

	COLOR	GRADE	Nominal Pipe Size	mm	20	25	32	40	50	63	75	90	110	160	200	250	315	355	600	800	
					in	1/2	3/4	1	1 1/4	1 1/2	2	2 1/2	3	4	6	8	10	12	14	24	30
Primers	AQUA BLUE	I	P75																		
	PURPLE CLEAR	I	P70																		
	PURPLE CLEAR	P	Plumbing Primer																		
Specialty	GREEN CLEAR	P	794***																		
	LIGHT AMBER	P	790**																		
ABS	BLACK BLACK	P	778																		
	BLACK BLACK	P	773																		
	MILKY YELLOW	P	771																		
CPVC	GRAY	I	729																		
	ORANGE GRAY	I	724 ^o																		
	ORANGE GRAY	I	714																		
	ORANGE	P	713																		
	YELLOW	P	Flow ^{†a} Guard Gold [®]																		
	YELLOW	P	Flow ^{†a} Guard Gold [®]																		
PVC	CLEAR BLUE	P	795																		
	BLUE CLEAR	I	738 [†]																		
	BLUE CLEAR	P	737 [†]																		
	BLUE	P	735 [†]																		
	CLEAR	P	727 [†]																		
	AQUA BLUE	I	725 [†]																		
	GRAY WHITE	I	719																		
	CLEAR GRAY	P	782																		
	GRAY	I	711																		
	BLUE	I	721 [†]																		
	CLEAR GRAY	I	705 [†]																		
	CLEAR GRAY	P	781 [†]																		
	CLEAR	I	710																		
CLEAR	P	702																			
CLEAR	P	780																			

For assistance in selecting the right Weld-On[®] products for your application, please refer to the selection guide.

Pipe Format

- Schedule 40/PN3.2, PN4, PN6
- Schedule 80/PN10, PN16

[†] Can be used without a primer with fittings having an interference fit (unless primer required by local code).

^a Flow Guard Gold[®] is a registered trademark of the Lubrizol Corp.

^o For CPVC and PVC Chemical Piping Systems

** PVC and CPVC

*** ABS to PVC Transition Joints

CTS: Copper Tube Size

P: Plumbing Grade

I: Industrial Grade



Solvent Cement Average Set and Cure Times



WELD-ON
IPS CORPORATION

GUY GRAY
IPS CORPORATION

WATER-TITE
IPS CORPORATION

TEST-TITE
IPS CORPORATION

AB&A
IPS CORPORATION

STUDOR
IPS CORPORATION

TRUBRO
IPS CORPORATION

AVERAGE INITIAL SET SCHEDULE FOR WELD-ON PVC/CPVC SOLVENT CEMENTS**					
Temperature Range	Pipe Sizes ½" to 1¼" 20mm to 40mm	Pipe Sizes 1½" to 2" 50mm to 63mm	Pipe Sizes 2½" to 8" 75mm to 200mm	Pipe Sizes 10" to 15" 250mm to 380mm	Pipe Sizes 15"+ 380mm +
60°-100°F/16°-38°C	2 minutes	5 minutes	30 minutes	2 hours	4 hours
40°-60°F/5°-16°C	5 minutes	10 minutes	2 hours	8 hours	16 hours
0°-40°F/-18°-5°C	10 minutes	15 minutes	12 hours	24 hours	48 hours

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 testing done under laboratory conditions. Field working conditions can vary significantly. This chart should be used as a general reference only.

AVERAGE JOINT CURE SCHEDULE FOR WELD-ON PVC/CPVC SOLVENT CEMENTS**								
Relative Humidity 60% or Less	Pipe Sizes ½" to 1¼" 20mm to 40mm		Pipe Sizes 1½" to 2" 50mm to 63mm		Pipe Sizes 2½" to 8" 75mm to 200mm		Pipe Sizes 10" to 15" 250mm to 380mm	Pipe Sizes 15"+ 380mm +
Temperature range during assembly and cure periods	up to 160 psi/ 11 Bar	160 to 370 psi/ 11 to 26 Bar	up to 160 psi/ 11 Bar	160 to 315 psi/ 11 to 22 Bar	up to 160 psi/ 11 Bar	160 to 315 psi/ 11 to 22 Bar	up to 100 psi / 7 Bar	up to 100 psi / 7 Bar
60°-100°F/16°-38°C	15 min	6 hrs	30 min	12 hrs	1½ hrs	24 hrs	48 hrs	72 hrs
40°-60°F/5°-16°C	20 min	12 hrs	45 min	24 hrs	4 hrs	48 hrs	96 hrs	6 days
0°-40°F/-18°-5°C	30 min	48 hrs	1 hour	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 testing done under laboratory conditions. Field working conditions can vary significantly. This chart should be used as a general reference only.

AVERAGE NUMBER OF JOINTS/QUART (1Kg) OF WELD-ON CEMENT*													
Pipe Diameters	½"	¾"	1"	1½"	2"	3"	4"	6"	8"	10"	12"	15"	18"
	20mm	25mm	32mm	50mm	63mm	90mm	110mm	160mm	200mm	250mm	315mm	380mm	450mm
Number of Joints	300	200	125	90	60	40	30	10	5	2-3	1-2	¾	½

Note – For Primer: Double the number of joints shown for cement.

* These figures are estimates based on our laboratory tests. Due to the many variables in the field, these figures should be used as a general guide only. **Note: 1 Joint = 1 Socket**

PIPE SIZE EQUIVALENT CHART – INCHES/MILLIMETERS																	
in.	½"	¾"	1"	1¼"	1½"	2"	2½"	3"	4"	6"	8"	10"	12"	14"	18"	24"	30"
mm.	20	25	32	40	50	63	75	90	110	160	200	250	315	355	450	600	800

PRODUCT SHELF LIFE	
Weld-On Products	Shelf-life
Primers / Cleaners	3 years
PVC Solvent Cement	3 years
CPVC Solvent Cement	2 years

