

**GENERAL DESCRIPTION:**

WELD-ON® 845™ is a tan (pink when cured), low VOC emission, high viscosity, two-component (4 to 1 mix ratio), high strength, reactive adhesive used for bonding a variety of materials. It has fast cure time, is impact resistant, can be used underwater and once cured, withstands very high pressure and large temperature range (-30°F / -35°C to 140°F / 60°C). **Not recommended for use on Ceramic, PTFE, Silicone, Polypropylene, Polyethylene and other Polyolefins.**

**APPLICATION:**

WELD-ON 845 is specially formulated for joining, fabricating and repairing PVC and CPVC pipe and fittings. It can also be used for bonding Fiberglass, ABS, Acrylic, FRP (fiberglass-reinforced plastic), concrete and other materials to themselves or to dissimilar materials. WELD-ON 845 is outstanding for joining very large sizes of plastic pipe and fittings with loose gaps. It also provides strong adhesion in peel, tensile or shear applications. Excellent for fabrication of fittings, joining saddles to pipe, and repairing cracks or leaky pipe valves and fittings. This product is not recommended for joints with interference fit.

**AVAILABILITY:**

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

**STANDARDS AND CERTIFICATION LISTINGS:**

- Meets SCAQMD Rule 1168
- Compliant with LEED® (Leadership in Energy and Environmental Design). When using this Weld-On low VOC product, credit can be claimed for LEED Green Building Rating System - Indoor Environmental Quality.

**SPECIFICATIONS:**

COLOR:	Tan (pink when cured)
RESIN:	Acrylic
SPECIFIC GRAVITY:	Component A = 1.089 ± 0.04 & Component B = 1.327 ± 0.04
BROOKFIELD VISCOSITY:	Minimum 400,000 cps @ 73° ± 3.6°F
APPROXIMATE COVERAGE:	1.5 sq. ft. per 43 ml cartridge* / 15 sq. ft. per 400 ml cartridge*

\*Based on laboratory evaluation @ 20 mil thickness. This data is for reference only. Actual coverage may vary.

**DIRECTIONS FOR USE:**

- Always wear safety glasses and polyethylene gloves. Use this product at room temperature.
- Wipe joining surfaces clean with a dry rag and/or with solvent cleaner. Do not soften surfaces with the solvent cleaner.
- Open the screw cap at the cartridge nozzle. Clear any obstructions inside the nozzle openings with a probe. Screw cap back onto cartridge nozzle.
- Insert cartridge into the dispensing gun. Re-open screw cap and dispense a small amount of adhesive making sure that both components flow freely from the cartridge nozzle.
- Attach a mixing tip and dispense approximately 1 to 2 inches to ensure both components of the adhesive are completely mixed before use. Note: the adhesive inside the mixing tip may cure if the tip is left on the cartridge for a prolonged duration without additional use. In this case, keep the mixing tip on the cartridge. When you are ready to dispense the adhesive again, replace the mixing tip. Dispense and discard the first few inches of the adhesive prior to use.
- Once dispensed, the adhesive pot life is about 8 to 10 minutes at 75°F (23°C). Working time is often shorter than the pot life. The adhesive initially cures to a hard gel in 1 to 2 hours and reaches near ultimate strength in 24 hours at 70°F (21°C). Cure will be faster in warm weather, slower in cold weather.

**SHELF LIFE:**

1 year in unopened cartridge when stored between 50°F (10°C) and 80°F (27°C). Keep away from sources of heat, sunlight and moisture. Refrigerator storage is recommended.

**QUALITY ASSURANCE:**

WELD-ON 845 is carefully evaluated to assure that consistent high quality is maintained. Fourier transform infrared spectroscopy, gas chromatography, and additional in depth testing ensures each batch is manufactured to exacting standards. A batch identification code is stamped on each can and assures traceability of all materials and processes used in manufacturing this product.

**IMPORTANT NOTE:**

This product is intended for use by skilled individuals at their own risk. These suggestions and data are based on information we believe to be reliable. Installers should verify for themselves that they can make satisfactory joints under varying conditions. Toward this end, it is highly desirable that they receive personal instruction from trained instructors or competent, experienced installers. Contact Weld-On or your supplier for additional information or instructions.



**Refer to the current WELD-ON 845™ GHS Safety Data Sheet for additional safety precautions, first-aid, handling, storage and transportation information.**

**WARRANTY:**

Weld-On Adhesives, Inc., warrants to all original purchasers of Weld-On products that all new Weld-On products shall be of good quality and free from defects in material and workmanship for the product's shelf life. If any Weld-On product becomes defective, or fails to conform to this written limited warranty under normal use and storage conditions, and if the original purchaser complies with the terms of this limited warranty, then Weld-On will, without charge, replace the nonconforming product.

This limited warranty shall extend to all products manufactured and sold by Weld-On. However, this limited warranty shall not extend to, nor shall Weld-On be responsible for, damages or loss resulting from accident, misuse, negligent use, improper application, or incorporation of Weld-On products into other products. In addition, any repackaging of Weld-On products also shall void the limited warranty provided herein.

Any defective Weld-On products shall be replaced pursuant to the terms of this limited warranty by returning the defective product, with transportation charges prepaid, to Weld-On at the following address:

Weld-On Adhesives, Inc.  
Attn: Customer Service  
455 West Victoria Street  
Compton, CA 90220

Any implied warranty in connection with any Weld-On product hereby is limited in duration to the period of this limited warranty. Weld-On shall not be responsible for, nor does this limited warranty extend to, consequential damage, or incidental damage or expense, including without limitation, injury to persons or property or loss of use. This limited warranty is in lieu of all other express warranties of Weld-On, and Weld-On does not assume, nor does it authorize any person to assume on its behalf, any other obligation or liability.