

WELD-ON®

2023 PRODUCT GUIDE



THE WORLD'S MOST TRUSTED BOND

Choosing the most critical materials for the biggest projects in the world requires trust.

That's why the leading architects, planners, engineers, contractors and installers around the globe choose Weld-On.



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®**, **CHRISTY'S®**, **WATER-TITE**, **TEST-TITE®**, **AB&A™**, **GUY GRAY™**, **METACRYLICS®**, **ROOF TOP BLOX®**, **STUDOR®** and **TRUEBRO®**. Our quality products are manufactured with proven formulation and design using state-of-the-art equipment and manufacturing techniques.

Headquartered in California, **Weld-On**, a division of 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 based on comprehensive production and quality management system. Our products are manufactured to the highest standards available and face stringent quality control tests prior to sale and distribution.

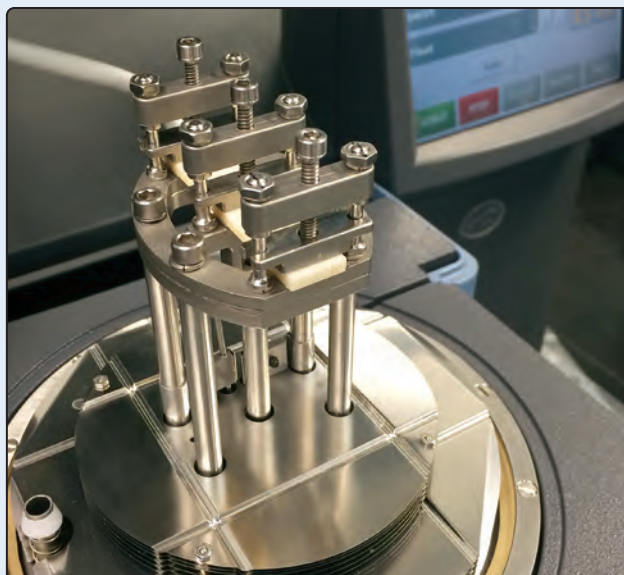
Excellent customer service – Our skilled team is readily available to help customers with product selection and ordering. We are experts in international shipping and our international customer service staff is certified in hazardous material shipment.

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.



Our laboratory is equipped with state-of-the-art equipment to ensure that our formulations and product performance meet the most stringent testing standards.

WELD-ON® SOLVENT CEMENTS, PRIMERS, AND CLEANERS

Weld-On is the original innovator of solvent cements, primers and cleaners for PVC, CPVC, and ABS plastic piping systems. Our **Weld-On** 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 **Weld-On** solvent cements, primers and cleaners **meet the most stringent requirements for 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 and all **Weld-On** solvent cements and primers meet 2023 SCAQMD Rule 1168 for the lowest VOC emission limits. **Weld-On** is proud to be the first in the industry to meet tomorrow’s regulations today.



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



All Weld-On products provide the following benefits:

- **High Quality Performance** with excellent installation properties.
- **User Friendly.** Reduced fumes and odor for the comfort and well-being of pipe installers.
- **NSF, UPC, and/or CSA Listed.** Products are qualified for use in applications such as potable water, turf, irrigation, pool, industrial, conduit, DWV and/or sewer.†
- **Meet ASTM Standards** for solvent cements and primers used for plastic pipe installation.‡
- **Environmentally Responsible.**

Weld-On solvent cements meet the stringent VOC content requirement per SCAQMD 1168. Credit can be earned per LEED® (Leadership in Energy and Environmental Design), IEQ Credit 4.1#.



**Current SCAQMD Rule 1168
Max VOC Content (gram/liter)***

Primer	550
PVC Solvent Cement	425
CPVC Solvent Cement	400
ABS Solvent Cement	325

†Refer to individual solvent cement and/or primer for specific ASTM Standards, NSF, UPC and/or CSA Listings.
 #LEED Indoor Environmental Air Quality 4.1: low-emitting materials – adhesives & sealant.
 *All Weld-On Cements and Primers meet SCAQMD Rule 1168 revised in 2023.



WELD-ON® SELECTION GUIDES

Choose the correct **Weld-On** products for your application based on the pipe diameter and material (PVC, CPVC, or ABS) being used. Refer to the following chart to find the product description on subsequent pages for further details.

NOMINAL PIPE SIZE		in	1/2	3/4	1	1 1/4	1 1/2	2	2 1/2	3	4	6	8	10	12	14	24	30
		mm	20	25	32	40	50	63	75	90	110	160	200	250	315	355	600	800
WELD-ON PVC PRODUCTS		PVC CEMENTS	COLOR	PRODUCT														
			CLEAR	700 ECO™	ECO™													
			CLEAR	700														
			CLEAR	710														
		MEDIUM BODY	CLEAR	704†														
			CLEAR	705 ECO™	ECO™													
			CLEAR	705†	INDUSTRIAL GRADE													
			BLUE	721 ECO™†	ECO™													
			BLUE	721†														
		HEAVY BODY	GRAY	711 ECO™	ECO™													
			GRAY	711	INDUSTRIAL GRADE													
			GRAY	717 ECO™	ECO™													
			CLEAR GRAY	717														
		EXTRA HEAVY BODY	GRAY WHITE	719	INDUSTRIAL GRADE													
		SPECIALTY CEMENTS	AQUA BLUE	725†														
			CLEAR	727†														
			BLUE	735														
			BLUE to CLEAR	737†														
			CLEAR	TURF 'N AG™														
			BLUE	795														
		POOL & SPA CEMENTS	CLEAR	740 ECO™	ECO™													
			CLEAR	740														
			CLEAR	744 ECO™	ECO™													
			CLEAR	744														
			GRAY	746 ECO™	ECO™													
			CLEAR GRAY	746														
			BLUE to CLEAR	747														
			BLUE to CLEAR	748 ECO™	ECO™													
			BLUE to CLEAR	748														

REGULAR BODIED CEMENT

for pipe size up to 4"

MEDIUM BODIED CEMENT

for pipe size 3" to 6"

HEAVY BODIED CEMENT

for pipe size 6" to 12"

EXTRA HEAVY BODIED CEMENT

for pipe size 12" to 30"

Weld-On solvent cements, primers and cleaning products have received UL GREENGUARD GOLD Certification. They have been tested and certified to meet some of the world's most rigorous, third-party chemical emissions to create improved indoor environments.



