

# Repair Stick Aqua -2025-



for underwater applications | ceramic-filled

Ideal for quick repairs on damp and wet surfaces and for underwater applications.

For the repair and sealing of cracks, holes and leaks in petrol and water tanks, radiators, electrical switchboards, sanitary installations and swimming pools.

The WEICON Repair Stick Aqua can be used in sanitary and heating system construction, electrical equipment, the maritime sector and many other industrial applications.

## Characteristics

Base	epoxy
Filler	ceramic
Texture	modelling compound
Colour	vintage white
Minimum shelf life	at room temperature 24 mon.

## Processing

Processing temperature	+15 °C (59 °F) to +40 °C (104 °F)
Component temperature	>3 °C above dew point
Cure temperature	+6 °C to +40 °C (+42 °F to +104 °F)
Mixing ratio by weight	1:1
Density of the mixture	1,9 g/cm <sup>3</sup>
Gap bridging up to max.	15 mm

## Curing

Pot life	at 20 °C, 10 g batch	25 min.
Handling strength	(35 % strength)	30 min.
Working strength after	(80 % strength)	60 min.
Final strength	(100 % strength)	24 h
Shrinkage		<1,0 %

## Mechanical properties after curing

Compressive strength	DIN EN ISO 604	55 MPa
Hardness (Shore D)	DIN ISO 7619	70±3
Adhesive strength	DIN EN ISO 4624	5 MPa

## Thermal parameters

Temperature resistance	-50°C (-58°F) to +120°C (248°F), briefly up to +150°C (302°F).	
Thermal conductivity	DIN EN ISO 22007-4	0,5 W/m·K

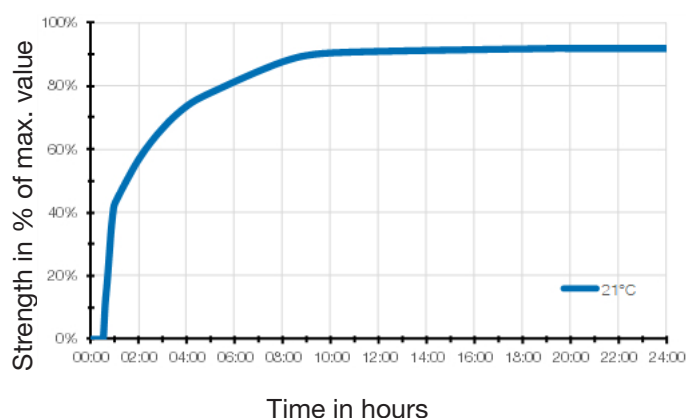
## Electrical parameters

Resistance	DIN EN 62631-3-1	~ 5·10 <sup>11</sup> Ω·m
Electrical resistance	ASTM D 257	5 Ω·cm
Dielectric strength		3,0 kV/mm
Magnetic		no

## Approvals / Guidelines

ISSA Code	75.530.02/03
IMPA Code	812923/24

## Increase in strength



## 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](http://www.weicon.com)) must be observed.

## Surface Pre-Treatment

The successful application of WEICON Repair Sticks depends on the careful preparation of the surfaces. Dust, dirt, oil, grease, residues, rust, moisture or dampness have a negative impact on adhesion. Best results are achieved with application on clean, solid and thoroughly roughened surfaces.

Surfaces must be clean, dry and free of grease. Almost all surface contaminants, such as old paint residues, oil, grease, dust and dirt, can be removed with WEICON Surface Cleaner or WEICON Sealant and Adhesive Remover. On surfaces that are extremely dirty or smooth, the adhesion can be improved by mechanical roughening with coarse abrasives.

After mechanical pre-treatment, the surface should be cleaned again with WEICON Surface Cleaner.

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### Application

We recommend an ambient temperature of 20°C (68°F) with less than 85% relative humidity for processing. Only prepare a batch as large as can be processed within the pot life. The pot life and curing time indicated refer to a material batch of 10 g at room temperature. With larger batch sizes or higher processing temperatures, the curing process is faster due to the typical reaction heat of epoxy resins (exothermic reaction).

Twist off or cut off the required amount from the Repair Stick. The components should be mixed together until a homogeneous mixture and colour is achieved. If necessary, the putty can be warmed to room temperature to facilitate mixing.

