

ERS-610 SUPER CERAMIC PASTE GRADE

SELECTION & SPECIFICATION DATA

- Type** Epoxy Ceramic Paste
- Description** ERS-610 Super Ceramic is a two-component 100% solids trowel-grade novolac epoxy polymeric repair paste used to fill voids and rebuild worn metal surfaces in pumps, motors, impellers, fans, tube sheets, heat exchangers, elbows, nozzles and more.
- Features**
 - » 100% solids, no VOCs
 - » Excellent chemical resistance
 - » Maximum heat resistance
- Uses**
 - » Coal chutes and silos
 - » Dry bag houses
 - » Slurry tanks
 - » Heat exchanger internals
 - » Pumps
 - » Motors, impellers, fans, elbows, nozzles
- Color** Dark gray
- Solids Content** 99 -100% by volume

SUBSTRATES & SURFACE

- ALL** Substrate must be clean, dry and free of contaminants.

- Steel**

Immersion: SSPC-SP 10/NACE 2 Near White Metal Blast with angular profile of 2.5 - 3.5 mils. Non-immersion: SSPC-SP 6/NACE 3 Commercial Blast with angular profile of 1.5 - 3.0 mils, SSPC-SP 2 Hand Tool or SSPC-SP 3 Power Tool Cleaning are suitable for mild environments.

Self-priming on steel.

- Weld Repair**

Use a flame to sweat out oil from deeply impregnated surfaces. Stabilize cracks by drilling the extremities.

Long cracks should be drilled, tapped and bolted every few inches. Vee-out all cracks using a file. Degrease using clean rags.

MIXING & THINNING

- Mixing** Do not mix partial kits. For small kits, transfer the entire contents of the Resin and Hardener onto the plastic mix board. For large kits, completely empty the hardener container into the resin container, scraping it clean. Mix together thoroughly until color of material is uniform and free of streaks.

- Thinning** Do not thin.

- Pot Life** 40 minutes at 75°F (24°C)
Pot life is shorter at higher temperatures. A larger volume of mixed material will have a shorter pot life than a smaller volume.

- Cleanup** MEK or Acetone.

APPLICATION GUIDELINES

- Conditions** Substrate surface temperature 50°F –140°F (10°C –60°C) and at least 5°F (3°C) above the dew point and rising. If surface temperature is above 140°F (60°C), consult Engineered Resin Solutions for guidance.

- Application** Apply directly onto the prepared surface with the spreader or mixing knife provided. Press down firmly to remove entrapped air, fill all cracks, and ensure maximum contact with the surface. Use reinforcement tape over holes and cracks.

- Brush & Roller** Brush or roller can be used to smooth uncured surface with solvent if desired.

CURE SCHEDULE & RECOAT WINDOW

RECOAT WINDOW	LIGHT LOADING	FULL OR CHEMICAL SERVICE
1 –1.5 hours at 70°F (21°C)	12 hours at 70°F (21°C)	7 days at 70°F (21°C)

Return-to-service will vary with temperature during cure and chemical exposure. Consult Engineered Resin Solutions for guidance.

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Theoretical Coverage 12.8 square feet per gallon at 125 mils
Allow for loss in mixing and application.

Storage & Shelf Life Maintain products in original packaging and sealed until ready for use. Estimated shelf life is 24 months for part A and 12 months for part B when stored in a dry area at 75°F (24°C). Actual shelf life may vary with storage conditions. Do not store below 40°F (4°C) or above 110°F (43°C).

If there is any question with respect to the quality of the components, check reactivity prior to use.
For assistance consult with ERS.

SAFETY

Safety Mixes and applications of this product present a number of hazards. Read and follow the hazard information, precautions and first aid directions on the individual product labels and safety data sheets before using.

Ventilation Provide thorough air circulation during and after application until the material has cured when used in enclosed areas.

TYPICAL PHYSICAL PROPERTIES

PROPERTY	VALUE
Pull-off adhesion test ASTM D4541	>2800 psi (19 MPa)
Flash point	>250°F (121°C)
Taber abrasion ASTM D4060 1000 cycles, H-22 wheels dry, 1 kg load	495 mg loss 29.1 mils loss 34.8 cycles per mil loss
Coefficient of thermal expansion	1.8 x 10 ⁻⁶ /°F (3.2 x 10 ⁻⁶ /°C)
VOC	0 lb/gal (0 g/L)
Density	11.4 lb/gal (1.4 kg/L)

TEMPERATURE RESISTANCE

SERVICE	MAXIMUM TEMPERATURE
Dry	450°F (232°C)
Splash/spill	Up to 360°F (182°C)
Immersion	175°F (79°C)

Temperature limitations will vary with chemical exposure. Consult Engineered Resin Solutions for guidance.

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