WELD-ON®

THE WORLD'S MOST TRUSTED BOND

CPVC Cements & Primers

Proven CPVC cements and primers for critical hot water, chemical transport and fire safety applications.

THE WORLD'S MOST 70+ YEARS TRUSTED BOND

WWW.WELDON.COM

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WELD·ON®

WORLD'S MOST TRUSTED BOND

Trust can't be compromised. Weld-On makes the planet's most reliable pipe joining products because failure is not an option.

For 70+ years, our products have proven to be unquestionably dependable in the biggest projects around the world—from the tallest skyscrapers to irrigation systems feeding families to high-tech factories and beyond.

OUR KEY INDUSTRIES ▶ INDUSTRIAL | IRRIGATION | POOL & SPA | CONSTRUCTION | FIRE SUPPRESSION

What defines us:

FAILPROOF PRODUCTS

Weld-On products are proven to perform under the most demanding conditions. Each product faces stringent quality control tests and is continuously evaluated in the field against rigorous requirements. We hold ourselves to nothing less than being completely reliable.

FIRST TO MARKET INNOVATORS

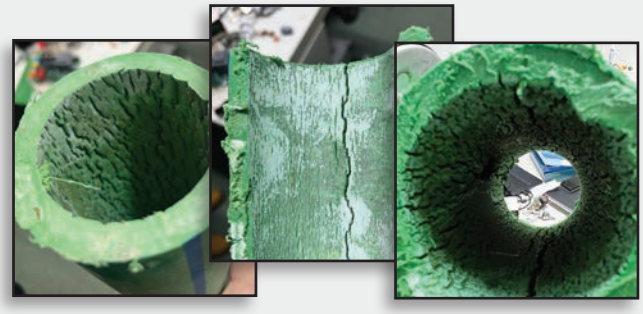
Expect forward-thinking products from Weld-On, the first company to pioneer solvent cement and the first to introduce environmentally responsible low VOC options. We continue to develop groundbreaking products to better suit our customers and their ever-changing needs, including regulatory compliance.

INDUSTRY EXPERTS

Rely on us for the most knowledgeable product recommendations, educational tools and training opportunities. From our technical team to our hazmat logistic specialists, we are here to support you with whatever you need so you can feel confident and increase productivity.

TECHNICAL HOTLINE
US: (877) 477-8327 | EU: 44 (191) 8202661

THE EFFECTS OF SODIUM HYPOCHLORITE ON CPVC AND PP-R PIPES



SODIUM HYPOCHLORITE ON CPVC AND PP-R PIPES CASE STUDY

CPVC is a stable, non-reactive material, making it highly resistant to hot, chlorinated water—as demonstrated in the image to the left. Remarkably, even after more than 20 years of use, the wall thickness remains unchanged.

What is Sodium Hypochlorite

Sodium hypochlorite (NaOCl) is a potent oxidizing agent commonly used in water treatment disinfection in certain parts of the world.

It is often found in household bleach and is used in municipal water supplies to control microbial contamination. However, it can also degrade certain plastics and polymer materials over time.

Chemical Interaction Between Sodium Hypochlorite and PPR Polypropylene Random Copolymer (PPR) pipes are sometimes used in plumbing systems for their durability and ability to withstand high temperatures.

PPR pipes are made of thermoplastic polymer with good chemical resistance under normal conditions. However, heat plays a crucial role in the reaction between sodium hypochlorite and PPR pipes. When PPR pipes are subjected to high temperatures, it can increase the oxidation rate, accelerating the breakdown of polymer chains and making the pipe more susceptible to chemical attack.

The heat may also create expansion and stress cracks, and in the presence of sodium hypochlorite, the material becomes more vulnerable to failure. PPR pipes are also more susceptible to faster chlorine diffusion, which increases the permeability of the pipe's surface, allowing chemicals like sodium hypochlorite to penetrate deeper and cause more extensive damage.

WHEN PPR PIPES DEGRADE DUE TO HEATED SODIUM HYPOCHLORITE EXPOSURE, SEVERAL PROBLEMS CAN OCCUR:

1. Structural Weakening – The oxidation process can break down polymer chains, making the material brittle and prone to cracking.

2. Surface Degradation – Prolonged exposure may cause discoloration, chalking, or roughening of the pipe's inner surface.

3. Loss of Mechanical Strength – The reduced molecular integrity of the polymer results in a decrease in impact resistance and flexibility.

Why Contractors Prefer CPVC for Sodium Hypochlorite Applications

CPVC pipes are specifically designed for high-temperature and chemically aggressive environments, making them the superior alternative to PPR in sodium hypochlorite environments. They have superior chemical resistance and a higher chlorine content than PPR, making them highly resistant to oxidation and degradation when exposed to sodium hypochlorite. Unlike PPR, which breaks down over time, CPVC maintains its integrity, ensuring a longer service life.

