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 (Supersedes November 2014)

# REZI-WELD™ GEL PASTE

## Gel Consistency-Thixotropic, Multi-Purpose Construction Epoxy

### DESCRIPTION

REZI-WELD GEL PASTE is a high viscosity, rapid setting, thixotropic, structural, epoxy-based, chemical anchoring/bonding adhesive and injection resin. REZI-WELD GEL PASTE provides high mechanical properties and bond strength to concrete and various other substrates. REZI-WELD GEL PASTE is a two-component, moisture-insensitive construction epoxy, which can be troweled, brushed, injected, or pumped.

### USES

REZI-WELD GEL PASTE is an easy-to-mix, easy-to-apply paste ideal for filling cracks, anchoring, doweling, and making small patches and general repairs in horizontal, vertical, and overhead concrete surfaces. It is also suitable for surface sealing prior to pressure injection. When used as an adhesive, REZI-WELD GEL PASTE fills all voids between surfaces to be bonded.

### FEATURES/BENEFITS

- Patches and repairs vertical or overhead concrete surfaces.
- Fills all gaps between surfaces to be bonded, unlike liquid epoxy adhesives, which might run out and reduce the bond area.
- Easy to mix and apply with its trowel-grade consistency.
- Offers high viscosity, high modulus, and high strength characteristics.
- Color-coded, innovative, unitized bulk packaging assures proper mixing of two components.
- Excellent bond strength suitable for cap sealing.
- Available in side-by-side and universal cartridges.

### PACKAGING

- 1 Quart (.95 Liter) Unit
- 1 Gallon (3.79 Liter) Unit
- 2 Gallon (7.58 Liter) Unit
- 10 Gallon (37.85 Liter) Unit

### COVERAGE

One gallon (3.79 L) neat yields 231 cubic inches (3785 cm<sup>3</sup>).

### TECHNICAL DATA

The following physical properties were determined at a 1:1 mix ratio of A: B by volume, cured at 77° F (25° C) & 50% RH

Test Method	Actual	Required per ASTM C 881-99, TYPE IV
Gel Time Per ASTM C 881 <sup>1</sup>	37 minutes	Minimum 30 minutes
Viscosity Per ASTM D 2393 Mixed	3,500 cps	Maximum 10,000 cps
Compressive Strength Per ASTM D 695 @ 1 day @ 7 days <sup>1</sup>	10,000 psi (70 MPa) 12,500 psi (79 MPa)	Not Required Minimum 10,000 psi (70 MPa)
Compressive Modulus Per ASTM D 695-96 <sup>1</sup> @ 7 Days	530,000 psi (3655 MPa)	Minimum 200,000 psi (1,400 MPa)
Slant Shear Bond Strength Per ASTM C 882 <sup>1</sup> , Moist Cured @ 2 days (Old to Old Concrete) @ 14 days (Old to Old Concrete) @ 14 days (New to Old Concrete)	1,250 psi (8.6 MPa) 1,900 psi (13.1 MPa) 2,100 psi (14.5 MPa)	Minimum 1,000 psi (7.0 MPa) Minimum 1,500 psi (10.0 MPa) Minimum 1,500 psi (10.0 MPa)
Tensile Strength Per ASTM D 638 <sup>1</sup> @ 7 days	7,250 psi (51 MPa)	Minimum 7,000 psi (48 MPa)
Tensile Elongation Per ASTM D 638 <sup>1</sup> @ 7 days	1.5%	Minimum 1%
Heat Deflection Temperature Per ASTM D 648 <sup>1</sup> @ 7 days	135° F (57° C)	Minimum 120° F (50° C)
Linear Coefficient of Shrinkage Per ASTM D 2566 <sup>1</sup> @ 7 days	0.002	Maximum 0.005
Water Absorption Per ASTM D 570 <sup>1</sup> @ 7 Days	0.41% w/w	Maximum 1.0% w/w

**Colors:** Part A ... White      **Pot Life:** 35 - 45 minutes @ 77° F (25° C)  
 Part B ... Black      **Cure Time:** 7 days @ 77° F (25° C)

**Mix ratio:** 1:1 by volume

All technical data is typical information, but may vary due to testing methods, conditions, and operators.

<sup>1</sup>Independent reports are available upon request.

**CONTINUED ON THE REVERSE SIDE...**

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## SHELF LIFE

One year when stored in unopened containers in dry conditions. Store between 40° - 95° F (4.4° - 35° C). Do not store product outside.

## SPECIFICATIONS

- AASHTO M 235, Type I, II, IV & V, Grade 3, Classes B & C
- ASTM C 881, Type I, II, IV & V, Grade 3, Classes B & C
- Various Departments of Transportation Approvals

## APPLICATION

**Surface Preparation** ... Mechanically roughen or abrasive blast concrete substrate. Remove all unsound concrete and provide a profiled surface. Substrate must be structurally sound, dust-free, and free of grease, oil, dirt, curing compounds, release agents, or any other surface or penetrated contaminants, coatings, sealers, or similar that will adversely affect bond. Sanding, acid etching, cup-grinding, or wire-abrading are not approved concrete surface preparation methods. Vacuum or blow away dust with oil-free compressed air.

