PRODUCT DESCRIPTION
Permatex® Steel Weld™ is a two part, hand kneadable, steel reinforced, putty type industrial strength epoxy adhesive in stick form. Contrasting grey and black colored materials are mixed together to form a uniform metallic grey color to indicate thorough mixing. After 1 hour, Steel Weld™ can be drilled, sanded, threaded, machined or painted and it is resistant to water and most solvents. Steel Weld™ is also NSF approved for use with repairs that are exposed to potable water. Permatex® Steel Weld™ is not intended for structural applications.

PRODUCT BENEFITS
• Easy to use
• No heating required
• 5 minute working time
• Useable in 1 hour
• Safe for repairs that come in contact with drinking water
• Good moisture resistance
• Withstands moderate temperatures
• Cured material will not shrink
• Non-flammable
• Contains no solvents or VOC’s

Bonds to most metals including:
• Steel
• Aluminum
• Stainless Steel
• Iron
• Copper
• Bronze
• Brass

DIRECTIONS FOR USE
1. Before starting, make sure your work area is protected from accidental spills. Surfaces must be clean, dry and free of grease and oil. Note: Wear impervious gloves when mixing or handling uncured Steel Weld™.
2. Roughen smooth surfaces to be repaired with sandpaper or mechanically.
3. Cut off required amount of epoxy stick and knead with fingers to a uniform color. This should take no longer than two minutes. Note: Steel Weld™ has a 3 to 5 minute working time (including mixing time).
4. Apply to the surface to be repaired. Force into cracks or holes to be filled. Excess material can be removed, before it is cured, with a tool wetted with clean water.
5. On wet or damp surfaces, work material into area forcefully and hold in place until adhesion begins. Do not use hands to hold in place as heat is given off during cure.
6. After 3 to 5 minutes, the epoxy will harden.
7. After 1 hour, the cured material can be drilled, sanded, tapped, threaded, machined or painted. Product fully cure in 24 hours.

For Cleanup
1. Cleanup must be completed before the product has cured. Use acetone or mineral spirits for project/tool cleanup.
2. Clean hands with Permatex® Fast Orange® hand cleaners.

PROPERTIES OF UNCURED MATERIAL

<table>
<thead>
<tr>
<th>Typical Value</th>
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</thead>
<tbody>
<tr>
<td>Typical Value</td>
</tr>
<tr>
<td>Chemical Type</td>
</tr>
<tr>
<td>Epoxy and mercaptan resins</td>
</tr>
<tr>
<td>Appearance</td>
</tr>
<tr>
<td>grey outside, black inside</td>
</tr>
<tr>
<td>Odor</td>
</tr>
<tr>
<td>Slight mercaptan</td>
</tr>
<tr>
<td>Specific Gravity (mixed)</td>
</tr>
<tr>
<td>2.25 g/ml</td>
</tr>
<tr>
<td>Flash Point, SCC, °F</td>
</tr>
<tr>
<td>&gt;200</td>
</tr>
<tr>
<td>Mix Ratio</td>
</tr>
<tr>
<td>1:1</td>
</tr>
<tr>
<td>Tensile Strength, steel</td>
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<tr>
<td>900 psi</td>
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</tbody>
</table>

TYPICAL CURING PERFORMANCE
Permatex® Steel Weld™ has a working time of 3 to 5 minutes, functionally cures in 1 hour, and fully cures in 24 hours.

TYPICAL ENVIRONMENTAL RESISTANCE

Temperature Resistance                  Typical Values
Continuous, °F Maximum                  -40°F to 250°F
Intermittent, °F Maximum                 -40°F to 300°F

Chemical / Solvent Resistance
This product retains effective properties when in contact with water, hydrocarbons, ketones, alcohols, esters, halocarbons, aqueous salt solutions, and dilute acids and bases.

GENERAL INFORMATION
This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as an adhesive for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

ORDERING INFORMATION

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Container Size</th>
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</thead>
<tbody>
<tr>
<td>84332</td>
<td>2 oz. Steel Weld™ with vial, carded</td>
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</tbody>
</table>
STORAGE
Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 46°F and 82°F (8°C and 28°C) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container.

NOTE
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