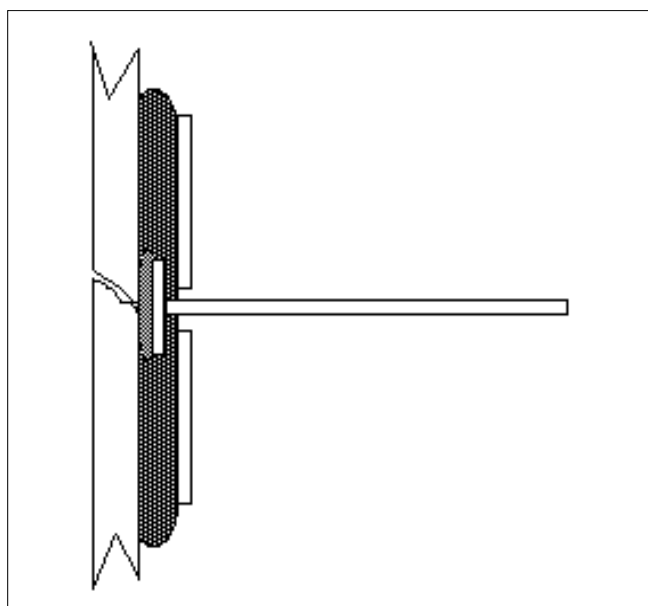
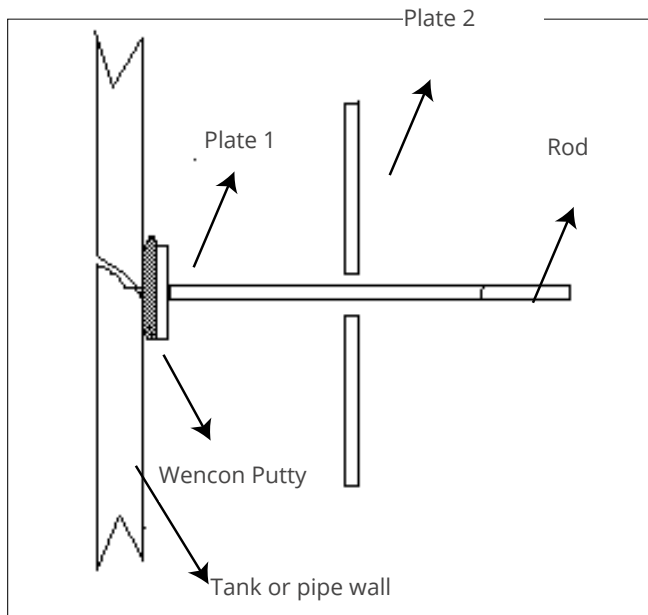


Tanks - emergency repair of leaking cracks

APPLICATION DATA SHEET No. 146



Cracks in tanks, pipes and other structures.

If possible, reduce or eliminate pump pressure during application.

The technique involves two steps. First, the leak must be stopped, thereafter, it must be secured.

1. Prepare three tools

One small steel plate (Plate 1.) big enough to cover the leak, and larger than the hole in the large plate (see below).

One larger steel plate (Plate 2.) to cover an area of 100 x 100 mm or larger. The size has influence on the strength of the repair. In the middle of this plate, drill a hole for the rod (see below). Clean the surface thoroughly acc. to Wencon surface preparation, next page.

One rod (could be a large screwdriver), long enough to serve its purpose (see below)

2. Stop the leak

Mix a suitable amount of Wencon Putty and place it directly in the leak. If pressure is high, await semi curing, that will make the Putty more stiff. Before the Putty cures, press and hold it by the means of the small plate, and fixate it with the rod. This will stop the leak.

As an alternative, a wooden plug can be hammered into the leak, to take most of the pressure.

3. Secure the leak

Grind an area around the leak, slightly larger than the large steel plate. Clean it using the Wencon Bio Cleaner. Mix and apply a thick layer of Wencon Rapid to the surface. Make sure that the thickness exceeds the combined thickness of the Putty and the small steel plate. Mount the large steel plate into the un-cured Wencon Rapid, and hold until full cure.

Variation

On applications where the crack is not on a flat surface, the plates will have to be shaped accordingly.

For quick cure, apply heat up to 100°C (340°F).

Alternative products: Wencon UW products

Wencon surface preparation

Choose the relevant surface preparation, depending on the nature of the job.

Surface preparation using dry blasting methods:

Application with Wencon products on a dry surface, at minimum 3°C above dew point.

1. Blast the machine part to SA 2,5 using sharp-edged blasting media, to a roughness of min. 75 microns.
2. Leave the part for sweating out salts in a warm place for at least 12 hours or heat it up to 30 - 40°C (86-104 °F) using gas torches.
3. Blast again to SA 2,5, prior to the application.
4. For parts containing a lot of water and salt, it may be necessary to repeat point 2 and 3, until the surface remains light grey, for at least 2 hours after blasting.
5. For optimal adhesion of Wencon products, always use Wencon Bio Cleaner or Wencon Cleaner prior to application. Follow one of below two methods:
 - 5.1 **Wencon Bio Cleaner**

Wet surface: Apply Wencon Bio Cleaner and let it work for 5-10 min. If necessary use a brush, to make sure the surface is clean. Rinse off with clean water and wipe off with an absorbing cloth.

Dry surface: Apply Wencon Bio Cleaner and let it work for 5-10 min. If necessary use a brush, to make sure the surface is clean. Rinse off with clean water and dry with an absorbing cloth or with compressed air for a completely dry surface. Hereafter any Wencon products can be applied.
 - 5.2 **Wencon Cleaner**

After surface preparation, apply Wencon Cleaner with a brush and allow the product to evaporate before applying other Wencon products. Wencon Cleaner is non-flammable. Use only in large or well ventilated rooms.

Surface preparation using wet/damp methods:

Water jet the entire surface with water and sand to a standard equal, to SA 2,5 as described above.

If the surface is left wet after surface preparation, is it important to dry out the surface or alternatively use a Wencon UW product.

Surface preparation for emergency/temporary applications:

If above surface preparation methods are not possible, it may be necessary to use one of below methods:

- Blasting
- Grinding
- Needle Gunning

In emergency / temporary applications it may be difficult to prepare the surface according to above methods. In any case, it is important to clean the surface to SA 2,5 and 75 microns roughness. If possible dry the surface before applying. If not possible, use Wencon UW products.

For further information on Wencon surface preparation, please contact our Area Sales Managers.