

WEICON HB 300



ISSA-Code 75.509.21
IMPA-Code 812951

pasty
steel-filled
high-temperature-resistant up to +280 °C (536 °F)
for short periods of time

WEICON HB 300 is pasty, steel-filled and resistant to high temperatures up to 200 °C (392 °F) (for short periods up to 280 °C/536 °F). It is processed in a mixing ratio of 1:1.

The epoxy resin system is also suitable for applications on vertical surfaces and can be used for repairs and adhesive bonding of castings and metal parts, for filling blowholes, for repairing damages on containers, car bodies and machine parts, and for sealing pumps and pipes. The product can be used in mechanical and industrial engineering, in equipment engineering, and in many other areas of industry.

Characteristics

Base	epoxy
Filler	steel
Texture	pasty
Colour after curing	dark-grey

Processing

Processing temperature	+15 °C up to +40 °C
Component temperature	>3 °C over dew point
Relative air humidity	max. 85 %
Mixing ratio by weight	100:100
Mixing ratio by volume	100:90
Viscosity of the mixture at 25 °C and 20 1/s	1,700,000 mPa·s
Density of the mixture	2.5 g/cm³
Consumption at layer thickness of 1.0 mm	2.5 g/cm²
Max. layer thickness per work step	20 mm

Curing

Pot life at 20 °C, 500g batch	30 min.
Repeated application possible after (35 % strength)	6 h
Capable of bearing mechanical loads (80 % strength)	10 h
Final strength after (100 % strength)	24 h
Shrinkage	0.15 %

Mechanical properties after curing

Tensile strength	DIN EN ISO 527-2	50 MPa
Elongation at break (tensile)	DIN EN ISO 527-2	0,7%
E-modulus (tensile)	DIN EN ISO 527-2	7000-7200 MPa
Compressive strength	DIN EN ISO 604	100 MPa
Bending strength	DIN EN ISO 178	42 MPa
Hardness (Shore D)	DIN ISO 7619	85±3
Adhesive strength	DIN EN ISO 4624	20 MPa
Lap shear strength material thickn. 1.5mm	DIN EN 1465	
Steel 1.0338 sandblasted		14 MPa
Stainless steel V2A sandblasted		15 MPa
Aluminium sandblasted		8 MPa
Galvanized steel		3 MPa

Thermal parameters

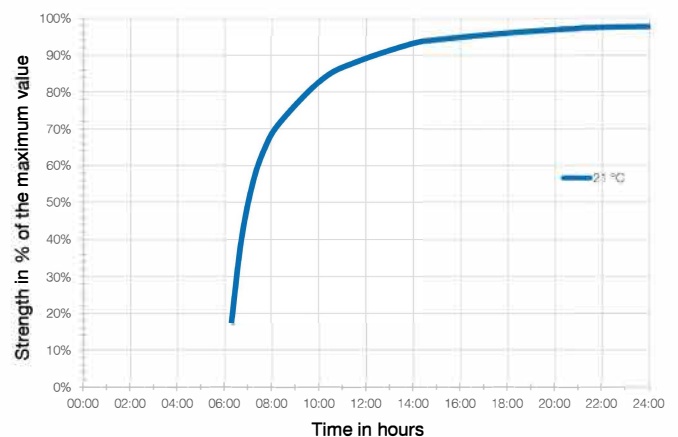
Temperature resistance		-35 °C up to +200 °C, up to +280 °C for short periods of time
T _g after curing at room temperature	(DSC)	approx. +57 °C
T _g after tempering (at 120 °C)	(DSC)	+ 92 °C
Heat deflection temperature	DIN EN ISO 75-2 (B)	+100 °C*
Thermal conductivity	DIN EN ISO 22007-4	0.5 W/m·K
Heat capacity	DIN EN ISO 22007-4	0.63 J/(g·K)

Electrical parameters

Resistivity	DIN IEC93	1.5·10 ¹³ Ωm
Magnetic		yes

* after tempering

Increase in strength



Note

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Instructions for use

When using WEICON products, the physical, safety-related, toxicological and ecological data and regulations in our EC safety data sheets (www.weicon.com) must be observed.



Surface pre-treatment

The successful application of WEICON HB 300 depends on the thorough preparation of the surfaces. This is the most important factor for overall success. Dust, dirt, oil, grease, rust and moisture or wetness have a negative impact on the adhesion. Therefore, before processing WEICON HB 300, the following points must be observed:

The surfaces must be free of any oil, grease, dirt, rust, oxides, paint and other impurities or residues. For cleaning and degreasing, we recommend WEICON Cleaner Spray S.

