

钢质修补胶棒



固化迅速

铁填充

经NSF认证能够用于饮用水领域

适用于各种金属强效且快速的维修与粘接；也可用于机器部件、水箱、管道、容器、泵、壳体、阳台栏杆、楼梯扶栏、磨损螺纹等的裂缝、孔隙和泄漏的修复及密封。

WEICON钢铁修补胶棒适用于机械制造、容器及仪器制造、食品、化妆品、制药行业及其他诸多行业领域。



技术参数

基础成分	环氧树脂金属填充
质地	膏状
固化后的颜色	深灰色
体积混合比例（树脂/固化剂）	1:1
混合物密度	2,0 g/cm ³
最大粘接缝隙	15 mm
操作温度	+10 至 +35 °C
固化温度	+6 至 +40 °C
温度为+20°C、混合物重量为25g时的可操作时间	4 分钟
达到初始强度（35%强度）所需时间	10 分钟
达到机械强度（50%强度）所需时间	60 分钟
达到最终强度（100%强度）所需时间	24 h
抗压强度(依据 DIN 53281-83)	80 N/mm ²
依据 DIN EN 1465, 在+25°C 温度下, 7天后的平均拉伸剪切强度为	钢, 喷砂处理: 4.1 N/mm ²
邵氏硬度 D	75
导热系数	0,6 W/m·K
线性收缩率	<1 %

提示

本资料中列出的所有产品，其参数和建议是我们在实验室的测试结果及经验总结，不得被视为对产品特性的保证。由于每一个用的实际应用情况并不在我们的认知、控制及责任范围内，我们对这些信息并不承担任何义务。我们保证我们的产品符合并遵守我们销售条款中承诺的高品质、无瑕疵的要求。我们建议用户通过自行试验来论证其希望选用的产品是否完全符合预期。因用户未遵照指定的操作方法使用产品而造成损失的情况，用户将独自承担全部责任。

电阻率(依据 ASTM D 257)	5•10 ¹¹ Ohm/cm
介电强度(依据 ASTM D 149)	3,0 kV/mm
热膨胀系数	30-40 x 10 ⁻⁶ K ⁻¹
耐温性	-50至+120, 短时可达+150 °C
ISSA 编码	75.530.15/01
IMPA 编码	812925/26

表面预处理

为确保粘接效果，待粘接的物体表面需干燥、清洁（可使用 WEICON 表面清洁剂进行清洁与去脂）。

操作

WEICON 修补胶棒单次涂层的最大厚度为15mm。技术参数表中所体现的可操作时间指的是在室温环境下，使用25克修补胶棒的可操作时间。如果需要使用的材料质量大于该数值，则固化时间会缩短，这是由环氧树脂典型的热反应所致（放热反应）。更高的环境温度也会加快固化速度（根据经验，以室温为基准，环境温度每增加10°C，可操作时间和固化时间将减半）。若温度低于16°C，则可操作时间和固化时间将被极大延长；温度低于5°C，则不会发生任何化学反应。

储藏

在室内恒温+20°C、干燥且未开封的情况下，WEICON 修补胶棒可存放至少18个月。避免阳光直射。

安全与健康

使用 WEICON 产品时，需注意产品的物理性、安全性、毒性、生态性的详细参数以及我们 ECG 材料安全数据表（www.weicon.com）的具体信息。

包装

10533057-47	钢质修补胶棒 57 g
10533115-47	钢质修补胶棒 115 g

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Repair Stick Steel



fast cure
steel-filled
NSF approval, can be used in drinking water areas

It is particularly suited for the fast and high-strength repair and bonding of metal parts and for the patching and sealing of cracks, holes, and leaks in machine parts, tanks and pipelines, containers, pumps and housings, balcony railings, banisters, and torn-out threads.

The WEICON Repair Stick Steel can be used in machine and system construction, in tank construction and apparatus engineering, in the foods, cosmetic and pharmaceutical industries and in many other applications.



Technical Data

Base	Epoxy resin steel-filled
Texture	paste
Colour after curing	dark-grey
Mixing ratio by volume resin/hardener	1:1
Density of the mixture	2,0 g/cm ³
Gap bridging max.	15 mm
Processing temperature	+10 to +35 °C
Curing temperature	+6 to +40 °C
Polt life for 25gr preparation and +20°C (+68°F)	4 min.
Handling strength (35% strength) after	10 min.
Capable of bearing mechanical loads (50% strength) after	60 min.
Final strength (100%) after	24 h
Pressure (DIN 53281-83)	80 N/mm ²
Medium shear strength after 7 days at +20°C (+65°F) DIN EN 1465 at	Steel sandblasted: 4,1 N/mm ²

Note

The specifications and recommendations given in this technical data sheet 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 guarantee the continuously high quality of our products. 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.

Shore hardness D	75
Thermal conductivity (ASTM D 257)	0,6 W/m-K
Linear shrinkage	<1 %
Electrical resistivity (ASTM D 149)	5•10 ¹¹ Ohm/cm
Dielectric strength (ASTM D 149)	3,0 kV/mm
Thermal expansion coefficient (ISO 11359)	30-40 x 10 ⁻⁶ K ⁻¹
Temperature resistance	-50 to +120 briefly +150 °C
ISSA-Code	75.530.15/01
IMPA-Code	812925/26

Surface pre-treatment

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

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.

Safety and health

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

Available sizes:

10533057	Repair Stick Steel 57 g
10533115	Repair Stick Steel 115 g

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