

845™

HIGH STRENGTH 2-PART REACTIVE ADHESIVE

Great for
underwater
repair



Weld-On® 845™ is a tan, two-part high strength, reactive adhesive for joining, fabricating and repairing fiberglass, PVC and CPVC pipe and fittings, as well as other dissimilar materials*.

STRONG BONDS

- Bonds fiberglass, PVC, CPVC, ABS, FRP (fiberglass reinforced polyester), concrete and other materials to themselves or to dissimilar materials
- Withstands pressure and large temperature range (-30° to 140°F)

VERSATILE

- May be used underwater
- Great for repairing cracks or leaky pipe valves and fittings
- Excellent gap filling properties; ideal for fabricating fittings and joining saddles to pipe
- Fast cure time

EASY TO USE

- Conveniently packaged in a dual cylinder cartridge, 4:1 mix ratio, for easy dispensing and application to the bonding surfaces
- Static mixing tip eliminates hand mixing

SPECIFICATIONS

Color:	Tan
Working Time:	10 Minutes
Cure Time:	20 Minutes
80% Strength:	1 Hour
Shelf Life:	1 Year @ 73°F or below

*Not recommended for use on ceramic, PTFE, silicone, polypropylene, polyethylene and other polyolefin.



845™ STARTER KIT (#12711)

PART NUMBER	DESCRIPTION	UNITS/CASE
12711	845™ STARTER KIT - CONTAINS 2-43ml CARTRIDGES, 1 MANUAL DISPENSER AND 6 MIXING TIPS	4
14094	845™ 43ml CARTRIDGE (4-PACK)	4
12709	845™ 43ml CARTRIDGE (12-PACK)	12
14077	MIXING TIPS (FOR 43ml CARTRIDGE)	12
12471	MANUAL DISPENSER (FOR 43ml CARTRIDGE)	1
12759	845™ 400ml CARTRIDGE	4
14040	MIXING TIPS (FOR 400ml CARTRIDGE)	10
14151	PLASTIC MANUAL DISPENSER (FOR 400ml CARTRIDGE)	1
14152	METAL FRAM MANUAL DISPENSER (FOR 400ml CARTRIDGE)	1

HIGH STRENGTH

VERSATILE

EASY TO USE

455 W. Victoria Street, Compton, CA 90220 • (800) 888-8312 • www.weldon.com

**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 140°F / 60°C). *Not recommended for use on ceramic, PTFE, silicone, polypropylene, polyethylene and other polyolefins.*

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

STANDARDS AND CERTIFICATION LISTINGS:

- 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.
- Meets SCAQMD Rule 1168/316A

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 the screw cap at the cartridge nozzle. Clear any obstructions inside the nozzle openings with a probe. Screw cap back onto cartridge nozzle.
- Insert cartridge into the dispensing gun. Re-open screw cap and 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 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.

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.



WARNING: This product can expose you to chemicals including N,N-Dimethyl-p-toluidine, which is known to the State of California to cause cancer. For more information go to www.P65Warnings.ca.gov.