

WELD-ON®



POOL & SPA PRODUCT GUIDE



All Low VOC · All the Time



OUR COMPANY

Established in 1954, IPS® Corporation has consistently grown over the past 60+ years. Today, we are the trusted leader in manufacturing solvent cements, adhesives, and components for the plumbing, construction and plastic fabrication industries. Our core brands include **WELD-ON®**, **WATER-TITE®**, **TEST-TITE®**, **GUY GRAY™**, **TRUEBRO®**, and **STUDOR®**. Our quality products are manufactured with proven formulation and design using state-of-the-art equipment and manufacturing techniques.

Headquartered in California, IPS Corp. has operations throughout the United States, as well as China, and a worldwide network of sales representatives and distributors.

OUR COMMITMENT

Weld-On is committed to our customers in all aspects of our operation and in all functions of our company:

Quality products – We are committed to manufacturing quality products for professionals. In fact, our California facility is ISO 9001: 2008 certified for its excellent quality management system. Our products are manufactured to the highest standards available and face stringent quality control tests prior to sale and distribution.

Excellent customer service – Our skilled team is readily available to help customers with product selection and ordering. We are experts in international shipping and our international customer service staff is certified in hazardous material shipment.

Professional technical service – Our technical specialists provide professional recommendations and product application/job-site installation training to suit the needs of our customers.

Expert R&D – Our research scientists and engineers have vast technical knowledge to develop the most technically advanced and innovative products to meet our customers' needs.



Our California facility takes pride in limiting volatile organic compound (VOC) emissions into the environment. Two regenerative thermo oxidizers are utilized to eliminate 99% of the VOC from our ventilation system before emitting air to the atmosphere.



Advanced automated filling and packaging lines of Weld-On products ensure fast, efficient and accurate completion of product orders.

WELD-ON® LOW VOC PVC CEMENTS FOR POOL & SPA APPLICATIONS

Weld-On is the original innovator of solvent cements, primers and cleaners for PVC, CPVC, and ABS plastic piping systems. Our name is globally recognized as the premium brand of products for joining plastic pipes and fittings. We are committed not only to providing the best product performance, but to do so in the **most environmentally responsible manner**. All solvent cements, primers and cleaners **meet the requirements for Low VOC (volatile organic compound) emission limits** established by the California South Coast Air Quality Management District (SCAQMD), one of the nation's strictest air quality regulatory bodies. Low VOC emissions contribute to cleaner air.

Weld-On® Pool & Spa series was developed to meet the professional needs of contractors in assembling PVC for pool and spa applications.

- High Quality Performance with excellent installation properties.
- User Friendly. Reduced fumes and odor for the comfort and well-being of pipe installers.
- Meets NSF/ANSI 14 and NSF/ANSI 64 Standards.
- Meets SCAQMD Rule 1168/316A – max VOC emission of 510 g/L for PVC solvent cement.
- Environmentally Responsible. LEED® Compliant (Leadership in Energy and Environmental Design). Credit can be gained through the use of Weld-On Low VOC products. This program, developed by the US Green Building Council, uses SCAQMD Rule 1168 as a benchmark for Low VOC products to earn one credit# toward LEED certification for green building.

#LEED Green Building Rating System For New Construction & Major Renovations Version 2.2 (Indoor Environmental Air Quality: EQ Credit 4.1 Low-Emitting Materials - Adhesives & Sealants)

