

# WELBOND 3510

FOOD GRADED EPOXY  
TANK LINING

## *DESCRIPTION:*

**WELBOND 3510** is a 100% solids two-component epoxy coating formulated from high-grade resins and curing agents specially for storage tanks. It is lead-free and non-toxic when fully cured. It hardens to an abrasive resistance coating with adhesive strength on properly prepared substrates such as concrete and steel.

**WELBOND 3510** is a water-impermeable and has excellent resistance to oils, solvents, alkalis and most dilute acids.

## *USES:*

Interior and exterior surfaces of concrete, steel and wooden tanks such as those use for storing potable water, chemicals (except high concentration acids), grain powder and other liquids. **WELBOND 3510** is also used as grouting materials to seal off the gaps where ceramic tiles are used to line storage tanks.

EPOXY TANK LINING

## **PHYSICAL PROPERTIES:**

<b>Property</b>	<b>Result</b>
<b>Viscosity</b>	<b>600 centipoises (resin) 26,000 centipoises (hardener)</b>
<b>Chemical Resistance</b>	<b>Excellent to oil, solvent, alkali and dilute acid (ASTM C581-68)</b>
<b>Electrical Conductivity</b>	<b>NIL</b>
<b>Adhesive Shear Strength</b>	<b>900 Psi (ASTM C-190)</b>
<b>Compressive Strength</b>	<b>8,000 psi (ASTM C-695)(solid coat only)</b>
<b>Mix Ratio</b>	<b>2 parts resin and 1 part hardener by volume</b>
<b>Pot life</b>	<b>20-30 minutes</b>
<b>Tack Free Time</b>	<b>4-6 hours</b>
<b>Theoretical Coverage as primer</b>	<b>12-15 sq.m/gal set</b>
<b>Top Coat</b>	<b>6-7.5 sq.m/gal set</b>
<b>Packaging</b>	<b>One (1) gallon ser</b>

## **APPLICATION**

### **Surface Preparation**

Surface to be coated must be dry and free of oil, dirt, dust, loose material, grease, paint, parting and curing compounds and other foreign matter. Oil lining must be completely removed. It is recommended that steel surfaces must be sand-blasted to bare metal. Concrete should be neutralized or acid-etched and washed thoroughly. Allow to dry thoroughly before coating.

### **Coating Preparation**

Prepare enough materials that can be applied within 20-30 minutes. Mix 2 parts of the resin-base (adhesive) to 1 part hardener by volume until a homogeneous compound is attained.

***Type of Application:***

**As Solid Coat**

The mixture may be thinned out using **WELBOND 3510** and applied by roller brush. Two or more coats should be necessary. An airless spray may also be used effectively.

**With Fiber glass reinforcement**

With roller or airless spray, a primer coat of the epoxy mixture thinned out with reducer using not more than 15% by volume. Immediately lay out the fiberglass mat of the still wet primer coat. Allow 2-3 hours drying time. Apply saturating coats and allow for initial curing time of 6-8 hours. Grind surface to a smooth finish before application of top coats.

***Limitations:***

**WELBOND 3510** is not designed for surface where moisture can reach the underside of the membrane.

***Precautions:***

Avoid contact with skin and eyes, and avoid breathing its vapor. Work areas must be adequately ventilated.

Keep containers properly closed and store in cool and dry places.