

US WELD

Solvent Cement Guide



Irrigation
Cement



Industrial
Cement



Pool & Spa
Cement



Plumbing
Cement



MADE IN U.S.A.



Choosing The Correct Solvent Cement Is Vital!

UNITED SEALANTS & ADHESIVES LLC. offers high strength solvent cements for thermoplastic piping systems including PVC, CPVC, and ABS, along with Primers and applicators to ensure reliable joints for any project. Our products are formulated for PVC pipe and fittings up to 900 mm (36") diameter for both pressure and non-pressure applications, CPVC through 300 mm (12") diameter and ABS through 200 mm (8") diameter.

With years of experience working alongside regulatory agencies and third-party certifiers, we bring unmatched reliability and technical precision to every product. Our commitment to innovation and quality has solidified our position in highly competitive markets. At United Sealants & Adhesives, our unwavering focus on sustainability, and customer-centric solutions ensures long-term success for our partners.





United Sealants & Adhesives was established with the objective of creating a sustainable organization for the future. Our experienced team is dedicated to delivering the right product, with the right quality, at the right market price. Founded on the principles of trust and reliability, United Sealants & Adhesives prioritizes the professional installers. The company envisions a customer-focused organization, leveraging a mix of talent, technology, resources, processes, and standards to use its international expertise. Our focus on solvent cement remains at the forefront as we continue to grow.

Our brand, US-WELD, was developed to meet the global requirements of plumbing contractors and installers. US-WELD solvent cement is designed with the concept of "Power of One," addressing the significant needs of plumbing professionals worldwide.



Vision

At United Sealants & Adhesives, our resolute and sustainable solutions drive global industry standards, expanding our presence globally. Our commitment to strong core technology ensures that we deliver reliable and sustainable products that our customers can depend on.



Mission

US Weld solvent cements are focused on our customers' needs first. Customer-centric solutions ensure long-term success for our partners. Our commitment to high-quality solvent cements solidifies our dedication to providing reliable and sustainable products.



Low-Voc

US-WELD Low VOC products are performance oriented specially developed to SCAQMD standards compliance and to USGBC council LEED projects. US-WELD Low VOC solvent cements helps to gain credits for green building certifications.



5113 CPVC/Regular-bodied



 Orange

- ▲ CPVC cement for all classes and schedules with interference fit through 4" (110 mm) diameter
- ▲ Specially formulated to use without primer if local code permits
- ▲ For portable water 180°F (82°C), suitable for residential or industrial piping system
- ▲ Recommended application Temperature: 0°F to 115°F/-17°C to 46°C



Body	Regular
Set Time	Fast
Color	Orange
Maximum Pipe Size (interference fit)	CPVC Pipe Size through 4"
Listing & Performance Specs	ASTM D2846 & F493
Available in Size:	
118ml (04 Oz) Tin, 237ml (08 Oz) Tin, 473ml (16 Oz) Tin, 946ml (32 Oz) Tin	

GOLD CPVC/Medium-bodied



 Yellow

- ▲ One step CPVC Cement for CTS & Sch. 40 pipe & fitting with interference fit through 2" (63mm) diameter.
- ▲ For residential & commercial hot & cold water system upto 180°F (82°C).
- ▲ Recommended application Temperature: 0°F to 115°F/-17°C to 46°C.



Body	Medium
Set Time	Fast
Color	Yellow
Maximum Pipe Size (interference fit)	CPVC Pipe Size through 2"
Listing & Performance Specs	ASTM D2846 & F493
Available in Size:	
118ml (04 Oz) Tin, 237ml (08 Oz) Tin, 473ml (16 Oz) Tin, 946ml (32 Oz) Tin	

5114 CPVC/Heavy-bodied



 Gray

 Orange

- ▲ CPVC cement for all classes and schedules with interference fit through 12" (315mm) diameter
- ▲ For residential & commercial hot & cold water system upto 180°F (82°C)
- ▲ Recommended application Temperature: 0°F to 115°F/-17°C to 46°C
- ▲ Used to Corzan type CPVC piping systems



Body	Heavy
Set Time	Medium
Color	Orange/ Gray
Maximum Pipe Size (interference fit)	CPVC Pipe Size through 12"
Listing & Performance Specs	ASTM D2846 & F493
Available in Size:	
118ml (04 Oz) Tin, 237ml (08 Oz) Tin, 473ml (16 Oz) Tin, 946ml (32 Oz) Tin	