WELD-ON® POOL & SPA CEMENTS AND PRIMER SELECTION GUIDE

	NOMINAL PIPE SIZE	in																			
		mm	1/2	3/4	1	1 1/4	1 1/2	2	2 1/2	3	4	6	8	10	12	14	24	30			
WELD-ON POOL & SPA PRODUCTS	PVC CEMENTS	REGULAR BODY	CLEAR	740		[Bar chart showing availability for sizes 1/2 to 30]															
			POOL REGULAR	[Bar chart showing availability for sizes 1/2 to 30]																	
		MEDIUM BODY	CLEAR	744†		[Bar chart showing availability for sizes 1/2 to 30]															
			GRAY	POOL MEDIUM		[Bar chart showing availability for sizes 1/2 to 30]															
		HEAVY BODY	CLEAR	746		[Bar chart showing availability for sizes 1/2 to 30]															
			GRAY	POOL HEAVY		[Bar chart showing availability for sizes 1/2 to 30]															
	SPECIALTY PRODUCTS	BLUE to CLEAR	747†		[Bar chart showing availability for sizes 1/2 to 30]																
		POOL 'R' SPA™	[Bar chart showing availability for sizes 1/2 to 30]																		
		BLUE to CLEAR	748†		[Bar chart showing availability for sizes 1/2 to 30]																
	POOL FAST™	[Bar chart showing availability for sizes 1/2 to 30]																			
	BLUE	798		[Bar chart showing availability for sizes 1/2 to 30]																	
	POOL FLEX™	[Bar chart showing availability for sizes 1/2 to 30]																			
PRIMER	PURPLE	Pool Primer		[Bar chart showing availability for sizes 1/2 to 30]																	
	CLEAR	[Bar chart showing availability for sizes 1/2 to 30]																			

PIPE FORMAT
















Schedule 40/PN3.2, PN4, PN6

Schedule 80/PN10, PN16

† Can be used without a primer on non-pressure systems with fittings having an interference fit (unless primer required by local code).

PVC POOL & SPA SOLVENT CEMENTS		Max Pipe Size (Interference Fit)	Set Time	Available Color	Industry Listing	Meets Following Performance Specification
	<p>740™ POOL REGULAR</p> <ul style="list-style-type: none"> Regular bodied cement for pool & spa applications. 	<ul style="list-style-type: none"> 4" (110 mm) PVC 	Fast	CLEAR	 PW-G/DWV/SW	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61
AVAILABLE SIZES		Gallon (#13550), Quart (#13551), Pint (#13552), 1/2 Pint (#13553), 1/4 Pint (#13652)				
	<p>744™ POOL MEDIUM</p> <ul style="list-style-type: none"> Medium bodied cement for pool & spa applications. Can be used without primer on non-pressure systems if local codes permit. 	<ul style="list-style-type: none"> 6" (160 mm) PVC 4" (110 mm) Schedule 80 PVC – PN 10 & 16 	Fast	CLEAR GRAY	 PW-G/DWV/SW US PW-G/DWV/SW (Gray Only)	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61 CSA B137.3 CSA B181.2
AVAILABLE SIZES		CLEAR: Gallon (#13554), Quart (#13555), Pint (#13556), 1/2 Pint (#13557), 1/4 Pint (#13653) GRAY: Gallon (#13558), Quart (#13559), Pint (#13560), 1/2 Pint (#13561)				
	<p>746™ POOL HEAVY</p> <ul style="list-style-type: none"> Heavy bodied cement for pool & spa applications. 	<ul style="list-style-type: none"> 12" (315 mm) PVC 18" (480 mm) PVC (non pressure applications) 	Medium	CLEAR GRAY	 PW-G/DWV/SW US PW-G/DWV/SW (Gray Only)	ASTM D 2564 CSA B137.3 CSA B181.2 NSF/ANSI 14 NSF/ANSI 61
AVAILABLE SIZES		CLEAR: Gallon (#13562), Quart (#13563), Pint (#13564), 1/2 Pint (#13565) GRAY: Gallon (#13566), Quart (#13567), Pint (#13568), 1/2 Pint (#13569)				



