

## Pipe repair - emergency



1. Empty and clean the leaking pipe and grind it with emery paper or the like. See Wencon surface preparation, next page.



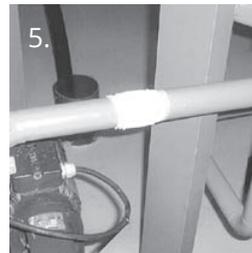
2. Unpack the Wencon Pipe Tape and submerge it in water for 30-40 seconds. For higher pressure, use Wencon Putty. (se fig. 6)



3. Wrap the Wencon Pipe Tape tight around the pipe. (min. 9 circles)



4. Dip the gloves in water and smoothen the surface with your hands.



5. After 10 minutes the products semi cures, and after 60 minutes it is fully cured (at 20°C (50-68°F).



6. If the pipe cannot be emptied, use the Wencon Putty. Eventually hold it in place with a small metal plate and a steel band, before applying the pipe tape.

### Technical Data

Pipe pressure without Wencon Putty: 10 Bar\*)  
 Pipe pressure with Wencon Putty: 50 Bar\*)  
 Flexural strength: ASTM D709 111 N/mmsq.  
 Tensile strength: ASTM D638 172 N/mmsq.  
 Compression strength: ASTM D695 180 N/mmsq.  
 Adhesion at one-inch single overlap: 19 N/mmsq.  
 Dielectric strength: 16 KV/mm

### Temperature Resistance

Continuous: 120°C (248°F)  
 Peak: 150°C (310°F)

### Chemical Resistance

Water, salt water, oil, diluted acids and alkalis.

### Handling Precautions

Read the instructions for use and the Material Safety Data Sheet

\*) Laboratory tests have shown much higher values, but the mentioned values will count for repairs done in situ. Users are advised to make their own tests if in doubt.

Pipe Diameter	Pipe Circ.	9 x Circles	Wencon Pipe Tape	Wencon Pipe Tape	Max pressure with Putty *)	Max pressure without Putty *)
mm	mm	mm	5cm x 150cm	5cm x 350cm	Bar/P.s.i.	Bar/P.s.i.
15	47	423	One		50/725	10/145
20	63	567	One		50/725	10/145
25	79	707	One		50/725	10/145
32	101	905	One		50/725	10/145
40	126	1131	One		50/725	10/145
50	157	1414	One		50/725	10/145
80	251	2262	Two	One	45/652	10/145
100	314	2828	Two	One	40/580	10/145
125	393	3535		One	35/510	10/145
150	471	4242		Two	30/430	8/120
200	628	5656		Two	25/360	5/70
250	786	7070		Two	20/290	5/70
300	943	8483		Three	10/145	5/70

## Wencon surface preparation

Choose the relevant surface preparation, depending on the nature of the job.

Surface preparation using dry blasting methods:

Application with Wencon products on a dry surface, at minimum 3°C. above dew point.

1. Blast the machine part to SA 2,5 using sharp-edged blasting media, to a roughness of min. 75 microns.
2. Leave the part for sweating out salts in a warm place for at least 12 hours or heat it up to 30 - 40°C (86-104 °F) using gas torches.
3. Blast again to SA 2,5, prior to the application.
4. For parts containing a lot of water and salt, it may be necessary to repeat point 2 and 3, until the surface remains light grey, for at least 2 hours after blasting.
5. For optimal adhesion of Wencon products, always use Wencon Bio Cleaner or Wencon Cleaner prior to application. Follow one of below two methods:
  - 5.1 **Wencon Bio Cleaner**  
**Wet surface:** Apply Wencon Bio Cleaner and let it work for 5-10 min. If necessary use a brush, to make sure the surface is clean. Rinse off with clean water and wipe off with an absorbing cloth. Apply Wencon UW Coating as a primer, and hereafter any Wencon products can be applied.  
  
**Dry surface:** Apply Wencon Bio Cleaner and let it work for 5-10 min. If necessary use a brush, to make sure the surface is clean. Rinse off with clean water and dry with an absorbing cloth or with compressed air for a completely dry surface. Hereafter any Wencon products can be applied.
  - 5.2 **Wencon Cleaner**  
After surface preparation, apply Wencon Cleaner with a brush and allow the product to evaporate before applying other Wencon products. Wencon Cleaner is non-flammable. Use only in large or well ventilated rooms.

Surface preparation using wet/damp methods:

Water jet the entire surface with water and sand to a standard, equal to SA 2,5 as described above.

If the surface is left wet after surface preparation, is it important to dry out the surface or alternatively use a Wencon UW product as a primer.

Surface preparation for emergency/temporary applications:

If above surface preparation methods are not possible, it may be necessary to use one of below methods:

- Blasting
- Grinding
- Needle Gunning

In emergency / temporary applications it may be difficult to prepare the surface according to above methods. In any case, it is important to clean the surface to SA 2,5 and 75 microns roughness. If possible dry the surface before applying. If not possible, use Wencon UW products prior to applying any other Wencon products.

For further information on Wencon surface preparation, please contact our Area Sales Managers.