"Sodium hypochlorite (NaOCl) is a potent oxidizing agent that can also degrade certain plastics and polymer materials over time."

CPVC also performs better at higher temperatures (up to 93°C [200°F]) compared to PPR (70°C [158°F]), making it ideal for hot water systems using water treatment chemicals. It retains its structural integrity, reducing the risk of cracks and leaks, and it remains tough and impact-resistant, even after prolonged exposure to sodium hypochlorite.

On a molecular level, CPVC is less permeable to chemicals, preventing sodium hypochlorite from penetrating and weakening the material, which ensures a more consistent performance over time.

Lastly, contractors prefer CPVC because it does not degrade into harmful microplastics or release contaminants into the water, unlike deteriorating PPR pipes. This makes CPVC a safer, long-term solution for drinking water systems and other sanitary applications.

SOLVENT CEMENT VS HEAT WELDING
THE DIFFERENCES BETWEEN CPVC & POLYOLEFIN

THE BENEFITS OF CPVC AND SOLVENT WELDING

Before explaining the pros and cons of solvent cement and heat welding, it's important to understand the differences between the two materials and how they are used.

CPVC (Chlorinated Polyvinyl Chloride) pipe is a type of plastic piping that is stronger and more heat-resistant than standard PVC. It is made by adding chlorine to PVC, which improves its ability to handle higher temperatures and makes it more resistant to chemicals and corrosion. CPVC pipes are commonly used in hot and cold-water plumbing, industrial piping, and fire sprinkler systems. They are lightweight, easy to install, and provide a durable and cost-effective solution for many applications. These pipes are generally fused together using solvent cement that is applied to the surface.

Polyolefin is a type of plastic made from simple molecules called olefins, such as polyethylene (PE) and polypropylene (PP). These materials are lightweight, durable, and resistant to water, and wear, making them useful in many everyday products. Polyolefin-based pipes include PP-R, HDPE, and PEX. Because they have a smooth, low-energy surface, they don't easily stick to glues, so they are often joined using heat welding or special adhesives.

THE BENEFITS OF CPVC AND SOLVENT WELDING

The popularity of CPVC (chlorinated polyvinyl chloride) pipes is far greater than polyolefin pipes due to CPVC's durability and resistance properties. Joining CPVC pipes using solvent cement is proven to be
a reliable, easy to use, and as durable as the pipe itself.

- Ease of Use - One key advantage of CPVC solvent cement is its ease of application. Solvent cement is a relatively simple process that makes it more accessible for installers and reduces the need for extensive training.
- Strong Leak-Proof Joints - CPVC solvent cement softens the plastic surfaces and fuses them together, creating a strong, homogenous bond. This results in a durable connection that resists pressure, chemicals, and temperature changes.
- Cost and Efficiency - Solvent cementing only requires a brush or applicator and the cement itself, making it a more economical option over heat welding.
- CPVC Solvent Cement is More Versatile - It can be used in various applications, including plumbing, industrial piping, and chemical processing. Heat welding is often limited by the specific type of polyolefin and the conditions required for a proper bond.

PROS AND CONS OF HEAT WELDING POLYOLEFIN

Heat welding is currently the only method that can join polyolefin pipes. Heat welding requires machinery, electrical power and a skilled installer. While this method has several advantages, it also presents some challenges.

Pros of Heat Welding Polyolefin:

- Strong, Durable Bonds – Heat welding creates a seamless, high-strength joint, often stronger than adhesive or mechanical fasteners.
- No Need for Adhesives – Since polyolefins have low surface energy, adhesives often struggle to bond effectively. Heat welding circumvents this issue.
- Cost-Effective for Large-Scale Production – Once the equipment is set up, heat welding can be an efficient and economical process, especially for mass production.
- Environmentally Friendly – Unlike some adhesives, heat welding does not introduce additional chemicals, which can make it a cleaner process.

Cons of Heat Welding Polyolefin:

- Specialized Equipment Required – Heat welding polyolefins require specific tools, such as hot plate welders or ultrasonic welders, which can be costly.
- Skilled Labor Needed – The process demands precise temperature and pressure control to avoid weak joints or warping.
- Potential for Material Degradation – Excessive heat can degrade polyolefins, leading to weaker welds or aesthetic issues.
- Limited Flexibility in Some Applications – Once welded, the material loses some flexibility at the joint, which may not be ideal for applications requiring movement.

While heat welding can be an effective method for joining polyolefins, CPVC solvent cement is generally the better choice due to its ease of use, strong and reliable bonding, lower costs, and greater versatility. These advantages make it the preferred method in many industries where durable plastic connections are essential.

Weld-On 724: The World's Most Specified CPVC Solvent Cement

Weld-On 724 has been consistently used for the most critical applications. It has been specified in semi-conductor production, wastewater treatment facilities, and commercial construction projects across the globe.

