Wearresist Technologies Private
An ISO 9001: 2000 Company

XL-XHAR Product Data Sheet

Carbide Composite

XL-XHAR is designed for highly abrasive environments which are also subject to aggressive chemical attack. Heavily filled with abrasion resistant silicon carbide, this product may be built up to an inch or more in a succession of layers. XL-XHAR can be used to rebuild badly eroded and corroded cast iron, steel and other metallic and nonmetallic surfaces. It provides a rapid, cost effective repair which returns worn equipment to its original specifications and protects it from future degradation due to abrasion, erosion and corrosive attack.

FEATURES

- **Outstanding resistance to entrained solids and abrasion**
- **Very good chemical resistance**
- **Excellent temperature and thermal shock resistance**
- **Extended pot life**
- **Easily built up for thick applications.**

PACKAGING

1 kg. (2.2 lb.) units; approximately 31 cubic inches (4 kg. units also available)

COVERAGE

XL-XHAR is a trowel-on rebuilding compound and can be applied up to 250 mils/coat. Thicker applications can be achieved by multiple layers. Theoretical coverage at 60 mils is 3.4 square feet per kg.

MIXING RATIO

2 parts base (B) to 1 part (A) hardener by weight
2 parts base (B) to 1 part (A) hardener by volume

POT LIFE

For a 1 kg unit mix at 70 F, pot life is approximately 45 minutes. High temperatures or larger mass will shorten this time, lower temperatures or smaller mass will extend it. Pot life can also be extended by spreading the mass out to dissipate heat.

COLORS

XL-XHAR-is gray in color.

TECHNICAL DATA AND INFORMATION

Basic Chemical Resistance at Room Temperature

Inorganic Acids Dilute	Very Good-Excellent
Organic Acids	Good-Very Good
Solvents	Good-Very Good
Alkalis	Excellent
Salts	Excellent
Alcohols	Excellent
Hydrocarbons	Excellent

Typical Physical Properties of Cured System :

Density	1.94
% Solids	100
Flexural Strength @ 70 F	20,800 psi
Tensile Strength @ 70 F	11,700 psi
Tensile shear @ 70 F	3,000 psi
Service Temperature Maximum	500 F
Operating pH Range	1.5-14.0

SURFACE PREPARATION

- **For maximum adhesion, material should be applied to a firm, clean, dry and abraded surface.**
- **Clean greasy, oily or waxed surfaces with suitable solvent before applying material.**
- **Best results will be obtained by abrasive blasting the surface.**
- **If blasting is impractical, water blasting, acid etching, or grinding can also be used.**

MIXING

Mix ALL of Part A with ALL of Part B. Mixing may be done on a large mixing board or container large enough to hold both the base and hardener. The selected mixing surface must be clean and dry. Mix the material thoroughly until no streaks of any kind are visible. If materials are cold, warm them to 70 F before mixing.

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