5115 PVC/Regular-bodied



- ▲ PVC Cement for all schedules with interference fit through 4" (110mm) diameter except schedule 80.
- ▲ Recommended for all grades and type of PVC pipe & fitting.
- ▲ Application Areas: Plumbing Electrical Conduit, Pool & Spa



Body	Regular
Set Time	Fast
Color	Clear/Gray
Maximum Pipe Size (interference fit)	4" PVC All rigid PVC Not for schedule 80
Listing & Performance Specs	ASTM D 2564
Available in Size:	118ml (04 Oz) Tin, 237ml (08 Oz) Tin, 473ml (16 Oz) Tin, 946ml (32 Oz) Tin



5116 PVC/Medium-bodied



- ▲ PVC Cement for all class & schedules with interference fit through 6" (160mm) diameter, Schedule 80 through 4" (110mm) diameter.
- ▲ Can be used as One step cement without primer on non-pressure piping systems if local codes permits.
- ▲ Application Areas: Portable Water, DWV, Sewer Application Electrical Conduit, Plumbing including PVC foam core pipes.



Body	Medium
Set Time	Fast
Color	Clear/Gray
Maximum Pipe Size (interference fit)	6" PVC 4" schedule 80
Listing & Performance Specs	ASTM D 2564
Available in Size:	118ml (04 Oz) Tin, 237ml (08 Oz) Tin, 473ml (16 Oz) Tin, 946ml (32 Oz) Tin



5117 PVC/Heavy-bodied



- ▲ PVC Cement for all class & schedules with interference fit through 12" (315mm) diameter & for non-pressure application up to 18" (450mm) diameter.
- ▲ Gap filling property and allows more working time during warm conditions.
- ▲ Application Areas: Plumbing, Industrial, Pool & Spa, Irrigations, & Electrical Conduit.



Body	Heavy
Set Time	Medium
Color	Gray/ Clear
Maximum Pipe Size (interference fit)	For all classes & sch. with interference fit through 12"
Listing & Performance Specs	ASTM D 2564
Available in Size:	118ml (04 Oz) Tin, 237ml (08 Oz) Tin, 473ml (16 Oz) Tin, 946ml (32 Oz) Tin



 Blue



5125 PVC/Medium-bodied

- 5125 is a medium bodied, EXTREMELY fast setting PVC cement for use on all schedules and classes of PVC pipe and fittings up to 6" diameter with interference fit; Schedule 80 through 4" diameter.
- Premium PVC cement specifically formulated to cure extremely fast in wet conditions and/or where quick pressurization of piping system is required
- Suitable for use on rigid and flex PVC piping systems.

Body	Medium
Set Time	Fast
Color	Blue
Maximum Pipe Size (interference fit)	6" PVC 4" schedule 80
Listing & Performance Specs	ASTM D 2564
Available in Size:	118ml (04 Oz) Tin, 237ml (08 Oz) Tin, 473ml (16 Oz) Tin, 946ml (32 Oz) Tin



5127 MULTI/Medium-bodied

- 5127 is a medium bodied, very fast setting PVC cement for use on all schedules and classes of PVC pipe and fittings up to 6" diameter with interference fit; Schedule 80 through 4" diameter.
- Specifically formulated for use during all seasons of the year, ranging from temperatures of -15°F to 110°F.
- Suitable for use on rigid and flex PVC piping systems. Can be used in wet conditions and/or where quick pressurization is required.



Body	Medium
Set Time	Fast
Color	Clear
Maximum Pipe Size (interference fit)	6" PVC 4" PVC schedule 80
Listing & Performance Specs	ASTM D 2564
Available in Size:	118ml (04 Oz) Tin, 237ml (08 Oz) Tin, 473ml (16 Oz) Tin, 946ml (32 Oz) Tin



 Clear

 Gray



5195 FLEX/Medium-bodied

- 5195 is a medium bodied, very fast setting PVC cement formulated for use in joining all types of flexible or rigid PVC pipe and fittings with interference fit up to 6" diameter; Schedule 80 up to 3" diameter.
- Premium formulation for all flex to flex and flex to rigid PVC piping systems widely used in the pool & spa industry.

