

# WELD-ON®

LOW VOC



## PRODUCT GUIDE

**All Low VOC • All the Time**

- Plastic Pipe Cements, Primers, and Cleaners
- Specialty Products
- Applicators and Accessories



## OUR COMPANY

Established in 1954, IPS® Corporation has consistently grown over the past 50+ years. Today, we are the trusted leader in manufacturing solvent cements, adhesives, and components for the plumbing, construction and plastic fabrication industries. Our core brands include **WELD-ON®**, **WATER-TITE**, **TEST-TITE®**, **GUY GRAY™**, **TRUEBRO®**, and **STUDOR®**. Our quality products are manufactured with proven formulation and design using state-of-the-art equipment and manufacturing techniques.

Headquartered in California, IPS Corp. has operations throughout the United States, as well as China, and a worldwide network of sales representatives and distributors.

## OUR COMMITMENT

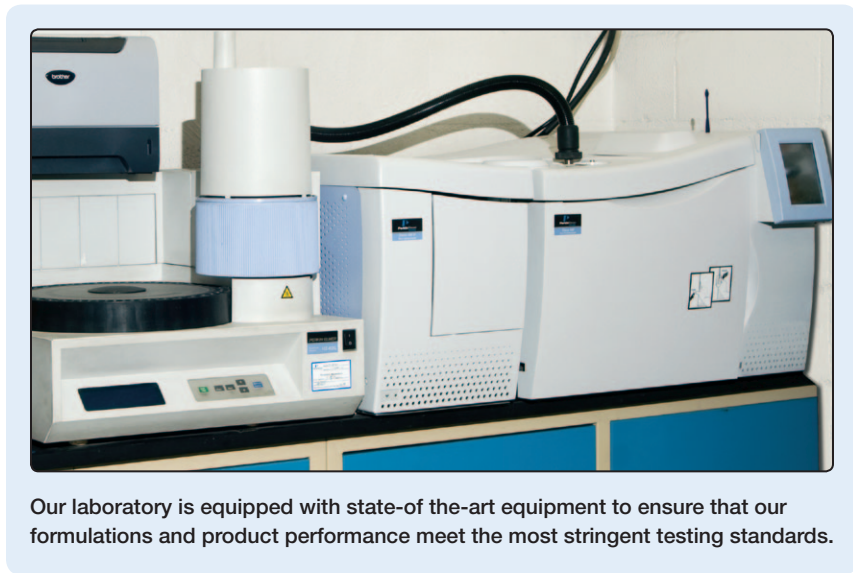
Weld-On is committed to our customers in all aspects of our operation and in all functions of our company:

**Quality products** – We are committed to manufacturing quality products for professionals. In fact, our California facility is ISO 9001: 2008 certified for its excellent quality management system. Our products are manufactured to the highest standards available and face stringent quality control tests prior to sale and distribution.

**Excellent customer service** – Our skilled team is readily available to help customers with product selection and ordering. We are experts in international shipping and our international customer service staff is certified in hazardous material shipment.



Our California facility takes pride in limiting volatile organic compound (VOC) emissions into the environment. Two regenerative thermo oxidizers are utilized to eliminate 99% of the VOC from our ventilation system before emitting air to the atmosphere.



Our laboratory is equipped with state-of-the-art equipment to ensure that our formulations and product performance meet the most stringent testing standards.

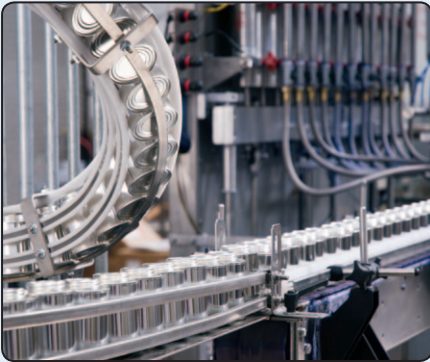
**Professional technical service** – Our technical specialists provide professional recommendations and product application/ job-site installation training to suit the needs of our customers.

**Expert R&D** – Our research scientists and engineers have vast technical knowledge to develop the most technically advanced and innovative products to meet our customers' needs.



# WELD-ON® SOLVENT CEMENTS, PRIMERS, AND CLEANERS

Weld-On is the original innovator of solvent cements, primers and cleaners for PVC, CPVC, and ABS plastic piping systems. Our Weld-On® name is globally-recognized as **the premium brand** of products for joining plastic pipes and fittings. We are committed not only to providing the best product performance, but to do so in the **most environmentally-responsible** manner. All Weld-On solvent cements, primers and cleaners **meet the requirements for Low VOC (volatile organic compound) emission limits** established by the California South Coast Air Quality Management District (SCAQMD), one of the nation's strictest air quality regulatory bodies. Low VOC emissions contribute to cleaner air.



Advanced automated filling and packaging lines of Weld-On products ensure fast, efficient and accurate completion of product orders.



### Weld-On's All Low VOC products provide the following benefits:

- **High Quality Performance** with excellent installation properties.
- **User Friendly.** Reduced fumes and odor for the comfort and well-being of pipe installers.
- **NSF, UPC, and/or CSA Listed.** Products are qualified for use in applications such as potable water, turf, irrigation, pool, industrial, fire protection, conduit, DWV and/or sewer.<sup>†</sup>
- **Meet ASTM Standards** for solvent cements and primers used for plastic pipe installation.<sup>†</sup>
- **Environmentally Responsible. LEED® Compliant (Leadership in Energy and Environmental Design).** Credit can be earned for LEED Project by using Weld-On Low VOC products. This program, developed by the US Green Building Council, uses SCAQMD Rule 1168 as the benchmark for Low VOC products to earn one credit<sup>#</sup> toward LEED certification for green building.

Weld-On Products	Maximum VOC Emission (gram/liter)
Primers / Cleaners	550
PVC Solvent Cement	510
CPVC Solvent Cement	490
ABS Solvent Cement	325

<sup>†</sup>Refer to individual solvent cement and/or primer for specific ASTM Standards, NSF, UPC and/or CSA Listings.

<sup>#</sup>LEED Green Building Rating System For New Construction & Major Renovations Version 2.2 (Indoor Environmental Air Quality: EQ Credit 4.1 Low-Emitting Materials - Adhesives & Sealants)

We offer comprehensive technical assistance to our valued customers; a manned, not pre-recorded, technical hotline (1-877-477-8327) to help answer questions about our Weld-On products and techniques for solvent welding plastic pipe and fittings. Pipe joint installation seminars are also routinely provided. Just call our hotline to learn more.





# WELD-ON® SELECTION GUIDE

For assistance in selecting the right Weld-On products for your application, please refer to the selection guide below. Refer to page 8 for the Weld-On® Pool & Spa Series Selection Guide.