Smooth and particularly heavily soiled surfaces should additionally be treated by mechanical surface pre-treatment, e.g. by grinding or preferably by blasting. In case of blasting, the surface should be brought to a degree of purity of SA 2 1/2 - "Near White Blast Cleaning" (according to ISO 8501/1-2, NACE, SSPC, SIS). In order to achieve an optimum surface roughness of 75 - 100 µm, angular, disposable blasting media (aluminum oxide, corundum) should be used. The surface quality is negatively influenced by the use of reusable blasting media (slag, glass, quartz) but also by ice blasting. The air for blasting must be dry and oil-free.

Metal parts that have come into contact with sea water or other salt solutions should first be rinsed thoroughly with demineralised water and, if possible, left to rest overnight so that all salts can be dissolved from the metal. Before each application of WEICON HB 300, a test for soluble salts should be carried out according to the Bresle method (DIN EN ISO 8502-6).

The maximum amount of soluble salts remaining on the substrate should not exceed 40 mg/m². Heating and repeated blasting of the surface may be necessary to remove all soluble salts and moisture.

After each mechanical pre-treatment, the surface should be cleaned again with WEICON Cleaner Spray S and protected from further contamination until the coating is applied.

Areas where no adhesion to the substrate is desired must be treated with silicone-free mould release agents. For smooth surfaces, we recommend WEICON Mould Release Agent Liquid F 1000 or, for porous surfaces, WEICON Mould Release Agent Wax P 500.

After the surface pre-treatment, WEICON HB 300 should be applied as soon as possible (within one hour) to avoid oxidation, flash rust or new contamination.

Mixing

First, stir the resin. Then mix the resin and hardener together thoroughly and bubble-free for at least four minutes at 20°C (68°F). The included processing spatula or a mechanical mixer, such as a mortar stirrer, can be used for this purpose. With mechanical mixers, a low speed of max. 500 rpm should be used. The components should be stirred until a homogeneous mixture is achieved. The mixing ratio of the two components must be strictly observed, as otherwise, strongly deviating physical values will result (max. deviation +/- 2 %). Only prepare a batch as large as can be processed within the pot life of 30 minutes. The specified pot life refers to a material batch of 500 g and 20°C (68°F) material temperature. Mixing larger quantities or higher processing temperatures will result in faster curing due to the typical reaction heat of epoxy resins.



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Application

For processing, we recommend an ambient temperature of 20°C (68°F) at less than 85% relative humidity. The highest adhesive strength is achieved when the parts to be processed are heated to >35°C (>95°F) before application. For a thin pre-coat, work WEICON HB 300 intensively into the surface in crosswise layers using the Contour Spatula Flexy to achieve maximum adhesion. By means of this technique, the epoxy resin penetrates well into all cracks and roughness depths. Afterwards, further applications can be carried out straight away, until the desired layer thickness is reached. Make sure that the epoxy resin is applied evenly and without air bubbles. To fill large gaps or holes, fibreglass, expanded metal or other mechanical fixation materials should be used. Finally, the surface can be smoothed easily with the help of a PE film and a rubber roller.

Curing

Final hardness is reached after 24 hours at 20°C (68°F) at the latest. At lower temperatures, the curing can be accelerated by evenly applying heat up to max. 40°C (104°F), e.g. with a heating pack, hot air blower or fan heater. Higher temperatures shorten the curing time.

The following rule of thumb applies: Each increase by +10°C (50°F) above room temperature (20°C/68°F) will decrease the curing time by half. Temperatures below 16°C (61°F) increase the curing time, until at approx. 5°C (41°F) and below, almost no reaction will take place at all.

Storage

Store WEICON HB 300 at room temperature in a dry place. Unopened containers can be stored at temperatures of +18°C to +28°C for at least 36 months after delivery date. Unopened containers must be used up within 6 months.