Body	Medium
Set Time	Fast
Color	Clear/Gray
Maximum Pipe Size (interference fit)	6" PVC 3" schedule 80
Listing & Performance Specs	ASTM D 2564
Available in Size:	118ml (04 Oz) Tin, 237ml (08 Oz) Tin, 473ml (16 Oz) Tin, 946ml (32 Oz) Tin



 Purple

5148 PRIMER/Non bodied

- ▲ Very aggressive fast acting primer for PVC and CPVC pipe and fittings
- ▲ Recommended for commercial & large diameter thermo-plastic piping systems, specially CPVC Sch. 40 & Sch. 80. Ideal for use in cold weather conditions
- ▲ Removes surface dirt, grease and grime as well as softens the pipe surface to allow a fast, secure solvent weld.



Body	Non bodied
Set Time	Fast
Color	Purple
Maximum Pipe Size (interference fit)	For all PVC/CPVC pipes & fittings
Listing & Performance Specs	ASTM F 656
Available in Size:	
118ml (04 Oz) Tin, 237ml (08 Oz) Tin, 473ml (16 Oz) Tin, 946ml (32 Oz) Tin	



 Clear

5170 Cleaner

- ▲ Specially formulated for removal of oil, dirt, grease for the surface of PVC/CPVC Pipe & Fittings
- ▲ Recommended for use before priming of pipe & fittings



Color	Clear
Maximum Pipe Size (interference fit)	No maximum All PVC/CPVC/ABS Styrene
Available in Size:	
118ml (04 Oz) Tin, 237ml (08 Oz) Tin, 473ml (16 Oz) Tin, 946ml (32 Oz) Tin	



PL-90 Lubricant

- ▲ Custom-formulated, multipurpose lubricant are great for motors, circulators and other pumps, sliding parts, bearings, chains, linkage or wherever metal lubricant is desired.
- ▲ Non-toxic, soft, paste like material for lubricant bell joint pipe gaskets.
- ▲ Will not deteriorate natural or synthetic rubber.
- ▲ Will nor support bacteria.
- ▲ Dissolves in hot water



PIPE SIZE	LBS. PER 100 JOINTS	PIPE SIZE	LBS. PER 100 JOINTS
4"	3	30"	22
6"	4	36"	28
8"	5	42"	32
10"	6	48"	40
12"	9	54"	45
15"	11	60"	54
18"	13	66"	60
21"	16	72"	67
24"	17	78"	70
27"	19	84"	77

Available in Size:
946ml (32 Oz) Tub

Average Number of Joints per Quart Can

Pipe Size	ASTM	½	¾	1	1¼	1½	2	2½	3	4	6	8	10	12	14	18
	ISO (DIN)	20	25	32	40	50	63	75	90	110	160	200	250	315	350	450
No. of Joints		300	200	125	105	90	60	50	40	30	10	6	3	2	¾	½

*This chart should be used as a general reference only as these figures are estimates based on testing done under laboratory conditions. Field working conditions can vary significantly

Pipe Size Equivalent Chart

ASTM (inc)	½	¾	1	1¼	1½	2	2½	3	4	6	8	10	12	14	18	24	30
ISO (DIN) (mm)	20	25	32	40	50	63	75	90	110	160	200	250	315	350	450	600	800

Average Handling / Set-up Times¹

Handling/Set-up time is the time required prior to handling the joint carefully. In damp or humid weather, allow 50% additional cure time.

Temperature While Joining	Pipe Diameter 1/2" to 1 1/4" 15mm to 32mm	Pipe Diameter 1 1/2" to 2" 40mm to 50mm	Pipe Diameter 2 1/2" to 5" 65mm to 125mm	Pipe Diameter 6" to 8" 150mm to 200mm	Pipe Diameter 10" to 16" 250mm to 375mm	Pipe Diameter 16" + 400mm
16°C - 38°C (60°F - 100°F)	2 minutes	5 minutes	25 minutes	30 minutes	2 hours	4 hours
5°C - 16°C (40°F - 60°F)	5 minutes	10 minutes	50 minutes	2 hours	8 hours	16 hours
-18°C - 5°C (0°F - 40°F)	10 minutes	15 minutes	4 minutes	4 hours	24 hours	48 hours

+ This chart should be used as a general reference only as these figures are estimates based on testing done under laboratory conditions. Field working conditions can vary significantly.