		NOMINAL PIPE SIZE																		
		in	mm	½	¾	1	1¼	1½	2	2½	3	4	6	8	10	12	14	24	30	
				20	25	32	40	50	63	75	90	110	160	200	250	315	355	600	800	
<b>WELD-ON PRODUCTS</b>	<b>PVC CEMENTS</b>	REGULAR BODY	CLEAR	700	[Schedule 40/80 bars]															
			CLEAR	702	[Schedule 40/80 bars]															
			CLEAR	710	[Schedule 40/80 bars]															
		MEDIUM BODY	CLEAR	704†	[Schedule 40/80 bars]															
			CLEAR	705†	INDUSTRIAL GRADE [Schedule 40/80 bars]															
			GRAY	705†	[Schedule 40/80 bars]															
		HEAVY BODY	GRAY	711	INDUSTRIAL GRADE [Schedule 40/80 bars]															
			CLEAR	717	[Schedule 40/80 bars]															
		EXTRA HEAVY BODY	GRAY	719	INDUSTRIAL GRADE [Schedule 40/80 bars]															
			WHITE	719	[Schedule 40/80 bars]															
	SPECIALTY CEMENTS	AQUA BLUE	725†	[Schedule 40/80 bars]																
		WET 'N DRY™		[Schedule 40/80 bars]																
		CLEAR	727†	[Schedule 40/80 bars]																
		HOT 'N COLD™		[Schedule 40/80 bars]																
		BLUE	735†	[Schedule 40/80 bars]																
		WET 'N FAST™		[Schedule 40/80 bars]																
		BLUE to CLEAR	737†	[Schedule 40/80 bars]																
		TURF 'N AG™		[Schedule 40/80 bars]																
	CPVC CEMENTS	ORANGE	713	CTS ONLY [Schedule 40/80 bars]																
		YELLOW	FlowGuard® GOLD	CTS ONLY [Schedule 40/80 bars]																
ORANGE		714	[Schedule 40/80 bars]																	
GRAY		714	[Schedule 40/80 bars]																	
ORANGE		724†	INDUSTRIAL GRADE [Schedule 40/80 bars]																	
GRAY	729	INDUSTRIAL GRADE [Schedule 40/80 bars]																		
<b>ABS</b>	MILKY YELLOW	771	ALL CLASSES & SCHEDULES [Schedule 40/80 bars]																	
	BLACK	773	ALL CLASSES & SCHEDULES [Schedule 40/80 bars]																	
	BLACK	778	ALL CLASSES & SCHEDULES [Schedule 40/80 bars]																	
<b>SPECIALTY</b>	MILKY	763†	FOR STYRENE-RUBBER (SR) PLASTIC DRAIN PIPE ONLY [Schedule 40/80 bars]																	
	CLEAR	790**	[Schedule 40/80 bars]																	
	GREEN	794***	ALL CLASSES & SCHEDULES EXCEPT SCHEDULE 80 [Schedule 40/80 bars]																	
<b>PRIMERS</b>	PURPLE	P68	[Schedule 40/80 bars]																	
	CLEAR	P70	INDUSTRIAL GRADE [Schedule 40/80 bars]																	
	AQUA BLUE	P75	[Schedule 40/80 bars]																	
		NOMINAL PIPE SIZE																		
		in	mm	½	¾	1	1¼	1½	2	2½	3	4	6	8	10	12	14	24	30	
				20	25	32	40	50	63	75	90	110	160	200	250	315	355	600	800	

**PIPE FORMAT**

Schedule 40/PN3.2, PN4, PN6

Schedule 80/PN10, PN16

- † Can be used without a primer on non-pressure systems with fittings having an interference fit (unless primer required by local code).
- ◇ For CPVC and PVC Chemical Piping Systems
- ª FlowGuard Gold® is a registered trademark of the Lubrizol Corp.
- \* Styrene Pipe
- \*\* PVC, CPVC, ABS and Styrene Pipes
- \*\*\* ABS to PVC Transition Joints
- CTS: Copper Tube Size





PVC SOLVENT CEMENTS		Max Pipe Size (Interference Fit)	Set Time	Available Color	Industry Listing	Meets Following Performance Specification	
	<b>700™ PVC</b> <ul style="list-style-type: none"> <li>Excellent for irrigation, electrical conduit, pool &amp; spa and plumbing, including PVC foam core pipe.</li> </ul>	<ul style="list-style-type: none"> <li>4" (110 mm) PVC</li> <li>Not for Schedule 80 – PN10 or higher</li> </ul>	Fast	CLEAR	  <small>PW-G/DWW/SW</small>	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61	Regular Bodied
<b>AVAILABLE SIZES</b> Gallon (#10078), Quart (#10079), Pint (#10080), ½ Pint (#10081), ¼ Pint (#10082)							
	<b>702™ PVC</b> <ul style="list-style-type: none"> <li>Excellent for DWV, irrigation, electrical conduit, pool &amp; spa and plumbing, including PVC foam core pipe.</li> </ul>	<ul style="list-style-type: none"> <li>4" (110 mm) PVC</li> <li>Not for Schedule 80 – PN10 or higher</li> </ul>	Fast	CLEAR	  <small>PW-G/DWW/SW</small>	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61	Regular Bodied
<b>AVAILABLE SIZES</b> Gallon (#10974), Quart (#10975), Pint (#10976), ½ Pint (#10977), ¼ Pint (#10978)							
	<b>710™ PVC</b> <ul style="list-style-type: none"> <li>Specially formulated for irrigation piping. Suitable for electrical conduit, pool &amp; spa and plumbing, including PVC foam core pipe.</li> </ul>	<ul style="list-style-type: none"> <li>2" (63 mm) PVC</li> <li>Not for Schedule 80 – PN10 or higher</li> </ul>	Very Fast	CLEAR	  <small>PW-G/DWW/SW</small>	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61	Regular Bodied
<b>AVAILABLE SIZES</b> Gallon (#10111), Quart (#10112), Pint (#10113), ½ Pint (#10114), ¼ Pint (#10115)							
	<b>704™ PVC</b> <ul style="list-style-type: none"> <li>Quality formulation for irrigation, electrical conduit, pool &amp; spa and plumbing, including PVC foam core pipe.</li> <li>Can be used without primer on non-pressure systems if local codes permit.</li> </ul>	<ul style="list-style-type: none"> <li>6" (160 mm) PVC</li> <li>4" (110 mm) Schedule 80 PVC – PN 10 &amp; 16</li> </ul>	Fast	CLEAR GRAY	  <small>PW-G/DWW/SW</small>  <small>PW-G/DWW/SW (Gray Only)</small>	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61 CSA B137.3 CSA B181.2	Medium Bodied
<b>AVAILABLE SIZES</b> CLEAR: Gallon (#12122), Quart (#12123), Pint (#12124), ½ Pint (#12125), ¼ Pint (#12126) GRAY: Gallon (#12127), Quart (#12128), Pint (#12129), ½ Pint (#12130), ¼ Pint (#12131)							
	<b>705™ PVC</b> <b>INDUSTRIAL GRADE</b> <ul style="list-style-type: none"> <li>High-strength formula for industrial, irrigation, DWV, electrical conduit, pool &amp; spa and plumbing, including PVC foam core pipe.</li> <li>Can be used without primer on non-pressure systems if local codes permit.</li> </ul>	<ul style="list-style-type: none"> <li>6" (160 mm) PVC</li> <li>4" (110 mm) Schedule 80 PVC – PN 10 &amp; 16</li> </ul>	Fast	CLEAR GRAY	  <small>PW-G/DWW/SW</small>   <small>PW-G/DWW/SW (Gray Only)</small> <small>(Gray Only)</small>	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61 CSA B137.3 CSA B181.2	Medium Bodied
<b>AVAILABLE SIZES</b> CLEAR: Gallon (#10085), Quart (#10089), Pint (#10093), ½ Pint (#10097), ¼ Pint (#10100), ¾ Oz (#10103) GRAY: Gallon (#10086), Quart (#10090), Pint (#10094), ½ Pint (#10098), ¼ Pint (#10101)							
	<b>721™ PVC</b> <ul style="list-style-type: none"> <li>Premium, high-strength formulation for irrigation, DWV, pool &amp; spa and plumbing.</li> <li>May be used without primer on Schedule 40 and SDR water piping systems thru 4" (110 mm) unless primer is required by local code.</li> <li>Do not use 721 without primer in any other application, schedule or size such as Sch. 80 industrial applications.</li> <li>When primer is used, joints must be properly cured before backfilling.</li> </ul>	<ul style="list-style-type: none"> <li>6" (160 mm) PVC</li> <li>4" (110 mm) Schedule 80 PVC – PN 10 &amp; 16</li> </ul>	Fast	BLUE	  <small>PW-G/DWW/SW</small>	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61	Medium Bodied
<b>AVAILABLE SIZES</b> Gallon (#10160), Quart (#10161), Pint (#10162), ½ Pint (#10163), ¼ Pint (#10849)							

