BUILDING TRUST CONSTRUIRE LA CONFIANCE



PRODUCT DATA SHEET

Edition 12.2017/v1 CSC Master Format™ 03 25 00 COMPOSITE REINFORCING

Sikadur[®]-30

HIGH MODULUS, HIGH STRENGTH, STRUCTURAL EPOXY PASTE ADHESIVE FOR USE WITH Sika[®] CarboDur[®] REINFORCEMENT SYSTEM

Description	Sikadur [®] -30 is a two-component, 100 % solids, moisture-tolerant, high modulus, high strength, structural epoxy paste adhesive. Meets ASTM C881 and AASHTO M-235 requirements.					
Where to Use	 Adhesive for bonding external reinforcement to concrete, masonry, steel, wood, stone, etc. Structural bonding of composite laminates (Sika® CarboDur® CFRP) to concrete, brickwork and timber. Structural bonding of steel plates to concrete. Suitable for use in vertical and overhead configurations. Multi-purpose, high strength, structural epoxy paste adhesive. As a binder for epoxy mortar repairs. Designed for use at normal temperatures between 8 and 35 °C (46 and 95 °F). 					
Advantages	 Long pot life and open time. Moisture tolerant before, during and after cure. High modulus, high strength, structural paste adhesive. Excellent adhesion to concrete, masonry, metals, wood and most structural materials. Fully compatible and excellent adhesion to Sika® CarboDur® CFRP composite laminates. Paste consistency ideal for vertical and overhead applications. High creep resistance under permanent loads. High abrasion and shock resistances. Convenient easy mix ratio A:B = 3:1 by weight. Solvent-free. Colour coded components to ensure proper mixing control. Canadian Food Inspection Agency accepted. 					
	Technical Data					
	Packaging	10 kg (6 L) unit				
	Colour	Component A	White			
		Component B	Black			
		Components A+B	Light Grey			
	Yield	c'i i ® 20				
	Type of Laminate	Sikadur®-30	11. 75)			
	5512	kg/Linear meter	(ID/TT) (0.20)			
	5512	0.30	(0.20)			
	101014	0.30	(0.24)			
	5612	0.48	(0.32)			
	S1012/S1014/M1014	0.54	(0.30)			
	S1012/31014/W1014 S1214/M1214	0.00	(0.40)			
	S1214/101214 S1517	0.92	(0.48)			
	Vield is based on a 3 mm (1/8 in) nominal thickness and does not take into consideration the plane roughness of substrate as well as laminate crossin					
	Actual consumption of adhesive will then be higher.					
	Shelf Life 2 years in original, unopened packaging. Store dry at 5 to 32 °C (41 to 89 °F). Condition product to 15 to 24 °C (59 to 75 °F) before using.					
	Mix Ratio A:B = 3:1 by weight and by volume					
	Properties at 23 °C (73 °F) an	d 50 % R.H.				
	Density (A+B)	1.65 kg/L (14.0 lb/US gal.)				
	Pot Life [20°C (68°F)]	Approx. 1 hr 30 min				
	Open Time	Approx. 1 hr 50 min				
	Tensile Properties ASTM D 638					
	7 days	Tensile strength	24.8 MPa (3598 psi)			
		Elongation at break	1%			
		Modulus of elasticity	4.5 GPa (65.3 x 10⁴ psi)			
	Flexural Properties ASTM D 790					
	14 days	Modulus of rupture	46.8 MPa (6790 psi)			
		langent modulus of	11 7 GPa (17 0 x 105 pci)			
	Shoar Strongth ASTM D 722	elasticity in benuing	11.7 GFa (17.0 X 10° µSI)			
	14 day cure @ 15 °C (50 °E)	15 MPa (2175 psi)				
	14 udy cure @ 15 (59 F) 15 MPA (21/5 ps)					
	14 udy cure @ 35 C (95 F)	17 IVIPa (2465 psi)				