Scope of delivery

10953001 Processing Spatula, short
10953020 Contour Spatula Flexy
10953015 Protective Gloves
Instructions for use

Accessories

11202500 Cleaner Spray S, spray can 500 ml
15200005 Cleaner S, canister 5 l
11207400 Surface Cleaner, spray can 400 ml
15207005 Surface Cleaner, canister 5 l
10604025 Mould Release Agent Liquid F 1000, 250 ml
10604515 Mould Release Agent Wax P 500, 150 g
10539115 Repair Stick Multi-Purpose 115 g
10850005 Glass Fibre Cloth Tape, 50 mm x 1 m
10953001 Processing Spatula, short
10953003 Processing Spatula, long
15841500 Pump-Dispenser WPS 1500
52000035 Cable Scissors No. 35
10851010 Processing Kit

Recommended tools

Angle grinder
Blast machine
Heating pack, hot air blower or fan heater
Smoothing trowel, spatula
PE foil 0.2 mm
Fabric tape
Paint brush, foam roller
Rubber roller
Lint-free cloths

Available sizes

10450002 WEICON HB 300 0.2 kg
10450005 WEICON HB 300 0.5 kg
10450010 WEICON HB 300 1.0 kg

Conversion table

(°C x 1,8) + 32 = °F
mm/25.4 = inch
µm/25.4 = mil
N x 0.225 = lb
N/mm² x 145 = psi
MPa x 145 = psi
Nm x 8.851 = lb-in
Nm x 0.738 = lb-ft
Nm x 141.62 = oz-in
mPa·s = cP
N/cm x 0.571 = lb/in
kV/mm x 25.4 = V/mil

	WEICON A	WEICON B	WEICON BR	WEICON C	WEICON F	WEICON FZ	WEICON HB 300	WEICON Ceramic BL	WEICON GL	WEICON Ceramic W	WEICON SF	WEICON ST	WEICON HP	WEICON TI	WEICON UW	WEICON WP	WEICON WR	WEICON WRZ	WEICON CBC
Repair and moulding	X	X	X	X	X	X	X				X	X		X	X			X	
Adhesive				X									X		X				
Wear protection								X	X	X						X			
Potting and gap filling	X					X											X	X	X

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Chemical resistance of WEICON Plastic Metals after curing*

Acetic acid dilute < 5%	+	Hydrocarbons, aliphatic (crude oil derivatives)	+
Acetone	0	Hydrocarbons, aromatic (benzene, toluene, xylene)	-
Alkalis (basic materials)	+	Hydrochloric acid < 10%	+
Amyl acetate	+	Hydrochloric acid 10 - 20%	+
Amyl alcohols	+	Hydrofluoric acid dilute	0
Anhydrous ammonia 25%	+	Hydrogen peroxide < 30% (hydrogen superoxide)	+
Barium hydroxide	+	Impregnating oils	+
Butyl acetate	+	Magnesium hydroxide	+
Butyl alcohol	+	Maleic acid (cis-butenedioic acid)	+
Calcium hydroxide (slaked lime)	+	Methanol (methyl alcohol) < 85%	0
Carbolic acid (phenol)	-	Milk of lime	+
Carbon disulphide	+	Naphthalene	-
Carbon tetrachloride (tetrachloromethane)	+	Naphthene	-
Caustic potash solution	+	Nitric acid < 5%	0
Chlorinated water	+	Oils, minerals	+
Chloroacetic acid	-	Oils, vegetable and animal	+
Chloroform (trichloromethane)	0	Oxalic acid < 25% (ethanedioic acid)	+
Chlorosulphonic acid	-	Paraffin	+
Chromic acid	+	Perchloroethylene	0
Chroming baths	+	Petrol (92 - 100 octane)	+
Creosote oil	-	Phosphoric acid < 5%	+
Cresylic acid	-	Phthalic acid, phthalic acid anhydride	+
Crude oil	+	Potassium carbonate (potash solution)	+
Crude oil and crude oil products	+	Potassium hydroxide (caustic potash) 0-20%	+
Diesel fuel oil	+	Soda lye	+
Ethanol < 85% (ethyl alcohol)	0	Sodium bicarbonate (sodium hydrogen carbonate)	+
Ethyl alcohol	0	Sodium carbonate (soda)	+
Ethyl benzole	-	Sodium chloride (cooking salt)	+
Ethyl ether	+	Sodium hydroxide < 20% (caustic soda)	0
Exhaust gases	+	Sulphur dioxide	+
Formic acid >10%	-	Sulphuric acid < 5%	0
Glycerine (trihydroxypropane)	+	Tannic acid dilute < 7%	+
Glycol	0	Tetralin (tetrahydronaphthalene)	0
Grease, oils and waxes	+	Toluene	-
Heating oil, diesel	+	Trichloroethylene	0
Humic acid	+	Turpentine substitute (white spirit)	+
Hydrobromic acid < 10%	+	Xylene	-

+ = resistant 0 = resistant for a limited time - = not resistant

* Storage of all WEICON Plastic Metals was at +20°C chemical temperature

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