NOMINAL PIPE SIZE				in	1/2	3/4	1	1 1/4	1 1/2	2	2 1/2	3	4	6	8	10	12	14	24	30
				mm	20	25	32	40	50	63	75	90	110	160	200	250	315	355	600	800
CPVC CEMENTS	REGULAR BODY	ORANGE	713	CTS ONLY																
		YELLOW	FlowGuard [†] GOLD	CTS ONLY																
		ORANGE GRAY	714 ECO™	ECO™																
		ORANGE GRAY	714																	
		ORANGE GRAY	724 ^a	INDUSTRIAL GRADE																
		GRAY	729	INDUSTRIAL GRADE																
		EXTRA HEAVY BODY																		
ABS	MEDIUM BODY	MILKY	771	ALL CLASSES & SCHEDULES																
		BLACK	773	ALL CLASSES & SCHEDULES																
SPECIALTY	MEDIUM BODY	LIGHT AMBER	790 [*]																	
		GREEN	794 ^{**}	ALL CLASSES & SCHEDULES EXCEPT SCHEDULE 80																
PRIMERS & CLEANERS	MEDIUM BODY	PURPLE CLEAR	P-68 ECO™ PRIMER	ECO™																
		PURPLE CLEAR	P-68																	
		PURPLE CLEAR	P-70	INDUSTRIAL GRADE																
		AQUA BLUE	P-75																	
		PURPLE CLEAR	POOL PRIMER																	
		PURPLE CLEAR	PC-64 Primer-Conditioner																	
		CLEAR	C-65 Cleaner																	
		CLEAR	POOL CLEANER																	
		CLEAR																		
		CLEAR																		
NOMINAL PIPE SIZE				in	1/2	3/4	1	1 1/4	1 1/2	2	2 1/2	3	4	6	8	10	12	14	24	30
				mm	20	25	32	40	50	63	75	90	110	160	200	250	315	355	600	800

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).

[◇] For CPVC and PVC Chemical Piping Systems

^a FlowGuard Gold® is a registered trademark of the Lubrizol Corp.

^{*} PVC and CPVC

^{**} ABS to PVC Transition Joints

CTS Copper Tube Size



Weld-On continues to lead the industry in offering the widest selection of regulatory-compliant, environmentally-friendly ultra low VOC solvent cements and primers.



PVC SOLVENT CEMENTS			Max Pipe Size (Interference Fit)	Set Time	Available Color	Industry Listing	Meets Following Performance Specification
Regular Bodied		700 ECO™ PVC <div><div>ECO™</div><ul style="list-style-type: none">Maximum strength. Reduced odorous fumes for improved workplace environment.Excellent for irrigation, electrical conduit, pool & spa and plumbing, including PVC foam core pipe.</div>	<ul style="list-style-type: none">4" (110 mm) PVC2" (63 mm) Schedule 80 PVC	Fast	<div>CLEAR</div>	 PW-G/DWV / SW U.P. CODE	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61
	AVAILABLE SIZES Gallon (#14800), Quart (#14801), Pint (#14802)						
		700™ PVC <ul style="list-style-type: none">Excellent for irrigation, electrical conduit, pool & spa and plumbing, including PVC foam core pipe.	<ul style="list-style-type: none">4" (110 mm) PVC2" (63 mm) Schedule 80 PVC	Fast	<div>CLEAR</div>	  PW-G/DWV / SW	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61
AVAILABLE SIZES Gallon (#10078), Quart (#10079), Pint (#10080), ½ Pint (#10081), ¼ Pint (#10082)							
Medium Bodied		710™ PVC <ul style="list-style-type: none">Specially formulated for irrigation piping. Suitable for electrical conduit, pool & spa and plumbing, including PVC foam core pipe.	<ul style="list-style-type: none">2" (63 mm) PVC Not for Schedule 80	Very Fast	<div>CLEAR</div>	  PW-G/DWV / SW	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61
	AVAILABLE SIZES Gallon (#10111), Quart (#10112), Pint (#10113), ½ Pint (#10114), ¼ Pint (#10115)						
		704™ PVC <ul style="list-style-type: none">Quality formulation for irrigation, electrical conduit, pool & spa and plumbing, including PVC foam core pipe.Can be used without primer on non-pressure systems if local codes permit.	<ul style="list-style-type: none">6" (160 mm) PVC4" (110 mm) Schedule 80 PVC	Fast	<div>CLEAR</div>	  PW-G/DWV / SW	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61
AVAILABLE SIZES Gallon (#12122), Quart (#12123), Pint (#12124), ½ Pint (#12125), ¼ Pint (#12126)							
		705 ECO™ PVC <div><div>ECO™</div><ul style="list-style-type: none">Maximum strength. Reduced odorous fumes for improved workplace environment.For industrial, irrigation, DWV, electrical conduit, pool & spa and plumbing, including PVC foam core pipe.Can be used without primer on non-pressure systems if local codes permit.</div>	<ul style="list-style-type: none">6" (160 mm) PVC4" (110 mm) Schedule 80 PVC	Fast	<div>CLEAR</div>	 PW-G/DWV / SW U.P. CODE  C US PW-G/DWV / SW (Gray Only)	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61 CSA B137.3 CSA B181.2
	AVAILABLE SIZES Gallon (#14805), Quart (#14806), Pint (#14807)						
		705™ PVC <div><div>INDUSTRIAL GRADE</div><ul style="list-style-type: none">High-strength formula for industrial, irrigation, DWV, electrical conduit, pool & spa and plumbing, including PVC foam core pipe.Can be used without primer on non-pressure systems if local codes permit.</div>	<ul style="list-style-type: none">6" (160 mm) PVC4" (110 mm) Schedule 80 PVC	Fast	<div>CLEAR</div> <div>GRAY</div>	  PW-G/DWV / SW  C 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 (#10085), Quart (#10089), Pint (#10093), ½ Pint (#10097), ¼ Pint (#10100) GRAY: Gallon (#10086), Quart (#10090), Pint (#10094), ½ Pint (#10098), ¼ Pint (#10101)							
		721 ECO™ PVC <div><div>ECO™</div><ul style="list-style-type: none">Maximum strength. Reduced odorous fumes for improved workplace environment.Premium, high-strength formulation for irrigation, DWV, pool & spa and plumbing.Can be used without primer on non-pressure systems if local codes permit.</div>	<ul style="list-style-type: none">6" (160 mm) PVC4" (110 mm) Schedule 80 PVC	Fast	<div>BLUE</div>	 PW-G/DWV / SW U.P. CODE	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61
	AVAILABLE SIZES Gallon (#14927), Quart (#14928), Pint (#14929)						

PVC SOLVENT CEMENTS



721™ PVC

- Premium, high-strength formulation for irrigation, DWV, pool & spa and plumbing.
- Can be used without primer on non-pressure systems if local codes permit.

