

## Repair Stick Steel



**fast cure**  
**steel-filled**  
**NSF approval, can be used in drinking water areas**

It is particularly suited for the fast and high-strength repair and bonding of metal parts and for the patching and sealing of cracks, holes, and leaks in machine parts, tanks and pipelines, containers, pumps and housings, balcony railings, banisters, and torn-out threads.

The WEICON Repair Stick Steel can be used in machine and system construction, in tank construction and apparatus engineering, in the foods, cosmetic and pharmaceutical industries and in many other applications.



### Technical Data

Base	Epoxy resin steel-filled
Texture	pasty
Colour after curing	dark-grey
Mixing ratio by volume resin/hardener	1:1
Density of the mixture	2,0 g/cm <sup>3</sup>
Gap bridging max.	15 mm
Processing temperature	+10 to +35 °C
Curing temperature	+6 to +40 °C
Polt life for 25gr preparation and +20°C (+68°F)	4 min.
Handling strength (35% strength) after	10 min.
Capable of bearing mechanical loads (50% strength) after	60 min.
Final strength (100%) after	24 h
Pressure (DIN 53281-83)	80 N/mm <sup>2</sup>
Medium shear strength after 7 days at +20°C (+65°F) DIN EN 1465 at	Steel sandblasted: 4,1 N/mm <sup>2</sup>

### Note

The specifications and recommendations given in this technical data sheet must not be seen as guaranteed product characteristics. They are based on our laboratory tests and on practical experience. Since individual application conditions are beyond our knowledge, control and responsibility, this information is provided without any obligation. We do guarantee the continuously high quality of our products. However, own adequate laboratory and practical tests to find out if the product in question meets the requested properties are recommended. A claim cannot be derived from them. The user bears the only responsibility for non-appropriate or other than specified applications.

Shore hardness D	75
Thermal conductivity (ASTM D 257)	0,6 W/m-K
Linear shrinkage	<1 %
Electrical resistivity (ASTM D 149)	5•10 <sup>11</sup> Ohm/cm
Dielectric strength (ASTM D 149)	3,0 kV/mm
Thermal expansion coefficient (ISO 11359)	30-40 x 10 <sup>-6</sup> K <sup>-1</sup>
Temperature resistance	-50 to +120 briefly +150 °C
ISSA-Code	75.530.15/01
IMPA-Code	812925/26

### Surface pre-treatment

To ensure a perfect bond, the surfaces to be joined must be clean and dry (e.g., clean and degrease using WEICON Surface Cleaner).

### Processing

WEICON Repair Sticks cover gaps of max. 15 mm per procedure. The pot life given is for a material quantity of 25 g at room temperature. If larger quantities are used, the curing time will be faster due to the typical reaction heat of epoxy resins (exothermic reaction). Similarly, higher ambient temperatures shorten the cure time (as a rule of thumb, every +10°C increase above room temperature will halve working and curing time). Temperatures below +16°C will extend working and curing times considerably, while below about +5°C, no reaction will take place at all.

### Storage

When kept at a constant room temperature of about +20°C and unopened in dry conditions, WEICON Repair Sticks will keep for at least 18 months. Avoid direct sunlight.

### Safety and health

When using WEICON products, the physical, safety technical, toxicological and ecological data and regulations in our EC safety data sheets ([www.weicon.com](http://www.weicon.com)) must be observed.

### Available sizes:

10533057 Repair Stick Steel 57 g  
10533115 Repair Stick Steel 115 g