POOL & SPA SPECIALTY "BLUE" SOLVENT CEMENTS		Max Pipe Size (Interference Fit)	Set Time	Available Color	Industry Listing	Meets Following Performance Specification
	<p>747™ POOL 'R SPA™</p> <ul style="list-style-type: none"> Medium bodied premium PVC cement specially formulated for pool & spa applications. Ideal for wet or quick pressurization conditions. Blue cement fades to clear in sunlight. Can be used without primer on non-pressure systems if local codes permit. 	<ul style="list-style-type: none"> 6" (160 mm) PVC 4" (110 mm) Schedule 80 PVC – PN 10 & 16 Rigid and Flexible PVC 	Extremely Fast	BLUE to CLEAR	  	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61 CSA B45.10
AVAILABLE SIZES Gallon (#10851), Quart (#10852), Pint (#10853), ½ Pint (#10854), ¼ Pint (#10855)						
	<p>748™ POOL FAST™</p> <ul style="list-style-type: none"> Medium bodied high-strength and ultra fast setting cement; specially formulated for pool maintenance and repair. For wet or quick pressurization conditions. Blue cement fades to clear in sunlight. Can be used without primer on non-pressure systems if local codes permit. 	<ul style="list-style-type: none"> 6" (160 mm) PVC 4" (110 mm) Schedule 80 PVC – PN 10 & 16 Rigid and Flexible PVC 	Ultra Fast	BLUE to CLEAR	 	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61
AVAILABLE SIZES Gallon (#13655), Quart (#13342), Pint (#13343), ½ Pint (#13344), ¼ Pint (#13654)						
	<p>798™ POOL FLEX™</p> <ul style="list-style-type: none"> Medium bodied cement ideal for flexible PVC pool application. Forms flexible, strong joints. 	<ul style="list-style-type: none"> 6" (160 mm) PVC 4" (110 mm) Schedule 80 PVC – PN 10 & 16 Rigid and Flexible PVC 	Fast	BLUE	 	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61
AVAILABLE SIZES Gallon (#13345), Quart (#13346), Pint (#13347)						
PRIMERS & CLEANERS				Available Color	Industry Listing	Meet Following Performance Specification
	<p>POOL PRIMER™</p> <ul style="list-style-type: none"> Quality Low VOC primer essential for proper softening and preparation of PVC and CPVC pipe and fitting surfaces 			PURPLE CLEAR	 	ASTM F 656 NSF/ANSI 14 NSF/ANSI 61
AVAILABLE SIZES PURPLE: Gallon (#13570), Quart (#13571), Pint (#13572), ½ Pint (#13658), ¼ Pint (#13659) CLEAR: Gallon (#13574), Quart (#13575), Pint (#13576), ½ Pint (#13656), ¼ Pint (#13657)						
	<p>PC-64™ PRIMER/CLEANER</p> <ul style="list-style-type: none"> For cleaning and surface preparation of PVC and CPVC pipe and fittings before bonding with solvent cements. 			CLEAR PURPLE	–	–
AVAILABLE SIZES PURPLE: Gallon (#10871), Quart (#10872), Pint (#10873), ½ Pint (#10874), ¼ Pint (#10875) CLEAR: Quart (#12656)						
	<p>C-65™ CLEANER</p> <ul style="list-style-type: none"> For removal of oil and grease from the surfaces of PVC, CPVC, ABS and STYRENE pipe and fittings for bonding. Recommended for use before priming of pipe and fittings. 			CLEAR	–	–
AVAILABLE SIZES Gallon (#10200), Quart (#10201), Pint (#10202), ½ Pint (#10203), ¼ Pint (#10204)						


APPLICATORS & ACCESSORIES

Roll-A-Weld Rollers and Swabs

 <p>SuperSwab™ A sturdy easy-to-grip 4" swab for pipe diameter from 4" through 8". Adjustable length and dual cap design that fits quart and gallon containers. The swab tip is disposable and swab handle is reusable.</p> <p>Individual Pack (#14108), Bulk Pack (#14111), Replacement Swab Tip (#14109), Replacement Swab Tip Bulk Pack (#14112)</p>	 <p>7020 Jumbo Roll-A-Weld 7" roller for pipe diameters of 6" or larger; fits MT-648 gallon can and cements available in wide mouth cans. (#10008)</p>
 <p>3020 Roll-A-Weld 3" roller for pipe diameters from 3" through 6"; fits MT-653 empty quart triple tight neck can. (#10007)</p>	 <p>4020 4" swab for pipe diameters of 6" or larger; fits MT-648 empty gallon can and cements available in wide mouth cans. (#10009)</p>
 <p>6020 Roll-A-Weld 4" roller for pipe diameters from 3" through 8"; fits standard quart can as well as MT-651 empty quart can. (#11957)</p>	 <p>5020 4" swab for pipe diameters from 3" through 8"; fits standard quart can as well as MT-651 empty quart can. (#12071)</p> <p>8020 4" cotton swab with wire handle for use on pipe diameter 6" or larger. (#13360)</p>