Max Pipe Size
(Interference Fit)

6" (160 mm) PVC
4" (110 mm) Schedule 80 PVC

Set Time

Fast

Available Color

BLUE



Meets Following Performance Specification

ASTM D 2564
NSF/ANSI 14
NSF/ANSI 61

AVAILABLE SIZES Gallon (#10160), Quart (#10161), Pint (#10162), ½ Pint (#10163), ¼ Pint (#10849)



711 ECO™ PVC

- Maximum strength. Reduced odorous fumes for improved workplace environment.
- For large diameter pressure piping systems.
- Good gap filling properties.
- Medium set allows for more working time in warm weather.



12" (315 mm) PVC all classes & schedules

Medium

GRAY



ASTM D 2564
NSF/ANSI 14
NSF/ANSI 61
CSA B137.3
CSA B181.2

AVAILABLE SIZES Gallon (#14834), Quart (#14835), Pint (#14836)



711™ PVC

INDUSTRIAL GRADE

- High-strength formula for large diameter pressure piping systems.
- Good gap filling properties.
- Medium set allows for more working time in warm weather.

12" (315 mm) PVC all classes & schedules

Medium

GRAY



ASTM D 2564
NSF/ANSI 14
NSF/ANSI 61
CSA B137.3
CSA B181.2

AVAILABLE SIZES Gallon (#10117), Quart (#10119), Pint (#10121), ½ Pint (#10123)



717 ECO™ PVC

- Maximum strength. Reduced odorous fumes for improved workplace environment.
- Quality formulation for plumbing, industrial, pool, irrigation and electrical piping systems.
- Good gap filling properties.
- Medium set allows for more working time in warm weather.



12" (315 mm) PVC all classes & schedules

Medium

CLEAR
GRAY



ASTM D 2564
NSF/ANSI 14
NSF/ANSI 61
CSA B137.3
CSA B181.2

AVAILABLE SIZES CLEAR: Quart (#14826), Pint (#14827) GRAY: Gallon (#14830), Quart (#14831), Pint (#14832)



717™ PVC

- Quality formulation for plumbing, industrial, pool, irrigation and electrical piping systems.
- Good gap filling properties.
- Medium set allows for more working time in warm weather.

12" (315 mm) PVC all classes & schedules

Medium

CLEAR
GRAY



ASTM D 2564
NSF/ANSI 14
NSF/ANSI 61
CSA B137.3
CSA B181.2

AVAILABLE SIZES CLEAR: Gallon (#10141), Quart (#10144), Pint (#10147), ½ Pint (#10150), ¼ Pint (#10861)
GRAY: Gallon (#10142), Quart (#10145), Pint (#10148), ½ Pint (#10151)



719™ PVC

INDUSTRIAL GRADE

- Premium, high-strength formulation for large size industrial piping systems.
- Ideal for fabrication of large fittings and applications requiring high gap filling properties.
- Suitable for irrigation, conduit, other pressure and non-pressure applications.

30" (800 mm) PVC all classes & schedules

Slow

WHITE
GRAY



ASTM D 2564
NSF/ANSI 14
NSF/ANSI 61
CSA B137.3
CSA B181.2

AVAILABLE SIZES WHITE: Gallon (#10155), Quart (#10157), Pint (#10159), 10.3 Oz (#12658) GRAY: Gallon (#13078), Quart (#10156)

PVC SPECIALTY SOLVENT CEMENTS



725™ WET 'R DRY™

- Premium formula for wet conditions and/or quick pressurization.
- Suitable for irrigation, plumbing, and pool & spa applications.
- Can be used without primer on non-pressure systems if local codes permit.

6" (160 mm) PVC
4" (110 mm) Schedule 80 PVC

Extremely Fast

AQUA BLUE



ASTM D 2564
NSF/ANSI 14
NSF/ANSI 61

AVAILABLE SIZES Gallon (#10164), Quart (#10165), Pint (#10166), ½ Pint (#10167), ¼ Pint (#10850)



727™ HOT 'R COLD™

- Premium formula for all weather conditions (-15°F to 110°F / -26°C to 43°C).
- Excellent for industrial, irrigation, electrical conduit, pool & spa and plumbing, including PVC foam core pipe.
- Can be used without primer on non-pressure systems if local codes permit.

6" (160 mm) PVC
4" (110 mm) Schedule 80 PVC

Very Fast

CLEAR



ASTM D 2564
NSF/ANSI 14
NSF/ANSI 61

AVAILABLE SIZES Gallon (#10840), Quart (#10841), Pint (#10842)



735™ Wet 'N Fast™

- Premium formula for wet conditions and/or quick pressurization.
- Suitable for plumbing, irrigation, and pool & spa applications.
- Can be used without primer on non-pressure systems if local codes permit.

