

Epoxy Putties and Adhesives

WEBAC® 4525 **CE**



Range of application

- Gluing of mineral building material underwater
- Bonding of concrete to concrete, steel to concrete
- Concrete protection according to DIN EN 13813
- Crack patching for injections according to DIN EN 1504-5
- Sealing of pipe ducts
- Tubbing, sewer and shaft repair
- Installation of sealing tape

Properties

- Epoxy-based putty/adhesive
- Cures underwater and on damp substrates
- Good adhesion to various plastics
- High chemical resistance also to biogenic sulfuric acid
- Total solid*

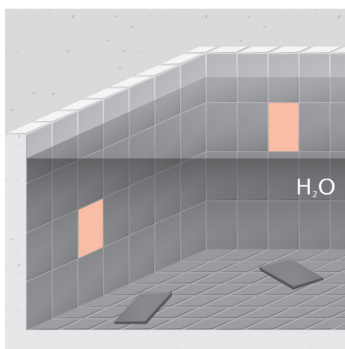
Test certificates

- Declaration of performance in accordance with the Construction Products Regulation (system 4)
- Test certificate according to KTW-BWGL recommendations: sealants, lubricants
- Environmental Product Declaration (EPD)
- List of chemical resistance

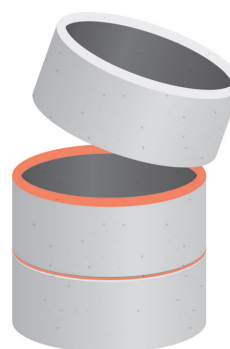
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Examples



Gluing of tiles underwater



Bonding of concrete to concrete

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

Technical Information

All the data indicated in this technical data sheet and any related information provided by our employees are of an advisory nature representing our current state of knowledge and in no way binding. As the exact chemical, technical and physical conditions of the actual application are beyond WEBAC's control, this information does not preclude examination of the products and/or procedures for the intended application and surface by the user. WEBAC is thus unable to guarantee results. The user is fully responsible for the observation of existing regulations and conditions when using the products.
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Technical data	Values			
Mixing ratio	5 : 1 parts by weight			
Density, 20 °C (DIN ISO 2811)	Comp. A Comp. B	≈ 1.4 g/cm ³ ≈ 1.2 g/cm ³		
Bulk density	≈ 1.55 g/cm ³			
Pot life (WEBAC test specification based on DIN ISO 9514)		30 °C ≈ 10 min	20 °C ≈ 25 min	12 °C ≈ 40 min
Application temperature Building structure and material	> 5 °C			
Curing time, 21 °C		5 mm layer thickness ≈ 8 h	8 mm layer thickness ≈ 4.5 h	
Curing time via compressive strength development, 8 °C (DIN ISO 604)	24 h 48 h 72 h 5 d	≈ 1 MPa (N/mm ²), concrete fracture ≈ 3–4 MPa (N/mm ²), concrete fracture ≈ 3–4 MPa (N/mm ²), concrete fracture ≈ 27 MPa (N/mm ²), concrete fracture		
Adhesive strength on concrete 7 d, 21 °C (DIN EN 1542)	dry underwater	≈ 5.2 MPa (N/mm ²) concrete fracture ≈ 3.4 MPa (N/mm ²), concrete fracture		
Compressive strength 7 d, 21 °C (DIN ISO 604)	≈ 50 MPa (N/mm ²)			
Bending tensile strength 7 d, 21 °C (DIN ISO 178)	≈ 50 MPa (N/mm ²)			
Tensile strength • Elongation at break 7 d, 21 °C (DIN ISO 527)	≈ 20 MPa (N/mm ²) • ≈ 1%			
E modulus 7 d, 21 °C (DIN ISO 527)	≈ 3,380 MPa (N/mm ²)			
CE classification (DIN EN 13813)	SR - B2.0 - AR0.5 - IR4			
Fire behavior (DIN 4102-4, 2.3.2)	minimum B2			
GISCODE	RE55			
EPD	EPD-DBC-20220176-IBF1-EN			
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 ($> 1.5 \text{ MPa (N/mm}^2\text{)}$)
 - Condition of surface (soiled, oily)

This results in:

- Selection of suitable material

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.

Application instruction

- Application by trowel
- The mixture must be used completely within 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

Mixing

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

Application

Patching

- For patching apply a layer $\approx 10 \text{ cm}$ wide and at least 3 mm thick to the entire crack area (also consider subsidiary cracks)
- Depending on the crack course, leave $\approx 3 - 5 \text{ cm}$ long sections at the highest points of the crack unpatched to allow the air in the crack to vent

Final work and cleaning

- After the material is cured, knock off patching if necessary and remove packers (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		
Material consumption	Patching ≈ 0.5 kg/m	
Delivery form	Comp. A	Comp. B
	2.5 kg	0.5 kg
	1 kg	0.2 kg
	0.5 kg	0.1 kg
Storage	- Between 8 °C and 25 °C - Protected from moisture - In original, sealed containers	
Compatibility	Compatible with masonry mortar, concrete, steel, foil, cable sheathing, metal and WEBAC injection materials	
Resistance	Specially resistant to structurally damaging salts, acids and alkalis	

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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.de.

Waste disposal

In Germany, empty containers can be disposed of via "Interzero Circular Solutions Germany 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 "Disposal Notes" in our product catalog or www.webac.de and the safety data sheets.