



## BIGA GROUP

SPECIAL WELDING, SHIP / OFF SHORE / INDUSTRY SERVICE  
ENGINEERING, CONSULTING AND SURVEY  
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### Technical Data Sheet

1/26/2012

## Wear Guard™ High Temp 450

<b>Description:</b>	High-density, ceramic bead-filled epoxy system for maximum wear and abrasion resistance in high-temperature applications
<b>Intended Use:</b>	Repair scrubbers, ash handling systems, pipe elbows, screens, and chutes; recontour chippers, bins, hoppers, bunkers, separators, diester tables; protect exhausters, chutes, launderers, housing fans, crushers, and breakers.
<b>Product features:</b>	<b>Provides up to 30% better abrasion resistance than conventional wear compounds</b> <b>Unmatched resistance to acids, bases, salts, and solvents</b> <b>Serves temperatures to 450°F</b> <b>Excellent adhesion to metal, ceramic, and concrete</b>
<b>Limitations:</b>	Requires heat cure for maximum performance. See Application Instructions section.

#### Typical Physical Properties:

*Technical data should be considered representative or typical only and should not be used for specification purposes.*

#### Cured 7 days @ 75°F

<b>Adhesive Tensile Shear</b>	<b>2,300 psi</b>
<b>Coefficient of Thermal Expansion</b>	<b>27 [(in.)/(in.) x °F]] x 10<sup>-6</sup></b>
<b>Color</b>	<b>Grey</b>
<b>Compressive Strength</b>	<b>13,200 psi</b>
<b>Coverage/lb</b>	<b>60 sq.in./lb. @ 1/4"</b>
<b>Cured Hardness</b>	<b>87D</b>
<b>Cured Shrinkage</b>	<b>0.0010 in./in.</b>
<b>Dielectric Constant</b>	<b>38.0</b>
<b>Flexural Strength</b>	<b>8,220 psi</b>
<b>Functional Cure</b>	<b>Heat Cure</b>
<b>Mix Ratio by Volume</b>	<b>6:1</b>
<b>Mix Ratio by Weight</b>	<b>13.7:1</b>
<b>Mixed Viscosity</b>	<b>Non-sag Putty</b>
<b>Pot Life @ 75F</b>	<b>120 min.</b>
<b>Recoat Time</b>	<b>2 - 4 hrs.</b>
<b>Solids by Volume</b>	<b>100</b>
<b>Specific Gravity</b>	<b>1.94 gm/cc</b>
<b>Specific Volume</b>	<b>14.3 in.(3)/lb.</b>
<b>Temperature Resistance</b>	<b>Wet: 150°F; Dry: 450°F</b>
<b>Tensile Strength</b>	<b>4,600 psi</b>

#### TESTS CONDUCTED

Compressive Strength ASTM D 695  
Cured Hardness Shore D ASTM D 2240  
Coef. of Thermal Expansion ASTM D 696  
Dielectric Constant ASTM D 150  
Flexural Strength ASTM D 790  
Thermal Conductivity ASTM C 177  
Cure Shrinkage ASTM D 2566  
Adhesive Tensile Shear ASTM D 1002  
Dielectric Strength, volts/mil ASTM D 149  
Modulus of Elasticity ASTM D 638

#### Surface Preparation:

1. Thoroughly clean the surface with Devcon® Cleaner Blend 300 to remove all oil, grease and dirt.
2. Grit blast surface area with 8-40 mesh grit, or grind with a coarse wheel or abrasive disc pad, to create increased surface area for better adhesion (Caution: An abrasive disc pad can only be used provided white metal is revealed). Desired profile is 3-5mil, including defined edges (do not "feather-edge+epoxy).

Note: For metals exposed to sea water or other salt solution, grit-blast and high-pressure-water-blast the area, then leave overnight to allow any salts in the metal to sweat+to the surface. Repeat blasting to sweat out+all soluble salts. Perform chloride contamination test to determine soluble salt content (should be no more than 40ppm).

3. Clean surface again with Devcon® Cleaner Blend 300 to remove all traces of oil, grease, dust or other foreign substances from the grit blasting.
4. Repair surface as soon as possible to eliminate any changes or surface contaminants.