8" (200 mm) PVC
4" (110 mm) Schedule 80 PVC

Very fast

BLUE











ASTM D 2564
NSF/ANSI 14
NSF/ANSI 61












AVAILABLE SIZES Gallon (#12494), Quart (#12495), Pint (#12496), ½ Pint (#12497), ¼ Pint (#12498)

Heavy Bodied

Extra Heavy Bodied

Medium Bodied

PVC SPECIALTY SOLVENT CEMENTS		Max Pipe Size (Interference Fit)	Set Time	Available Color	Industry Listing	Meets Following Performance Specification
Regular Bodied	 737™ TURF ‘N AG™ <ul style="list-style-type: none">This high quality blue cement has a slightly higher viscosity making it ideal for turf and agricultural applications and excellent for PVC well casing.Blue color fades to clear in sunlight for cleaner looking joints.Can be used without primer on non-pressure systems if local codes permit.	<ul style="list-style-type: none">8" (200 mm) PVC4" (110 mm) Schedule 80 PVC	Very fast			ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61
	AVAILABLE SIZES Gallon (#10988), Quart (#10989), Pint (#10990), ½ Pint (#11984), ¼ Pint (#11985)					
	 795™ PVC <ul style="list-style-type: none">Premium cement specially formulated for use on flexible and/or rigid PVC.Forms flexible high-strength joints.	<ul style="list-style-type: none">6" (160 mm) PVC3" (90 mm) Schedule 80 PVC	Fast			ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61
AVAILABLE SIZES CLEAR: Gallon (#10278), Quart (#10280), Pint (#10281), ½ Pint (#10282), ¼ Pint (#10283) BLUE: Gallon (#11727), Quart (#11905)						
CPVC SOLVENT CEMENTS						
Medium Bodied	 713™ CPVC <ul style="list-style-type: none">For potable water to 180°F (82°C).Suitable for residential plumbing and industrial systems.	<ul style="list-style-type: none">2" (63 mm) CPVC copper tube size	Fast			ASTM D 2846 ASTM F 493 NSF/ANSI 14 NSF/ANSI 61
	AVAILABLE SIZES Quart (#10126), Pint (#10127), ½ Pint (#10128), ¼ Pint (#10129)					
	 FlowGuard Gold® <ul style="list-style-type: none">ONE STEP CEMENT. Formulated to be used without primer if local codes permit.For potable water to 180°F (82°C).Suitable for residential plumbing and industrial systems.Approved by Lubrizol Advanced Materials, Inc. for use on FlowGuard Gold® Systems.	<ul style="list-style-type: none">2" (63 mm) CPVC copper tube size	Fast			ASTM D 2846 ASTM F 493 NSF/ANSI 14 NSF/ANSI 61 CSA B137.6
AVAILABLE SIZES Gallon (#11025), Quart (#11026), Pint (#11027), ½ Pint (#11028), ¼ Pint (#11029)						
Heavy Bodied	 714 ECO™ CPVC  <ul style="list-style-type: none">Maximum strength. Reduced odorous fumes for improved workplace environment.Suitable for cold and hot water applications up to 180°F (82°C), residential plumbing and industrial systems.Great gap filling properties.	<ul style="list-style-type: none">12" (315 mm) CPVC, all classes & schedules	Medium			ASTM D 2846 ASTM F 493 NSF/ANSI 14 NSF/ANSI 61
	AVAILABLE SIZES ORANGE: Quart (#15693), Pint (#15694) GRAY: Quart (#15695), Pint (#15696)					
	 714™ CPVC <ul style="list-style-type: none">Industrial quality for non-chemical applications up to 180°F (82°C).Approved for use on Corzan® CPVC piping systems.	<ul style="list-style-type: none">12" (315 mm) CPVC, all classes & schedules	Medium			ASTM D 2846 ASTM F 493 NSF/ANSI 14 NSF/ANSI 61
AVAILABLE SIZES ORANGE: Gallon (#10130), Quart (#10132), Pint (#10135), ½ Pint (#10137) GRAY: Quart (#10131), Pint (#10134)						
Extra Heavy Bodied	 724™ CPVC INDUSTRIAL GRADE <ul style="list-style-type: none">Premium, high-strength, chemical-resistant solvent cement for use with CPVC and PVC piping systems carrying acids, bases, salts, and hypochlorites.Approved for use on Corzan® CPVC piping systems.	<ul style="list-style-type: none">12" (315 mm) CPVC and PVC, all classes & schedules	Medium			ASTM F 493 NSF/ANSI 14 NSF/ANSI 61
	AVAILABLE SIZES ORANGE: Gallon (#12817), Quart (#12818), Pint (#13531) GRAY: Gallon (#12233), Quart (#11659), Pint (#11890)					
	 729™ CPVC INDUSTRIAL GRADE <ul style="list-style-type: none">Extra heavy body industrial quality cement for applications requiring high gap filling properties. Ideal for fabrication of large sized fittings.May be used for chemical applications.	<ul style="list-style-type: none">24" (600 mm) CPVC, all classes & schedules	Slow		—	ASTM F 493
AVAILABLE SIZES Gallon (#10844), Quart (#10845)						

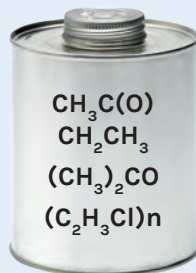
ABS SOLVENT CEMENTS		Max Pipe Size (Interference Fit)	Set Time	Available Color	Industry Listing	Meets Following Performance Specification	Medium Bodied
	771™ ABS ▪ For plumbing applications (DWV, sewer & drain pipe), conduit and foam core.	▪ 8" (200 mm) ABS	Fast	MILKY	 (Milky Only)  	ASTM D 2235 NSF/ANSI 14 CSA B181.1	
AVAILABLE SIZES MILKY: Gallon (#10230), Quart (#10232), Pint (#10233)							
	773™ ABS ▪ For plumbing applications (DWV, sewer & drain pipe), conduit and foam core.	▪ 8" (200 mm) ABS	Fast	BLACK	 	ASTM D 2235 NSF/ANSI 14	
AVAILABLE SIZES Gallon (#10241), Quart (#10243), Pint (#10244), ½ Pint (#10245), ¼ Pint (#10246)							
TRANSITION & SPECIALTY SOLVENT CEMENTS							
	790™ MULTI-PURPOSE ▪ High-strength multi-purpose cement for PVC and CPVC pipe and fittings.	▪ 6" (160 mm) ▪ 4" (110 mm) Schedule 80	Fast	LIGHT AMBER	—	—	Medium Bodied
AVAILABLE SIZES Gallon (#11248), Quart (#10257), Pint (#10258), ½ Pint (#10259), ¼ Pint (#10260)							
	794™ ABS - PVC ▪ For use only on ABS to PVC transition joints in non-pressure systems. ▪ Suitable for sewer, DWV and conduit.	▪ 6" (160 mm) Not for Schedule 80	Fast	GREEN	 	ASTM D 3138	
AVAILABLE SIZES Gallon (#10272), Quart (#10273), Pint (#10274), ½ Pint (#10275), ¼ Pint (#13369)							

COMMITMENT TO PRODUCT EXCELLENCE IN EVERY CAN

Weld-On is committed to developing top quality products for joining plastic piping systems.

