Epoxy Resin Systems
Plastic Metal

WEICON WAL04



pasty | mineral-filled | impact-resistant

The epoxy resin system WEICON WAL04 provides high wear protection and high abrasion resistance. It is chemical-resistant and has a high temperature resistance up to +230 °C; for a short period of time even up to +250 °C.

WEICON WAL04 is non-sagging, can be spread with a spatula. It can be applied on vertical surfaces and even overhead. It is suitable for the bonding or lining of aluminium oxide stones in mill construction, for the lining of heavily stressed pump housings, as wear protection for slide bearings, slides and pipes and wherever darker-coloured products are not suitable for optical reasons. The product can be used in machine and system construction, mill construction, apparatus engineering, and in many other industrial areas

Characteristics		
Base		Epoxy
Filler		mineral
Texture		pasty
Colour		white
Minimum shelf life	at room temperature	36 mon.
Processing		
Processing temperature		+15°C to +40°C
Component temperature		>3 °C above dew point
Relative air humidity		< 85 %
Mixing ratio by weight		100:25
Mixing ratio by volume		100:26
Viscosity of the mixture	at +25 °C	120.000 mPa·s
Density of the mixture		1,9 g/cm³
Consumption	Layer thickness 10 mm	1,9 kg/m²
Max. layer thickness	per step	10 mm

Curing		
Pot life	at 20 °C, 500 g batch	80 min.
Additional layer after	(35 % strength)	5 h
Working strength after	(80 % strength)	7 h
Final strength	(100 % strength)	24 h
Shrinkage		0,27 %
Mechanical properties after curing		
- Measured after curing at		24 h RT + 14 h +120 °C
Tensile strength	DIN EN ISO 527-2	54 MPa
Elongation at break (tensile)	DIN EN ISO 527-2	0,5 %
E-modulus (tensile)	DIN EN ISO 527-2	9.400-10.000 MPa
Compressive strength	DIN EN ISO 604	135 MPa
Bending strength	DIN EN ISO 178	89 MPa
Hardness (Shore D)	DIN ISO 7619	91±3
Adhesive strength	DIN EN ISO 4624	17,7 MPa
Taber Test	DIN ISO 9352 (H18, 1 kg, 1000 rotations)	1,5 g / 0,8 cm³
Lap shear strength material thickn. 1,5mm DIN EN 1465		
Steel 1.0338 sandblasted		12 MPa
Stainless steel V2A sandblasted		12 MPa
Aluminium sandblasted		8 MPa
Galvanized steel		2 MPa
Thermal parameters		
Temperature resistance		-35 to +230 °C, briefly up to +250 °C
Tg after curing at room temperature	(DSC)	~ +50 °C
Tg after tempering (at 120°C)	(DSC)	+107 °C
Heat deflection resistance	DIN EN ISO 75-2 (*after tempering)	+97* °C
Thermal conductivity	DIN EN ISO 22007-4	1,01 W/m·K
Heat capacity	DIN EN ISO 22007-4	0,98 kJ/KG·K
Electrical parameters		
Resistance	DIN EN 62631-3-1	$7 \cdot 10^{14}$ Ω·m
Magnetic		no
Approvals / Guidelines		
IMPA Code		812941/42

Instructions for use

When using WEICON products, the physical, safety-related, toxicological and ecological data and regulations in our EC safety data sheets (www.weicon.com) must be observed.

Surface pretreatment

The successful application of WEICON WAL04 depends on the thorough preparation of the surfaces. This is the most important factor for overall success. Dust, dirt, oil, grease, rust and moisture or wetness have a negative impact on the adhesion. Therefore, before processing WEICON WAL04, the following points must be observed: The areas to be bonded or repaired must be free of any oil, grease, dirt, rust, oxides, paint and other impurities or residues. For cleaning and degreasing, we recommend WEICON Cleaner Spray S.

Smooth and particularly heavily soiled surfaces should additionally be treated by mechanical surface pre-treatment, e.g. by grinding or preferably by blasting. In case of blasting,

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the surface should be brought to a degree of purity of SA 2 ½ - "Near White Blast Cleaning" (according to ISO 8501/1-2, NACE, SSPC, SIS). In order to achieve an optimum surface roughness of 75 - 100 µm, angular, disposable blasting media (aluminum oxide, corundum) should be used. The surface quality is negatively influenced by the use of reusable blasting media (slag, glass, quartz), but also by ice blasting. The air for blasting must be dry and oil-free. Metal parts that have come into contact with sea water or other salt solutions should first be rinsed thoroughly with demineralised water and, if possible, left to rest overnight so that all salts can be dissolved from the metal. Before each application of WEICON WAL04, a test for soluble salts should be carried out according to the Bresle method (DIN EN ISO 8502-6).