Weld-On 724 is specifically formulated for joining CPVC and PVC industrial piping systems carrying corrosive chemicals. It is the most chemical resistant CPVC solvent cement in the industry.

Laboratory analysis showed no joint failure even after 1,000 hours of pressure tests in numerous chemical solutions.

Weld-On 724 is UPC and NSF PW-G / DWV / SW® listed, meets ASTM F 493 standard, and is approved for Corzan® industrial piping systems. It is used for CPVC and PVC pipe and fittings with interference fit up to 12 inches (315 mm) diameter, all classes & schedules. This cement is GreenGuard Gold certified by UL and can be used for LEED® Green Building credits.

There will be variables that will affect the chemical resistance of thermoplastic piping systems such as temperature, pressure, chemical concentration, and external stresses that may exist in the design and construction of the system. Be sure to take into consideration the specific use conditions that will apply to your project. The final decision to use CPVC or PVC piping should be based on in-service testing and evaluation by the responsible engineer and end-user. The use of Weld-On P-70 Purple Primer is recommended when installing CPVC and PVC piping systems for chemical applications.

Available in Orange, Gray and Clear

Rendimiento de alta resistencia. Cumple con ASTM F493 y el Código Uniforme de Plomería. Certificado por NSF International e IAPMO.

EN 14814
EN 14680
CE 24

NSF C US

UPC ®

GREENGUARD GOLD

UK CA

WRAS APPROVED MATERIAL

Weld-On 724

CHEMICAL RESISTANCE DATA

Weld-On commissioned an independent third-party laboratory to conduct chemical resistance tests on CPVC and PVC piping systems under controlled pressure and temperature conditions similar to those normally found in the chemical processing industry. The tests were conducted for continuous 1.000 hours with CPVC and PVC piping systems carrying a variety of chemical solutions. The resulting data conclusively showed no joint failure in all tests.

CPVC TEST DATA

All CPVC joints were solvent-welded with Weld-On 724. Test duration = 1,000 hours.

CHEMICAL		CONCENTRATION	TEMPERATURE °F (°C)	PRESSURE PSI (BARS)	HYDROSTATIC TESTING
Chromic Acid	H_2CrO_4	40%	180 (82)	100 (7)	No Failure
Ethylene Glycol	$HOCH_2CH_2OH$	100%	180 (82)	100 (7)	No Failure
Hydrochloric Acid	HCl	37%	180 (82)	100 (7)	No Failure
Nitric Acid	HNO_3	70%	180 (82)	100 (7)	No Failure
Propylene Glycol	$CH_3CHOHC_{H2}OH$	100%	180 (82)	100 (7)	No Failure
Sulfuric Acid	H_2SO_4	98%	180 (82)	100 (7)	No Failure
Water, distilled	H_2O	—	180 (82)	100 (7)	No Failure
Fluorosilicic Acid	H_2SiF_6	25%	180 (82)	100 (7)	No Failure
Hydrogen Peroxide	H_2O_2	35%	180 (82)	100 (7)	No Failure
Calcium Hypochlorite	Ca_2	70%	180 (82)	100 (7)	No Failure
Hydrofluoric Acid	HF	50%	140 (60)	100 (7)	No Failure

PVC TEST DATA

All PVC pipe joints were solvent-welded with WELD-ON 724. Test duration = 1,000 hours.

CHEMICAL		CONCENTRA-TION	TEMPERATURE °F (°C)	PRESSURE PSI (BARS)	HYDROSTATIC TESTING
Chromic Acid	H_2CrO_4	40%	140 (60)	100 (7)	No Failure
Ethylene Glycol	$HOCH_2CH_2OH$	100%	140 (60)	100 (7)	No Failure
Hydrochloric Acid	HCl	37%	140 (60)	100 (7)	No Failure
Nitric Acid	HNO_3	35%	140 (60)	100 (7)	No Failure
Propylene Glycol	$CH_3CHOHCH_2OH$	100%	140 (60)	100 (7)	No Failure
Sulfuric Acid	H_2SO_4	90%	140 (60)	100 (7)	No Failure
Water, distilled	H_2O	—	140 (60)	100 (7)	No Failure
Ammonium Hydroxide	H_2SiF_6	10%	140 (60)	100 (7)	No Failure
Fluorosilicic Acid	NH_4OH	25%	140 (60)	100 (7)	No Failure
Hydrogen Peroxide	$H2O_2$	35%	140 (60)	100 (7)	No Failure
Calcium Hypochlorite	Ca_2	70%	140 (60)	100 (7)	No Failure
Hydrofluoric Acid	HF	50%	140 (60)	100 (7)	No Failure

SPECIFICATION GUIDE FOR WELD-ON 724

CSI 3-Part Specification for WELD-ON® 724™ Low VOC Cement for CPVC and PVC Plastic Pipe

Specifier Note: The purpose of this guide specification language is to assist the specifier in correctly specifying solvent cement for CPVC and PVC plastic piping (WELD-ON 724™) for process piping applications. The specifier needs to edit the guide specifications to fit the needs of specific projects. Contact Weld-On to assist in making appropriate product selections. Throughout the guide specification, there are Specifier Notes to assist in the editing of the file.

