



IPS®

WELD-ON

JOINING PVC and CPVC PLASTIC PIPE



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 IPS WELD-ON SOLVENT CEMENTS.**

Weld-On solvent cements have **EXCELLENT COLD WEATHER STABILITY** for virtually all practical applications. In addition to our regular and low VOC cements, Weld-On offers a solvent cement specially formulated for cold weather applications. (See Weld-On "Hot 'R Cold" product bulletin.)

GOOD JOINTS CAN BE MADE WITH WELD-ON AT SUB-ZERO TEMPERATURES

By following our standard instructions and using a little extra care and patience, successful solvent cemented joints can be made at temperatures even as low as -15°F. In cold weather, solvents penetrate and soften the plastic pipe and fitting's surfaces more slowly than in warm weather. Also, the plastic is more resistant to solvent attack. Therefore, it becomes even more important to pre-soften surfaces with an aggressive primer. And, because of slower evaporation, a longer cure time is necessary. The cure schedules printed in our "Guide to Solvent Cementing" booklet already allow a margin for safety, but for colder weather, more time should be allowed.

TIPS TO FOLLOW WHEN SOLVENT CEMENTING IN COLD WEATHER

1. Prefabricate as much of the system as is possible in a heated work area.
2. Store cements and primers in a warmer area when not in use and make sure they remain fluid. If possible, store the fittings and valves the same way.
3. Take special care to remove moisture including ice and snow from the surfaces to be joined, especially from the ends of the pipe.
4. Use Weld-On P-70 Primer to soften the joining surfaces before applying cement. More than one application may be necessary.
5. Allow a longer cure period before the system is used. A heat blanket may be used to speed up the set and cure times.
6. Read and follow all of our directions carefully before installation.

All Weld-On cements are formulated to have well balanced drying characteristics and to have good stability in sub-freezing temperatures.



For all practical purposes, good solvent cemented joints can be made in very cold conditions with proper care and a little common sense.

ALL YEAR LONG . . . YOU CAN DEPEND ON . . . WELD-ON!

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