

# PC® 136 COMPOUND PRODUCT DATA SHEET

IMPORTANT: MATERIAL SAFETY DATA SHEETS ARE AVAILABLE AND SHOULD BE READ BEFORE USING THIS PRODUCT.

## DESCRIPTION:

PC® 136 compound is a reactive cementitious product that is mixed with water to form an inorganic, noncombustible compound for fabricating, or bore coating.

PC® 136 compound is normally used at ambient and above temperatures to 482°C (900°F) where stress-crack corrosion is a concern with stainless steel.

## \*TYPICAL PROPERTIES:

PROPERTY	
Color:	Gray
Appearance:	Dry fine powder
Density, g/cm <sup>3</sup> ( lbs/ft <sup>3</sup> )	0.74 to 0.83 (46 to 52)
Application Temp °C (°F):	4 – 38 (40 – 100)
**Set Time, 25°C (77°F), mins:	20 - 30
Service Temp, °C (°F):	-73 to 482 (-100 to 900)
Water Vapor Transmission:	Not Available
pH:	Alkaline
Combustibility:	Incombustible wet or dry

\* Properties subject to change. Consult Pittsburgh Corning

\*\*Will vary with batch size, temperature and mixing ratio.

## SPECIFICATION COMPLIANCE:

Will meet the requirements of ASTM C795, NRC 1.36 and MIL-DTL-24244(SH) specifications, if chloride and fluoride levels of mixing water are acceptable.

Materials containing chloride, fluoride, mercury, zinc or other low melting metals should not be added.

## ESTIMATING:

The working time and quantity of product used may vary depending on cell size, application method, and temperature. Therefore, the figures listed below are estimated quantities. The suggested quantities are offered as a guide to the user and should not be relied upon as absolutes.

Fabrication Joint:	1.66 to 1.71 kg powder/m <sup>2</sup> (34 to 35lbs. powder/100ft <sup>2</sup> )
Bore Coating:	0.44 to 0.48 kg powder/m <sup>2</sup> (9 to 10 lbs. powder/100 ft <sup>2</sup> )

## TOOLS AND EQUIPMENT:

Hand mixing is usually sufficient. A plastic coated straight mixing paddle (similar to what paint stores provide) is

recommended. Containers and tools should be plastic. Brushes should be disposable bristle type. Have sufficient tools and containers available. Clean tools and containers with water before compound sets.

## SURFACE PREPARATION:

Check substrate surfaces for flatness, compound cannot make up for poor surface uniformity. FOAMGLAS® insulation should be free of loose dust. Lay out work before mixing compound

## MATERIAL PREPARATION:

Store in a dry area. Lumpy material should not be used. The volume mix ratio for fabricating is 3.0/1 (powder/water). Powder and water may be mixed in a container and applied by tool as slurry. It is NOT recommended that powder and water be mixed on the block surfaces. The proper powder/water ratio is important.

The volume mix ratio for bore coating is approximately 2.5/1 (powder/water).

For slurry application, add powder to water and mix until desired consistency. Use immediately. Cold water will delay set, hot water will accelerate set.

Once compound sets, it cannot be recovered.

## JOINT FABRICATION:

Apply slurry to both faces. A Type "A" notch trowel is useful in getting the proper coverage rate. Application to both faces is necessary.. Provide any needed support and don't move piece until compound sets. Fabricate assembled billets within 24 to 72 hours after assembly. Compound sets by chemical reaction, not by drying.

## BORE COAT APPLICATION:

Check FOAMGLAS® insulation for fit and clearance to allow for pipe expansion and bore coat. Hot work should be loose fitting. Apply to bore with brush or other suitable applicator. Cells should not be filled and a continuous coating is not needed. A salt and pepper appearance is sufficient. Remove any lumps or excess compound from all surfaces before compound sets.

# PC<sup>®</sup> 136 COMPOUND PRODUCT DATA SHEET

## CLEAN UP AND DISPOSAL:

PC<sup>®</sup> 136 compound will set under water. Do not wash or discard into sewer.

Clean up with water before compound hardens. Set compound must be mechanically removed.

Set compound can be land filled. Powder should be mixed with water before discarding to landfill.

## STORAGE:

To achieve maximum shelf life, store unopened containers in a dry area.

## LIMITATIONS:

Do not use for permanent bonding of FOAMGLAS<sup>®</sup> insulation to other materials without first contacting Pittsburgh Corning for more information.

Compound is not a vapor barrier. Some coatings may blister over cured compound

**PACKAGING:** Available in 20.4 kg (45 lb) pails

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