

1954 – Weld-On® pioneered the solvent cement industry

The plastic piping era in the United States began with the introduction of Weld-On®'s first plastic pipe cement. Ever since, Weld-On cements, cleaners and primers have been delivering industry-leading performance and revolutionizing plastic piping assembly.

Today's Weld-On® – all low-VOC, all the time

Recognized as the world's premium line of products for joining plastic pipes and fittings, today's Weld-On solvent cements, primers and cleaners all meet low-VOC (Volatile Organic Compound) emission limits. These eco-friendly, plumber-friendly products are yet another industry first, from the industry's first plastic pipe cement provider.



		COLOR	GRADE	Nominal Pipe Size	mm in	20 1/2	25 3/4	32 1	40 1 1/4	50 1 1/2	63 2	75 2 1/2	90 3	110 4	160 6	200 8	250 10	315 12	355 14	600 24	800 30
Primers		AQUA BLUE	I	P75																	
		PURPLE CLEAR	I	P70																	
		PURPLE CLEAR	P	Plumbing Primer																	
Specialty		GREEN	P	794***																	
		LIGHT AMBER	P	790**																	
ABS		BLACK	P	778																	
		BLACK	P	773																	
		W/WHITE	P	771																	
CPVC		GRAY	I	729																	
		ORANGE GRAY	I	724 [∅]																	
		ORANGE GRAY	I	714																	
		ORANGE	P	713																	
		YELLOW	P	Flow ^{†a} Guard Gold [®]																	
PVC	SPECIALTY CEMENTS	CLEAR BLUE	P	795																	
		CLEAR BLUE	I	738 [†]																	
		CLEAR BLUE	P	737 [†]																	
		CLEAR BLUE	P	735 [†]																	
		CLEAR BLUE	P	727 [†]																	
		CLEAR BLUE	I	725 [†]																	
	EXTRA HEAVY BODY	GRAY WHITE	I	719																	
		GRAY	P	782																	
	HEAVY BODY	GRAY	I	711																	
		GRAY	P	781 [†]																	
	MEDIUM BODY	BLUE	I	721 [†]																	
		CLEAR GRAY	I	705 [†]																	
	REGULAR BODY	CLEAR GRAY	P	781 [†]																	
		CLEAR	I	710																	
		CLEAR	P	702																	
		CLEAR	P	780																	

For assistance in selecting the right Weld-On® products for your application, please refer to the selection guide.

Pipe Format

- ☐ Schedule 40/PN3.2, PN4, PN6
- ☒ Schedule 80/PN10, PN16

[†] Can be used without a primer with fittings having an interference fit (unless primer required by local code).

^a Flow Guard Gold® is a registered trademark of the Lubrizol Corp.

[∅] For CPVC and PVC Chemical Piping Systems

** PVC, CPVC, ABS and Styrene Pipes

*** ABS to PVC Transition Joints

CTS: Copper Tube Size

P: Plumbing Grade

I: Industrial Grade



Solvent Cement Average Set and Cure Times



AVERAGE INITIAL SET SCHEDULE FOR WELD-ON PVC/CPVC SOLVENT CEMENTS**

Temperature Range	Pipe Sizes ½" to 1¼" 20mm to 40mm	Pipe Sizes 1½" to 2" 50mm to 63mm	Pipe Sizes 2½" to 8" 75mm to 200mm	Pipe Sizes 10" to 15" 250mm to 380mm	Pipe Sizes 15"+ 380mm +
60°-100°F/16°-38°C	2 minutes	5 minutes	30 minutes	2 hours	4 hours
40°-60°F/5°-16°C	5 minutes	10 minutes	2 hours	8 hours	16 hours
0°-40°F/-18°-5°C	10 minutes	15 minutes	12 hours	24 hours	48 hours

Note – Initial set schedule is the necessary time to allow before the joint can be carefully handled.
In damp or humid weather allow 50% more set time.

** These figures are estimates based on testing done under laboratory conditions. Field working conditions can vary significantly. This chart should be used as a general reference only.

AVERAGE JOINT CURE SCHEDULE FOR WELD-ON PVC/CPVC SOLVENT CEMENTS**

Relative Humidity 60% or Less	Pipe Sizes ½" to 1¼" 20mm to 40mm		Pipe Sizes 1½" to 2" 50mm to 63mm		Pipe Sizes 2½" to 8" 75mm to 200mm		Pipe Sizes 10" to 15" 250mm to 380mm	Pipe Sizes 15"+ 380mm +
Temperature range during assembly and cure periods	up to 160 psi/ 11 Bar	160 to 370 psi/ 11 to 26 Bar	up to 160 psi/ 11 Bar	160 to 315 psi/ 11 to 22 Bar	up to 160 psi/ 11 Bar	160 to 315 psi/ 11 to 22 Bar	up to 100 psi/ 7 Bar	up to 100 psi/ 7 Bar
60°-100°F/16°-38°C	15 min	6 hrs	30 min	12 hrs	1½ hrs	24 hrs	48 hrs	72 hrs
40°-60°F/5°-16°C	20 min	12 hrs	45 min	24 hrs	4 hrs	48 hrs	96 hrs	6 days
0°-40°F/-18°-5°C	30 min	48 hrs	1 hour	96 hrs	72 hrs	8 days	8 days	14 days

Note – Joint cure schedule is the necessary time to allow before pressurizing system.
In damp or humid weather allow 50% more cure time.

** These figures are estimates based on testing done under laboratory conditions. Field working conditions can vary significantly. This chart should be used as a general reference only.