Each Weld-On can is a result of:

Comprehensive R&D analysis to determine the optimal formulations for production.










Meticulous raw materials testing, sourcing and qualification conducted by Weld-On's R&D, procurement and quality control team.



Rigorous testing and certification per ASTM standards Tests, including lap shear, hydrostatic burst, dissolution, resin content, viscosity, etc. are carried out by Weld-On and independent accreditation organizations such as CSA, NSF International and IAPMO.

Manufactured under comprehensive production and quality management process

WELD-ON IS THE WORLD'S MOST TRUSTED BOND

PRIMERS & CLEANERS		Available Color	Industry Listing	Meet Following Performance Specification
	P-68 ECO™ PRIMER <ul style="list-style-type: none">▪ Reduced odorous fumes for improved workplace environment.▪ Quality primer essential for proper softening and preparation of PVC and CPVC pipe and fitting surfaces.	 <div>CLEAR</div> <div>PURPLE</div>	  C US U.P. CODE (Purple only)	ASTM F 656 NSF/ANSI 14 NSF/ANSI 61
AVAILABLE SIZES PURPLE: Gallon (#14843), Quart (#14844), Pint (#14845) CLEAR: Gallon (#14838), Quart (#14839), Pint (#14840)				
	P-68™ PRIMER <ul style="list-style-type: none">▪ Quality primer essential for proper softening and preparation of PVC and CPVC pipe and fitting surfaces.	<div>CLEAR</div> <div>PURPLE</div>	  PW-G/DWV / SW	ASTM F 656 NSF/ANSI 14 NSF/ANSI 61
AVAILABLE SIZES PURPLE: Gallon (#10208), Quart (#10210), Pint (#10212), ½ Pint (#10214), ¼ Pint (#10216) CLEAR: Gallon (#10207), Quart (#10209), Pint (#10211), ½ Pint (#10213), ¼ Pint (#10215)				
	P-70™ PRIMER INDUSTRIAL GRADE <ul style="list-style-type: none">▪ Premium industrial strength primer essential for proper softening and preparation of PVC and CPVC pipe and fitting surfaces.▪ Specially recommended for use on Schedule 80 (PN 10 and higher) and large size pipe.▪ Excellent for cold weather applications.	<div>CLEAR</div> <div>PURPLE</div>	  (Purple only) PW-G/DWV / SW	ASTM F 656 NSF/ANSI 14 NSF/ANSI 61
AVAILABLE SIZES PURPLE: Gallon (#10221), Quart (#10223), Pint (#10225), ½ Pint (#10227), ¼ Pint (#10229) CLEAR: Gallon (#10220), Quart (#10222), Pint (#10224), ½ Pint (#10226), ¼ Pint (#10228)				
	P-75™ PRIMER <ul style="list-style-type: none">▪ Premium, fast acting, industrial strength primer essential for proper softening and preparation of PVC and CPVC pipe and fitting surfaces.▪ Specially formulated for wet and/or quick set applications.	<div>AQUA BLUE</div>	 PW-G/DWV / SW	ASTM F 656 NSF/ANSI 14 NSF/ANSI 61
AVAILABLE SIZES Gallon (#10247), Quart (#10248), Pint (#10249), ½ Pint (#10250)				
	PC-64™ PRIMER/CONDITIONER <ul style="list-style-type: none">▪ For surface preparation of PVC and CPVC pipe and fittings before bonding with solvent cements.	<div>CLEAR</div> <div>PURPLE</div>	—	—
AVAILABLE SIZES PURPLE: Gallon (#10871), Quart (#10872), Pint (#10873) CLEAR: Quart (#12656)				
	C-65™ CLEANER <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.	<div>CLEAR</div>	—	—
AVAILABLE SIZES Gallon (#10200), Quart (#10201), Pint (#10202), ½ Pint (#10203), ¼ Pint (#10204)				

VOLUME EQUIVALENCE	
US UNIT	METRIC UNIT
Gallon	3.785 Liter
Quart	946 mL (milliliter)
Pint	473 mL
½ Pint	237 mL
¼ Pint	118 mL

PVC POOL & SPA SOLVENT CEMENTS		Max Pipe Size (Interference Fit)	Set Time	Available Color	Industry Listing	Meets Following Performance Specification
	740™ POOL REGULAR <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/DWW / SW	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61
	AVAILABLE SIZES 740: Gallon (#13550), Quart (#13551), Pint (#13552), ½ Pint (#13553) 740 ECO™: Quart (#14849)					
	744™ POOL MEDIUM <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 	Fast	CLEAR GRAY	 PW-G/DWW / SW US PW-G/DWW / SW (Gray Only)	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61 CSA B137.3 CSA B181.2
	AVAILABLE SIZES 744 CLEAR: Gallon (#13554), Quart (#13555), Pint (#13556), ½ Pint (#13557) 744 GRAY: Gallon (#13558), Quart (#13559) 744 ECO™ CLEAR: Quart (#14854)					
	746™ POOL HEAVY <ul style="list-style-type: none"> Heavy bodied cement for pool & spa applications. 	<ul style="list-style-type: none"> 12" (315 mm) PVC all classes & schedules 	Medium	CLEAR GRAY	 PW-G/DWW / SW US PW-G/DWW / SW (Gray Only)	ASTM D 2564 CSA B137.3 CSA B181.2 NSF/ANSI 14 NSF/ANSI 61
	AVAILABLE SIZES 746 CLEAR: Gallon (#13562), Quart (#13563) 746 GRAY: Gallon (#13566), Quart (#13567), Pint (#13568), ½ Pint (#13569) 746 ECO™ CLEAR: Quart (#14867)					
	747™ POOL 'R' SPA™ <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 for cleaner looking joints. 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 	Extremely Fast	BLUE to CLEAR	 PW-G/DWW / SW	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)					
	748™ POOL FAST™ <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 for cleaner looking joints. 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 	Ultra Fast	BLUE to CLEAR	 PW-G/DWW / SW	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61
	AVAILABLE SIZES 748: Gallon (#13655), Quart (#13342), Pint (#13343), ½ Pint (#13344) 748 ECO™: Quart (#14871)					