PVC SOLVENT CEMENTS		Max Pipe Size (Interference Fit)	Set Time	Available Color	Industry Listing	Meets Following Performance Specification
Heavy Bodied	<p><b>711™ PVC INDUSTRIAL GRADE</b></p> <ul style="list-style-type: none"> <li>High-strength formula for industrial piping systems.</li> <li>Good gap filling properties.</li> <li>Medium set allows for more working time in warm weather.</li> </ul>	<ul style="list-style-type: none"> <li>12" (315 mm) PVC all classes &amp; schedules</li> </ul>	Medium	GRAY	  PW-G/DWW/SW 	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61 CSA B137.3 CSA B181.2
	<p><b>AVAILABLE SIZES</b>      Gallon (#10117), Quart (#10119), Pint (#10121), ½ Pint (#10123)</p>					
	<p><b>717™ PVC</b></p> <ul style="list-style-type: none"> <li>Quality formulation for plumbing, industrial, pool, irrigation and electrical piping systems.</li> <li>Good gap filling properties.</li> <li>Medium set allows for more working time in warm weather.</li> </ul>	<ul style="list-style-type: none"> <li>12" (315 mm) PVC all classes &amp; schedules</li> </ul>	Medium	CLEAR GRAY	  PW-G/DWW/SW  PW-G/DWW/SW (Gray Only)	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61 CSA B137.3 CSA B181.2
	<p><b>AVAILABLE SIZES</b>      CLEAR: Gallon (#10141), Quart (#10144), Pint (#10147), ½ Pint (#10150), ¼ Pint (#10861)            GRAY: Gallon (#10142), Quart (#10145), Pint (#10148), ½ Pint (#10151)</p>					
Extra Heavy Bodied	<p><b>719™ PVC INDUSTRIAL GRADE</b></p> <ul style="list-style-type: none"> <li>Premium, high-strength formulation for large size industrial piping systems.</li> <li>Ideal for fabrication of large fittings and applications requiring high gap filling properties.</li> <li>Suitable for irrigation, conduit, other pressure and non-pressure applications.</li> </ul>	<ul style="list-style-type: none"> <li>30" (800 mm) PVC, all classes &amp; schedules</li> </ul>	Slow	WHITE GRAY	 PW-G/DWW/SW  PW-G/DWW/SW (Gray Only)	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61 CSA B137.3 CSA B181.2
	<p><b>AVAILABLE SIZES</b>      WHITE: Gallon (#10155), Quart (#10157), Pint (#10159), 10.3 Oz (#12658)            GRAY: Gallon (#13078), Quart (#10156)</p>					
PVC SPECIALTY SOLVENT CEMENTS						
Medium Bodied	<p><b>725™ WET'R DRY™</b></p> <ul style="list-style-type: none"> <li>Premium formula for wet conditions and/or quick pressurization.</li> <li>Suitable for irrigation, plumbing, and pool &amp; spa applications.</li> <li>Can be used without primer on non-pressure systems if local codes permit.</li> </ul>	<ul style="list-style-type: none"> <li>6" (160 mm) PVC</li> <li>4" (110 mm) Schedule 80 PVC – PN 10 &amp; 16</li> </ul>	Extremely Fast	AQUA BLUE	  PW-G/DWW/SW	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61
	<p><b>AVAILABLE SIZES</b>      Gallon (#10164), Quart (#10165), Pint (#10166), ½ Pint (#10167), ¼ Pint (#10850)</p>					
	<p><b>727™ HOT'R COLD™</b></p> <ul style="list-style-type: none"> <li>Premium formula for all weather conditions (-15°F to 110°F / -26°C to 43°C).</li> <li>Excellent for industrial, irrigation, electrical conduit, pool &amp; spa and plumbing, including PVC foam core pipe.</li> <li>Can be used without primer on non-pressure systems if local codes permit.</li> </ul>	<ul style="list-style-type: none"> <li>6" (160 mm) PVC</li> <li>4" (110 mm) Schedule 80 PVC – PN 10 &amp; 16</li> </ul>	Very Fast	CLEAR	  PW-G/DWW/SW	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61
	<p><b>AVAILABLE SIZES</b>      Gallon (#10840), Quart (#10841), Pint (#10842)</p>					
	<p><b>735™ WET'N FAST™</b></p> <ul style="list-style-type: none"> <li>Plumbing quality cement for wet conditions and/or quick pressurization.</li> <li>Can be used without primer on non-pressure systems if local codes permit.</li> </ul>	<ul style="list-style-type: none"> <li>6" (160 mm) PVC</li> <li>4" (110 mm) Schedule 80 PVC – PN 10 &amp; 16</li> </ul>	Extremely Fast	BLUE	  PW-G/DWW/SW	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61
	<p><b>AVAILABLE SIZES</b>      Gallon (#12494), Quart (#12495), Pint (#12496), ½ Pint (#12497), ¼ Pint (#12498)</p>					

**PVC SPECIALTY SOLVENT CEMENTS**      Max Pipe Size (Interference Fit)      Set Time      Available Color      Industry Listing      Meets Following Performance Specification

	<p><b>737™ TURF 'N AG™</b></p> <ul style="list-style-type: none"> <li>This high quality blue cement has a slightly higher viscosity making it ideal for turf and agricultural applications and excellent for PVC Well casing.</li> <li>Blue color fades to clear in sunlight.</li> <li>Can be used without primer on non-pressure systems if local codes permit.</li> </ul>	<ul style="list-style-type: none"> <li>8" (200 mm) PVC</li> <li>4" (110 mm) Schedule 80 PVC – PN 10 &amp; 16</li> </ul>	<p>Very fast</p>	<p>BLUE to CLEAR</p>		<p>ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61</p>	<p>Medium Bodied</p>
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AVAILABLE SIZES      Gallon (#10988), Quart (#10989), Pint (#10990), ½ Pint (#11984), ¼ Pint (#11985)

	<p><b>738™ HOT 'N FAST™</b></p> <ul style="list-style-type: none"> <li>High strength and fast setting speed make this cement ideal for irrigation, pool and plumbing.</li> <li>For wet or quick pressurization conditions.</li> <li>Blue cement fades to clear in sunlight.</li> <li>Can be used without primer on non-pressure systems if local codes permit.</li> </ul>	<ul style="list-style-type: none"> <li>6" (160 mm) PVC</li> <li>4" (110 mm) Schedule 80 PVC – PN 10 &amp; 16</li> </ul>	<p>Very Fast</p>	<p>BLUE to CLEAR</p>		<p>ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61</p>	<p>Medium Bodied</p>
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AVAILABLE SIZES      Gallon (#12245), Quart (#12246), Pint (#12247), ½ Pint (#12248)

	<p><b>750™ HOTWELD</b></p> <ul style="list-style-type: none"> <li>Medium bodied and fast setting speed make this cement ideal for irrigation, DWV, pool and spa, plumbing and non-pressure applications.</li> <li>Works great in wet conditions.</li> <li>Extremely hot, fast set-up blue cement.</li> <li>Can be used without primer on non-pressure systems if local codes permit.</li> </ul>	<ul style="list-style-type: none"> <li>6" (160 mm) PVC</li> <li>4" (110 mm) Schedule 80 PVC – PN 10 &amp; 16</li> </ul>	<p>Fast</p>	<p>BLUE</p>		<p>ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61</p>	<p>Medium Bodied</p>
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AVAILABLE SIZES      Gallon (#13750), Quart (#13751), Pint (#13752), ½ Pint (#13753), ¼ Pint (#13754)

	<p><b>795™ PVC</b></p> <ul style="list-style-type: none"> <li>Premium cement specially formulated for use on flexible and/or rigid PVC.</li> <li>Forms flexible high-strength joints.</li> </ul>	<ul style="list-style-type: none"> <li>6" (160 mm) PVC</li> <li>3" (90 mm) Schedule 80 PVC – PN 10 &amp; 16</li> </ul>	<p>Fast</p>	<p>CLEAR BLUE</p>		<p>ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61</p>	<p>Medium Bodied</p>
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AVAILABLE SIZES      CLEAR: Gallon (#10278), Quart (#10280), Pint (#10281), ½ Pint (#10282), ¼ Pint (#10283)  
BLUE: Gallon (#11727), Quart (#11905)

