













Solvent Cement and Primer

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Weld-On® Solvent Cements

PVC SOLVENT CEMENTS

| | | | MAX PIPE SIZE (INTERFERENCE FIT) | SET TIME | INDUSTRY LISTING | PERFORMANCE SPECIFICATIONS |
|---------------|--|--|---|-------------------|---|---|
| HEAVY BODIED |  <p>711™ PVC INDUSTRIAL GRADE (Gray)</p> <ul style="list-style-type: none"> High-strength formula for industrial piping systems. Good gap filling properties Medium set allows for more working time in warm weather. | | 12" (315 mm) PVC all classes & schedules | Medium |  PW-G/DWV/SW | ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61 CSA B137.3 CSA B181.2 |
| |  <p>719™ PVC INDUSTRIAL GRADE (White or Gray)</p> <ul style="list-style-type: none"> Premium, high-strength formulation for large size industrial piping systems. Ideal for fabrication of large fittings and applications requiring high gap filling properties. Suitable for irrigation, conduit, other pressure and non-pressure applications. | | 30" (800 mm) PVC, all classes & schedules | Slow |  PW-G/DWV/SW  PW-G/DWV/SW (Gray Only) | ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61 CSA B137.3 CSA B181.2 |
| MEDIUM BODIED |  <p>705™ PVC INDUSTRIAL GRADE (Clear or Gray)</p> <ul style="list-style-type: none"> High-strength formula for industrial, irrigation, DWV, electrical conduit, pool & spa and plumbing, including PVC foam core pipe. Can be used without primer on non-pressure systems if local codes permit. | | 6" (160 mm) PVC 4" (110 mm) Schedule 80 PVC – PN 10 & 16 | Fast |  PW-G/DWV/SW  PW-G/DWV/SW (Gray Only) | ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61 CSA B137.3 CSA B181.2 |
| |  <p>725™ WET 'R DRY™* (Aqua Blue)</p> <ul style="list-style-type: none"> Premium formula for wet conditions and/or quick pressurization. Suitable for irrigation, plumbing, and pool & spa applications. Can be used without primer on non-pressure systems if local codes permit. | | 6" (160 mm) PVC 4" (110 mm) Schedule 80 PVC – PN 10 & 16 | Extremely Fast |  PW-G/DWV/SW | ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61 CSA B137.3 CSA B181.2 |
| |  <p>727™ HOT 'R COLD™* (Clear)</p> <ul style="list-style-type: none"> Premium formula for all weather conditions (-15°F to 110°F / -26°C to 43°C). Excellent for industrial, irrigation, electrical conduit, pool & spa and plumbing, including PVC foam core pipe. Can be used without primer on non-pressure systems if local codes permit. | | 6" (160 mm) PVC 4" (110 mm) Schedule 80 PVC – PN 10 & 16 | Very Fast |  PW-G/DWV/SW | ASTM D 2564 NSF/ANSI 14 NSF/ANSI 61 |

NOTE: * Special Order Only
-Contact FABCO for Eco Series availability



ECO SERIES



ALL WELD-ON PRODUCTS

INTRODUCING

ECO™ Series

your responsible choice








**The strength you trust,
now with ultra low VOC**

- Superior joint strength
- Fast setting
- 30% lower solvent emissions
- Less odorous fumes
- Improved working environment



PIPES & FITTINGS

CPVC SOLVENT CEMENTS

| | | | | | |
|--------------------|---|---|--------|--|---|
| HEAVY BODIED | 714™ CPVC (Gray or Orange)  <ul style="list-style-type: none"> Industrial quality for non-chemical applications up to 180°F (82°C). Approved for use on Corzan® CPVC piping systems. | 12" (315 mm) CPVC, all classes & schedules | Medium |   PW-G/DWV/SW (Orange Only) | ASTM D 2846 ASTM F 493 NSF/ANSI 14 NSF/ANSI 61 CSA B137.6 |
| | 724™ CPVC INDUSTRIAL GRADE (Gray or Orange)  <ul style="list-style-type: none"> Premium, high-strength, chemical-resistant solvent cement for use with CPVC and PVC piping systems carrying acids, bases, salts, and hypochlorites. Approved for use on Corzan® CPVC piping systems. | 12" (315 mm) CPVC, all classes & schedules | Medium |   PW-G/DWV/SW | ASTM F 493 NSF/ANSI 14 NSF/ANSI 61 |
| EXTRA HEAVY BODIED | 729™ CPVC* INDUSTRIAL GRADE (Gray)  <ul style="list-style-type: none"> Extra heavy body industrial quality cement for applications requiring high gap filling properties. Ideal for fabrication of large sized fittings. May be used for chemical applications. | 24" (600 mm) CPVC, all classes & schedules | Slow | - | ASTM F 493 |