The language provided is not adequate as a complete stand-alone specification section because it is an accessory product.

Recommended section numbers and titles where this information may be appropriately included are Section 40 05 13.73 - Plastic Process Piping; Section 40 23 00 - Water Process Piping or other process piping sections. Language that the specifier may elect to include in each of the 3-Parts has been provided. Article numbering is only for navigating this document and language should be incorporated into the appropriate Article heading in the desired section.

References have been made within the text of the specification to MasterFormat 2004 Section numbers and titles; specifier needs to coordinate these numbers and titles with sections included for the specific project.

Specifier Notes included in *(italicized blue text)* are included to provide assistance in selecting appropriate text for inclusion in a Specification. **[Bracketed Bold Text]** indicates a selection is required. Text in the brackets may not be the only options available, but are recommended or common selections.

PART 1— GENERAL

1.1 SECTION INCLUDES

A. (Accessory) Low VOC Solvent Cement for Process Piping

1.2 REFERENCES

A. ASTM International
   1. ASTM D 2855 Standard Practice for Making Solvent-Cemented Joints with Poly (Vinyl Chloride) (PVC) Pipe and Fittings
   2. ASTM F 493 Standard Specification for Solvent Cements for Chlorinated Poly (Vinyl Chloride) (CPVC) Plastic Pipe and Fittings.

B. NSF International/American National Standards Institute
   1. NSF/ANSI 14 Plastics Piping System Components and Related Materials
   2. NSF/ANSI 61 Drinking Water System Components - Health Effects

C. SCAQMD: South Coast Air Quality Management District
   1. SCAQMD Rule 1168/316A: Adhesive and Sealant Applications

1.3 SUBMITTALS

(Specifier Note: DELETE Submittal Procedures paragraph when not required, coordinate requirements with Division 01, Section 01 33 00 – Submittal Procedures.)

A. Refer to Section **[01 33 00 Submittal Procedures] [insert section number and title]**.

B. Product Data: Submit manufacturer current technical literature for each type of product, including installation instructions.

C. LEED Submittals:

1. Product Data for Credit **[IEQ 4.1] [EQ 4.1]**: For sealants, including printed statement of VOC content.

PART 2— PRODUCTS

(Specifier Note: Product information is proprietary to Weld-On. For Weld-On technical support, contact 877-477-8327.)

2.1 MANUFACTURER

A. Weld-On, PO Box 379, Gardena, CA 90248-0379; 310-898-3300; www.weldon.com

2.2 SOLVENT CEMENT

(Specifier Note: Product Information is proprietary to Weld-On. Weld-On recommends the use of WELD-ON® P-70 primer.)

A. Basis of Design - WELD-ON CPVC 724™

1. Characteristics:

a. Color: [Orange] [Gray]

b. Specific Gravity: 0.984 ± 0.040

c. Meets ASTM F 493 for use on potable water and chemical transport applications.

d. Conforms to NSF/ANSI 61- Drinking Water System Components - Health Effects.

e. VOC Content ≤ 490 g/l, applied as directed, per SCAQMD Rule 1168/316a.

f. Viscosity of 1600 cP @ 73 degrees ± 2 degrees F, minimum.

g. CPVC Resin Content: 10% minimum.

h. Cement capable of dissolving an additional 3% by weight, of CPVC 41 compound.

PART 3— EXECUTION

3.1 SOLVENT CEMENT APPLICATION

(Specifier Note: Manufacturer recommends the use of appropriate primer, prior to application of solvent cement.)