**CPVC SPECIALTY SOLVENT CEMENTS**

	<p><b>713™ CPVC</b></p> <ul style="list-style-type: none"> <li>For potable water to 180°F (82°C).</li> <li>Suitable for residential plumbing and industrial systems.</li> <li>Can be used without primer if local codes permit.</li> </ul>	<ul style="list-style-type: none"> <li>2" (63 mm) CPVC copper tube size</li> </ul>	<p>Fast</p>	<p>ORANGE</p>		<p>ASTM D 2846 ASTM F 493 NSF/ANSI 14 NSF/ANSI 61</p>	<p>Regular Bodied</p>
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AVAILABLE SIZES      Quart (#10126), Pint (#10127), ½ Pint (#10128), ¼ Pint (#10129)

	<p><b>FlowGuard Gold®</b></p> <ul style="list-style-type: none"> <li>ONE STEP CEMENT. Formulated to be used without primer if local codes permit.</li> <li>For potable water to 180°F (82°C).</li> <li>Suitable for residential plumbing and industrial systems.</li> <li>Approved by Lubrizol Advanced Materials, Inc. for use on FlowGuard Gold® Systems.</li> </ul>	<ul style="list-style-type: none"> <li>2" (63 mm) CPVC copper tube size</li> </ul>	<p>Fast</p>	<p>YELLOW</p>		<p>ASTM D 2846 ASTM F 493 NSF/ANSI 14 NSF/ANSI 61 CSA B137.6</p>	<p>Medium Bodied</p>
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AVAILABLE SIZES      Gallon (#11025), Quart (#11026), Pint (#11027), ½ Pint (#11028), ¼ Pint (#11029)

	<p><b>714™ CPVC</b></p> <ul style="list-style-type: none"> <li>Industrial quality for non-chemical applications up to 180°F (82°C).</li> <li>Approved for use on Corzan® CPVC piping systems.</li> </ul>	<ul style="list-style-type: none"> <li>12" (315 mm) CPVC, all classes &amp; schedules</li> </ul>	<p>Medium</p>	<p>GRAY ORANGE</p>		<p>ASTM D 2846 ASTM F 493 NSF/ANSI 14 NSF/ANSI 61 CSA B137.6</p>	<p>Heavy Bodied</p>
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AVAILABLE SIZES      ORANGE: Gallon (#10130), Quart (#10132), Pint (#10135), ½ Pint (#10137)  
GRAY: Quart (#10131), Pint (#10134)





CPVC SOLVENT CEMENTS		Max Pipe Size (Interference Fit)	Set Time	Available Color	Industry Listing	Meets Following Performance Specification
Heavy Bodied	 <b>724™ CPVC INDUSTRIAL GRADE</b> <ul style="list-style-type: none"> <li>Premium, high-strength, chemical-resistant solvent cement for use with CPVC and PVC piping systems carrying acids, bases, salts, and hypochlorites.</li> <li>Approved for use on Corzan® CPVC piping systems.</li> </ul>	12" (315 mm) CPVC and PVC, all classes & schedules	Medium	GRAY ORANGE	UPC NSF PW-G/DWV/SW	ASTM F 493 NSF/ANSI 14 NSF/ANSI 61
	<b>AVAILABLE SIZES</b> ORANGE: Gallon (#12817), Quart (#12818) GRAY: Gallon (#12233), Quart (#11659), Pint (#11890)					
Extra Heavy Bodied	 <b>729™ CPVC INDUSTRIAL GRADE</b> <ul style="list-style-type: none"> <li>Extra heavy body industrial quality cement for applications requiring high gap filling properties. Ideal for fabrication of large sized fittings.</li> <li>May be used for chemical applications.</li> </ul>	24" (600 mm) CPVC, all classes & schedules	Slow	GRAY	—	ASTM F 493
	<b>AVAILABLE SIZES</b> Gallon (#10844), Quart (#10845)					
ABS SOLVENT CEMENTS						
Medium Bodied	 <b>771™ ABS</b> <ul style="list-style-type: none"> <li>For plumbing applications (DWV, sewer &amp; drain pipe), conduit and foam core.</li> </ul>	8" (200 mm) ABS	Fast	MILKY YELLOW	UPC (Milky Only) NSF DWV/SW NSF C US DWV/SW (Yellow Only)	ASTM D 2235 NSF/ANSI 14 CSA B181.1
	<b>AVAILABLE SIZES</b> MILKY: Gallon (#10230), Quart (#10232), Pint (#10233) YELLOW: Gallon (#10965), Quart (#10966), Pint (#10967), ½ Pint (#10968), ¼ Pint (#10969) - Canada Only					
Medium Bodied	 <b>773™ ABS</b> <ul style="list-style-type: none"> <li>For plumbing applications (DWV, sewer &amp; drain pipe), conduit and foam core.</li> </ul>	8" (200 mm) ABS	Fast	BLACK	UPC NSF DWV/SW	ASTM D 2235 NSF/ANSI 14
	<b>AVAILABLE SIZES</b> Gallon (#10241), Quart (#10243), Pint (#10244), ½ Pint (#10245), ¼ Pint (#10246)					
Medium Bodied	 <b>778™ ABS</b> <ul style="list-style-type: none"> <li>For plumbing applications (DWV, sewer &amp; drain pipe), conduit and foam core.</li> </ul>	8" (200 mm) ABS	Fast	BLACK	UPC NSF DWV/SW	ASTM D 2235 NSF/ANSI 14
	<b>AVAILABLE SIZES</b> Gallon (#13647), Quart (#13648), Pint (#13649), ½ Pint (#13650)					
TRANSITION & SPECIALTY SOLVENT CEMENTS						
Medium Bodied	 <b>763™ STYRENE</b> <ul style="list-style-type: none"> <li>High-strength styrene rubber cement for styrene rubber plastic drain and sewer pipe and fittings.</li> <li>Can also be used on styrene vacuum pipe systems.</li> <li>Do not use this cement for other plastic types.</li> </ul>	6" (160 mm) Styrene	Fast	MILKY	—	ASTM D 2852
	<b>AVAILABLE SIZES</b> Gallon (#11060), Quart (#11061), Pint (#11062), ½ Pint (#11063)					
Medium Bodied	 <b>790™ MULTI-PURPOSE</b> <ul style="list-style-type: none"> <li>High-strength multi-purpose cement for PVC and CPVC pipe and fittings.</li> <li>Can be used on ABS and Styrene low-pressure systems.</li> </ul>	6" (160 mm) 4" (110 mm) Schedule 80-PN 10 & 16	Fast	CLEAR	—	ASTM D 2564 ASTM D 2235 ASTM F 493
	<b>AVAILABLE SIZES</b> Gallon (#11248), Quart (#10257), Pint (#10258), ½ Pint (#10259), ¼ Pint (#10260)					
Medium Bodied	 <b>794™ ABS - PVC</b> <ul style="list-style-type: none"> <li>For use only on ABS to PVC transition joints in non-pressure systems.</li> <li>Suitable for sewer, DWV and conduit.</li> </ul>	6" (160 mm) Not for Schedule 80-PN 10 or higher	Fast	GREEN	UPC NSF DWV/SW	ASTM D 3138
	<b>AVAILABLE SIZES</b> Gallon (#10272), Quart (#10273), Pint (#10274), ½ Pint (#10275), ¼ Pint (#13369)					