PVC POOL & SPA PRIMER & CLEANER			Available Color	Industry Listing	Meets Following Performance Specification
	POOL PRIMER™ <ul style="list-style-type: none"> Quality primer essential for proper softening and preparation of PVC and CPVC pipe and fitting surfaces in pool and spa applications. 		PURPLE CLEAR	 (Purple Only) PW-G/DWW / SW	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61
	AVAILABLE SIZES PURPLE: Gallon (#13570), Quart (#13571), Pint (#13572), ½ Pint (#13658) CLEAR: Gallon (#13574), Quart (#13575), Pint (#13576), ½ Pint (#13656)				
	POOL CLEANER™ <ul style="list-style-type: none"> For removal of oil and grease from the surfaces of PVC, CPVC, ABS in pool and spa applications. and STYRENE pipe and fittings for bonding. Recommended for use before priming of pipe and fittings. 		CLEAR	—	—
	AVAILABLE SIZES CLEAR: Gallon (#15917), Quart (#15918), Pint (#15919), ½ Pint (#15920)				

WELD-ON SOLVENT CEMENTS AND PRIMERS

Applicators



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.
Patent No. 8747004

Individual Pack (#14108), **Bulk Pack** (#14111), **Replacement Swab Tip Bulk Pack** (#14112)



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)



4020

4" swab for pipe diameters of 6" or larger; fits MT-648 empty gallon can and cements available in wide mouth cans. (#10009)



3020

Roll-A-Weld 3" roller for pipe diameters from 3" through 6"; fits MT-653 empty quart triple tight neck can. (#10007)



5020

4" swab for pipe diameters from 3" through 8"; fits standard quart can as well as MT-651 empty quart can. (#12071)



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)



8020

4" cotton swab with wire handle for use on pipe diameter 6" or larger. (#13360)



SuperDauber™

Fully adjustable, telescopic stem that fits quart, pint and 1/2 pint cans. Easy grip, ribbed handle allows better dauber control. Shed-resistant dauber material is better for smooth, full application of cement or primer. Available in 3/4" (#10832) and 1 1/4" (#10833) dauber sizes.



Cap Daubers

DH Daubers fit 1/4 pint & 1/2 pint cans; DP daubers fit 1/2 pint & pint cans; DQ daubers fit quart cans. Available in 3/8", 1/2", 3/4", and 1 1/2" dauber sizes.

AVAILABLE SIZES

DH-38	(#13199)	DP-50	(#10003)	DP-75	(#10004)
DP-150	(#10005)	DQ-50	(#11831)	DQ-75	(#12429)
DQ-150	(#10006)				



PB-1

Plastic handle brush.
Fits standard pint and quart cans. (#12121)

Accessories



Can-Tote Cement & Primer Carrier

For carrying quart and pint cans.

6 pack (#14147)
24 pack (#12891)



Easy Twist™

The Easy Twist™ is ergonomically designed to easily open the can in a simple twist without damaging the cap. When closing the can, the Easy Twist™ helps tighten and seal the cap with extra torque preventing solvent cements or primers from drying out. (#14550 8-pack)



Mounted Power Beveling Tool

For beveling the ends of small diameter plastic pipe (PVC, CPVC, ABS). Nominal pipe sizes 1/2" CTS - 3" IPS. (#12863)



Empty Metal Cans

(Caps not available for sale. Daubers sold separately.)

AVAILABLE SIZES

MT-648	Gallon can with 2 7/8" neck	(#10010)
MT-651	Quart can with 1 3/4" neck	(#10012)
MT-653	Quart can with triple tight neck (paint style)	(#10014)
MT-654	Pint can with 1 3/4" neck	(#10015)



Pipe and Fitting Pullers

For installation of large diameter plastic pipe and fittings (PVC, CPVC, ABS). Available for pipe and fittings sizes 4" - 12" diameter (#12816) and 14" - 20" diameter (#12815). Lightweight, durable and can easily be operated by one person.

SPECIALTY PRODUCTS




Weld-On® offers extensive specialty products to meet your plumbing needs.

- **Repair and fabrication adhesives** are great for repairing cracks, leaky pipe valves and fittings. These adhesives are also great for pipe fabrication because of their excellent gap-filling properties.
- **Weld-On® pipe thread sealant** product line is the best in the industry, sealing and lubricating metal and plastic pipe threads. These sealants work well on pipelines conveying various materials from compressed gas to corrosive liquids.
- **Joint compounds** set and seal plumbing fixtures, drains, as well as pipe threads.
- **Joint lubricants** are excellent for lubricating valves and gasketed joints.
- **Cutting oils** are used for cutting and threading ferrous and non-ferrous metal pipes.

Please refer to the individual product description for additional details.

REPAIR AND FABRICATION ADHESIVES

The following Weld-On adhesives have Low VOC emissions per SCAQMD Rule 1168. Use of these products can qualify for one credit in the LEED® Green Building Rating System - Indoor Environmental Quality.