APPLICATORS

Daubers

 <p>Can-Mate daubers Adjustable plastic applicator with telescoping stem to fit ½ pint, pint, and quart cans. Available in ½" (#12307), ¾" (#10832) and 1¼" (#10833) dauber sizes.</p>	<p>Cap daubers DH Daubers fit ¼ pint & ½ pint cans; DP daubers fit ½ pint & pint cans; DQ daubers fit quart cans. Available in ⅜", ½", ¾", and 1½" dauber sizes.</p> <p>AVAILABLE SIZES DH-38 (#13199) DP-50 (#10003) DP-75 (#10004) DP-150 (#10005) DQ-50 (#11831) DQ-75 (#12429) DQ-150 (#10006)</p>
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Brushes

 <p>PB-1 Plastic handle brush. Fits standard pint and quart cans. (#12121)</p>	 <p>CM BCP Can-Mate® Adjustable plastic handle. Natural bristle brush. Fits standard pint and quart cans. (#10963)</p>
 <p>CST-36 Cable Saw 36" cable saw with T-Handle for cutting plastic pipe through 8" diameters. (#12739)</p>	<p>Empty Metal Cans (dauber not included)</p> <p>AVAILABLE SIZES MT-648 Gallon can with 2⅞" neck (#10010) MT-651 Quart can with 1¾" neck (#10012) MT-653 Quart can with triple tight neck (paint style) (#10014) MT-654 Pint can with 1¾" neck (#10015)</p>
 <p>Can-Tote Cement & Primer Carrier For carrying quart and pint cans.</p> <p>6 pack (#14147) 24 pack (#12891)</p>	 <p>Professional Hand Cleaner An advanced hand cleaner in liquid and disposable wipe format for removing residual solvent cements (PVC, CPVC, ABS), primers & sealants. Also removes dirt, oil, grease and much more.</p> <p>PINT (#12752) WIPE (#12762)</p>
 <p>DEB-2 Deburring Tool For PVC, CPVC, ABS, PE & PB pipe from ½" through 2" IPS. (#12079)</p>	 <p>Mounted Power Beveling Tool For beveling the ends of small diameter plastic pipe (PVC, CPVC, ABS). Nominal pipe sizes ½" CTS - 3" IPS. (#12863)</p>

ACCESSORIES

PIPE THREAD SEALANTS

All Weld-On® pipe thread sealants are lead free, odor free, non-staining, applicable in a large temperature range, can be immediately pressurized, easy to clean and have a creamy texture that packs well between pipe threads for a better seal.

