

## PHYSICAL PROPERTIES

Application time	
Working time at 70°F	20 minutes
Initial set at 70°F	6 hours
Bond strength to concrete (ASTM D-4541)	Concrete failure
Components	2 part
Percent solids	100%
Thickness	5-10 mils

Physical properties were determined on specimens prepared under laboratory conditions using applicable ASTM procedures. Actual field conditions may vary and yield different results; therefore, data are subject to reasonable deviation.

ConoWeld No. 501 is a primer to be used in conjunction with the Sauereisen line of epoxy coatings, linings and flooring materials. ConoWeld No. 501 is applied by spray, brush or roller over concrete and steel.

This primer is an integral part of the Sauereisen lining system in that it seals porous substrates and promotes adhesion of the specified protective material. Easy application properties help to reduce total downtime.

## CHARACTERISTICS

- Seals porous substrates and promotes adhesion of topcoats.
- Easy to apply - brush, roll, or spray.
- No noxious or toxic odors during application.

## AREA PREPARATION

### Temperature of Working Area

Maintain a temperature of 60°-85°F on air, substrate, Liquid, and Hardener components during mixing, application, and cure. The material components should be maintained at 65°F to 85°F for 48 hours prior to beginning work.

At temperatures below 65°F, the application becomes more difficult and curing is retarded. Above 80°F, the material working time decreases.

Application in direct sunlight and rising surface temperatures may result in blistering of materials due to expansion of entrapped air or moisture in the substrate. Concrete that has been in direct sunlight must be shaded 24 hours prior to application and remain shaded until after the initial set. When the surface temperatures are rising, it may be necessary to postpone the application or to apply during cooler hours.

### Surface Preparation

**New Concrete** - All structures must have the necessary strength to withstand imposed loads during normal use and operation. Surface should be floated free of ridges or depressions and all voids are to be filled with Sauereisen Underlayment No. F-120 or Filler Compound No. 209. The choice of underlayment will depend on the severity of the voids to be filled. Surfaces should be sloped a maximum of 1/4 inch per foot for drainage.

Surfaces should be made free of oil, grease, water, and other contaminants that may inhibit bond. This can be achieved by chemical cleaning. Abrasive blast, high-pressure water blast, or acid etch concrete to remove laitance and obtain uniform surface texture exposing fine aggregate resembling coarse sandpaper.

**Old Concrete** - Concrete must be dry, firm and must have the necessary strength to withstand imposed loads during normal use and operation. Mechanical methods should be utilized to remove laitance, old paints, protective coatings, and attacked or deteriorated concrete. Surfaces should be made free of oil, grease, water, and other contaminants that may inhibit bond. This can be achieved by chemical cleaning.

Abrasive blast, high-pressure water blast, or acid etch concrete to obtain uniform sound substrate. All prepared surfaces must be allowed to dry prior to the primer application.

All structural cracks should be repaired with Filler Compound No. 209, and all slopes reestablished with Underlayment No. F-120 prior to applying ConoWeld.

Prior to application of the Sauereisen epoxy topcoat, inspect the primed surface for voids, bubbles or defects that may result in blistering or pinholes in the lining. Repair with Sauereisen Filler Compound No. 209 Fast Set to ensure a sealed surface.

**Brick** - Surfaces should be made free of oil, grease, water, and other contaminants that may inhibit bond. This can be achieved by chemical cleaning. Abrasive blast or high-pressure water blast all foreign particles and attacked or unsound mortar from the joints. Loose brickwork should be regouted with appropriate Sauereisen mortar to ensure structural integrity. Mortar joints should be repointed to be flush with the face of the masonry units.

**Metal** - Abrasive blast to a nominal 2.5 mil profile employing SSPC-SP5 White Metal Blast for immersion and SSPC-SP10 Near White Metal Blast for other service conditions. An SSPC SP-6 Commercial Blast is acceptable for some applications in which the Sauereisen General Purpose Systems are specified. All welds must be continuous, free of flux and have a smooth rounded radius without any sharp edges.

