



EA-616 EPOXY WELD ADHESIVE

PRODUCT BULLETIN



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DESCRIPTION

EA-616 EPOXY WELD ADHESIVE is a two component adhesive system developed for bonding similar and dissimilar substrates at room temperature. EA-616 has a convenient 1 to 1 mix ratio with color change to indicated positive mix. The black resin and white hardener when properly mixed is a uniform dark gray. EA-616 has a relatively fast set (8-13 minutes @ 77°F) and reaches handling strength within 1½ to 3 hours. **EA-616 exhibits excellent bond strength to such unusual bonds as fiberglass, graphite epoxy, rubber, thermo plastics, stainless steel, aluminum, oily metal and other difficult bonds.**

HANDLING CHARACTERISTICS @ 25°C/77°F

Mix Ratio (by weight or volume)	100R/100H
Density.....	9.4 lb/gal
Specific Gravity	1.13 gms/cc
Work Life (4 oz mass).....	8-13 minutes
Handling Strength	1½-3 hours
Cure (complete)	16-24 hours
Shelf Life of Resin and Hardener (in original unopened containers)	1 year

PHYSICAL PROPERTIES

Ultimate Tensile Strength (ASTM D-638)	3,563 psi
Tensile Elongation (ASTM D-638)	1.14%
Tensile Modulus (ASTM D-638).....	622,400 psi
Impact Strength (ASTM D-256.93a)	5.7 in-lbf/in
Heat Defection Temperature @ 66 psi (ASTM D-648.88)	115.1°F
Heat Defection Temperature @ 264 psi (ASTM D-648.88)	108.0°F
Compressive Strength (ASTM D-695.91)	8,104 psi
Compressive Modulus (ASTM D-695.91)	223,300 psi
Coefficient of Thermal Expansion (ASTM D-696.91)	29.7 x 10 ⁻⁶ in/in°F
Flexural Strength (ASTM D-790).....	5,953 psi
Flexural Modulus (ASTM D-790).....	305,500 psi
Lap Shear Strength (metal to metal) (ASTM D-1002).....	1,596 psi
Peel Resistance (ASTM D-1876)	6.474 lbs/in

EA-616 Tech/Revised 5/20/10
Supercedes 6/22/06

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