	Industry Listing	Pressure Rating (PSI)		Temperature Range	Color	Shelf-life
		Liquids	Gases			
 <p>All Seal™ MULTI-PURPOSE SEALANT</p> <ul style="list-style-type: none"> Slow drying, soft-setting formula allows ample time to work with pipe joints. Also easy for disassembly. Creamy, non-separating consistency provides excellent thread coverage. Product is grit-free to provide leak-proof seal on pipe threads. For sealing and lubricating all metal and plastic (ABS, PVC, CPVC, Polypropylene, & Nylon) piping systems carrying various materials.¹ Very low VOC content: 152 g/L. 	 	6,000	3,000	-50°F to 455°F	BEIGE	2 year
AVAILABLE SIZES Pint (#87670), 1/2 Pint (#87665), 1/4 Pint (#87660)						
 <p>Blue Seal™ INDUSTRIAL GRADE SEALANT</p> <ul style="list-style-type: none"> Heavy duty, grit-free formula. Excellent for industrial applications and pipe lines in high vibration environments. Contains finely homogenized PTFE particles for filling cracks and thread imperfections – ensuring a leak-proof seal. For sealing and lubricating all metal and plastic (ABS, PVC, CPVC, Polypropylene, & Nylon) piping systems carrying various materials.¹ Tested and approved for addition to the FBC System compatible program for use with FlowGuard Gold®, BlazeMaster®, and Corzan® CPVC plastic piping systems. No VOC content. 	  	10,000	3,000	-50°F to 455°F	BLUE	3 year
AVAILABLE SIZES Quart (#87695), Pint (#87690), 1/2 Pint (#87685)						
 <p>White Seal™ Plus MULTI-PURPOSE SEALANT WITH PTFE</p> <ul style="list-style-type: none"> Contains finely homogenized PTFE particles for filling cracks and thread imperfections – ensuring a leak-proof seal. Non-setting formula allows easy disassembly of joints without damage to pipe, fittings or threads. Protects threaded areas from rust and corrosion and prevents galling. For sealing and lubricating all metal and plastic (ABS, PVC, CPVC, Polypropylene, & Nylon) piping systems carrying various materials.¹ Tested and approved for addition to the FBC System compatible program for use with FlowGuard Gold®, BlazeMaster®, and Corzan® CPVC plastic piping systems. No VOC content. 	  	10,000	3,000	-50°F to 455°F	WHITE	3 year
AVAILABLE SIZES Quart (#87740), Pint (#87735), 1/2 Pint (#87730), 1/4 Pint (#87725)						
 <p>505 Key Tite™ METAL PIPE SEALANT</p> <ul style="list-style-type: none"> Special formulation seals and lubricates metal pipe joints as well as protects them from rusting and seizing. Applicable for all types of metal joints (threaded, flanged or gasketed). For sealing and lubricating all metal piping systems carrying various materials.² 	—	Dependent on pressure rating of the piping systems		-50°F to 450°F	GREEN	1 year
AVAILABLE SIZES Gallon (#10062), Quart (#10063), Pint (#10064), 1/2 Pint (#10068), 1/4 Pint (#10069)						

¹ All Seal, Blue Seal, and White Seal can be used on **metal and plastic** piping systems carrying: air & gases (compressed, manufactured or natural), ammonia, brine, acid (diluted), caustic alkalis (diluted), corrosives, freons, fuel (diesel, gasoline, jet fuel, and kerosene), oils, petroleum, propane, solvents, steam, sugar, and water. Not recommended for oxygen, fluorine, or liquid sodium systems.

² 505 Key Tite can be used on **metal** piping systems carrying: acids (diluted), air (compressed or gaseous), alcohols, alkalis (diluted), brine, caustics (diluted), gases (manufactured or natural), low pressure steam lines, sugar (liquid), and hot or cold water.

JOINT COMPOUNDS

In addition to our premium Weld-On® sealants, we also offer a cost-effective sealant alternative - our joint compounds. They are semi-solid, lead-free, non-toxic, and also provide effective seals to plumbing fixtures & drains, as well as pipe threads.



Soft Seal Plumber Putty

- For setting and sealing plumbing fixtures and drains. Will not harden, crack or crumble.
- Complies with Federal Specification TT-P-1536A.
- Lead-free, non-corrosive and stainless.
- 100% water-proof.

AVAILABLE SIZES: 5 LB. (#80105), 3 LB. (#80103), 14 Oz. (#80100)



Epoxy Putty Stick

- Quick hardening sealant/adhesive.
- Plugs, seals, patches or repairs most materials.
- Excellent for underwater repairs.
- Hardens in 20 minutes and cures in 1 hour.
- Non-toxic, safe for potable water line.

AVAILABLE SIZES: 4 Oz (#84055)



Pipe Stick Joint Compound

- Thread sealant for metal and plastic pipe.
- Prevents rust and corrosion allowing easier disassembly.
- Lead-free and non-toxic.

AVAILABLE SIZES: 1.3 Oz (#81255)



Thread Seal Tape

- Contains PTFE.
- Complies with MIL-T-27730A specifications.
- Available in various colors, widths and lengths.