Smooth surfaces, such as wood, require sanding or other mechanical abrasion. Exposed steel surfaces should be sandblasted and vacuumed clean . . . if not possible, degrease the surface and use sandpaper or a wire brush to reveal continuous, bright metal.

**Mixing (Bulk Units)** ... Condition all components to above 65° F (18.3° C) for 24 hours prior to use. Use the double-boiler method or store material in a warm room for 24 hours prior to application. Pre-mix each component. Mechanically mix at slow speed (600-900 rpm) using a drill and Jiffy® Blade or drum mixer for three minutes or until completely mixed while scraping the sides to ensure complete blending of components. The mixed product should be uniform gray in color and not show streaks. Avoid air entrapment. Mix only very small quantities by hand for a minimum of three minutes and uniform gray in color. Scrape the sides of the container to ensure complete blending of the components. Mix only the amount of epoxy that can be applied within the product's pot life. Pot life will decrease as the ambient temperature and/or mass size increases.

## Metal Anchors in Preformed Holes in

**Concrete** ... Preformed holes should be approximately 1/8" (3.175 mm) larger in diameter than the anchor bolt diameter. The depth of the hole should be 10-15 times the bolt diameter. Fill the hole from the bottom up, about half way, with mixed epoxy and place the bolt, dowel, or rebar. Top off with more epoxy and finish. All anchoring and doweling configurations must be approved and/or designed by an engineer.

**Cracks in Vertical or Overhead Structures** ... For non-moving cracks and joints, use a trowel to apply the paste full depth and strike off flush at the surface in a single pass. For structural crack injection repairs, use a dual-component gel pump. REZI-WELD GEL PASTE is not recommended for overhead applications.

**Patches in Concrete Structures** ... REZI-WELD GEL PASTE makes a high-strength material for patching, topping, grouting, and repairing spalls and other defects in concrete. Average thickness of the patch or topping should be no greater than 1/4" to 1/2" (6.35 to 12.7 mm) per lift, not to exceed a total depth of 1 1/2" (38 mm).

**Surface Sealing** ... Apply mixed epoxy over entire length of crack to be pressure injected. Ensure complete coverage to avoid leaking. Adjacent concrete surfaces must be mechanically abraded to ensure a proper bond. Allow for suitable cure time prior to injecting.

## Bonding Fresh Concrete to Hardened Concrete or Hardened Concrete to Hardened Concrete

Use a stiff masonry brush to apply a layer of mixed epoxy to concrete surfaces. Application rate should be 85-100 sq. ft./gal. Place fresh or hardened concrete to mixed REZI-WELD GEL PASTE prior to epoxy becoming tack-free. If REZI-WELD GEL PASTE becomes tack-free prior to application of fresh or hardened concrete, consult a W. R. MEADOWS representative.

**Other Bonding** ... To bond metal to concrete, apply a layer of the adhesive [at 85-100 sq. ft./gal. (20 mils)] to the prepared surface and join immediately. Clamping pressure, beyond what will hold parts in place, is not necessary.

**Cleanup** ... Clean tools and equipment immediately with toluene or xylene. Clean equipment away from all ignition sources.

## PRECAUTIONS

DO NOT DILUTE. Mix complete units only. Not recommended for use when the concrete temperature has been below 40° F (4° C) for the past 24 hours. Do not use to seal cracks under hydrostatic pressure. Do not warm epoxy over direct heat.

## HEALTH AND SAFETY

Failure to follow all industry standard practices, such as the American Concrete Institute (ACI), will compromise the performance of REZI-WELD GEL PASTE. Product should not be applied to existing concrete until it is at least 14 days old and has reached 80% of its original design strength. Not intended for submerged or continuously saturated conditions. Minimum air and substrate temperature is 45° F (7.2° C) and rising for 48 hours. Do not apply when rain is expected within 24 hours. High ambient (air), product, and substrate temperatures will decrease working time. Overhead applications must be approved and/or designed by a professional engineer to ensure durability and long term bonding/anchoring. Creep and service temperature must be considered in structural applications. Cold ambient (air), product, and/or substrate temperature will increase working, cure, and bolt-up time. This data sheet does not supersede engineering or architectural recommendations or drawings. A professional engineer must determine suitability of REZI-WELD GEL PASTE for anchoring, doweling, or similar applications. This is not a standalone engineering document. DO NOT DILUTE. Mix complete units only. Not recommended for use when the ambient and substrate temperature is below 40° F (4° C) for the past 24 hours or when rain is imminent. Do not seal cracks under hydrostatic pressure. Do not warm epoxy over direct heat.

## HEALTH AND SAFETY

Avoid breathing vapors or allowing epoxy-containing solvent to contact skin. Should this material come in contact with the skin, wash thoroughly with soap and water, not solvent. Unused epoxy will generate excessive heat, especially in large quantities. Unused epoxy should be mixed with dry sand in the container to help lower heat. Refer to Safety Data Sheet for complete health and safety information.

**For most current data sheet, further LEED information, and SDS, visit [www.wrmeadows.com](http://www.wrmeadows.com).**



**LIMITED WARRANTY**

W. R. MEADOWS, INC. warrants at the time and place we make shipment, our material will be of good quality and will conform with our published specifications in force on the date of acceptance of the order. Read complete warranty. Copy furnished upon request.

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