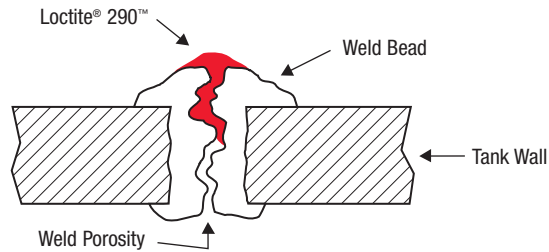


POROSITY SEALING

EXISTING WELD POROSITIES AND CASTINGS



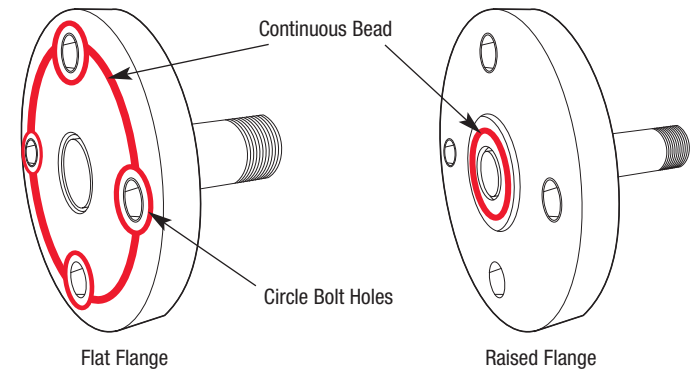
1. **IMPORTANT! TAKE PROPER SAFETY PRECAUTIONS IF WORKING WITH FLAMMABLE LIQUID TANKS. AVOID USE WITH COMPRESSIBLE GASSES.**
2. Wire brush to remove paint, rust, etc. from repair area.
3. Clean repair area with Loctite[®] ODC-Free Cleaner & Degreaser.
4. Apply localized heat to bring repair area to approximately 250°F.
5. Allow repair area to cool to approximately 185°F.
6. Brush or spray sealant on repair area.
 - Note:**
 - Steel – Use Loctite[®] 290™ Threadlocker at 185°F.
 - Aluminum/Stainless Steel – Use Loctite[®] 290™ Threadlocker at 120°F.
 - Note:**
 - Not recommended for “blowholes”.
 - Maximum porosity sealed – .005”.
7. Allow to cure for 30 minutes (High Pressure, above 150 psi – 1 hour).
8. Clean with Loctite[®] ODC-Free Cleaner & Degreaser to remove excess sealant. Do not grind.
9. Paint as required.
 - Note:** Casting repair uses same procedure.

SEALING NEW WELDS – PREVENTATIVE MAINTENANCE

1. Remove all slag and scale while hot.
2. Apply sealant when weld is 185°F and falling.
3. Follow information above.

FORM-IN-PLACE GASKETING

SEALING CAST RIGID FLANGES



1. Remove old gasketing material and other heavy contaminants with Loctite[®] Chisel[®] Gasket Remover. Use mechanical removal technique if required.
 - Note:** Avoid grinding.
2. Clean both flanges with Loctite[®] ODC-Free Cleaner & Degreaser.
3. Spray Loctite[®] 7649™ Primer N™ on only one surface. Allow 1-2 minutes to dry.
4. Apply a continuous bead of Loctite[®] Gasket Eliminator[®] Flange Sealant to the other surface.
 - Note:** Circle all bolt holes with sealant, if appropriate.
5. Mate Parts. Assemble and tighten as required.
 - Note:** Immediate assembly not required; however avoid delays over 45 minutes.
6. Allow to cure:
 - a. No pressure – immediate service
 - b. Low pressure (up to 500 psi) – 30 to 45 minutes
 - c. High pressure (500 to 2500 psi) – 4 hours
 - d. Extreme high pressure (2500 to 5000 psi) – 24 hours

LOCTITE[®] BRAND GASKETING QUICK SELECTOR

Use	Product	Gap Fill	Temp. Range
General	518™ Gasket Eliminator [®]	.050"	-65°F to 300°F
General	515™ Gasket Eliminator [®]	.050"	-65°F to 300°F
High Temperature	510™ Gasket Eliminator [®]	.020"	-65°F to 400°F
General/Overhead	QuickStix™ 548™ Gasket Eliminator [®]	.010"	-65°F to 300°F