PRIMERS & CLEANERS		Available Color	Industry Listing	Meet Following Performance Specification
	<b>P-68™ PRIMER</b> ■ Quality primer essential for proper softening and preparation of PVC and CPVC pipe and fitting surfaces.	CLEAR PURPLE	 (Purple Only)  PW-G/DWW/SW	ASTM F 656 NSF/ANSI 14 NSF/ANSI 61
<b>AVAILABLE SIZES</b> PURPLE: Gallon (#10208), Quart (#10210), Pint (#10212), ½ Pint (#10214), ¼ Pint (#10216) CLEAR: Gallon (#10207), Quart (#10209), Pint (#10211), ½ Pint (#10213), ¼ Pint (#10215)				
	<b>P-70™ PRIMER</b> <b>INDUSTRIAL GRADE</b> ■ Premium industrial strength primer essential for proper softening and preparation of PVC and CPVC pipe and fitting surfaces. ■ Specially recommended for use on Schedule 80 (PN 10 and higher) and large size pipe. ■ Excellent for cold weather applications.	CLEAR PURPLE	 (Purple Only)  PW-G/DWW/SW	ASTM F 656 NSF/ANSI 14 NSF/ANSI 61
<b>AVAILABLE SIZES</b> PURPLE: Gallon (#10221), Quart (#10223), Pint (#10225), ½ Pint (#10227), ¼ Pint (#10229) CLEAR: Gallon (#10220), Quart (#10222), Pint (#10224), ½ Pint (#10226), ¼ Pint (#10228)				
	<b>P-75™ PRIMER</b> ■ Premium, fast acting, industrial strength primer essential for proper softening and preparation of PVC and CPVC pipe and fitting surfaces. ■ Specially formulated for wet and/or quick set applications.	AQUA BLUE	 PW-G/DWW/SW	ASTM F 656 NSF/ANSI 14 NSF/ANSI 61
<b>AVAILABLE SIZES</b> Gallon (#10247), Quart (#10248), Pint (#10249), ½ Pint (#10250)				
	<b>PC-64™ PRIMER/CLEANER</b> ■ For cleaning and surface preparation of PVC and CPVC pipe and fittings before bonding with solvent cements.	CLEAR PURPLE	—	—
<b>AVAILABLE SIZES</b> PURPLE: Gallon (#10871), Quart (#10872), Pint (#10873), ½ Pint (#10874), ¼ Pint (#10875) CLEAR: Quart (#12656)				
	<b>C-65™ CLEANER</b> ■ For removal of oil and grease from the surfaces of PVC, CPVC, ABS and STYRENE pipe and fittings for bonding. ■ Recommended for use before priming of pipe and fittings.	CLEAR	—	—
<b>AVAILABLE SIZES</b> Gallon (#10200), Quart (#10201), Pint (#10202), ½ Pint (#10203), ¼ Pint (#10204)				

NOMINAL PIPE SIZE	in		½	¾	1	1¼	1½	2	2½	3	4	6	8	10	12	14	24	30	
	mm		20	25	32	40	50	63	75	90	110	160	200	250	315	355	600	800	
WELD-ON POOL & SPA PRODUCTS	PVC CEMENTS	REGULAR BODY	CLEAR	740 POOL REGULAR															
		MEDIUM BODY	CLEAR	744 <sup>†</sup> POOL MEDIUM															
	HEAVY BODY	CLEAR	746 POOL HEAVY																
		GRAY																	
	SPECIALTY PRODUCTS	BLUE to CLEAR	747 <sup>†</sup> POOL "R SPA"																
		BLUE to CLEAR	748 <sup>†</sup> POOL FAST™																
		BLUE	798 POOL FLEX™																
	PRIMER	PURPLE	Pool Primer																
		CLEAR																	

**PIPE FORMAT**

- Schedule 40/PN3.2, PN4, PN6
- Schedule 80/PN10, PN16

† Can be used without a primer on non-pressure systems with fittings having an interference fit (unless primer required by local code).



PVC POOL & SPA SOLVENT CEMENTS		Max Pipe Size (Interference Fit)	Set Time	Available Color	Industry Listing	Meets Following Performance Specification
	<b>740™ POOL REGULAR</b> <ul style="list-style-type: none"> <li>Regular bodied cement for pool &amp; spa applications.</li> </ul>	<ul style="list-style-type: none"> <li>4" (110 mm) PVC</li> </ul>	Fast	<div style="border: 1px solid gray; padding: 2px; display: inline-block;">CLEAR</div>	  <small>PW-G/DWV/SW</small>	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61
	<b>AVAILABLE SIZES</b> Gallon (#13550), Quart (#13551), Pint (#13552), ½ Pint (#13553), ¼ Pint (#13652)					
	<b>744™ POOL MEDIUM</b> <ul style="list-style-type: none"> <li>Medium bodied cement for pool &amp; spa applications.</li> <li>Can be used without primer on non-pressure systems if local codes permit.</li> </ul>	<ul style="list-style-type: none"> <li>6" (160 mm) PVC</li> <li>4" (110 mm) Schedule 80 PVC – PN 10 &amp; 16</li> </ul>	Fast	<div style="border: 1px solid gray; padding: 2px; display: inline-block;">CLEAR</div> <div style="border: 1px solid gray; padding: 2px; display: inline-block;">GRAY</div>	  <small>PW-G/DWV/SW</small>  <small>US PW-G/DWV/SW (Gray Only)</small>	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61 CSA B137.3 CSA B181.2
	<b>AVAILABLE SIZES</b> CLEAR: Gallon (#13554), Quart (#13555), Pint (#13556), ½ Pint (#13557), ¼ Pint (#13653) GRAY: Gallon (#13558), Quart (#13559), Pint (#13560), ½ Pint (#13561)					
	<b>746™ POOL HEAVY</b> <ul style="list-style-type: none"> <li>Heavy bodied cement for pool &amp; spa applications.</li> </ul>	<ul style="list-style-type: none"> <li>12" (315 mm) PVC</li> <li>18" (480 mm) PVC (non pressure applications)</li> </ul>	Medium	<div style="border: 1px solid gray; padding: 2px; display: inline-block;">CLEAR</div> <div style="border: 1px solid gray; padding: 2px; display: inline-block;">GRAY</div>	  <small>PW-G/DWV/SW</small>  <small>US PW-G/DWV/SW (Gray Only)</small>	ASTM D 2564 CSA B137.3 CSA B181.2 NSF/ANSI 14 NSF/ANSI 61
	<b>AVAILABLE SIZES</b> CLEAR: Gallon (#13562), Quart (#13563), Pint (#13564), ½ Pint (#13565) GRAY: Gallon (#13566), Quart (#13567), Pint (#13568), ½ Pint (#13569)					
	<b>747™ POOL 'R SPA™</b> <ul style="list-style-type: none"> <li>Medium bodied premium PVC cement specially formulated for pool &amp; spa applications.</li> <li>Ideal for wet or quick pressurization conditions.</li> <li>Blue cement fades to clear in sunlight.</li> <li>Can be used without primer on non-pressure systems if local codes permit.</li> </ul>	<ul style="list-style-type: none"> <li>6" (160 mm) PVC</li> <li>4" (110 mm) Schedule 80 PVC – PN 10 &amp; 16</li> </ul>	Extremely Fast	<div style="border: 1px solid gray; padding: 2px; display: inline-block;">BLUE to CLEAR</div>	  <small>PW-G/DWV/SW</small> 	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61 CSA B45.10
	<b>AVAILABLE SIZES</b> Gallon (#10851), Quart (#10852), Pint (#10853), ½ Pint (#10854), ¼ Pint (#10855)					
	<b>748™ POOL FAST™</b> <ul style="list-style-type: none"> <li>Medium bodied high-strength and ultra fast setting cement; specially formulated for pool maintenance and repair.</li> <li>For wet or quick pressurization conditions.</li> <li>Blue cement fades to clear in sunlight.</li> <li>Can be used without primer on non-pressure systems if local codes permit.</li> </ul>	<ul style="list-style-type: none"> <li>6" (160 mm) PVC</li> <li>4" (110 mm) Schedule 80 PVC – PN 10 &amp; 16</li> </ul>	Ultra Fast	<div style="border: 1px solid gray; padding: 2px; display: inline-block;">BLUE to CLEAR</div>	  <small>PW-G/DWV/SW</small>	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61
	<b>AVAILABLE SIZES</b> Gallon (#13655), Quart (#13342), Pint (#13343), ½ Pint (#13344), ¼ Pint (#13654)					
	<b>798™ POOL FLEX™</b> <ul style="list-style-type: none"> <li>Medium bodied cement ideal for flexible PVC pool application.</li> <li>Forms flexible, strong joints.</li> </ul>	<ul style="list-style-type: none"> <li>6" (160 mm) PVC</li> <li>4" (110 mm) Schedule 80 PVC – PN 10 &amp; 16</li> </ul>	Fast	<div style="border: 1px solid gray; padding: 2px; display: inline-block;">BLUE</div>	  <small>PW-G/DWV/SW</small>	ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61
	<b>AVAILABLE SIZES</b> Gallon (#13345), Quart (#13346), Pint (#13347)					
	<b>POOL PRIMER™</b> <ul style="list-style-type: none"> <li>Quality Low VOC primer essential for proper softening and preparation of PVC and CPVC pipe and fitting surfaces</li> </ul>	—	—	<div style="border: 1px solid gray; padding: 2px; display: inline-block;">PURPLE</div> <div style="border: 1px solid gray; padding: 2px; display: inline-block;">CLEAR</div>	 <small>(Purple Only)</small>  <small>PW-G/DWV/SW</small>	ASTM F 656 NSF/ANSI 14 NSF/ANSI 61
	<b>AVAILABLE SIZES</b> PURPLE: Gallon (#13570), Quart (#13571), Pint (#13572), ½ Pint (#13658), ¼ Pint (#13659) CLEAR: Gallon (#13574), Quart (#13575), Pint (#13576), ½ Pint (#13656), ¼ Pint (#13657)					