NOTE: * Special Order Only
-Contact FABCO for Eco Series availability



ECO SERIES



ALL WELD-ON PRODUCTS



Weld-On® 724™ CPVC and PVC (orange)

One Cement for CPVC and PVC



A Chemical-resistant cement for acids, bases, salts and hypochlorites. For CPVC and PVC industrial piping systems thru 12" (315mm) diameters.

Specifically formulated for joining CPVC and PVC industrial piping systems carrying corrosive chemicals, WELD-ON 724™ is the most chemical resistant CPVC solvent cement in the industry. Laboratory analysis showed no joint failure even after 2,500 hours of pressure tests in numerous chemical solutions.

WELD-ON 724™ is  and  (PW-G / DWV / SW) listed, meets ASTM F 493 standard, and is approved for Corzan® industrial piping systems. For CPVC and PVC pipe and fittings with interference fit up to 12 inches (315 mm) diameter, all classes & schedules. This LOW VOC product meets strict environmental air quality regulations and can qualify for credit under the LEED® Green Building Rating System.

Product Description:

- Heavy bodied, medium setting orange or gray Low VOC cement for all classes and schedules with interference fit through 12" diameter.
- Professional grade, high-strength, chemical-resistant solvent cement for use with CPVC and PVC piping systems carrying acids, bases, salts, and hypochlorites.
- Approved for use on Corzan® CPVC piping systems.
- 2 year shelf life.

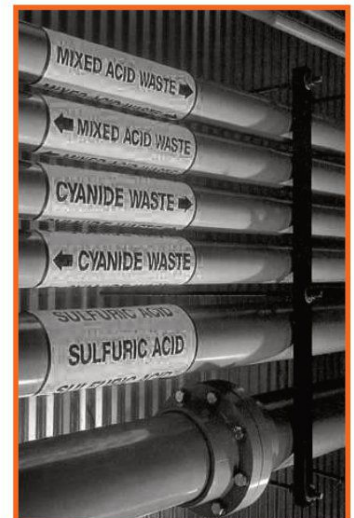
Performance Specifications:

Meets and exceeds:

- ASTM F 493
- NSF/ANSI 14
- NSF/ANSI 61

ORDER GUIDELINES

| STOCK NUMBER | CAN SIZE | PACKAGING | UNITS PER CASE | LBS PER CASE |
|--------------|----------|-------------------------------------|----------------|--------------|
| 12817 | Gallon | metal wide-mouth can with screw top | 6 | 56 |
| 12818 | Quart | metal can with applicator top | 12 | 29 |
| 13531 | Pint | metal can with applicator top | 12 | 15 |



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PIPES & FITTINGS

Weld-On® Primers, Adhesives and Accessories

PRIMERS

INDUSTRY LISTING

PERFORMANCE SPECIFICATIONS

P-70™ PRIMER (Clear or Purple)



- Premium industrial strength primer essential for proper softening and preparation of PVC and CPVC pipe and fitting surfaces.
- Specially recommended for use on Schedule 80 (PN 10 and higher) and large size pipe.
- Excellent for cold weather applications.



(Purple Only)



PW-G/DWV/SW

ASTM F 656
NSF/ANSI 14
NSF/ANSI 61

REPAIR AND FABRICATION ADHESIVES**

APPLICABLE FOR USE WITH

VISCOSITY

SET TIME

SHELF LIFE

810™ (White)



- Thick syrupy, two-component, high strength reactive adhesive.
- Product can withstand very high pressures and is high impact resistant. Great for repairing cracks or leaky pipe valves and fittings.
- Excellent gap-filling properties. Ideal for fabricating fittings and joining saddles to pipe. Good for bonding large diameter PVC and CPVC pipe and fittings.