AVERAGE NUMBER OF JOINTS/QUART (1Kg) OF WELD-ON CEMENT*

Pipe Diameters	½" 20mm	¾" 25mm	1" 32mm	1½" 50mm	2" 63mm	3" 90mm	4" 110mm	6" 160mm	8" 200mm	10" 250mm	12" 315mm	15" 380mm	18" 450mm
Number of Joints	300	200	125	90	60	40	30	10	5	2-3	1-2	¾	½

Note – For Primer: Double the number of joints shown for cement.

* These figures are estimates based on our laboratory tests. Due to the many variables in the field, these figures should be used as a general guide only. **Note: 1 Joint = 1 Socket**

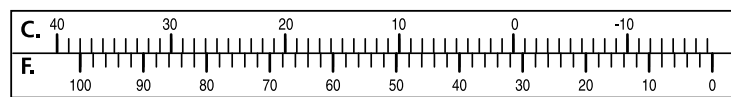
PIPE SIZE EQUIVALENT CHART – INCHES/MILLIMETERS

in.	½"	¾"	1"	1¼"	1½"	2"	2½"	3"	4"	6"	8"	10"	12"	14"	18"	24"	30"
mm.	20	25	32	40	50	63	75	90	110	160	200	250	315	355	450	600	800

PRODUCT SHELF LIFE

Weld-On Products	Shelf-life
Primers / Cleaners	3 years
PVC Solvent Cement	3 years
CPVC Solvent Cement	2 years

FAHRENHEIT TO CELSIUS CONVERSION CHART



Can Applicator Brushes and Daubers

- Available in fixed and adjustable handle styles
- Options for ¼ pint, ½ pint, pint and quart cans
- Designed to fit standard pint and quart can types

Product Code #	Product Description	Model Number	UPC Barcode	Cubic ft./Case	Units/Case	Lbs/Case
12121	PB-1 Brush in Plastic Cap w/Handle for Pt. & Qt. Cans	006010000	012181-121214	1.014	25	3
10963	CM-BCP Can-Mate™ Adjustable Plastic Brush	001930000	012181-109632	1.014	25	2
12307	CM-50 Can-Mate™ Adjustable ½" Dauber	001730000	012181-123072	0.335	50	2
10832	CM-75 Can-Mate™ Adjustable ¾" Dauber	001720000	012181-108321	0.335	50	2
10833	CM-150 Can-Mate™ Adjustable 1 ¼" Dauber	001710000	012181-108338	0.335	50	2
10004	DP-75 Cap Dauber for ¾" up to 1 ½" Pipe Diameter	006150000	012181-100042	0.330	50	2
10005	DP-150 Cap Dauber 1 ½" for up to 3" Pipe Diameter	006160000	012181-100059	0.010	50	2
12429	DQ-75 Cap Dauber ¾" for up to 1 ½" Pipe Diameter	006580000	012181-124291	0.335	50	2
10006	DQ-150 Cap Dauber 1 ½" for up to 3" Pipe Diameter	006170000	012181-100066	0.010	50	3
13199	DH-38, ¾" Cap Dauber for FlowGuard Gold® ¼ & ½ Pint Cans	006200000	012181-131992	0.335	50	2
10003	Pint Sized Cap Dauber ¾" for FlowGuard Gold®	006190000	012181-100035	0.315	50	2
11831	DQ-50, ½" Cap Dauber for FlowGuard Gold® Qt. Can	006180000	012181-118313	0.010	50	2



Can Applicator Rollers and Swabs

- Available in a range of applicator options
- Products designed to handle 3"-8" pipe diameters
- Applicator options to fit standard and empty cans
- Suitable for empty and wide-mouth cans

Product Code #	Product Description	Model Number	UPC Barcode	Cubic ft./Case	Units/Case	Lbs/Case
10007	3020 Roll-A-Weld 3" Roller for MT-653 Qt. Can	006300000	012181-100073	0.010	24	6
11957	6020 4" Roller for MT-651 Qt. Can	006330000	012181-119570	0.010	24	7
10008	7020 Jumbo Roll-A-Weld 7" Roller for MT-648 Gal. Can	006310000	012181-100080	0.010	20	7
10009	4020 4" Swab for MT-648 Gal. Can	006320000	012181-100097	0.010	24	5
12071	5020 4" Swab for MT-651 Qt. Can	006340000	012181-120712	0.010	24	4
13360	8020 4" Cotton Swab, Wire Handle for 6" Diameter or Larger Pipe	13360	012181-133606	0.010	24	6



SuperSwab™ Applicator NEW

- Shed-resistant swab material-best for smooth full application of cements or primers
- Product designed to handle 4"-8" pipe diameters
- Extra-long handle for convenient grip
- Adjustable length and dual cap design that fits quart and gallon containers
- Disposable swab, reusable handle

Product Code #	Product Description	Model Number	UPC Barcode	Cubic ft./Case	Units/Case	Lbs/Case
14108	SuperSwab (swab and handle included)	14108	012181-141083	0.9308	12	3.5
14111	SuperSwab - bulk pack (swabs and handles included)	14111	012181-141113	0.9308	24	4
14109	Replacement swabs (4 swabs per bag)	14109	012181-141090	0.1984	3 bags	3.5
14112	Replacement swabs - bulk pack	14112	012181-141120	0.9308	24	4



Empty Solvent Welding Containers

- Applicator not included

Product Code #	Product Description	Model Number	UPC Barcode	Cubic ft./Case	Units/Case	Lbs/Case
10010	MT-648 Gal. Can with 2 ⅝" Neck	006480000	012181-100103	0.010	6	5
10012	MT-651 Qt. Can with 1 ¾" Neck	006510000	012181-100127	0.010	12	3
10014	MT-653 Qt. Can with Triple Tight Paint Can	006530000	012181-100141	0.010	12	3
10015	MT-654 Pt. Can with 1 ¾" Neck	006540000	012181-100158	0.010	12	2



FlowGuard Gold® is a registered trademark of The Lubrizol Corporation.