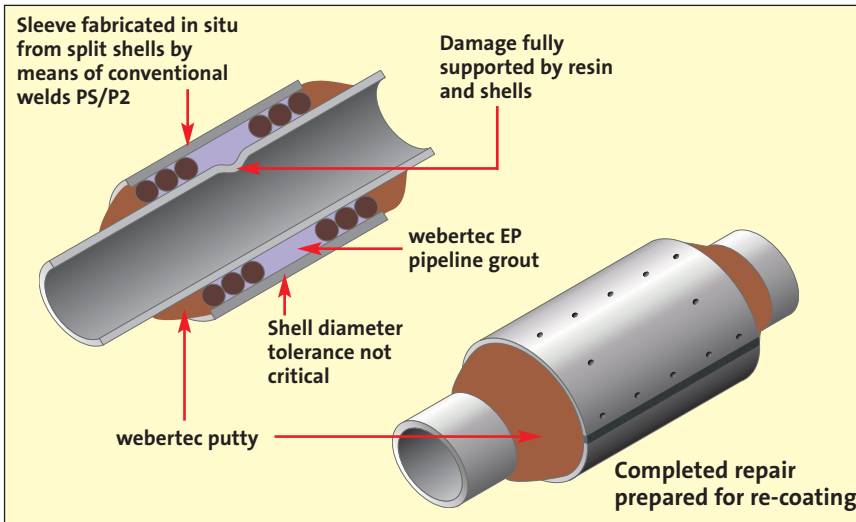


*Rapid setting fluid grout for pipeline shell repair*

# webertec EP pipeline grout



## Uses

- Repair of most types of pipeline damage, including dents, gouges, cracking and combinations of these
- 3 Grades to suit most application conditions:
  - DG 38** – Low temperatures  
3°C – 20°C
  - DG 118** – Medium temperatures  
15°C – 30°C
  - DG 2088** – High temperatures  
20°C – 45°C

## About this product

**webertec EP pipeline grouts** are formulated to repair damaged and defective gas pipelines subject to high internal pressure and a range of external and internal service temperatures. The grouts allow rapid cure with sufficient working time over temperatures ranging from 3 – 45°C. They have exceptional toughness, good flow characteristics and negligible shrinkage.

## Features and benefits

- ▲ Highly fluid to penetrate small annular gaps
- ▲ Pumpable, does not segregate under pressure
- ▲ Fully complies with British Gas provisional specification S 81 for new work and PS/CP/P12 for remedial work on existing pipelines
- ▲ Once fully cured, minimum operating temperature for all grades is –20°C and maximum operating temperature for all grades is +45°C. (assuming gas and ambient temperature are the same)

**Note:** The grouts may be suitable for operations beyond this temperature range but further testing would be needed. Contact our Technical Services Staff.

## Technical data

webertec EP pipeline grout Grades	DG 38 Winter Grade	DG 118 Summer Grade	DG 2088 Tropical Grade
<b>Working times (minutes)</b>			
5°C	40	NR	NR
10°C	32	NR	NR
15°C	19	52	NR
20°C	15	45	115
25°C	<9	30	–
30°C	NR	–	60
35°C	NR	NR	–
40°C	NR	NR	30
45°C	NR	NR	24
<b>Exotherm characteristics</b>			
at 15°C	4°C	<1°C	*
at 25°C	9°C	6°C	*
at 40°C	13°C	7°C	*
<b>Volume shrinkage</b>			
at 15°C	0.51%	0.48%	*
at 25°C	0.58%	0.56%	*
<b>Tensile adhesion</b>			
at 22°C	12.61 N/mm <sup>2</sup>	11.31 N/mm <sup>2</sup>	*
<b>8 hr compressive strength</b>			
at 22°C	62 N/mm <sup>2</sup>	53 N/mm <sup>2</sup>	*
at 32°C	70 N/mm <sup>2</sup>	62 N/mm <sup>2</sup>	*

\* Please refer to Technical Service Department  
 NR – Not recorded or recordable

# webertec EP pipeline grout

## Preparation

The bonding surfaces of the pipeline and securing sleeve must be clean, sound, degreased and free of all contamination.

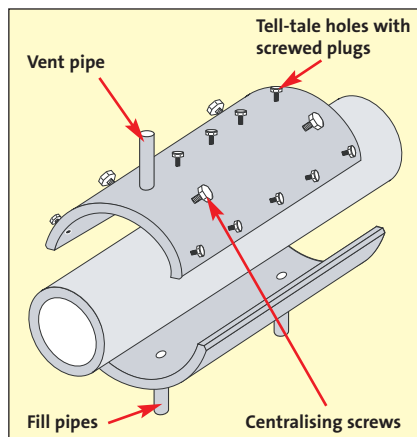
### Sealing the gap

Having first welded the sleeve in position with a 6 mm annular gap, push in two complete rounds of compressible foam seal at each end followed by one seal of compressed plastic tubing at each end.