		Applicable for use with	Viscosity	Set Time	Color	Shelf Life
	810™ <ul style="list-style-type: none"> ▪ Thick syrupy, two-component, high strength reactive adhesive. ▪ Product can withstand very high pressures and is high impact resistant. Great for repairing cracks or leaky pipe valves and fittings. ▪ Excellent gap-filling properties. Ideal for fabricating fittings and joining saddles to pipe. Good for bonding large diameter PVC and CPVC pipe and fittings. 	<ul style="list-style-type: none"> ▪ PVC ▪ ABS ▪ Acrylic ▪ Clay ▪ Concrete ▪ CPVC ▪ Styrene ▪ FRP (fiberglass-reinforced polyester) 	40,000 cps	1 hour	WHITE	1 year
AVAILABLE SIZES Gallon (#10810), Quart (#10811), Pint (#10812), 4 Oz (#10813)						
	811™ <ul style="list-style-type: none"> ▪ Thick syrupy, two-component, high strength reactive adhesive. Same formula as 810, but different packaging format. ▪ Product can withstand very high pressures and is high impact resistant. Great for repairing cracks or leaky pipe valves and fittings. ▪ Excellent gap-filling properties. Ideal for fabricating fittings and joining saddles to pipe. Good for bonding large diameter PVC and CPVC pipe and fittings. ▪ Conveniently packaged in a dual cylinder cartridge for easy dispensing and application to the bonding surfaces. ▪ See below for accessories. 	<ul style="list-style-type: none"> ▪ PVC ▪ ABS ▪ Acrylic ▪ Clay polyester) ▪ Concrete ▪ CPVC ▪ Styrene ▪ FRP (fiberglass-reinforced 	40,000 cps	1 hour	WHITE	1 year
AVAILABLE SIZES 470mL (#10985)						
	845™ <ul style="list-style-type: none"> ▪ Highly viscous, two-component, high strength, reactive adhesive. ▪ Product can withstand very high pressure and large temperature range (-30°F / -35°C to 140°F / 60°C). It is also impact resistant and can be used in wet conditions. ▪ Excellent gap-filling properties. Ideal for fabricating fittings and joining saddles to pipe. Good for bonding large diameter PVC and CPVC pipe and fittings. ▪ Conveniently packaged in a dual cylinder cartridge for easy dispensing and application to the bonding surfaces. ▪ See below for accessories. 	<ul style="list-style-type: none"> ▪ PVC ▪ ABS ▪ Acrylic ▪ Concrete ▪ CPVC ▪ Fiberglass ▪ FRP (fiberglass-reinforced polyester) 	400,000 cps	30 mins.	TAN	1 year
AVAILABLE SIZES 400mL (#12759), 43mL (#12709-12-pack), 43mL Starter Kit (#12711)						

ADHESIVE ACCESSORIES

	811 Dispensing gun and mixing tips <ul style="list-style-type: none"> ▪ Manual or pneumatic dispensing gun for convenient application of Weld-On 811 dual cartridge, high strength adhesive. ▪ Straight mixing tip provides even blending of the two adhesive components prior to application. 		845 Dispensing gun and mixing tips <ul style="list-style-type: none"> ▪ Manual or pneumatic dispensing gun for convenient application of Weld-On 845 dual cartridge, high strength adhesive. ▪ Straight mixing tip provides even blending of the two adhesive components prior to application.
AVAILABLE SIZES Manual gun (#14150) Mixing tip (#14080)		AVAILABLE SIZES 400mL: Metal frame manual gun (#14152) Mixing tip (#14040) 43mL: Manual gun (#12471), mixing tip (#14077)	

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) Liquids Gases		Temperature Range	Color	Shelf-life
	All Seal™ MULTI-PURPOSE SEALANT <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.¹Very low VOC content: 152 g/L.	 PW/DWW / SW 	6,000	3,000	-50°F to 455°F	BEIGE	2 years
AVAILABLE SIZES Pint (#87670), 1/2 Pint (#87665), 1/4 Pint (#87660)							
	Blue Seal™ INDUSTRIAL GRADE SEALANT <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.¹Tested 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.	 PW/DWW / SW  	10,000	3,000	-50°F to 455°F	BLUE	3 years
AVAILABLE SIZES Quart (#87695), Pint (#87690), 1/2 Pint (#87685)							
	White Seal™ Plus MULTI-PURPOSE SEALANT WITH PTFE <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.¹Tested 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.	 PW/DWW / SW  	10,000	3,000	-50°F to 455°F	WHITE	3 years
AVAILABLE SIZES Quart (#87740), Pint (#87735), 1/2 Pint (#87730), 1/4 Pint (#87725)							
	505 Key Tite™ METAL PIPE SEALANT <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	2 years	
AVAILABLE SIZES Gallon (#10062), Quart (#10063), Pint (#10064), 1/2 Pint (#10068)							

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

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" Pink Extra Duty (#80325)

JOINT LUBRICANTS

Weld-On joint lubricants are non-toxic, non-corrosive and can be easily washed out of piping systems.



EZ Flush Pipe Lubricant

- Applicable for joining all metal and plastic gasketed pipes.
- Lubricates slip-on or "O" ring type joints without harming rubber or plastic gaskets.
- Easily flushes out of piping system.
- Non-toxic and non-corrosive. No taste or odor.



PW/DWV/SW

AVAILABLE SIZES

5 Gallon (#87721), Gallon (#87719), Quart (#87718)



Seal Lube Gasket Lubricant

- Primes and lubricates slip-on or "O" ring type joints with rubber or synthetic rubber gaskets.
- Non-toxic and non-corrosive. No taste or odor.
- 100% water soluble.



PW

AVAILABLE SIZES

Gallon (#87715), Quart (#87710), Pint (#87705)

CUTTING OILS

Weld-On offers two types of cutting oil for use on metal pipe threading, cutting and other machines.



Light Cutting Oil

- For light duty manual or low rpm threading machines as well as for drilling, reaming and rolling machines using ferrous and non-ferrous metals.

AVAILABLE SIZES

Gallon (#80425), Quart (#80424)



Dark Cutting Oil

- High-grade oil blend.
- For medium to heavy duty cutting, threading, drilling, reaming and rolling machines using ferrous and non-ferrous metals.