The maximum amount of soluble salts remaining on the substrate should not exceed 40 mg/m^2. Heating and repeated blasting of the surface may be necessary to remove all soluble salts and moisture.

After each mechanical pre-treatment, the surface should be cleaned again with WEICON Cleaner Spray S and protected from further contamination until the coating is applied.

Areas where no adhesion to the substrate is desired must be treated with silicone-free mould release agents. For smooth surfaces, we recommend WEICON Mould Release Agent Liquid F 1000 or, for porous surfaces, WEICON Mould Release Agent Wax P 500.

After the surface pre-treatment, WEICON WAL04 should be applied as soon as possible (within one hour) to avoid oxidation, flash rust or new contamination.

Mixing

First, stir the resin. Then mix the resin and hardener together thoroughly and bubble-free for at least four minutes at 20 °C (68 °F). The included processing spatula or a mechanical mixer, such as a mortar stirrer, can be used for this purpose. With mechanical mixers, a low speed of max. 500 rpm should be used. The components should be stirred until a homogeneous mixture is achieved. The mixing ratio of the two components must be strictly observed, as otherwise, strongly deviating physical values will result (max. deviation + /- 2 %). Only prepare a batch as large as can be processed within the pot life of 120 minutes. The specified pot life refers to a material batch of 500 g and 20 °C (68 °F) material temperature. Mixing larger quantities or higher processing temperatures will result in faster curing due to the typical reaction heat of epoxy resins.

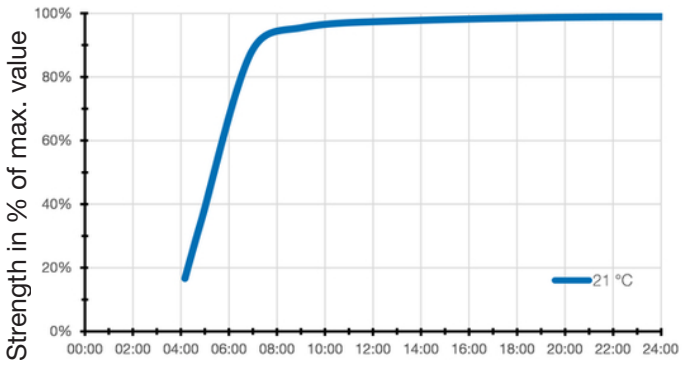
Apply

For processing, we recommend an ambient temperature of 20 °C (68 °F) at less than 85% relative humidity. For a thin pre-coat, work WEICON WAL04 intensively into the surface in crosswise layers using the Contour Spatula Flexy to achieve maximum adhesion By means of this technique, the epoxy resin penetrates well into all cracks and roughness depths. Afterwards, further applications can be carried out straight away, until the desired layer thickness is reached. Make sure that the epoxy resin is applied evenly and without air bubbles. To fill large gaps or holes, fibreglass, expanded metal or other mechanical fixing materials should be used. Finally, the surface can be smoothed easily with the help of a PE film and a rubber roller.

Curing

Final hardness is reached after 24 hours at 20 °C (68 °F) at the latest. At lower temperatures, the curing can be accelerated by evenly applying heat up to max. 40 °C (104 °F), e.g. with a heating pack, hot air blower or fan heater. Higher temperatures shorten the curing time. The following rule of thumb applies: Each increase by +10 °C (50 °F) above room temperature (20 °C/68 °F) will decrease the curing time by half. Temperatures below 16 °C (61 °F) increase the curing time, until at approx. 5 °C (41 °F) and below, almost no reaction will take place at all.

Increase in strength



Time in hours

Storage

WEICON Epoxy Resin Systems should be stored in a dry place at room temperature. Unopened containers can be stored at temperatures from +18 °C to +28 °C. Opened containers must be used up within 6 months.

