

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***		ALL CLASSES & SCHEDULES EXCEPT SCHEDULE 80															
		LIGHT AMBER	P	790**																	
ABS		BLACK	P	778		ALL CLASSES & SCHEDULES															
		BLACK	P	773		ALL CLASSES & SCHEDULES															
		BLACK	P	771		ALL CLASSES & SCHEDULES															
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																	
	HEAVY BODY	GRAY	P	782																	
		GRAY	I	711																	
	MEDIUM BODY	BLUE	I	721 [†]																	
		CLEAR GRAY	I	705 [†]																	
		CLEAR GRAY	P	781 [†]																	
	REGULAR BODY	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**

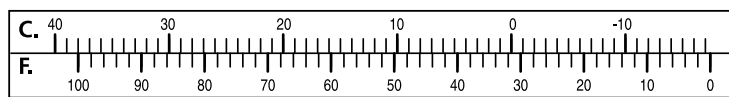
PIPE SIZE EQUIVALENT CHART – INCHES/MILLIMETERS

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



CATEGORY *

Cement and Primer Carriers



CanTote™ Carrier

• For carrying quart and pint cans

Product Code #	Product Description	Model Number	UPC Barcode	Cubic ft./Case	Units/Case	Lbs/Case
12891	CanTote™ for carrying quart & pint cement cans	001870000	012181-128916	1.790	24	14
10864	Can-Mate® Carrier/2 Dauber Kit for ½ pt., pt. & qt. cans	001840000	012181-108642	0.010	24	3



Can-Mate® Carrier

Plastic Pipe Prep Tools



• Plastic pipe cable saw features T-handles

• Deburring tool for PVC, CPVC, ABS, PE & PB pipe

Product Code #	Product Description	Model Number	UPC Barcode	Cubic ft./Case	Units/Case	Lbs/Case
12739	36" Plastic Pipe Cable Saw for up to 8" Diameter T-Style Handle	CST-36	012181-127391	0.010	24	2
12079	DEB-2 Plastic Pipe Deburring Tool for Sizes ½" – 2" IPS	006350000	012181-120798	0.010	6	2

Gluebuster Professional Hand Cleaner



• Advanced hand cleaner in liquid format for removing residual solvent cements (PVC, CPVC, ABS), primers and sealants, dirt, oil, grease and much more

Product Code	Product Description	Model Number	UPC Barcode	Cubic ft./Case	Units/Case	Lbs/Case
12752	Pt. Advanced liquid hand cleaner	006220000	012181-127520	0.010	12	13

Professional Hand Cleaner Wipes



• Advanced hand cleaner in disposable wipe format for removing residual solvent cements (PVC, CPVC, ABS), primers and sealants, dirt, oil, grease and much more

Product Code #	Product Description	Model Number	UPC Barcode	Cubic ft./Case	Units/Case	Lbs/Case
12762	10" x 12" Advanced strong hand cleaner wipes (72 wipes per container)	0002110000	012181-127629	0.010	6	14