WORKING CONDITIONS: Ideal application temperature is 55°F to 90°F. In cold working conditions, directly heat repair area to 100-110°F prior to applying epoxy and maintain at this temperature during product cure to dry off any moisture, contamination or solvents, as well as to achieve maximum performance properties.

**Mixing Instructions:**

---- It is strongly recommended that full units be mixed, as ratios are pre-measured. ----

1. Add hardener to resin.
2. Mix thoroughly with screwdriver or similar tool (continuously scrape material away from sides and bottom of container) until a uniform, streak-free consistency is obtained.

INTERMEDIATE SIZES (1,2,3 lb. units): Place resin and hardener on a flat, disposable surface such as cardboard, plywood or plastic sheet. Use a trowel or wide-blade tool to mix the material as in Step 2 above.

LARGE SIZES: (25 lb., 30 lb., 50 lb. buckets): Use a T-shaped mixing paddle or a propeller-type Jiffy Mixer Model ES on an electric drill. Thoroughly fold putty by vigorously moving paddle/propeller up and down until a homogenous mix of resin and hardener is attained.

**Application Instructions:****ADDITIONAL SURFACE PREPARATION INFORMATION:**

If grit blasting is not possible, and expandable metal cannot be used, apply Devcon Brushable Ceramic at 11-18 mils to prime the metal surface. Allow to cure for approximately 2 hours, or until a fingernail can almost depress the primed surface. Immediately apply Wear Guard<sup>®</sup> High Temp 450 to the surface. DO NOT let the "prime coat" fully cure before applying Wear Guard<sup>®</sup> High Temp 450.

Spread mixed material on repair area at a minimum thickness of 1/4". Work firmly into substrate to ensure maximum surface contact. Wear Guard<sup>®</sup> High Temp 450 fully cures in 16 hours, at which time it can be machined, drilled, or painted.

**FOR BRIDGING LARGE GAPS OR HOLES**

Place fiberglass sheet, expanded metal, or mechanical fasteners between repair area and Wear Guard<sup>®</sup> High Temp 450 prior to application.

**FOR VERTICAL SURFACE APPLICATIONS**

Wear Guard<sup>®</sup> High Temp 450 can be troweled up to 3/4" thick without sagging.

**FOR MAXIMUM PHYSICAL PROPERTIES**

Cure at room temperature for 2.5 hours, then heat cure for 3 hours at 250°F to 300°F.

**FOR ± 70°F APPLICATIONS**

Applying epoxy at temperatures below 70°F lengthens functional cure and pot life times. Conversely, applying above 70°F shortens functional cure and pot life.

**Storage:**

Store at room temperature, 70 °F.

**Compliances:**

None

**Chemical Resistance:**

*Chemical resistance is calculated with a 7 day, room temp. cure (30 days immersion) @ 75°F*

1,1,1-Trichloroethane	Excellent
Gasoline (Unleaded)	Excellent
Hydrochloric 10%	Excellent
Hydrochloric 36%	Excellent
Methanol	Fair
Methyl Ethyl Ketone	Fair
Methylene Chloride	Poor
Nitric 10%	Very good

Phosphoric 10%	Very good
Potassium Hydroxide 40%	Excellent
Sodium Hydroxide 50%	Excellent
Sodium Hypochlorite	Excellent
Sulfuric 10%	Excellent
Toluene	Excellent
Trisodium Phosphate	Excellent

**Precautions:**

Please refer to the appropriate material safety data sheet (MSDS) prior to using this product.

**For technical assistance, please call 1-800-933-8266**

**FOR INDUSTRIAL USE ONLY****Warranty:**

Devcon will replace any material found to be defective. Because the storage, handling and application of this material is beyond our control, we can accept no liability for the results obtained.

**Disclaimer:**

All information on this data sheet is based on laboratory testing and is not intended for design purposes. ITW Devcon makes no representations or warranties of any kind concerning this data. For product information visit [www.bigagroup.com](http://www.bigagroup.com) / [www.devcon.com](http://www.devcon.com) alternatively for technical assistance please call +385 52 880 882 or send an e-mail to [biga@biga.hr](mailto:biga@biga.hr).

**Order Information:**

**11480 30 lb.**