Non-anodized aluminum, Other metals, Concrete, PVC, CPVC, ABS, Acrylic, Clay, Styrene, FRP

40,000 cps

1 hour

1 year

845™* (White)



- Thick syrupy, two-component, high strength reactive adhesive. Same formula as 810, but different packaging format.
- Product can withstand very high pressures and is high impact resistant. Great for repairing cracks or leaky pipe valves and fittings.
- Excellent gap-filling properties. Ideal for fabricating fittings and joining saddles to pipe. Good for bonding large diameter PVC and CPVC pipe and fittings.
- Conveniently packaged in a dual cylinder cartridge for easy dispensing and application to the bonding surfaces.

Non-anodized aluminum, Other metals, Concrete, PVC, CPVC, ABS, Acrylic, Clay, Styrene, FRP

40,000 cps









1 hour

1 year



NOTE: * Special Order Only

** The following Weld-On adhesives have Low VOC emissions per SCAQMD Rule 1168. Use of these products can qualify for one credit in the LEED® Green Building Rating System – Indoor Environmental Quality.


ROLL-A-WELD ROLLERS, SWABS & BRUSHES

| | | | |
|---|--|---|---|
|  | SuperSwab: See next page SuperSwab for 4-24" pipe |  | PB-1 Brush: 0000600 Plastic Handle Brush; fits standard pint and quart cans. |
|  | 3020MT653 Roll-A-Weld 3" roller for pipe diameters from 3" through 6"; fits MT-653 empty quart triple tight neck can. |  | 4020 4" swab for pipe diameters of 6" or larger; fits MT-648 empty gallon can and cements available in wide mouth cans. |
|  | 5020 4" swab for pipe diameters from 3" through 8"; fits standard quart can as well as MT-651 empty quart can. |  | 6020MT651 Roll-A-Weld 4" roller for pipe diameters from 3" through 8"; fits standard quart can as well as MT-651 empty quart can. |
|  | 7020MT648 Jumbo Roll-A-Weld 7" roller for pipe diameters of 6" or larger; fits MT-648 gallon can and cements available in wide mouth cans. |  | 8020 4" cotton swab with wire handle for use on pipe diameter 6" or larger. |

DAUBERS

| | | | |
|---|---|---|---|
|  | Can-Mate daubers: CM-75 or CM150 Adjustable plastic applicator with telescoping stem to fit ½ pint, pint, and quart cans. Available in ½", ¾" and 1¼" dauber sizes. |  | Cap daubers: 000016 DH Daubers fit ¼ pint & ½ pint cans; DP daubers fit ½ pint & pint cans; DQ daubers fit quart cans. Available ¾" dauber sizes. |
|---|---|---|---|

ACCESSORIES

| | | | | |
|---|---|-------------------------|--|------------------------|
|  | Empty Metal Cans (dauber not included) | | | |
| | MT-648 | MT-651 | MT-653 | MT-654 |
| | Gallon can with 2 7/8" neck | Quart can with 1¾" neck | Quart can with triple tight neck (paint style) | Pint can with 1¾" neck |

SuperSwab®

A sturdy easy-to-grip 4" swab for pipe diameter from 4" through 24". Adjustable length and dual cap design that fits quart and gallon containers.



*Note: The swab is disposable and replaceable. Swab holder and handle are reusable.

ORDER GUIDELINES

| PART NUMBER | DESCRIPTION |
|-------------|---|
| 14108 | Complete assembly |
| 14111 | SuperSwab bulk pack contains swabs, swab holders and handles. |
| 14112 | Replacement swab bulk pack only contains swabs. |

Assembly Instructions

1. Replace used swab by using a tool (e.g. flat screwdriver or key), position it between swab holder and handle, and unsnap. Remove swab from holder.