# WELD-ON SOLVENT CEMENTS AND PRIMERS ACCESSORIES

## Roll-A-Weld Rollers and Swabs

 <p><b>3020</b> Roll-A-Weld 3" roller for pipe diameters from 3" through 6"; fits MT-653 empty quart triple tight neck can. (#10007)</p>	 <p><b>4020</b> 4" swab for pipe diameters of 6" or larger; fits MT-648 empty gallon can and cements available in wide mouth cans. (#10009)</p>
 <p><b>6020</b> Roll-A-Weld 4" roller for pipe diameters from 3" through 8"; fits standard quart can as well as MT-651 empty quart can. (#11957)</p>	 <p><b>5020</b> 4" swab for pipe diameters from 3" through 8"; fits standard quart can as well as MT-651 empty quart can. (#12071)</p>
 <p><b>7020</b> Jumbo Roll-A-Weld 7" roller for pipe diameters of 6" or larger; fits MT-648 gallon can and cements available in wide mouth cans. (#10008)</p>	 <p><b>8020</b> 4" cotton swab with wire handle for use on pipe diameter 6" or larger. (#13360)</p>

APPLICATORS

## Daubers

 <p><b>Can-Mate daubers</b> Adjustable plastic applicator with telescoping stem to fit 1/2 pint, pint, and quart cans. Available in 1/2" (#12307), 3/4" (#10832) and 1 1/4" (#10833) dauber sizes.</p>	 <p><b>Cap daubers</b> DH Daubers fit 1/4 pint &amp; 1/2 pint cans; DP daubers fit 1/2 pint &amp; pint cans; DQ daubers fit quart cans. Available in 3/8", 1/2", 3/4", and 1 1/2" dauber sizes.</p> <p><b>AVAILABLE SIZES</b>  <b>DH-38</b> (#13199)    <b>DP-50</b> (#10003)    <b>DP-75</b> (#10004)  <b>DP-150</b> (#10005)    <b>DQ-50</b> (#11831)    <b>DQ-75</b> (#12429)  <b>DQ-150</b> (#10006)</p>
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## Brushes

 <p><b>PB-1</b> Plastic handle brush. Fits standard pint and quart cans. (#12121)</p>	 <p><b>CM BCP Can-Mate®</b> Adjustable plastic handle. Natural bristle brush. Fits standard pint and quart cans. (#10963)</p>
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## Empty Metal Cans

 <p><b>CST-36 Cable Saw</b> 36" cable saw with T-Handle for cutting plastic pipe through 8" diameters. (#12739)</p>	 <p><b>Empty Metal Cans</b> (dauber not included)</p> <p><b>AVAILABLE SIZES</b>  <b>MT-648</b> Gallon can with 2 7/8" neck (#10010)  <b>MT-651</b> Quart can with 1 3/4" neck (#10012)  <b>MT-653</b> Quart can with triple tight neck (paint style) (#10014)  <b>MT-654</b> Pint can with 1 3/4" neck (#10015)</p>
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ACCESSORIES

 <p><b>Can-Tote Cement &amp; Primer Carrier</b> For carrying quart and pint cans. (#12891)</p>	 <p><b>Can-Mate Carrier Kit</b> Kit includes plastic carrier arm and two Can-Mate® CM-150 adjustable shaft 1 1/4" diameter daubers. Job site convenience for carrying 1/2 pint, pint or quart cans of cement and primer. (#10864)</p>
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 <p><b>Professional Hand Cleaner</b> An advanced hand cleaner in liquid and disposable wipe format for removing residual solvent cements (PVC, CPVC, ABS), primers &amp; sealants. Also removes dirt, oil, grease and much more.  <b>PINT</b> (#12752)    <b>WIPE</b> (#12762)</p>	 <p><b>DEB-2 Deburring Tool</b> For PVC, CPVC, ABS, PE &amp; PB pipe from 1/2" through 2" IPS. (#12079)</p>
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 <p><b>Mounted Power Beveling Tool</b> For beveling the ends of small diameter plastic pipe (PVC, CPVC, ABS). Nominal pipe sizes 1/2" CTS - 3" IPS. (#12863)</p>	 <p><b>Pipe and Fitting Pullers</b> For installation of large diameter plastic pipe and fittings (PVC, CPVC, ABS). Available for pipe and fittings sizes 4" - 12" diameter (#12816) and 14" - 20" diameter (#12815). Lightweight, durable and can easily be operated by one person.</p>
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## SOLVENT CEMENTS SET/CURE TIMES AND APPLICATOR GUIDE

### Average Initial Set Schedule For WELD-ON® PVC/CPVC Solvent Cements\*\*

Temperature Range	Pipe Sizes				
	½" to 1¼" (20mm to 40mm)	1½" to 2" (50mm to 63mm)	2½" to 8" (75mm to 200mm)	10" to 15" (250mm to 380mm)	15"+ (380mm +)
60°-100°F/16°-38°C	2 minutes	5 minutes	30 minutes	2 hours	4 hours
40°-60°F/5°-16°C	5 minutes	10 minutes	2 hours	8 hours	16 hours
0°-40°F/-18°-5°C	10 minutes	15 minutes	12 hours	24 hours	48 hours

**Note** - Initial set schedule is the necessary time to allow before the joint can be carefully handled. In damp or humid weather allow 50% more set time.

### Average Joint Cure Schedule For WELD-ON® PVC/CPVC Solvent Cements\*\*

Relative Humidity 60% or less	Pipe Sizes							
	½" to 1¼" (20mm to 40mm)		1½" to 2" (50mm to 63mm)		2½" to 8" (75mm to 200mm)		10" to 15" (250mm to 380mm)	15"+ (380mm +)
Temperature range during assembly and cure periods	up to 160 psi / 11 Bar	160 to 370 psi / 11 to 26 Bar	up to 160 psi / 11 Bar	160 to 315 psi / 11 to 22 Bar	up to 160 psi / 11 Bar	160 to 315 psi / 11 to 22 Bar	up to 100 psi / 7 Bar	up to 100 psi / 7 Bar
60°-100°F/16°-38°C	15 min	6 hrs	30 min	12 hrs	1½ hrs	24 hrs	48 hrs	72 hrs
40°-60°F/5°-16°C	20 min	12 hrs	45 min	24 hrs	4 hrs	48 hrs	96 hrs	6 days
0°-40°F/-18°-5°C	30 min	48 hrs	1 hour	96 hrs	72 hrs	8 days	8 days	14 days

**Note** - Joint cure schedule is the necessary time to allow before pressurizing system. In damp or humid weather allow 50% more cure time.

\*\* These figures are estimates based on testing done under laboratory conditions. Field working conditions can vary significantly. This chart should be used as a general reference only.

