

CONCRETE WELDER GRAY FOR CONCRETE REPAIR

PRODUCT INFORMATION

Concrete Welder Gray is a low viscosity waterproof - two component urethane consisting of equal parts of A side, a diphenylmethane di-isocyanate urethane pre-polymer, and of B side, a polyether diols triols. Concrete Welder Gray is 100% solids and contains no VOCs. Concrete Welder Gray is dispensed by a pump at a 1 to 1 ratio of parts A & B and combined with a clean DRY 3/8 inch round washed dried pea stone or washed DRIED size 1A aggregate, with lack of moisture content being key.

STORAGE

Store in cool dry, ventilated storage area, in closed containers and out of direct sunlight in rooms with ambient temperatures maintained between 32 degree and 80 degrees F.

SURFACE PREPARATION

- Method of Cleaning - Saw cut or hammer the perimeter of the repair site back to sound concrete, using abrasive blasting remove loose concrete, debris, dirt, and dust using a minimum 150 psi continuously dry compressed air. Wet saw cut is NOT recommended unless sufficient time for drying is allowed.
- Level of Cleanliness – Removal all loose and foreign materials by profiling surfaces in accordance with ICRI Guide 03732 to a minimum of CSP 3 by abrasive blasting.
- Moisture content of structure – Maximum moisture content is 5% measured by a moisture meter. Concrete may be dried with a propane torch as necessary to achieve this. Only place Concrete Welder Gray in temperatures between 40 degrees and 100 degrees F. and on concrete with a surface temperature at least 5 degrees F. above the dew point and avoid application over damp surfaces.
- Concrete surfaces being prepared must be fully cured 28 days and fast setting concrete surfaces being prepared must be fully cured 7 days.
- For applications over previously installed polymers, the polymer surfaces must be cleaned, abraded and vacuumed prior to placement.

APPLICATION PROCEDURES

- Pre-application: Pre-condition both drums of Parts A and B Concrete Welder Gray to 50-70 degrees F before use. Using the stir stick provided to mix Part B for a minimum of 5 minutes prior to initial use of Part B drums.
- Using the pump dispensing machine, with the manifold and static tube removed, perform the 1 to 1 ratio test of Parts A and B by pumping about a quart into two separate recipients and verify the machine is pumping equal volumes in each before proceeding with the repair.
- Place and level out approved aggregate to within about ¼ inch of surrounding surface and using the machine, dispense Concrete Welder Gray into the repair site completely immersing the aggregate. It is not necessary to use Concrete Welder Gray as a primer.
- For repair sites greater than 3 inches deep apply aggregate and Concrete Welder Gray in 3 inch lifts without waiting for cure of previous lift and trowel level with surrounding surface and avoid overfilling.
- For topping sand use top rock or bagged US Silica washed and dried coarse sand and add to refusal.

Note: With the addition of catalyst to the B side drum of the Concrete Welder Gray by Roklin before shipping, the installation can typically be ready for traffic in about 20 minutes at 70 degrees F. with the cure faster in warmer temperatures and slower in colder temperatures.

EFFECT OF TEMPERATURE ON SET TIME

TEMPERATURE	SET TIME	RETURN TO SERVICE
80-100 degrees F.	3 minutes	15 minutes
60-80 degrees F.	5 minutes	25 minutes
40-60 degrees F.	7 minutes	40 minutes
20-40 degrees F.	10 minutes	60 minutes



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TECHNICAL DATA SHEET / CWGRAY

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CLEANING AND MAINTENANCE

For machine, clean the three manifold ports and threads on tube ends daily after use with acetone. Flush A side pump and lines through manifold with vegetable oil when storing machine more than 3-4 weeks between uses.

For hand tools, wipe clean with dry cloth before cure. Cured material must be removed mechanically. Do not attempt to burn off cured material.

DEFICIENCY AND REPAIR

Concrete Welder Gray can be saw cut and ground similar to concrete ideally after a 24 hour period but if necessary after 1-2 hour cure depending on the ambient temperature. If excess material needs to be removed, saw cut, sand, or grind as needed.

MATERIAL REQUIREMENTS

Physical Test Requirements. Elastomeric concrete will conform to the following physical test requirements per NYS DOT Standard Specification 701-11:

*The physical information shown in the column on the right in the table below are the results of the New York State DOT Materials Testing Laboratory test of Roklin Systems' Concrete Welder Gray product in March 2014.

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TESTS	PROCEDURE	MINIMUM REQUIREMENTS	Roklin Systems Concrete Welder Gray*
Resilience	ASTM C579-01	70%	Pass
5 hr. Compressive Strength	ASTM C579-01 Mod.	3.45 MPa (500 psi)	2,700+ psi
24 hr. Compressive Strength	ASTM C579-01 Mod.	14 MPa (2000 psi)	6,400+ psi
7-Day Tensile	ASTM D638	1 MPa (150 psi)	1,100+ psi
7-Day Tear	ASTM D624	7kN/m (40 lbf/in)	150+ lbf/in
Pot Life	Gardeo GT-S gel timer	5 minutes	Pass