Work the thoroughly kneaded Repair Stick into the cracks and holes to be filled, and wipe off any excess material before it hardens. To achieve a smooth surface, the material can be smoothed with water or a damp cloth before it hardens. The curing process can be accelerated by heating the Repair Stick or by applying it to a warm surface. After approx. 60 minutes at room temperature, the repaired area is mechanically stable and can be threaded, drilled or sanded.

WEICON Repair Sticks can bridge a gap of up to 15 mm per application.



### Curing

The specified final hardness refers to curing at 20°C (68°F). At lower temperatures, the curing process can be accelerated by evenly applying heat up to max. 40°C (104°F), e.g. with

heat pockets, hot air or fan heaters. Higher temperatures also reduce the pot life and 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 pot life and curing time by half. Temperatures below +16°C (61°F) increase the pot life and curing time, until at approx. +5°C (41°F) and below, almost no reaction will take place at all.

### Storage

Store in unopened original container at constant room temperature in a dry place. Avoid sources of heat and both direct and indirect sunlight. Once opened, the shelf life is reduced.

### Scope of delivery

Adhesive

### Accessories

- 10024313 Surface Cleaner, 400 ml, transparent
- 10026705 Sealant and Adhesive Remover, 400 ml, pink

### Conversion table

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$	$\text{Nm} \times 8.851 = \text{lb}\cdot\text{in}$
$\text{mm}/25.4 = \text{inch}$	$\text{Nm} \times 0.738 = \text{lb}\cdot\text{ft}$
$\mu\text{m}/25.4 = \text{mil}$	$\text{Nm} \times 141.62 = \text{oz}\cdot\text{in}$
$\text{N} \times 0.225 = \text{lb}$	$\text{mPa}\cdot\text{s} = \text{cP}$
$\text{N}/\text{mm}^2 \times 145 = \text{psi}$	$\text{N}/\text{cm} \times 0.571 = \text{lb}/\text{in}$
$\text{MPa} \times 145 = \text{psi}$	$\text{kV}/\text{mm} \times 25.4 = \text{V}/\text{mil}$

### Available sizes

- 10006608\_ALT Repair Stick Aqua -2025-, 115 g, vintage white
- 10006608 Repair Stick Aqua, 115 g, vintage white
- 10008519\_ALT Repair Stick Aqua -2025-, 57 g, vintage white
- 10008519 Repair Stick Aqua, 57 g, vintage white

To the product detail page:



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## Chemical resistance after curing\* (Excerpt)

1,4-Dioxane	-	Uric acid	-
Exhaust fumes	+	Impregnating oils	+
Adipic acid	-	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	-	Cresol	-
aromatic hydrocarbons	+	Magnesium hydroxide	+
Barium hydroxide	+	Maleic acid (cis-ethylenedicarboxylic acid)	-
Benzoic acid	-	Methanol (methyl alcohol ) <85 %	o
Benzyl alcohol	-	Methylene chloride	-
Benzyl chloride	-	Mineral oil	+
Boric acid	-	Naphthalene	+
Bromides	-	Sodium bicarbonate (sodium hydrogen carbonate)	+
Butadiene (1,3-)	-	Sodium carbonate (soda)	+
Butyric acid	-	Sodium chloride (table salt)	+
Butyl acetate	+	Nitrates	-
Butyl alcohol	o	Nitrobenzene	-
Calcium hydroxide (slaked lime)	+	Oils, vegetable and animal	+
Chloroanilines	-	Oxalic acid <25 % (ethanedioic acid)	o
Chloroform (trichlormethane)	-	Perchloraethylene	-
Chlorosulphuric acid (wet and dry)	-	Kerosene	+
Chlorosilanes	-	Phenol	-
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	-
Diethyl ether	+	Sulphuric acid <5%	+
Mineral oil and mineral oil products	+	Soap solution	+
Acetic acid diluted <5%	o	Turpentine	+
Ethanol <85 % (ethyl alcohol)	o	Carbon tetrachloride (tetrachloromethane)	-
Greases, oils and waxes	+	Tetralin (tetrahydronaphthalene)	-
Hydrofluoric acid	-	Trichloraethylene	-
Tannic acid diluted <7%	o	Hydrogen peroxide <30 % (hydrogen superoxide)	o
Glycerin (trihydroxipropane)	+	Xylene	-
Glycol	+		

+ = 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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