



- ▶ WEBAC® 4204 is an epoxy resin for primers, mortars, scratch primers and leveling finishes.

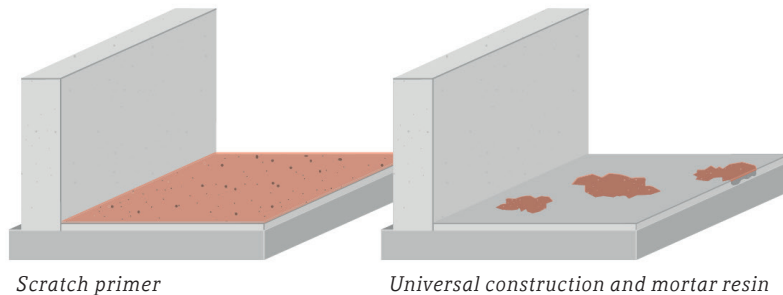
### Range of application

- Resin screed according to EN 13813 (CE-Declaration of Performance/4)
- Construction and mortar resin
- Scratch primer
- Adhesive agent for low-absorbent substrates

### Properties

- Good adhesion on mineral substrates
- Highly fillable
- Tack-free curing
- Resistant to mechanical stress
- Trowable with **WEBAC® ST200/ST300**
- Total solid\*

### Examples



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\*according to test method by Deutsche Bauchemie e.V. (German Industry Association for Manufacturers of Construction Chemicals)

## Epoxy Coating Systems – Primers

# WEBAC® 4204 CE

Technical data	Values			
Mixing ratio	4 : 1 parts by volume			
Density, 20 °C / 68 °F (ISO 2811)	<b>Comp. A</b>	≈ 1.14 g/cm <sup>3</sup>		
	<b>Comp. B</b>	≈ 0.99 g/cm <sup>3</sup>		
Pot life		<b>30 °C / 86 °F</b> ≈ 12 min	<b>20 °C / 68 °F</b> ≈ 30 min	<b>12 °C / 54 °F</b> ≈ 60 min
Application temperature Building structure and material	> 5 °C / 41 °F			
Viscosity of mixture		<b>30 °C / 86 °F</b> ≈ 330 mPa·s	<b>23 °C / 73 °F</b> ≈ 550 mPa·s	<b>12 °C / 54 °F</b> ≈ 1,600 mPa·s
Adhesive strength on concrete 7 d, 21 °C / 70 °F (EN 1542)	<b>dry</b>	> 4 N/mm <sup>2</sup>		
Compressive strength 7 d, 21 °C / 70 °F (ISO 604)	≈ 90 N/mm <sup>2</sup>			
Bending tensile strength 7 d, 21 °C / 70 °F (ISO 178)	≈ 120 N/mm <sup>2</sup>			
Shore hardness D 7 d, 21 °C / 70 °F (EN 868)	≈ 79/74			
CE classification (EN 13813)	SR - B2.0 - AR0.5 - IR4			
Fire behavior	minimum B2 according to DIN 4102-4. 2.3.2			
GISCODE	RE1			
EPD	EPD-DBC-20130018-IBE1-DE			
Exposure scenarios according to REACH	Assessment of industry standard application			

The specified data are values determined under laboratory conditions and are subject to a certain fluctuation. Deviations are possible in practice depending on the respective object situation.

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## Preparatory work

### Structural analysis:

- Inspection of the substrate
  - Moisture condition (dry, damp or wet)
  - Surface strength (> 1.5 N/mm<sup>2</sup>)
  - State of the surface (soiled, oily)
- Observe Dew Point Table ▶ p. 258 (the substrate temperature must be 3 °C / 37 °F above dew point temperature to avoid condensation)

Substrates must be open-pored and free of cement paste layers, loose particles and separative substances such as oil, grease and similar.



## Mixing

- Empty component A and B at the given mixing ratio into a bucket (make sure that the containers are completely empty) and mix homogeneously
- Transfer the mixed material to another clean bucket and stir briefly



## Application instruction

- The mixture must be used completely within the specified pot life
- Only use pure WEBAC material without any residues of cleaning agents or other impurity
- The pot life/curing time are influenced by the amount of material/layer thickness and the temperature of the material/building structure – higher temperatures accelerate, lower temperatures slow down the reaction



## Application

### Primer

- Apply the primer to the substrate by brush, roller or rubber scraper
- Apply the material evenly covering the entire surface in one or several operations (depending on the substrate's absorbency) avoiding puddle formation
- In case of oily substrates, the primer must be worked in thoroughly
- The primer must fill all pores and cavities/voids
- It is not necessary to scatter quartz sand onto the primer if it is coated within 24 hours

### Scratch- and leveling primer

- Fill the material with stoved quartz sand, mix well and distribute on the surface by trowel, scraper or rubber scraper immediately after mixing
- When working on sloping or vertical surfaces the material can be additionally rendered thixotropic by adding a set-up agent (**WEBAC. ST200/300**)
- If necessary, vent the installation and leveling finish with a porcupine roller and scatter with stoved quartz sand



## Cleaning

- Clean the equipment with **WEBAC. Cleaner A**
- Never use **WEBAC. Cleaner A** for diluting products; avoid mixing with the primer
- Use **WEBAC. Cleaner B** for dissolving cured material
- Observe the technical data sheets of the cleaners used

## Epoxy Coating Systems – Primers

# WEBAC® 4204 CE

# WEBAC®

### Product data

<b>Application</b>	By brush, roller, rubber scraper or trowel	
<b>Material consumption</b> depending on the substrate's absorbency	<b>Primer</b>	≈ 300 g/m <sup>2</sup>
	<b>Scratch primer</b> mixing ratio 1 : 3 parts by weight, per mm layer thickness	≈ 0.5 kg/m <sup>2</sup> WEBAC 4204 with 1.5 kg/m <sup>2</sup> quartz sand (grain size 0.3–0.7 mm)
	<b>Epoxy mortar</b> mixing ratio 1 : 10 parts by weight, per mm layer thickness	≈ 0.2 kg/m <sup>2</sup> WEBAC 4204 with 2.0 kg/m <sup>2</sup> quartz sand (grain size 0.1–1.2 mm, mixture of 0.1–0.3/0.3–0.7 and 0.7–1.2 mm (per 33 parts by weight))
<b>Packing</b>	<b>Comp. A</b> 23.5 kg <b>Combi:</b> 8.28 kg	<b>Comp. B</b> 5.2 kg 1.72 kg
<b>Storage</b>	<ul style="list-style-type: none"> <li>• Between 5 °C / 41 °F and 30 °C / 86 °F</li> <li>• Protect from moisture</li> <li>• In original, sealed containers</li> </ul>	
<b>Compatibility/Resistance</b>	<ul style="list-style-type: none"> <li>• Compatible with masonry mortar, concrete, steel, foil, cable sheathing and WEBAC injection materials</li> <li>• Resistant to diluted acids and alkalis, lubricants, oil and fuels</li> </ul>	

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### Test certificate

- Declaration of performance according to Construction Products Regulation

### Occupational safety/waste disposal

- ▶ Downloads on [webac-grouts.com](http://webac-grouts.com)



[webac-grouts.com/  
downloads](http://webac-grouts.com/downloads)

## ▶ Technical Information

All the data indicated in this technical data sheet and any related information provided by our employees are of an advisory nature representing our current state of knowledge and in no way binding. As the exact chemical, technical and physical conditions of the actual application are beyond WEBAC's control, this information does not preclude examination of the products and/or procedures for the intended application and surface by the user. WEBAC is thus unable to guarantee results. The user is fully responsible for the observation of existing regulations and conditions when using the products.  
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