

# Repair Stick Titanium



wear resistant  
titanium-filled  
high temperature resistant up to +280°C (+536°F)(briefly up to +300°C/+572°F)

It is suited for the permanent and wear resistant repair and bonding of metal parts such as tanks and pipelines, aluminium, light metal and injection moulded parts, shafts and slide bearings, pumps and housings and torn-out threads.

The WEICON Repair Stick Titanium can be used in machine and system construction, tank construction and apparatus engineering, and in many other industrial applications.

ISSA: 75.530.06/07

IMPA: 81 29 77/78

## Technical data

Final strength (100%) at +20°C after	72 (24 at +65°C) h
Composition	Epoxy resin and titanium fillers, putty
Pressure (DIN 53281-83)	80 N/mm <sup>2</sup>
Pot life at 25 g material and at +20°C	30 Min.
Shore hardness D	80
Density of the mixture	1,9 g/cm <sup>3</sup>
Average tensile shear strength after 7 days	
Processing temperature	+10 bis +50 °C
ac. to DIN 53283	5,1 (Steel sandblasted) N/mm <sup>2</sup>
Curing temperature	+6 bis +65 °C
Temperature resistance	-50 to +280 (briefly +300) °C
Colour after curing	grey-green
Gap covering power to maximum	15 mm
Handling strength (35% strength/+20°C) after	60 Min.
Capable of bearing mechanical loads(50% strength/+2	4 h

## Pretreatment of the surface

To ensure a perfect bond, the surfaces to be joined must be clean and dry (e.g., clean and degrease using WEICON Surface Cleaner). Smooth surfaces should be roughened, e.g. by sandblasting.

## Processing

WEICON Repair-Sticks cover gaps of max. 15 mm per procedure. The pot life given is for a material quantity of 25 g at room temperature. If larger quantities are used, the curing time will be faster due to the

typical reaction heat of epoxy resins (exothermic reaction).

Similarly, higher ambient temperatures shorten the cure time (as a rule of thumb, every +10°C increase above room temperature will halve working and curing time). Temperatures below +16°C will extend working and curing times considerably, while below about +5°C, no reaction will take place at all.

## Storage

When kept at a constant room temperature of about +20°C and unopened in dry conditions, WEICON Repair Sticks will keep for at least 18 months.

Avoid direct sunlight.

## Note

Any product specifications and recommendations given herein must not be seen as guaranteed product characteristics. They are based on our laboratory tests and on practical experience. Since individual application conditions are beyond our knowledge, control and responsibility, this information is provided without any obligation. We do warrant the continuously high quality of our products being free from defects in accordance with and subject to our General Sales Conditions. However, own adequate laboratory and practical tests to find out if the product in question meets the requested properties are recommended. A claim cannot be derived from them. The user bears the only responsibility for non-appropriate or other than specified applications.

## Health and Safety

When using WEICON products, the physical, safety technical, toxicological and ecological data and regulations in our EC safety data sheets ([www.weicon.com](http://www.weicon.com)) must be observed.

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