Scope of delivery

Processing Spatula | Contour Spatula Flexy | Instructions for use | Gloves | Resin & Hardener

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Accessories

10000147	Cleaner Spray S, 500 ml, transparent
10000347	Cleaner S, 5 L, colourless, transparent
10024313	Surface Cleaner, 400 ml, transparent
10025288	Surface Cleaner, 5 L, transparent
10026647	Mould Release Agent Liquid F 1000, 250 ml, white, milky
10026712	Mould Release Agent Wax P 500, 150 g
10053995	Repair Stick Multi-Purpose, 115 g, vintage white
10000913	Glass Fibre Cloth Tape, 1 PCE, white
10010887	Processing Spatula short, 1 PCE
10022562	Processing Spatula long, 1 PCE
10016002	Pump Dispenser WPS 1500, 1 PCE
10039667	Cable Scissors No. 35, 1 PCE
10045523	Processing Kit, 1 PCE

Recommended equipment

Angle grinder
Blast machine
Heat pocket
Hot or fan heater
Smoothing trowel, spatula
PE film 0.2 mm
Fabric tape
Brush
Foam roller
Rubber roller
Lint-free cloth

Conversion table

(°C x 1.8) + 32 = °F
mm/25.4 = inch
µm/25.4 = mil
N x 0.225 = lb
N/mm^2 x 145 = psi
MPa x 145 = psi
Nm x 8.851 = lb·in
Nm x 0.738 = lb·ft
Nm x 141.62 = oz·in
mPa·s = cP
N/cm x 0.571 = lb/in
kV/mm x 25.4 = V/mil

Available sizes

10020990 WEICON WAL04, 2 kg, white

	WEICON A	WEICON B	WEICON BR	WEICON C	WEICON F	WEICON F2	WEICON HB 300	WEICON HT 111	WEICON SF	WEICON ST	WEICON TI	WEICON UW	WEICON WR2	WEICON HP	WEICON Fire Safe	WEICON Anti-Static	WEICON Food Grade	WEICON Anti-Stick	WEICON Ceramic BL	WEICON GL	WEICON GL-S	WEICON Ceramic W	WEICON Ceramic HC 220	WEICON WP	WEICON WR	WEICON CBC
Repair and moulding	x	x	x	x	x	x	x	x	x	x	x	x	x													
Adhesive				x	x		x	x		x				x	x											
Wear, erosion and corrosion protection – abrasion-resistant coating																x	x	x	x	x	x	x	x	x		
Casting, relining and gap compensation – casting and injecting potting compound	x					x							x												x	x

To the product detail page:

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Chemical resistance after curing* (Excerpt)

1,4-Dioxane	-	Glycol	+
Exhaust fumes	+	Uric acid	-
Adipic acid	-	Impregnating oils	+
Diethyl ether	+	Iodides (K, Na etc.)	-
aliphatic hydrocarbons	+	Potassium carbonate	+
Formic acid >10 % (methanoic acid)	-	Potassium hydroxide 0-20 % (caustic potash)	+
Ammonia anhydrous 25%	-	Milk of lime	+
Aniline	-	Phenol	-
aromatic hydrocarbons	+	Cresol	-
Barium hydroxide	+	Magnesium hydroxide	+
Benzoic acid	-	Maleic acid (cis-ethylenedicarboxylic acid)	-
Benzyl alcohol	-	Methanol (methyl alcohol) <85 %	o
Benzyl chloride	-	Methylene chloride	-
Boric acid	-	Mineral oil	+
Bromides	-	Naphthalene	+
Butadiene (1,3-)	-	Sodium bicarbonate (sodium hydrogen carbonate)	+
Butyric acid	-	Sodium carbonate (soda)	+
Butyl acetate	o	Sodium chloride (table salt)	+
Butyl alcohol	o	Nitrates	-
Calcium hydroxide (slaked lime)	+	Nitrobenzene	-
Chloroanilines	-	Oxalic acid <25 % (ethanedioic acid)	o
Chloroform (trichlormethane)	-	Perchloraethylene	-
Chlorosulphuric acid (wet and dry)	-	Kerosene	+
Chlorosilanes	-	Oils, vegetable and animal	+
Chlorinated water (swimming pool concentration)	-	Phosphoric acid <50%	+
Chromates (K, Na, etc.)	-	Phthalic acid, phthalic anhydride	-
Chromic acid	-	Nitric acid <5%	-
Cyanides (K, Na etc.)	-	Sulphur dioxide (wet and dry)	-
Cyclohexanone	-	Carbon disulphide	-
Mineral oil and mineral oil products	+	Sulphuric acid <5%	+
Acetic acid diluted <5%	o	Soap solution	+
Ethanol <85 % (ethyl alcohol)	o	Turpentine	+
Greases, oils and waxes	+	Carbon tetrachloride (tetrachloromethane)	-
Hydrofluoric acid	-	Tetralin (tetrahydronaphthalene)	-
Tannic acid diluted <7%	o	Trichloraethylene	-
Glycerin (trihydroxipropane)	+	Hydrogen peroxide <30 % (hydrogen superoxide)	o

+ = resistant 0 = for a limited time - = not resistant *The storage of all WEICON Plastic Metal types was carried out at +20°C chemical temperature.

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