A. Comply with standard practices indicated in ASTM D 2855.

B. Apply heavy layer of solvent cement to pipe outside diameter surface.

C. Immediately after application to outside diameter surface, apply medium layer of solvent cement to fitting socket.

D. Assemble pipe and fitting while solvent cement is still wet.

E. Hold joint together as recommended by manufacturer.

F. Clean excess cement from pipe including bead around socket entrance.

G. Avoid disturbing joint during curing.

WELD-ON CPVC CEMENT & PRIMER FAMILY

CPVC SOLVENT CEMENTS		Max Pipe Size	Set Time	Available Color	Industry Listing	Meets Following Performance Specification
REGULAR BODIED	 **713™ CPVC** ▪ For residential plumbing and industrial systems. ▪ For potable water to 180°F (82°C).	▪ 2" (63 mm) CPVC copper tube size	Fast	Orange	NSF	ASTM D 2846 ASTM F 493 NSF/ANSI 14 NSF/ANSI 61
Heavy Bodied	 **714™ CPVC** ▪ Industrial quality for non-chemical applications up to 180°F (82°C). ▪ Approved for use on Corzan® CPVC piping systems	▪ 12" (315 mm) CPVC, all classes & schedules	MEDIUM	Gray Orange	NSF UPC	ASTM D 2846 ASTM F 493 NSF/ANSI 14 NSF/ANSI 61
Heavy Bodied	 **724™ CPVC** ▪ Premium, chemical-resistant, high-strength solvent cement for use with CPVC and PVC piping systems carrying acids, bases, salts, and hypochlorites. ▪ Approved for Corzan® CPVC piping systems.	▪ 12" (315 mm) CPVC, all classes & schedules	MEDIUM	Gray Orange	NSF UPC	ASTM F 493 NSF/ANSI 14 NSF/ANSI 61
EXTRA HEAVY BODIED	 **729™ CPVC** ▪ Extra heavy bodied industrial quality cement for ▪ applications requiring high gap filling properties. ▪ Ideal for fabrication of large sized fittings. ▪ May be used for chemical applications.	▪ 24" (600 mm) CPVC, all classes & schedules	Slow	Gray		ASTM F 493
Medium Bodied	 **500™ CPVC** ▪ Suitable for residential plumbing and industrial systems. ▪ ONE STEP CEMENT: Formulated to be used without primer if local codes permit. ▪ Approved for use on FlowGuard Gold® Systems.	▪ 2" (63 mm) CPVC copper tube size	Fast	Yellow	NSF UPC NSF	ASTM D 2846 ASTM F 493 NSF/ANSI 14 NSF/ANSI 61 CSA B137.6

CLEANERS & PRIMERS					
 **P-68 Primer** ▪ Essential for proper softening and preparation of PVC and CPVC pipe and fitting surfaces ▪ Code compliant, THF-free primer with 30% lower solvent emission rate and significantly reduced odorous fumes	N/A	Purple Clear	NSF UPC	ASTM F 656 NSF/ANSI 14 NSF/ANSI 61
 **P-70™ Primer** ▪ Premium, industrial strength primer essential for proper softening and preparation of PVC and CPVC pipe and fitting surfaces. ▪ Recommended for use on Schedule 80 (PN 10 and higher) and large size pipe. ▪ Excellent for cold weather applications.	N/A	Purple Clear	NSF UPC	ASTM F 656 NSF/ANSI 14 NSF/ANSI 61

Weld-On® 713™ CPVC

Weld-On® 713™ is an orange, ultra low VOC emission, regular bodied, fast setting, CPVC solvent cement for copper tube size and Schedule 40 CPVC pipe and fittings with interference fit through 2 inches (63 mm) diameter.

For potable cold and hot water up to 180°F (82°C). Suitable for residential plumbing, recreational vehicles, mobile homes and industrial systems.

- Ultra low VOC emissions. Meets SCAQMD Rule 1168/316A.
- GreenGuard Gold certified. Visit the UL Sustainable Database at www.spot.ul.com to find all the sustainable credits covered by UL GreenGuard Gold.
- High strength performance. Meets ASTM F493 and D2846. Certified by NSF International.

PW-G/DWV/SW
U.P. CODE

PRODUCT SPECIFICATIONS

Pipe type	Copper Tube Size & Sch. 40 CPVC
Cement Uses	For potable cold and hot water up to 180°F (82°C), residential and industrial systems.
Maximum Diameter	2 inches (63mm)
Color	Orange
Relative Set Time	Fast
Body	Regular Bodied
Performance Specification	ASTM F493 and D2846 SCAQMD Rule 1168/316A NSF/ANSI Standard 14 and 61 Uniform Plumbing Code
Brookfield Viscosity	Minimum 90 cps
Specific Gravity	0.934 ± 0.04
VOC Emissions	384 g/L
Shelf Life	2 Years
LEED Compliant	Credit can be earned per LEED® (Leadership in Energy and Environmental Design), IEQ Credit 4.1

SPECIAL PRECAUTION

Weld-On solvent cements must never be used in plastic piping system using or being tested by compressed air or gases; including air-over-water booster. Do not use in conjunction with flue gas ventilation systems.

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 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 Safety Data Sheet for additional safety precautions, first-aid, storage, handling, transportation and disposal information.

Refer to website for complete Terms and Conditions.

SHAKE WELL

IPS Corporation
455 W. Victoria St.,
Compton, CA 90220
(800) 888-8312

Weld-On® 714™ CPVC

Weld-On® 714™ is an orange or gray, ultra low VOC emission, heavy bodied, medium setting, CPVC solvent cement for all classes and schedules of CPVC pipe and fittings with interference fit through 12 inches (315 mm) diameter, including Schedule 80.

Industrial quality for cold and hot water systems and non-chemical applications up to 180°F (82°C). Approved for use on Corzan® CPVC piping systems.