If chemical cleaning is utilized to remove contaminants, the substrate must be neutralized. When abrasive or high-pressure water blasting is used as the method of surface preparation, all sand and/or debris must be removed by thoroughly vacuuming the area with an industrial vacuum cleaner. If the surface does not have desired conditions, repeat surface preparation procedures.

## APPLICATION

### Mixing

ConoWeld primer is packaged in premeasured containers consisting of Hardener Part A and Resin Part B which must be mixed together before use. Remix the Part A and Part B before combining.

Completely empty contents of Hardener Part A into Resin Part B container. Using a slow speed 1/2 inch drill motor with a "Jiffy" type blade mix thoroughly until blended for 3 minutes. Primer is ready for use immediately after mixing.

### Installation

Apply primer to concrete or steel using either a short nap adhesive roller with a nondegradable core, or a nylon bristle brush. For horizontal applications, pour primer onto the surface and spread with a squeegee before backrolling or brushing.

ConoWeld may also be sprayed using airless spray equipment. Typical application thickness is 5-10 mils. Consult Sauereisen for specific details.

## COVERAGE

1 gallon unit	200 ft <sup>2</sup> at 8 mils thick.
3 gallon unit	600 ft <sup>2</sup> at 8 mils thick

\*Coverage is theoretical and will vary depending upon surface conditions, porosity, application techniques, and project specifics.

## SETTING/CURING

The necessary cure time of ConoWeld No. 501 will vary depending on the topcoat that is used. In certain cases, application may proceed while the primer is firm, but tacky. Adhere to the following guidelines for the cure time required with different Sauereisen epoxy coatings.:

*FibreCrete, ConoGlaze* - At 70°F, primer should be allowed to cure for eight hours, but no longer than 24 hours, prior to application of FibreCrete or ConoGlaze. If topcoat time exceeds 24 hours, consult Sauereisen.

*ConoCrete, Epoxy Polymer Concrete* - Epoxy polymer concretes and ConoCrete floor coatings can be placed immediately after application of primer, but within 6 hours. ConoCrete should be applied while the primer is wet to tacky. If topcoat time exceeds 6 hours, consult a Sauereisen representative.

*ConoSpread* - After primer is applied, a six hour cure at 70°F is ideal prior to installing the ConoSpread system. In any event, the ConoSpread should be placed within 24 hours. Consult Sauereisen before deviating from any curing recommendations.

## PACKAGING

### No. 501-G (1 Gallon unit)

Part A Hardener - 2.85 lbs, packaged in a 1 gallon metal can

Part B Liquid - 6.43 lbs., packaged in a 1 gallon metal can

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### No. 501-T (3-Gallon unit)

Part A Hardener - 8.56 lbs. packaged in a 2-1/2 gallon metal pail

Part B Liquid - 19.29 lbs. packaged in a 3 1/2 gallon plastic pail.

*Containers are filled by weight, not volume. Container size does not indicate volume of contents.*

## CLEAN-UP

All equipment should be cleaned with MEK before material cures. If removal is required after cure, consult Sauereisen for recommendations.

## SHELF LIFE

ConoWeld Liquid and Hardener components have a shelf life of one (1) year when stored in unopened, tightly sealed containers in a dry location at 70°F. If there is a doubt as to the quality of the materials, consult a Sauereisen representative.

## CAUTION

Consult Material Safety Data Sheets and container label Caution Statements for hazards in handling these materials.

## WARRANTY

We warrant that our goods will conform to the description contained in the order, and that we have good title to all goods sold. WE GIVE NO WARRANTY, WHETHER OF MERCHANTABILITY, FITNESS FOR PURPOSE OR OTHERWISE, EXPRESS OR IMPLIED, OTHER THAN AS EXPRESSLY SET FORTH HEREIN. We are glad to offer suggestions or to refer you to customers using Sauereisen Cements and Compounds for a similar application. Users shall determine the suitability of the product for intended application before using, and users assume all risk and liability whatsoever in connection therewith regardless of any suggestions as to application or construction. In no event shall we be liable hereunder or otherwise for incidental or consequential damages. Our liability and your exclusive remedy hereunder or otherwise, in law or in equity, shall be expressly limited to our replacement of nonconforming goods at our factory or, at our sole option, to repayment of the purchase price of nonconforming goods.

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