Make rigid back up seal with **webertec putty** at each end. Wait until the seal has set firmly. (Approximately 60 – 90 minutes)

### Equipment and services required

- A slow speed drill with MR4 100B type stirrer attachment for mixing the grout.
- A suitable air driven or peristaltic pump with hopper feed, complete with hoses, clips and shut off valves for pressure filling/venting the grout throughout the sleeve void.
- Clean dry compressed air to 30 cfm.
- Top and bottom repair sleeves to the correct oversize of the pipe i.e. 6 mm annular gap.
- Four circumference lengths of compressible foam seal.
- Two circumference lengths of compressible plastic tubing.



## Mixing

Transfer the total contents of the resin into a clean 20 litre plastic bucket. Allow adequate time for drainage from the can. Add the total contents of the plastic bottle of hardener to the resin in the plastic bucket and mix together thoroughly using a slow speed (400 – 500 rpm) electric stirrer.

Gradually add the bag of filler whilst mixing thoroughly, to produce a free flowing homogeneous grout.

The total mixing operation should not take more than five minutes, however, it is essential to ensure that the grout is fully homogeneous and free from any lumps.

## Application

Connect pump to compressed air source (clean dry compressed air).

Connect pump to grout hose.

Connect pump inlet to grout hopper.

Pour the mixed grout from the bucket into the hopper.

Commence pumping through hose and return to hopper feed via the pump.

When this becomes a continuous flow, stop pumping and connect grout hose to bottom inlet and clamp in place with jubilee clip.

Commence pumping at controlled flow of around 2 – 5 litres/min.

Continue pumping from inlet with all tell tale breathers unscrewed and alternate inlet valves open.

Immediately grout exudes from any of the tell-tale breathers screw these up and re-continue pumping via the inlet and outlet valves.

Continue pumping until the void is filled and the complete system is filled under pressure.

If it does not prove practical to fill the complete void from one inlet proceed to a further stage:

Close valve on bottom outlet.

Release pressure.

Remove hose and refit to most appropriate alternative inlet.

Continue pumping until the void is completely filled.

When the void is completely filled and under pressure remove several of the top screwed breathers and continue pumping for about 5 minutes observing the amount of entrapped air which escapes.

When no further air is apparent seal up all outlets and apply maximum pressure from the pump. Close the inlet valve with repair still under pressure and leave to cure.

## Cleaning

After use, but before materials set, tools, mixer and pump should be cleaned with **webertec solvent**. The solvent can also be used to clean the peristaltic hose. Rinse solvent residue from the hose with water after cleaning.

## Packaging and yield

**webertec EP pipeline grout** is supplied in 17.5 kg packs comprising :

- 1 can of resin
- 1 bottle of hardener
- 1 bag of filler

Each pack yields approx. 10 litres.

In addition to the grout, a pack of fast setting **webertec putty** is required to produce the rigid seal at each end of the sleeve. The **webertec putty** pack consists of:

- 1 can resin
- 1 bag hardener/filler powder

Each pack will yield approx. 8 litres.

## Storage and shelf life

Although **webertec EP pipeline grout DG 38** can be mixed and poured slowly at 5°C it is strongly recommended that all grades of the grout are stored in warm conditions overnight at a minimum temperature of 15°C before mixing and pouring.

Stored under the correct conditions shelf life is 12 months.

## Health and safety

Contains epoxy constituents. See information supplied by manufacturer. All skin contact with **webertec EP pipeline grout** and **webertec putty** should be avoided. Creams plus rubber gloves, protective clothing and goggles should be worn and mixing should be carried out in a well ventilated area.

**For further details on safe handling, please refer to the relevant Material Safety Data Sheet.**

To the best of our knowledge and belief, this information is true and accurate, but as conditions of use and any labour involved are beyond our control, the end user must satisfy himself by prior testing that the product is suitable for his specific application, and no responsibility can be accepted, or any warranty given by our Representatives, Agents or Distributors. Products are sold subject to our Standard Conditions of Sale and the end user should ensure that he has consulted our latest literature.

## Technical services

Weber's Customer Services Department has a team of experienced advisors available to provide on-site advice both at the specification stage and during application. Detailed specifications can be provided for specific projects or more general works. Site visits and on-site demonstrations can be arranged on request.

### Technical helpline

Tel: 08703 330 070

e-mail [technical@netweber.co.uk](mailto:technical@netweber.co.uk)

## Sales enquiries

Weber products are distributed throughout the UK through selected stockists and distributors. Please contact the relevant Customer Services Team below for all product orders and enquiries.

### UK and Ireland

Tel: 08703 330 070

Fax: 0800 014 2995

e-mail [sales@netweber.co.uk](mailto:sales@netweber.co.uk)

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