




## Solvent Welding PVC and CPVC Plastic Pipes



# Cold Weather Tips

**Good joints can be made with Weld-On® solvent cement at sub-zero temperatures.**

Working in freezing temperatures is never easy, but sometimes the job is necessary. If that unavoidable job includes solvent cementing plastic pipe, you can do it successfully with Weld-On solvent cements.

Weld-On solvent cements have excellent cold weather stability for virtually all practical applications. Our cements are formulated to have well-balanced drying characteristics and to have good stability in sub-freezing temperatures. In addition to our regular and low VOC cements, Weld-On offers a solvent cement specially formulated for cold weather applications. See the Weld-On 727™ “Hot  Cold” product bulletin.

By following our standard instructions and using a little extra care and patience, successful solvent welded joints can be made at temperatures as low as -15°F (-26°C). In cold weather, solvent cements penetrate and soften the surfaces of plastic pipe and fittings more slowly than in warm weather. The plastic is also more resistant to solvent attack. Therefore, it is very important to pre-soften surfaces with an aggressive primer. A longer cure time is necessary due to a slower evaporation rate in cold weather.



**Tips to follow when solvent welding in cold weather:**

1. Prefabricate as much of the system as possible in a heated work area.
2. Store bulk quantities of primer & cement in a warm location above 40°F (4°C) when not in use and make sure they remain fluid. We recommend the use of smaller containers to transport the fluid products to the joint assembly work-site.
3. If Weld-On solvent cement is stored at a very cold temperature and gels, it can be reconstituted by bringing it into a warm environment (60°F - 90°F / 15°C - 32°C) and allowing it to sit for 24 hours. Do not try to artificially heat it in order to speed up the process. Before use, vigorously shake the solvent cement.
4. Take special care to remove moisture including ice and snow from the surfaces to be joined, especially from the ends of the pipe as well as fittings and valve sockets.
5. Ensure that the pipe, fittings, and valves are at the same temperature prior to priming and solvent cementing.
6. Use Weld-On P-70™ Primer to soften the joining surfaces before applying the solvent cement. More than one application may be necessary. Surfaces are sufficiently “primed” when scraping a blade on the treated part will result in the effortless removal of some plastic material.
7. Allow a longer cure period before the system is pressure tested. A heat blanket may be used to speed up the set and cure times.
8. Read and follow all directions on Weld-On product labels carefully before installation.

*All year long...*

*you can depend on...*

**Weld-On!**

