Weld-On. 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 provided herein.

Any defective Weld-On products shall be replaced pursuant to the terms of this limited warranty by returning the defective product, with transportation charges prepaid, to Weld-On at the following address:

Weld-On Adhesives, Inc.  
Attn: Customer Service  
455 West Victoria Street  
Compton, CA 90220

Any implied warranty in connection with any Weld-On product hereby is limited in duration to the period of this 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. This limited warranty is in lieu of all other express warranties of Weld-On, and Weld-On does not assume, nor does it authorize any person to assume on its behalf, any other obligation or liability.

