

Epoxy Putties and Adhesives

WEBAC® 4525 CE



WEBAC®

- ▶ WEBAC® 4525 is an epoxy adhesive specially designed for bonding tiles, glass, ceramics to damp and wet substrates, it even cures underwater.

Range of application

- Gluing of mineral building material underwater
- Bonding and fixing of concrete on concrete, steel on concrete
- Concrete protection for floor and wall surfaces according to EN 13813 (CE-Declaration of Performance/4)
- Crack patching for injections
- Sealing of pipe ducts
- Tubbing, sewer and shaft repair
- Installation of **WEBAC® Sealing Tape TPE**

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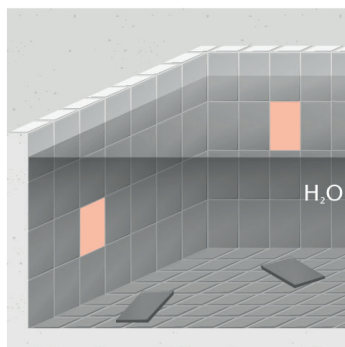
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Properties

- Cures underwater and on damp and wet substrates
- Good adhesion to various plastics
- High chemical resistance also to biogenic sulfuric acid
- Adjustable reaction time (accelerator **WEBAC® B45**)
- Microbiologically tested (W270 test according to DVGW regulations)
- Total solid*

Examples

Meaning of the icons ▶ WEBAC Product Catalog, www.webac.de or www.webac-grouts.com



Gluing of tiles underwater



Bonding of precast concrete units

*according to test method by Deutsche Bauchemie e.V. (German Industry Association for Manufacturers of Construction Chemicals)

▶ Technical Information

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Technical data	Values			
Mixing ratio	5 : 1 parts by weight			
Density, 20 °C / 68 °F (ISO 2811)	Comp. A	≈ 1.4 g/cm ³		
	Comp. B	≈ 1.2 g/cm ³		
Apparent density	≈ 1.55 g/cm ³			
Pot life		30 °C / 86 °F ≈ 10 min	20 °C / 68 °F ≈ 25 min	12 °C / 54 °F ≈ 40 min
Application temperature Building structure and material	> 5 °C / 41 °F			
Curing time, 21 °C / 70 °F		5 mm layer thickness ≈ 8 h	8 mm layer thickness ≈ 4.5 h	
Curing time via compressive strength development, 8 °C / 46 °F (ISO 604)	24 h	≈ 1 N/mm ²		
	48 h	≈ 3–4 N/mm ²		
	72 h	≈ 3–4 N/mm ²		
	5 d	≈ 27 N/mm ²		
Adhesive strength on concrete 7 d, 21 °C / 70 °F (EN 1542)	dry	≈ 5.2 N/mm ² , concrete fracture		
	underwater	≈ 3.4 N/mm ² , concrete fracture		
Compressive strength 7 d, 21 °C / 70 °F (ISO 604)	≈ 50 N/mm ²			
Bending tensile strength 7 d, 21 °C / 70 °F (ISO 178)	≈ 50 N/mm ²			
Tensile strength · elongation at break 7 d, 21 °C / 70 °F (ISO 527)	≈ 20 N/mm ² · ≈ 1%			
E modulus 7 d, 21 °C / 70 °F (ISO 527)	≈ 3,380 N/mm ²			
CE classification (EN 13813)	SR - B2.0 - AR0.5 - IR4			
Fire behavior	minimum B2 according to DIN 4102-4. 2.3.2			
GISCODE	RE1			
EPD	EPD-DBC-20130033-IBE1-DE			
Exposure scenarios according to REACH	Assessment of industry standard application			

The specified data are values determined under laboratory conditions and are subject to a certain fluctuation. Deviations are possible in practice depending on the respective object situation.

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Preparatory work

Structural analysis:

- Inspection of the substrate
 - Moisture condition (dry, damp or wet)
 - Surface strength (> 1.5 N/mm²)
 - Condition of surface (soiled, oily)
- Ensure that the temperature limit is maintained before application
- Remove all dirt, loose and separative substances from the surfaces
- Roughen the surfaces before working on tiles, ceramics or stoneware to improve adhesion



Mixing

- Empty component B in the container of component A (make sure the containers are completely empty) and mix homogeneously
- Transfer the mixed material to another clean bucket and stir briefly



Application instruction

- The mixture must be used completely within the specified pot life
- Only use pure WEBAC material without any residues of cleaning agents or other impurity
- The pot life/curing time are influenced by the amount of material/layer thickness and the temperature of the material/building structure – higher temperatures accelerate, lower temperatures slow down the reaction



Application

Patching

- Apply the putty/adhesive with a flat trowel
- For patching apply a layer approx. 10 cm wide and at least 3 mm thick to the entire crack area (also consider subsidiary cracks)
- Depending on the crack course, leave approx. 3–5 cm long sections at the highest points of the crack unpatched to allow the air in the crack to vent

Gluing of Sealing Tape

- Apply a 2–3 mm thick layer of the adhesive to the pretreated substrate with a flat trowel or serrated trowel
- Embed **WEBAC® Sealing Tape TPE** in the fresh adhesive layer and apply a second layer to the adhesive zone of the inserted sealing tape



Final work and cleaning

- The patching can be removed mechanically as soon as the injection process is completed and the filling material has cured (e.g. by hot air gun)
- Clean the equipment with **WEBAC® Cleaner A**
- Use **WEBAC® Cleaner B** for dissolving cured material
- Observe the technical data sheets of the cleaners used

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Product data									
Application	By flat trowel								
Material consumption	Patching ≈ 500 g/m								
Packing	<table border="1"><thead><tr><th>Comp. A</th><th>Comp. B</th></tr></thead><tbody><tr><td>2.5 kg</td><td>0.5 kg</td></tr><tr><td>1 kg</td><td>0.2 kg</td></tr><tr><td>0.5 kg</td><td>0.1 kg</td></tr></tbody></table>	Comp. A	Comp. B	2.5 kg	0.5 kg	1 kg	0.2 kg	0.5 kg	0.1 kg
Comp. A	Comp. B								
2.5 kg	0.5 kg								
1 kg	0.2 kg								
0.5 kg	0.1 kg								
Storage	<ul style="list-style-type: none">• Between 8 °C / 46 °F and 25 °C / 77 °F• Protect from moisture• In original, sealed containers								
Compatibility/Resistance	<ul style="list-style-type: none">• Compatible with masonry mortar, concrete, steel, foil, cable sheathing and WEBAC injection materials• Specially resistant to structurally damaging salts, acids and alkalis								

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Test certificates

- Declaration of performance according to Construction Products Regulation
- Test certificate* according to KTW recommendations: D1/D2 (large sealing of surfaces/ other sealants and adhesives)
- Microbiologically tested (W270 test according to DVGW regulations)
- Further test certificates on request

Occupational safety

The safety regulations of the industrial trade associations and the WEBAC Safety Data Sheets are to be observed at all times when working with this product. Safety data sheets according to Regulation (EC) No. 1907/2006 (REACH) must be accessible to all persons responsible for occupational safety, health protection and the handling of materials. For further information, please see the separate information sheet "Occupational Safety" in our product catalog or www.webac-grouts.com.

Waste disposal

In Germany, empty containers can be disposed of via "Interseroh Dienstleistungs GmbH" observing the respective terms and conditions. It is not possible to dispose of containers at production facilities or delivery warehouses. For more detailed information, please see the separate information sheet "Information on the disposal and return of WEBAC packaging" in our product catalog or www.webac-grouts.com and the safety data sheets.

* for drinking water

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