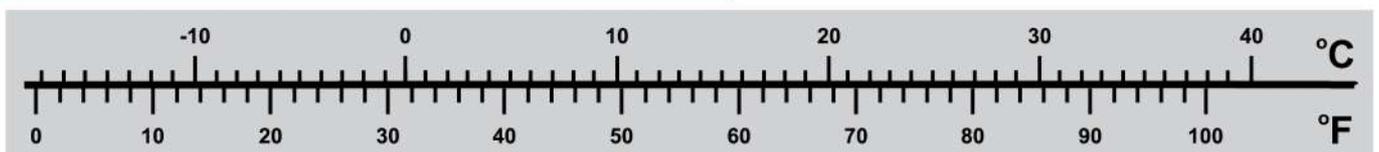
Average Joint Cure Times²

Joint Cure Time is the time required before pressure testing the system. In damp or humid weather, allow 50% additional cure time

Relative Humidity 60% or Less	Pipe Diameter 1/2" to 1 1/4" 15mm to 32mm		Pipe Diameter 1 1/2" to 2" 40mm to 50mm		Pipe Diameter 2 1/2" to 8" 65mm to 200mm		Pipe Diameter 10" to 15" 250mm to 375mm	Pipe Diameter 16" + 400mm
	up to 145 psi / 10 bar	145 to 363 psi / 10 to 25 bar	up to 145 psi / 10 bar	145 to 363 psi / 10 to 25 bar	up to 145 psi / 10 bar	145 to 363 psi / 10 to 25 bar	up to 100 psi / 7 bar	up to 100 psi / 7 bar
16°C - 38°C (60°F-100°F)	15 minutes	6 hour	30 minutes	12 hour	1.5 hour	24 hour	48 hour	72 hour
5°C - 16°C (40°F-60°F)	20 minutes	12 hour	45 minutes	24 hour	4 hour	48 hour	96 hour	6 days
-18°C - 5°C (0°F-40°F)	30 minutes	48 hour	1 hour	96 hour	72 hour	8 days	8 days	14 days

+ This chart should be used as a general reference only as these figures are estimates based on testing done under laboratory conditions. Field working conditions can vary significantly.

Fahrenheit to Celsius Conversion Chart



SELECTION GUIDE

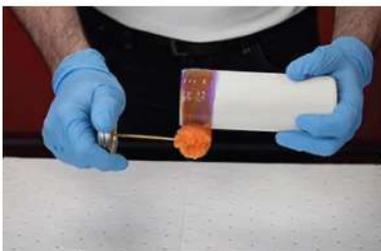


Choose the right US WELD products for your application based on the pipe diameter and material (PVC, CPVC, ABS) being used. Refer to the chart below and see the product description on the details pages.

		NOMINAL PIPE SIZE		in	1/2	3/4	1	1 1/4	1 1/2	2	2 1/2	3	4	6	8	10	12	14	24	30		
		mm		20	25	32	40	50	63	75	90	110	160	200	250	315	355	600	800			
US WELD PRODUCTS	PVC CEMENTS	COLOR	PRODUCT																			
		REGULAR BODY	CLEAR 5115																			
		MEDIUM BODY	CLEAR GRAY 5116																			
	HEAVY BODY	CLEAR GRAY 5117																				
	SPECIALTY CEMENT	MEDIUM BODY	AQUA BLUE 5125																			
		Multi	CLEAR GRAY 5127																			
		Flex	CLEAR GRAY 5195																			
	CPVC CEMENTS	REGULAR BODY	ORANGE 5113																			
		MEDIUM BODY	YELLOW GOLD																			
		HEAVY BODY	ORANGE GRAY 5114																			
	PRIMERS		CLEAR PURPLE 5148																			
	CLEANER		CLEAR 5170																			
		NOMINAL PIPE SIZE		in	1/2	3/4	1	1 1/4	1 1/2	2	2 1/2	3	4	6	8	10	12	14	24	30		
		mm		20	25	32	40	50	63	75	90	110	160	200	250	315	355	600	800			

PIPE FORMAT: Sch 40 Sch 80 DWV Ring Fit Pipes

Can be used without a primer on non-pressure systems with fittings having an interference fit (unless primer required by local code).



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WE MAKE GLUE...AND IT STICKS

UNITED SEALANTS & ADHESIVES
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