	Bond Strength ASTM C882							
	Hardened concrete to hardened concre	te						
	2 days	Moist cure		18.6 MPa (2699 psi)				
	2 days	Dry cure		22 MPa (3192 psi)				
	14 days Hardened concrete to steel	worst cure		21.3 MPa (3091 psi)				
	2 days	Moist cure		17 9 MPa (2597 nsi)				
	2 days	Dry cure		20.6 MPa (2989 psi)				
	14 days	Moist cure		17.9 MPa (2597 psi)				
	Deflection Temperature ASTM D648							
	7 day cure @ 10 °C (50 °F)	Fiber stress loading = 1.8 MPa (264 psi)		30 °C (86 °F)				
	7 day cure @ 35 °C (95 °F)			53 °C (127 °F)				
	Water Absorption ASTM D570							
	24 hrs 0.03%							
	Compressive Strength ASTM D695, MP	a (psi)						
	4 h.m.	5 °C (41 °F)*	23 °C (73 °F)*	32 °C (89 °F)*				
	4 nrs	-	-	37.9 (5499)				
	8 nrs	-	24.1 (3497)	46.2 (6/03) E1 (7400)				
	10 IIIS	- E 1 (740)	40.2 (0703)	51 (7400) 52 7 (7702)				
	2 days	3.1 (740)	55.7 (7792)	53.7 (7792)				
	3 udys 7 days	40.8 (0790)	57.2 (8500)	57.2 (8500) 59.2 (8604)				
	1 days	58 6 (8503)	59.3 (8604)	53.3 (8004) 61.2 (8804)				
	28 days	58.6 (8503)	59.3 (8604)	62 (8996)				
	*Product cured and tested at temperate	ures indicated	55.5 (0004)	02 (0550)				
	Modulus of Elasticity ASTM D695							
	7 days	2 69 GPa (39 0	x 104 nsi)					
	Coefficient of Thermal Expansion	9 x 10 ⁵ /°C [Tem	perature range: -10	/ e range: -10 to 40 °C (14 to 104 °F)]				
	Product properties are typically averages, ob	btained under laboratory	conditions. Reasonabl	e variations can be expected on-site due to local factors, including envir	ronment,			
	preparation, application, curing and test meth	ods.						
HOW TO USE								
Surface	Surface must be clean and sou	nd It may be dry	or damn but	free of standing water and frost Remove dust lai	itance			
Dremeration	grosse ouring compounds imp	reanations way	, of during, but	islas disintegrated materials and other hand inh	ibiting			
Preparation	grease, curing compounds, imp	oregnations, waxe	es, ioreign part	icles, disintegrated materials, and other bond inn	gninia			
	materials from the surface. Exist	materials from the surface. Existing uneven surfaces must be filled with an appropriate repair mortar (i.e. Sikadur®-30						
	with the addition of 1 part silica sand). The concrete adhesive strength must be verified after surface preparation							
by random null-off testing (ACI 503R) at the engineer's discretion. Minimum tensile strength :								
	by random pull-off testing (ACI	a sand). The conc 503R) at the eng	rete adhesive s ineer's discretic	trength must be verified after surface preparation on. Minimum tensile strength :				
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Mixing Application	with the addition of 1 part silica by random pull-off testing (ACI 1.5 MPa (218 psi) with concrete Planeness of substrate to be c 2.5 mm (3/32 in) for 50 cm (20 Concrete: Blast clean, shotblast steel: Sandblast to white metal Timber: Blast clean or grind. Af vacuum cleaner. CarboDur®: Surface should be a receiving adhesive (this side is remains white after wiping the In the case where the design re sanded (emery paper type 180) Pre-mix each component. Propu for three (3) minutes using a lo paddle (recommended model). straight edge trowel at least ond in colour. Mix only that quantity For bonded, external reinforce a nominal thickness of 1.5 mm spatula to a nominal thickness place CarboDur® laminate onto until the adhesive is forced out laminate must not be disturbed For vertical and overhead patc into the prepared substrate, fill Clean all tools and equipment	a sand). The cond 503R) at the eng e substrate failure hecked with a m in) length respe- c or use other app finish. ter cleaning, rem wiped clean usin not labeled) with laminate). equires "stacking") and cleaned as a ortion 1 part of c pw-speed drill (30 During the mixin ce to ensure thore y you can use with ement: Apply the 1 (1/16 in). Apply of 1.5 mm (1/16) the concrete sur on both sides. Red for a minimum of hing: Work Sikad ing the cavity. Str immediately with	rete adhesive s ineer's discretic e tetal batten. to ctively. proved mechani ove all dust fro g an appropriat n acetone until ' of the strips, t above prior to t omponent B to 00 - 450 rpm) to g operation, sc pugh mixing. Up hin its pot life. neat mixed Sikadur' 5 in). Within th face. Using a h emove excess a of 24 hours. The ur®-30 with the ike off level. Lif h Sika® Epoxy	trength must be verified after surface preparation on. Minimum tensile strength : lerance for 2 m (6.5 ft) length max. 10 mm (3/8 cal means to provide an open roughened texture. (m the surface with an industrial e cleaner. Using a clean white cloth wipe down th all residual carbon dust is removed (i.e. the white he bottom surface of the strip (labeled) should be he application of the second strip. 3 parts of component A by volume into a clean pa o minimize air entrapment. Use a <i>Exomixer</i> ® type is rape down the sides and bottom of the pail with a bon completion of mixing, Sikadur®-30 should be un cadur®-30 onto the concrete with a trowel or spat ^b -30 onto the CarboDur® laminate with a "roof-sh e epoxy open time and depending on the tempera ard rubber roller, press the laminate into the epoxy dhesive. Glue line should not exceed 3 mm (1/8 ir e epoxy will reach its design strength after 7 days. • addition of 1 part oven dried sand ts should not exceed 25 mm (1 in). Cleaner. Once hardened, product can only be rer	in), or (CSP 5) ne side cloth lightly mixing flat or niform tula to naped" rature, y resin n). The moved			





Limitations	Minimum substrate a	: (41 °F).											
	 Maximum substrate and ambient temperature: 35 °C (95 °F). 												
	 Do not thin: Solvents will prevent proper cure. Use oven-dried aggregate only. Maximum glue line of neat epoxy: 3 mm (1/8 in). 												
								 Maximum epoxy mortar thickness: 25 mm (1 in) per lift. Material is a vapour barrier after cure. Minimum adhesive strength of concrete substrate: 1.5 MPa (218 psi). Minimum adhesive strength of concrete substrate: 1.5 MPa (218 psi). 					
	 Conditions. Descriptions must be tested for maisture uppeur transmission prior to marter applications. 												
		 Porous substrates must be tested for moisture-vapour transmission prior to mortar applications. 											
	Health and Safety Information	For information and advice on the safe handling, storage and disposal of chemical products, users should refer to the most recent SAFETY DATA SHEET containing physical, ecological, toxicological and other safety-related data.											
		KEEP OUT OF REACH OF CHILDREN											
		FOR INDUSTRIAL USE ONLY											
		The Information, and in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions, within their shelflife. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any recommendations, or from any other advice offered. The information contained herein does not relieve the user of the products from testing them for the intended application and purpose. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request or may be downloaded from our website at: www.sika.ca											
	Head Office	Other locations											
	601, avenue Delmar Pointe-Claire, Quebec	Toronto	1-800-933-SIKA	C+									
	H9R 4A9	Vancouver	www.sika.ca	Certified ISO 14001 (CERT-0102780)									