2. Lay new swab wire end into groove with curved tip downward in desired oval opening.

Position A for gallon container
Position B for quart container



3. Align wire with tooth. Push swab holder into handle and snap into position.



4. The assembled SuperSwab is now ready for use with Weld-On products.



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Weld-On® Solvent Cement Average Set and Cure Times

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

| RELATIVE HUMIDITY 60% OR LESS | PIPE SIZES | | | | | | | |
|---|-----------------------------|-------------------------------|---------------------------|-------------------------------|----------------------------|-------------------------------|---------------------------|--------------------------|
| | 1/2" TO 1-1/4" (20-40MM) | | 1-1/2" TO 2" (50-63MM) | | 2-1/2" TO 8" (75-200MM) | | 10" TO 15" (250-380MM) | 15"+ (380MM+) |
| TEMPERATURE RANGE DURING ASSEMBLY AND CURE PERIODS | UP TO 160 PSI (11 BAR) | 160 TO 370 PSI (11-26 BAR) | UP TO 160 PSI (11 BAR) | 160 TO 315 PSI (11-22 BAR) | UP TO 160 PSI (11 BAR) | 160 TO 315 PSI (11-22 BAR) | UP TO 100 PSI (7 BAR) | UP TO 100 PSI (7 BAR) |
| 60°-100°F | 15 min. | 6 hrs. | 30 min. | 12 hrs. | 1 1/2 hrs. | 24 hrs. | 48 hrs. | 72 hrs. |
| 40°-60°F | 20 min. | 12 hrs. | 45 min. | 24 hrs. | 4 hrs. | 48 hrs. | 96 hrs. | 6 days |
| 0°-40°F | 30 min. | 48 hrs. | 1 hr. | 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 our laboratory tests. These figures should be used as a general guide only.

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

| TEMPERATURE RANGE | 1/2" TO 1 1/4" (20-40MM) | 1 1/2" TO 2" (50-63MM) | 2 1/2" TO 8" (75-200MM) | 10" TO 15" (250-380MM) | 15"+ (380MM+) |
|----------------------|-----------------------------|---------------------------|----------------------------|---------------------------|------------------|
| 60-100°F / 16 - 38°C | 2 min. | 5 min. | 30 min. | 2 hrs. | 4 hrs. |
| 40-60°F / 5 - 16°C | 5 min. | 10 min. | 2 hrs. | 8 hrs. | 16 hrs. |
| 0-40°F / -18 - 5°C | 10 min. | 15 min. | 12 hrs. | 24 hrs. | 48 hrs. |

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 our laboratory tests. These figures should be used as a general guide only.

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

| PIPE DIAMETER | 1/2" | 3/4" | 1" | 1 1/2" | 2" | 3" | 4" | 6" | 8" | 10" | 12" | 15" | 18" |
|------------------|------|------|-----|--------|----|----|----|----|----|-----|-----|-----|-----|
| NUMBER OF JOINTS | 300 | 200 | 125 | 90 | 60 | 40 | 30 | 10 | 5 | 2-3 | 1-2 | 3/4 | 1/2 |

For Primer: Double the number of joints shown for cement. Note: 1 Joint = 1 Socket

*These figures are estimates based on our laboratory tests. These figures should be used as a general guide only.

PIPE SIZE EQUIVALENT CHART - INCHES/MILLIMETERS

| INCHES | 1/2 | 3/4 | 1 | 1-1/4 | 1-1/2 | 2 | 2-1/2 | 3 | 4 | 6 | 8 | 10 | 12 | 14 | 18 | 24 | 30 |
|-------------|-----|-----|----|-------|-------|----|-------|----|-----|-----|-----|-----|-----|-----|-----|-----|-----|
| MILLIMETERS | 20 | 25 | 32 | 40 | 50 | 63 | 75 | 90 | 110 | 160 | 200 | 250 | 315 | 355 | 450 | 600 | 800 |

PRODUCT SHELF LIFE

| WELD-ON PRODUCT | SHELF-LIFE |
|---------------------|------------|
| Primers/Cleaners | 3 years |
| PVC Solvent Cement | 3 years |
| CPVC Solvent Cement | 2 years |
| ABS Solvent Cement | 3 years |

FARENHEIT TO CELSIUS CONVERSION CHART