AVAILABLE SIZES: 1/2" x 260" White (#80315), 1/2" x 520" White (#80310), 3/4" x 260" White (#87750), 3/4" x 520" White (#87755), 1" x 520" White (#87720), 1/2" x 260" Yellow Gas Line (#80320), 1/2" x 260" Pink Extra Duty (#80325)

REPAIR & FABRICATION ADHESIVE



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), metals, concrete and other materials to themselves or to dissimilar materials
- Withstands pressure and large temperature range (-30° to 200°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

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

Part Number	Description	#12711 - 845™ Starter kit
12711	845™ Starter kit - contains 2-43ml cartridges, 1 manual dispenser and 6 mixing tips	
14094	845™ 43ml cartridge (4-pack)	
12709	845™ 43ml cartridge (12-pack)	
14077	Mixing tips (for 43ml cartridge)	
12471	Manual dispenser (for 43ml cartridge)	
12759	845™ 400ml cartridge	
14040	Mixing tips (for 400ml cartridge)	
14151	Plastic manual dispenser (for 400ml cartridge)	
14152	Metal frame manual dispenser (for 400ml cartridge)	

WELD-ON® SOLVENT CEMENTS SET AND CURE TIMES

Average Initial Set Schedule For WELD-ON® PVC/CPVC Solvent Cements**

Temperature Range	Pipe Sizes ½" to 1¼" 20mm to 40mm	Pipe Sizes 1½" to 2" 50mm to 63mm	Pipe Sizes 2½" to 8" 75mm to 200mm	Pipe Sizes 10" to 15" 250mm to 380mm	Pipe Sizes 15"+ 380mm +
60°-100°F/16°-38°C	2 minutes	5 minutes	30 minutes	2 hours	4 hours
40°-60°F/5°-16°C	5 minutes	10 minutes	2 hours	8 hours	16 hours
0°-40°F/-18°-5°C	10 minutes	15 minutes	12 hours	24 hours	48 hours

Note: Initial set schedule is the necessary time to allow before the joint can be carefully handled. In damp or humid weather allow 50% more set time.

Average Joint Cure Schedule For WELD-ON PVC/CPVC Solvent Cements**

Relative Humidity 60% or Less	Pipe Sizes ½" to 1¼" 20mm to 40mm		Pipe Sizes 1½" to 2" 50mm to 63mm		Pipe Sizes 2½" to 8" 75mm to 200mm		Pipe Sizes 10" to 15" 250mm to 380mm	Pipe Sizes 15"+ 380mm +
	Temperature range during assembly and cure periods	up to 160 psi/ 11 Bar	160 to 370 psi/ 11 to 26 Bar	up to 160 psi/ 11 Bar	160 to 315 psi/ 11 to 22 Bar	up to 160 psi/ 11 Bar	160 to 315 psi/ 11 to 22 Bar	up to 100 psi/ 7 Bar
60°-100°F/16°-38°C	15 min	6 hrs	30 min	12 hrs	1½ hrs	24 hrs	48 hrs	72 hrs
40°-60°F/5°-16°C	20 min	12 hrs	45 min	24 hrs	4 hrs	48 hrs	96 hrs	6 days
0°-40°F/-18°-5°C	30 min	48 hrs	1 hour	96 hrs	72 hrs	8 days	8 days	14 days

Note: Joint cure schedule is the necessary time to allow before pressurizing system. In damp or humid weather allow 50% more cure time.

** These figures are estimates based on testing done under laboratory conditions. Field working conditions can vary significantly. This chart should be used as a general reference only.

Average Number of Joints/QUART (1Kg) of WELD-ON Cement*

Pipe Diameters	½"/ 20mm	¾"/ 25mm	1"/ 32mm	1½"/ 50mm	2"/ 63mm	3"/ 90mm	4"/ 110mm	6"/ 160mm	8"/ 200mm	10"/ 250mm	12"/ 315mm	15"/ 380mm	18"/ 450mm
Number of Joints	300	200	125	90	60	40	30	10	5	2-3	1-2	¾	½

Note - For Primer: Double the number of joints shown for cement.

* These figures are estimates based on our laboratory tests. Due to the many variables in the field, these figures should be used as a general guide only. **Note: 1 Joint = 1 Socket**

Pipe Size Equivalent Chart - Inches/Millimeters

in.	½"	¾"	1"	1¼"	1½"	2"	2½"	3"	4"	6"	8"	10"	12"	14"	18"	24"	30"
mm.	20	25	32	40	50	63	75	90	110	160	200	250	315	355	450	600	800



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Lit. #230126 ©2014 WELD-ON 04-2014 IC