- Ultra low VOC emissions. Meets SCAQMD Rule 1168/316A.
- GreenGuard Gold certified. Visit the UL Sustainable Database at www.spot.ul.com to find all the sustainable credits covered by UL GreenGuard Gold.
- High strength performance. Meets ASTM F493, D2846 and the Uniform Plumbing Code. Certified by NSF International and IAPMO.

PW-G/DWV/SW U.P. Code

Orange only

PRODUCT SPECIFICATIONS

Pipe type	All Rigid CPVC
Cement Uses	For cold and hot water systems and non-chemical applications up to 180°F (82°C).
Maximum Diameter	12" (315 mm)
Color	Orange or Gray
Relative Set Time	Medium Set
Body	Heavy Bodied
Performance Specification	ASTM F493 & D2846 SCAQMD Rule 1168/316A NSF/ANSI Standard 14 and 61 IAPMO Uniform Plumbing Code (orange only)
Brookfield Viscosity	Minimum 1,600 cps
Specific Gravity	0.978 ± 0.04 (both gray and orange)
VOC Emissions	393 g/L
Shelf Life	Orange: 3.5 years Gray: 2 Years
LEED Compliant	Credit can be earned per LEED® (Leadership in Energy and Environmental Design), IEQ Credit 4.1

IPS Corporation
455 W. Victoria St.,
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(800) 888-8312

WARNING: Cancer -www.P65Warnings.ca.gov

SPECIAL PRECAUTION

Weld-On solvent cements must never be used in plastic piping system using or being tested by compressed air or gases; including air-over-water booster. Do not use in conjunction with flue gas ventilation systems.

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 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.

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Refer to website for complete Terms and Conditions.

SHAKE WELL

Weld-On® 724™ CPVC

Weld-On® 724™ is an industrial grade, orange or gray, low VOC emission, heavy bodied, medium setting, CPVC solvent cement for all classes and schedules of pipe and fittings with interference fit, including Schedule 80 through 12 inches (315 mm) diameter.

Premium, high-strength, chemical-resistant solvent cement for use with CPVC piping systems carrying acids, bases, salts, and hypochlorites. Ideal for use in wastewater plants. May be used on PVC industrial piping systems for chemical applications. Approved for Corzan® CPVC piping systems.

- Low VOC emissions. Meets SCAQMD Rule 1168/316A.
- GreenGuard Gold certified. Visit the UL Sustainable Database at www.spot.ul.com to find all the sustainable credits covered by UL GreenGuard Gold.
- High strength performance. Meets ASTM F493 and the Uniform Plumbing Code. Certified by NSF International and IAPMO.

PW-G/DW/SW

PRODUCT SPECIFICATIONS

Pipe type	All Rigid CPVC and PVC
Cement Uses	For industrial CPVC and PVC piping systems with chemical applications
Maximum Diameter	12" (315 mm)
Color	Orange or Gray
Relative Set Time	Medium Set
Body	Heavy Bodied
Performance Specification	ASTM F493 SCAQMD Rule 1168/316A NSF/ANSI Standard 14 and 61 IAPMO Uniform Plumbing Code
Brookfield Viscosity	Minimum 1,600 cps
Specific Gravity	Gray 0.984 ± 0.04 Orange 0.982 ± 0.04
VOC Emissions	457 g/L
Shelf Life	2 Years
LEED Compliant	Credit can be earned per LEED® (Leadership in Energy and Environmental Design), IEQ Credit 4.1

Corzan® is a registered trademark of The Lubrizol Corporation.

WARNING: Cancer -www.P65Warnings.ca.gov

SPECIAL PRECAUTION

Weld-On solvent cements must never be used in plastic piping system using or being tested by compressed air or gases; including air-over-water booster. Do not use in conjunction with flue gas ventilation systems.

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 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 Safety Data Sheet for additional safety precautions, first-aid, storage, handling, transportation and disposal information.

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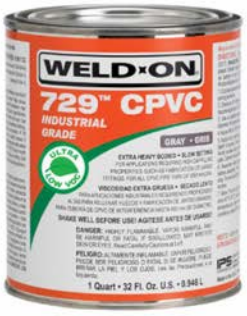


Weld-On® 729™ CPVC

Weld-On® 729™ is an industrial grade, gray, low VOC emission, extra heavy bodied, slow setting, CPVC solvent cement for all classes and schedules of industrial piping and duct with interference fit through 24 inches (600 mm) diameter.

Industrial quality cement for applications requiring high gap filling properties. Ideal for fabrication of large sized fittings. May be used for chemical applications.

- Low VOC emissions. Meets SCAQMD Rule 1168/316A.
- GreenGuard Gold certified. Visit the UL Sustainable Database at www.spot.ul.com to find all the sustainable credits covered by UL GreenGuard Gold.
- High strength performance. Meets ASTM F493.