### Average Number of Joints/Quart (1Kg) of WELD-ON® Cement\*

Pipe Diameters	½"/ 20mm	¾"/ 25mm	1"/ 32mm	1½"/ 50mm	2"/ 63mm	3"/ 90mm	4"/ 110mm	6"/ 160mm	8"/ 200mm	10"/ 250mm	12"/ 315mm	15"/ 380mm	18"/ 450mm
Number of Joints	300	200	125	90	60	40	30	10	5	2-3	1-2	¾	½

**Note - For Primer:** Double the number of joints shown for cement.

\* These figures are estimates based on our laboratory tests. Due to the many variables in the field, these figures should be used as a general guide only. **Note: 1 Joint = 1 Socket**

### Pipe Size Equivalent Chart - Inches/Millimeters

in.	½"	¾"	1"	1¼"	1½"	2"	2½"	3"	4"	6"	8"	10"	12"	14"	18"	24"	30"
mm.	20	25	32	40	50	63	75	90	110	160	200	250	315	355	450	600	800

## WELD-ON APPLICATOR SELECTION GUIDE

Weld-On solvent cements are packaged with can-lid daubers: ¾" dauber on quarter pint and half pint cans and 1½" dauber on pint and quart cans. For proper solvent welding of pipe and fittings, the cement applicator **must** be no less than half the size of the pipe. See the following charts for applicator (daubers, swabs, and rollers) recommendations pertaining to pipe size.

DAUBERS	Pipe Diameters						
	¼"	½"	¾"	1"	1¼"	1½"	2"
¾" Dauber	•	•	•				
½" Dauber			•	•			
¾" Dauber					•	•	
1½" Dauber							•

ROLLERS & SWABS	SIZE	FOR PIPE DIAMETERS
3020	3" Roller	3"-6"
6020	4" Roller	3"-8"
7020	7" Roller	6" +
4020	4" Swab	6" +
5020	4" Swab	3"-8"
8020	4" Swab	6" +

## PRODUCT SHELF LIFE

Weld-On Products	Shelf-life	Weld-On Products	Shelf-life
Primers / Cleaners	3 years	CPVC Solvent Cement	2 years
PVC Solvent Cement	3 years	ABS Solvent Cement	3 years




## SPECIALTY PRODUCTS

Weld-On® offers extensive specialty products to meet your plumbing needs.



- **Repair and fabrication adhesives** are great for repairing cracks, leaky pipe valves and fittings. These adhesives are also great for pipe fabrication because of their excellent gap-filling properties.
  - **Weld-On® pipe thread sealant** product line is the best in the industry, sealing and lubricating metal and plastic pipe threads. These sealants work well on pipelines conveying various materials from compressed gas to corrosive liquids.
  - **Joint compounds** set and seal plumbing fixtures, drains, as well as pipe threads.
  - **Joint lubricants** are excellent for lubricating valves and gasketed joints.
  - **Cutting oils** are used for cutting and threading ferrous and non-ferrous metal pipes.
- Please refer to the individual product description for additional details.

## REPAIR AND FABRICATION ADHESIVES

The following Weld-On adhesives have Low VOC emissions per SCAQMD Rule 1168. Use of these products can qualify for one credit in the LEED® Green Building Rating System – Indoor Environmental Quality.

	Applicable for use with	Viscosity	Set Time	Color	Shelf Life
 <p><b>810™</b></p> <ul style="list-style-type: none"> <li>▪ Thick syrupy, two-component, high strength reactive adhesive.</li> <li>▪ Product can withstand very high pressures and is high impact resistant. Great for repairing cracks or leaky pipe valves and fittings.</li> <li>▪ Excellent gap-filling properties. Ideal for fabricating fittings and joining saddles to pipe. Good for bonding large diameter PVC and CPVC pipe and fittings.</li> </ul>	<ul style="list-style-type: none"> <li>▪ PVC</li> <li>▪ ABS</li> <li>▪ Acrylic</li> <li>▪ Non-anodized aluminum</li> <li>▪ Clay</li> </ul> <ul style="list-style-type: none"> <li>▪ CPVC</li> <li>▪ Styrene</li> <li>▪ FRP (fiberglass-reinforced polyester)</li> <li>▪ Other metals</li> <li>▪ Concrete</li> </ul>	40,000 cps	1 hour	<b>WHITE</b>	1 year
<b>AVAILABLE SIZES</b>	Gallon (#10810), Quart (#10811), Pint (#10812), 4 Oz (#10813)				
 <p><b>811™</b></p> <ul style="list-style-type: none"> <li>▪ Thick syrupy, two-component, high strength reactive adhesive. Same formula as 810, but different packaging format.</li> <li>▪ Product can withstand very high pressures and is high impact resistant. Great for repairing cracks or leaky pipe valves and fittings.</li> <li>▪ Excellent gap-filling properties. Ideal for fabricating fittings and joining saddles to pipe. Good for bonding large diameter PVC and CPVC pipe and fittings.</li> <li>▪ Conveniently packaged in a dual cylinder cartridge for easy dispensing and application to the bonding surfaces.</li> <li>▪ See below for accessories.</li> </ul>	<ul style="list-style-type: none"> <li>▪ PVC</li> <li>▪ ABS</li> <li>▪ Acrylic</li> <li>▪ Non-anodized aluminum</li> <li>▪ Clay</li> </ul> <ul style="list-style-type: none"> <li>▪ CPVC</li> <li>▪ Styrene</li> <li>▪ FRP (fiberglass-reinforced polyester)</li> <li>▪ Other metals</li> <li>▪ Concrete</li> </ul>	40,000 cps	1 hour	<b>WHITE</b>	1 year
<b>AVAILABLE SIZES</b>	470mL (#10985)				
 <p><b>845™</b></p> <ul style="list-style-type: none"> <li>▪ Highly viscous, two-component, high strength, reactive adhesive.</li> <li>▪ Product can withstand very high pressure and large temperature range (-30°F / -35°C to 200°F / 93°C). It is also impact resistant and can be used in wet conditions.</li> <li>▪ Excellent gap-filling properties. Ideal for fabricating fittings and joining saddles to pipe. Good for bonding large diameter PVC and CPVC pipe and fittings.</li> <li>▪ Conveniently packaged in a dual cylinder cartridge for easy dispensing and application to the bonding surfaces.</li> <li>▪ See below for accessories.</li> </ul>	<ul style="list-style-type: none"> <li>▪ PVC</li> <li>▪ ABS</li> <li>▪ Acrylic</li> <li>▪ Metals</li> </ul> <ul style="list-style-type: none"> <li>▪ CPVC</li> <li>▪ Fiberglass</li> <li>▪ FRP (fiberglass-reinforced polyester)</li> <li>▪ Concrete</li> </ul>	400,000 cps	30 mins.	<b>TAN</b>	1 year
<b>AVAILABLE SIZES</b>	400mL (#12759), 43mL (#12709), 43mL Starter Kit (#12711)				













## ADHESIVE ACCESSORIES

 <p><b>811 Dispensing gun and mixing tips</b></p> <ul style="list-style-type: none"> <li>▪ Manual or pneumatic dispensing gun for convenient application of Weld-On 811 dual cartridge, high strength adhesive.</li> <li>▪ Straight mixing tip provides even blending of the two adhesive components prior to application.</li> </ul>	 <p><b>845 Dispensing gun and mixing tips</b></p> <ul style="list-style-type: none"> <li>▪ Manual or pneumatic dispensing gun for convenient application of Weld-On 845 dual cartridge, high strength adhesive.</li> <li>▪ Straight mixing tip provides even blending of the two adhesive components prior to application.</li> </ul>
<b>AVAILABLE SIZES</b>	Manual gun (#11652), Pneumatic gun (#11199), Mixing tip (#13147)
<b>AVAILABLE SIZES</b>	400mL: Manual gun (#12613), Metal frame manual gun (#13302), Pneumatic gun (#12933), mixing tip (#14040) 43mL: Manual gun (#12471), mixing tip (#11195)



## PIPE THREAD SEALANTS

All Weld-On® pipe thread sealants are lead free, odor free, non-staining, applicable in a large temperature range, can be immediately pressurized, easy to clean and have a creamy texture that packs well between pipe threads for a better seal.