AVAILABLE SIZES

Gallon (#80421), Quart (#80420)





SOLVENT CEMENTS SET/CURE TIMES AND APPLICATOR GUIDE

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

Temperature Range	Pipe Sizes				
	½" to 1¼" (20mm to 40mm)	1½" to 2" (50mm to 63mm)	2½" to 8" (75mm to 200mm)	10" to 15" (250mm to 380mm)	15"+ (380mm +)
60°-100°F/16o-38oC	2 minutes	5 minutes	30 minutes	2 hours	4 hours
40°-60°F/5o-16oC	5 minutes	10 minutes	2 hours	8 hours	16 hours
0°-40°F/-18o-5oC	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)	1½" to 2" (50mm to 63mm)	2½" to 8" (75mm to 200mm)	10" to 15" (250mm to 380mm)	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/16o-38oC	15 min	6 hrs	30 min	12 hrs	1½ hrs	24 hrs	48 hrs
40°-60°F/5o-16oC	20 min	12 hrs	45 min	24 hrs	4 hrs	48 hrs	96 hrs
0°-40°F/-18o-5oC	30 min	48 hrs	1 hour	96 hrs	72 hrs	8 days	8 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

WELD-ON APPLICATOR SELECTION GUIDE

Weld-On solvent cements are packaged with can-lid daubers: ¾" dauber on quarter pint and half pint cans and 1½" dauber on pint and quart cans. For proper solvent welding of pipe and fittings, the cement applicator **must** be no less than half the size of the pipe. See the following charts for applicator (daubers, swabs, and rollers) recommendations pertaining to pipe size.

DAUBERS	Pipe Diameters						
	¼"	½"	¾"	1"	1¼"	1½"	2"
⅜" Dauber	•	•	•				
½" Dauber			•	•			
¾" Dauber					•	•	
1½" Dauber							•
ROLLERS & SWABS			SIZE		FOR PIPE DIAMETERS		
3020			3" Roller		3"- 6"		
6020			4" Roller		3"- 8"		
7020			7" Roller		6"+		
4020			4" Swab		6"+		
5020			4" Swab		3"- 8"		
8020			4" Swab		6"+		
SuperSwab™			4" Swab		4"- 8"		

PRODUCT SHELF LIFE

Weld-On Products	Shelf-life	Weld-On Products	Shelf-life
Primers / Cleaners	3 years	CPVC Solvent Cement	2-3.5 years
PVC Solvent Cement	3-4 years	ABS Solvent Cement	3 years

* Refer to individual product for shelf-life detail.

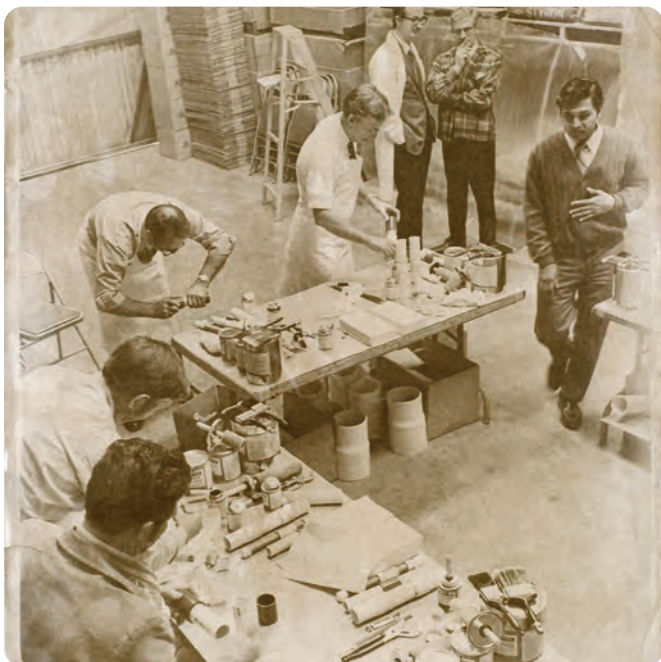
TECHNICAL TRAINING

Proper solvent welding of plastic pipe and fittings is the key to a long, trouble-free service life for your piping system. The cost of solvent cement and primer is less than 1% of the entire cost of a plastic piping system project. However, if this 1% is not correctly implemented and there is a pipe joint failure, the remaining 99% will not work.

Common causes of joint failure are:

- *Insufficient or over application of solvent cement*
- *Inadequate insertion of the pipe into fitting*
- *Lack of knowledge about proper solvent welding techniques*

Weld-On offers a manned, not pre-recorded, technical hotline to help answer questions about **Weld-On** products and techniques for solvent welding plastic pipe and fittings. We also offer a comprehensive technical training program covering the best practices of solvent welding technique based on ASTM D2855 standard as well as field practice – for FREE. Call our technical team to learn more and sign up at 1-877-477-8327.



circa 1960's





- Safer, low fume formula for installers
- Strongest bond - exceeds 1000 hour hydro-pressure test
- Meets the most stringent codes and regulations



ECO™ SERIES

your responsible choice

MAXIMUM STRENGTH

Weld-On's ECO Series solvent cement is formulated differently from other solvent cements on the market. The proprietary compounds in the ECO solvent cements are chemically unique, work differently to achieve greater bond strength in plastic pipe joints and do not use large amounts of strong solvents in the process.

Laboratory tests per ASTM D2564 standard specification for solvent cement for PVC plastic piping systems repeatedly showed that the ECO Series high-strength performance is comparable to top quality solvent cements currently on the market.

ULTRA LOW VOC

With minimal use of strong solvents, the VOC content of the ECO Series was significantly reduced to less than 414 grams / liter and some products as low as 361 grams / liter. The ultra low VOC content meets the 2023 SCAQMD Rule 1168 VOC limit. **Weld-On** is proud to be the first in the industry to meet tomorrow's regulation today.

BREATHE EASIER

An independent, certified industrial hygienist conducted a study of enclosed workplace exposure to different solvent cements. The result showed that the ECO Series has 30% less solvent emissions and significantly reduced odorous fumes versus leading products in the market. Now you and your crew can breathe a little easier while you work.

NOW AVAILABLE

We keep it simple. The ECO Series is named just like the current Weld-On PVC and CPVC solvent cements for PVC and CPVC piping systems 2" to 12" and has an "ECO" behind the name.

Choose your favorite product from the following:

✓ **700ECO**

✓ **717ECO**

✓ **705ECO**

✓ **721ECO**

✓ **711ECO**

✓ **P-68ECO Primer**

✓ **714ECO**

✓ **740ECO***

✓ **744ECO***

✓ **746ECO***

✓ **748ECO***

* Only available in Quarts

WELD-ON IS THE INDUSTRY LEADING, INNOVATIVE PLASTIC PIPE JOINING SOLUTIONS PROVIDER



455 W. Victoria Street, Compton, CA 90220 U.S.A.

Customer Service: 800.421.2677

www.weldon.com



Find out more about our affiliate brand at:

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