PRODUCT SPECIFICATIONS

Pipe type	All Rigid CPVC
Cement Uses	For fabrication of large sized fittings and CPVC industrial applications requiring high gap filling properties. May be used for chemical applications.
Maximum Diameter	24" (600 mm)
Color	Gray
Relative Set Time	Slow Set
Body	Extra Heavy Bodied
Performance Specification	ASTM F493 SCAQMD Rule 1168/316A
Brookfield Viscosity	Minimum 8,000 cps
Specific Gravity	0.993 ± 0.04
VOC Emissions	451 g/L
Shelf Life	2 Years
LEED Compliant	Credit can be earned per LEED® (Leadership in Energy and Environmental Design), IEQ Credit 4.1

WARNING: Cancer -www.P65Warnings.ca.gov

SPECIAL PRECAUTION

Weld-On solvent cements must never be used in plastic piping system using or being tested by compressed air or gases; including air-over-water booster. Do not use in conjunction with flue gas ventilation systems.

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 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.

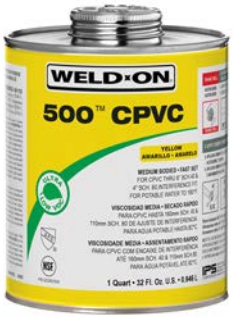
This product is intended for use by skilled individuals at their own risk. Installers should verify for themselves that they can make satisfactory joints under varying conditions. Detailed directions on making solvent cemented joints are printed on the container label. It is highly recommended that the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

Refer to the current Safety Data Sheet for additional safety precautions, first-aid, storage, handling, transportation and disposal information.

Refer to website for complete Terms and Conditions.

SHAKE WELL

IPS Corporation
455 W. Victoria St.,
Compton, CA 90220
(800) 888-8312



Weld-On® 500™ CPVC

Weld-On® FlowGuard Gold® (Amarillo) es un cemento solvente de CPVC amarillo, de ultra bajo COV, de viscosidad media, de fraguado rápido, para tuberías y accesorios de tamaño de tubo de cobre de CPVC con ajuste de interferencia a través de 2 pulgadas (63 mm) de diámetro.

CEMENTO DE UN PASO – formulado para ser utilizado sin imprimación si los Códigos lo permiten. Para agua potable a 180°F (82°C). Adecuado para fontanería residencial y sistemas industriales. Aprobado por Lubrizol Advanced Materials, Inc. para FlowGuard Gold® Systems.

- Ultra baja emisión de COV. Cumple con la regla 1168/316A del SCAQMD.
- Certificación GreenGuard Gold. Visite la base de datos sostenible de UL en www.spot.ul.com para encontrar todos los créditos sostenibles cubiertos por UL GreenGuard Gold.
- Rendimiento de alta resistencia. Cumple con ASTM F493, D2846 y el Código Uniforme de Plomería. Certificado por NSF International e IAPMO

PW-G/DWV/SW

FlowGuard Gold® es una marca registrada de The Lubrizol Corporation.

ESPECIFICACIONES DEL PRODUCTO

Tipo de tubería	Todo CPVC rígido, tamaño tubo de cobre
Usos del cemento	Para agua potable a 180°F (82°C). Adecuado para fontanería residencial y sistemas industriales.
Diámetro máximo	2" (63 mm)
Color	Amarillo
Tiempo de ajuste relativo	Rápido
Viscosidad	Media
Especificación de rendimiento	ASTM F493 & D2846 Reglamento 1168/316A del SCAQMD NSF/ANSI 14 y 61 Código Uniforme de Plomería IAPMO CSA B137.6
Brookfield Viscosidad	Mínimo 500 cps
Gravedad específica	0.977 ± 0.04
Emisiones de COV	377 g/L
Vida útil	2 años
El crédito compatible con LEED	Se puede obtener por LEED® (Liderazgo en Energía y Diseño Ambiental), Crédito IEQ 4.1

ADVERTENCIA: Cáncer -www.P65Warnings.ca.gov

PRECAUCIONES ESPECIALES

Los cementos solventes Weld-On nunca deben usarse en sistemas de tuberías de plástico que utilicen o estén siendo probados por aire comprimido o gases; incluyendo refuerzo de agua de aire. No utilizar junto con sistemas de ventilación de gases de combustión.

No utilice un hipoclorito de calcio granular seco como material desinfectante para la purificación del agua en sistemas de tuberías de agua potable. La introducción de gránulos o gránulos de hipoclorito de calcio con cementos solventes e imprimaciones (incluidos sus vapores) puede provocar una reacción química violenta si no se utiliza una solución acuosa. Es aconsejable purificar las líneas bombeando agua clorada al sistema de tuberías, esta solución no será volátil. Además, el hipoclorito de calcio granular seco no debe almacenarse ni usarse cerca de cementos solventes e imprimaciones.