	Industry Listing	Pressure Rating (PSI)		Temperature Range	Color	Shelf-life
		Liquids	Gases			
 <p><b>All Seal™</b> <span style="float: right;"><b>MULTI-PURPOSE SEALANT</b></span></p> <ul style="list-style-type: none"> <li>Slow drying, soft-setting formula allows ample time to work with pipe joints. Also easy for disassembly.</li> <li>Creamy, non-separating consistency provides excellent thread coverage.</li> <li>Product is grit-free to provide leak-proof seal on pipe threads.</li> <li>For sealing and lubricating all metal and plastic (ABS, PVC, CPVC, Polypropylene, &amp; Nylon) piping systems carrying various materials.<sup>1</sup></li> <li>Very low VOC content: 152 g/L.</li> </ul>	 	6,000	3,000	-50°F to 455°F	<b>BEIGE</b>	2 year
<b>AVAILABLE SIZES</b> Pint (#87670), 1/2 Pint (#87665), 1/4 Pint (#87660)						
 <p><b>Blue Seal™</b> <span style="float: right;"><b>INDUSTRIAL GRADE SEALANT</b></span></p> <ul style="list-style-type: none"> <li>Heavy duty, grit-free formula. Excellent for industrial applications and pipe lines in high vibration environments.</li> <li>Contains finely homogenized PTFE particles for filling cracks and thread imperfections – ensuring a leak-proof seal.</li> <li>For sealing and lubricating all metal and plastic (ABS, PVC, CPVC, Polypropylene, &amp; Nylon) piping systems carrying various materials.<sup>1</sup></li> <li>Tested and approved for addition to the FBC System compatible program for use with FlowGuard Gold®, BlazeMaster®, and Corzan® CPVC plastic piping systems.</li> <li>No VOC content.</li> </ul>	  	10,000	3,000	-50°F to 455°F	<b>BLUE</b>	3 year
<b>AVAILABLE SIZES</b> Quart (#87695), Pint (#87690), 1/2 Pint (#87685)						
 <p><b>White Seal™ Plus</b> <span style="float: right;"><b>MULTI-PURPOSE SEALANT WITH PTFE</b></span></p> <ul style="list-style-type: none"> <li>Contains finely homogenized PTFE particles for filling cracks and thread imperfections – ensuring a leak-proof seal.</li> <li>Non-setting formula allows easy disassembly of joints without damage to pipe, fittings or threads. Protects threaded areas from rust and corrosion and prevents galling.</li> <li>For sealing and lubricating all metal and plastic (ABS, PVC, CPVC, Polypropylene, &amp; Nylon) piping systems carrying various materials.<sup>1</sup></li> <li>Tested and approved for addition to the FBC System compatible program for use with FlowGuard Gold®, BlazeMaster®, and Corzan® CPVC plastic piping systems.</li> <li>No VOC content.</li> </ul>	  	10,000	3,000	-50°F to 455°F	<b>WHITE</b>	3 year
<b>AVAILABLE SIZES</b> Quart (#87740), Pint (#87735), 1/2 Pint (#87730), 1/4 Pint (#87725)						
 <p><b>505 Key Tite™</b> <span style="float: right;"><b>METAL PIPE SEALANT</b></span></p> <ul style="list-style-type: none"> <li>Special formulation seals and lubricates metal pipe joints as well as protects them from rusting and seizing.</li> <li>Applicable for all types of metal joints (threaded, flanged or gasketed).</li> <li>For sealing and lubricating all metal piping systems carrying various materials.<sup>2</sup></li> </ul>	—	Dependent on pressure rating of the piping systems	-50°F to 450°F	<b>GREEN</b>	1 year	
<b>AVAILABLE SIZES</b> Gallon (#10062), Quart (#10063), Pint (#10064), 1/2 Pint (#10068), 1/4 Pint (#10069)						

<sup>1</sup> All Seal, Blue Seal, and White Seal can be used on **metal and plastic** piping systems carrying: air & gases (compressed, manufactured or natural), ammonia, brine, acid (diluted), caustic alkalis (diluted), corrosives, freons, fuel (diesel, gasoline, jet fuel, and kerosene), oils, petroleum, propane, solvents, steam, sugar, and water. Not recommended for oxygen, fluorine, or liquid sodium systems.

<sup>2</sup> 505 Key Tite can be used on **metal** piping systems carrying: acids (diluted), air (compressed or gaseous), alcohols, alkalis (diluted), brine, caustics (diluted), gases (manufactured or natural), low pressure steam lines, sugar (liquid), and hot or cold water.

## JOINT COMPOUNDS


In addition to our premium Weld-On® sealants, we also offer a cost-effective sealant alternative - our joint compounds. They are semi-solid, lead-free, non-toxic, and also provide effective seals to plumbing fixtures & drains, as well as pipe threads.



**Soft Seal Plumber Putty**

- For setting and sealing plumbing fixtures and drains. Will not harden, crack or crumble.
- Complies with Federal Specification TT-P-1536A.
- Lead-free, non-corrosive and stainless.
- 100% water-proof.


**AVAILABLE SIZES** 5 LB. (#80105), 3 LB. (#80103), 14 Oz. (#80100)



**Epoxy Putty Stick**

- Quick hardening sealant/adhesive.
- Plugs, seals, patches or repairs most materials.
- Excellent for underwater repairs.
- Hardens in 20 minutes and cures in 1 hour.
- Non-toxic, safe for potable water line.


**AVAILABLE SIZES** 4 Oz (#84055)



**Pipe Stick Joint Compound**

- Thread sealant for metal and plastic pipe.
- Prevents rust and corrosion allowing easier disassembly.
- Lead-free and non-toxic.

**AVAILABLE SIZES** 1.3 Oz (#81255)




**Thread Seal Tape**

- Contains PTFE.
- Complies with MIL-T-27730A specifications.
- Available in various colors, widths and lengths.

**AVAILABLE SIZES:** 1/2" x 260" White (#80315), 1/2" x 520" White (#80310), 3/4" x 260" White (#87750), 3/4" x 520" White (#87755), 1" x 520" White (#87720), 1/2" x 260" Yellow Gas Line (#80320), 1/2" x 260" Pink Extra Duty (#80325)

## JOINT LUBRICANTS



Weld-On joint lubricants are non-toxic, non-corrosive and can be easily washed out of piping systems.



**EZ Flush Pipe Lubricant**

- Applicable for joining all metal and plastic gasketed pipes.
- Lubricates slip-on or "O" ring type joints without harming rubber or plastic gaskets.
- Easily flushes out of piping system.
- Non-toxic and non-corrosive. No taste or odor.



**AVAILABLE SIZES** 5 Gallon (#87721), Gallon (#87719), Quart (#87718), Pint (#87717)

**Seal Lube Gasket Lubricant**

- Primes and lubricates slip-on or "O" ring type joints with rubber or synthetic rubber gaskets.
- Non-toxic and non-corrosive. No taste or odor.
- 100% water soluble.

**AVAILABLE SIZES** Gallon (#87715), Quart (#87710), Pint (#87705)


**Slik Seal Plumber Grease**

- For lubricating valve stems.
- 100% water-proof.

**AVAILABLE SIZES** 1 Oz. (#80427)

## CUTTING OILS


Weld-On offers two types of cutting oil for use on metal pipe threading, cutting and other machines.



**Light Cutting Oil**

- For light duty manual or low rpm threading machines as well as for drilling, reaming and rolling machines using ferrous and non-ferrous metals.

**AVAILABLE SIZES** Gallon (#80425), Quart (#80424)



**Dark Cutting Oil**

- High-grade oil blend.
- For medium to heavy duty cutting, threading, drilling, reaming and rolling machines using ferrous and non-ferrous metals.

**AVAILABLE SIZES** 5 Gallon (#80422), Gallon (#80421), Quart (#80420), Pint (#80415)

# WELD-ON® – THE TRUSTED BRAND FOR JOINING PLASTIC PIPE, VALVES, AND FITTINGS IN ANY INDUSTRY



All Low VOC • All the Time



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Lit. #230103

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