Este producto está diseñado para ser utilizado por personas calificadas bajo su propio riesgo. Los instaladores deben verificar por sí mismos que pueden hacer uniones satisfactorias en condiciones variables. Las instrucciones detalladas sobre cómo hacer juntas cementadas con solvente están impresas en la etiqueta del contenedor. Se recomienda encarecidamente que el instalador revise las instrucciones suministradas por el fabricante de tuberías y accesorios.

Consulte la Hoja de datos de seguridad actual para obtener información adicional sobre primeros auxilios, almacenamiento, manipulación, transporte y eliminación de precauciones de seguridad.

Consulte el sitio web para ver los Términos y condiciones completos.

AGITE BIEN

IPS Corporation
455 W. Victoria St.,
Compton, CA 90220
(800) 888-8312

Weld-On® P-68 Primer

Weld-On Primer P-68 is a clear or purple, ultra-low VOC, fast acting primer that rapidly softens and dissolves the joining surfaces of PVC and CPVC pipe and fitting prior to the application of solvent cement. Available in clear for a clean appearance and purple to allow easy identification when used on joining surfaces.

- Ultra low VOC emissions. Meets SCAQMD Rule 1168/316A.
- GreenGuard Gold Certified. Visit UL Sustainable Database at www.spot.ul.com to find all sustainable credits covered by UL GreenGuard Gold.
- High-strength performance. Meets ASTM F656 and Uniform Plumbing Code. Certified by NSF International.

PRODUCT SPECIFICATIONS

Pipe Type	All rigid CPVC and PVC
Primer Use	Soften and dissolve the joining surfaces of PVC and CPVC pipe and fittings prior to the application of solvent cement
Maximum Diameter	N/A
Color	Clear or Purple
Relative Setting Time	N/A
Viscosity	N/A
Performance Specification	ASTM F656 SCAQMD Rule 1168/316A NSF/ANSI 14 and 61 Uniform Plumbing Code
Brookfield Viscosity	Water thin
Specific Gravity	0.857 ± 0.04
VOC emissions	398 g/L
Shelf life	3 years
LEED compliant credit	Credit can be earned per LEED® (Leadership in Energy and Environmental Design), IEQ Credit 4.1

NSF PW-G/DWV/SW

NSF PW-G/DWV/SW U.P. Code (Purple)

GREENGUARD

SPECIAL PRECAUTIONS

Weld-On solvent cements must never be used in plastic piping systems using or being tested for compressed air or gases; including air-over-water booster. Do not use in conjunction with flue gas ventilation systems.

Do not use a dry granular calcium hypochlorite as a disinfecting material for water purification in potable water piping systems. The introduction of calcium hypochlorite granules or pellets with solvent cements and primers (including their vapours) may cause a violent chemical reaction if an aqueous 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 reviews the instructions supplied by the pipe and fitting manufacturer.

Refer to the current Safety Data Sheet for additional safety precautions, first-aid, storage, handling, transportation and disposal information.

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IPS Corporation
455 W. Victoria St.,
Compton, CA 90220

Weld-On® P-70™

Weld-On® P-70™ primer is industrial grade, fast acting primer. Premium, industrial strength, ultra low VOC 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. Handle with care, will stain most materials and surfaces.

- Ultra low VOC emissions. Meets SCAQMD Rule 1168/316A.
- GreenGuard Gold certified. Visit the UL Sustainable Database at www.spot.ul.com to find all the sustainable credits covered by UL GreenGuard Gold.
- High strength performance. Meets ASTM F656 and the Uniform Plumbing Code. Certified by NSF International and IAPMO.

NSF PW-G/DW/SW UPC Purple only GREENGUARD

PRODUCT SPECIFICATIONS

Pipe type	All Rigid CPVC and PVC
Primer Use	Soften and dissolve the joining surfaces of PVC and CPVC pipe and fittings prior to the application of solvent cement
Color	Clear or Purple
Performance Specification	ASTM F656 SCAQMD Rule 1168/316A NSF/ANSI Standard 14 and 61 IAPMO Uniform Plumbing Code (Purple Only)
Brookfield Viscosity	Water-thin
Specific Gravity	0.858 ± 0.04 (both clear and purple)
VOC Emissions	452 g/L
Shelf Life	3 Years
LEED Compliant	Credit can be earned per LEED® (Leadership in Energy and Environmental Design), IEQ Credit 4.1

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

SPECIAL PRECAUTION

Weld-On solvent products must never be used in plastic piping system using or being tested by compressed air or gases; including air-over-water booster. Do not use in conjunction with flue gas ventilation systems.

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Storage temperature: 40°F (5°C) – 110°F (43°C)

Refer to website for complete Terms and Conditions.

WELD-ON®

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.

TECHNICAL HOTLINE

- US: (877) 477-8327
- EU: 44 (191) 8202661

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- WELDON.COM

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