

	WELD-ON® NUMBER	COLOR	NUMBER OF COMPONENTS	WORKING TIME	FIXTURE TIME	ULTIMATE BOND STRENGTH	MINIMUM EXPECTED SHELF LIFE @73°F (yr)	TYPICAL SPECIFIC GRAVITY (g/cc)	TYPICAL VISCOSITY (cps)	VISCOSITY REFERENCE
ACRYLICS	3★	clear	1	1 min	2 min	24 hrs	2	1.330	–	water thin
	4★	clear	1	1-2 min	3 min	72 hrs	2	1.375	–	water thin
	16★	clear	1	1-2 min	3 min	72 hrs	2	1.120	–	water thin
	28●	clear	1	5-6 min	10 min	72 hrs	2	1.107	800	motor oil
	40●	clear	3	15 min	2 hrs	72 hrs	1*	1.0354	3,400	syrup
	42●	clear	2	20 min	2 hrs	72 hrs	1*	1.026	2,900	syrup
	1802	clear	2	15 min	2 hrs	72 hrs	1*	1.026	2,900	syrup
		clear	1	8 min	10-15 min	72 hrs	3	0.880	350	motor oil
VINYL PVC, CPVC	1910	clear	1	15 min	20-25 min	72 hrs	3	0.924	2,100	syrup
	2007●	clear	1	1-2 min	3 min	24-48 hrs	3	0.849	–	water thin
	4052●	clear**	1	15 min	20-25 min	72 hrs	2	0.955	500	motor oil
	4784	clear	1	20 min	20-30 min	72 hrs	3	0.904	335	motor oil
ABS	2354	clear	1	3 min	15 min	72 hrs	3	0.805	–	water thin
	4707●	milky	1	10 min	10-15 min	72 hrs	3	0.884	4,000	syrup
POLYCARBONATE	55●	clear	2	5-6 min	1-2 hrs	72 hrs	1	1.168	3,000	syrup
	58●	clear	2	2-3 min	20 min	72 hrs	1	1.166	3,000	syrup
STRUCTURAL	30	off white	2	4-5 min	15-20 min	24 hrs	.5	1.010	225,000	peanut butter
	31	off white	2	13-17 min	30-40 min	24 hrs	.5	1.010	225,000	peanut butter
	45●	tan	2	5-6 min	15 min	24 hrs	1	1.064	500,000	peanut butter
	46C●	translucent	2	6-9 min	15-25 min	24 hrs	.75	0.99	100,000	toothpaste

★ Methylene Chloride (DCM) and Trichloroethylene (TCE) FREE. For professional use only.

* Refrigeration is recommended to increase shelf life.

** Thin amber layer of solvent cement on substrate appears clear when dry.

● These products meet requirements of California South Coast Air Quality Management District (SCAQMD) Rule 1168.

Technical Data Sheets and Material Safety Data Sheets should be read before using our products.

© 2025 Weld-On S&D Typical Properties/Quick Selection Chart 03/23

ABS	Acrylic Cell Cast	Acrylic Cross-Linked	Acrylic Extruded	Butyrate	Fiberglass	Metal	PETG	Polycarbonate	Polyester	Polyurethane	PVC (Rigid)	PVC (Flexible)	PVC (Foamed)	
55/58/2354 4707 30/31/46C	16/40/42 1802 30/31	40/42	16/40/42 1802 30/31	16/55/58 45/40/42 30/31	45 30/31	45 30/31	16/55/58 40/42 30/31	16/55/58 40/42 30/31	40/42 30/31	4784 55/58	45 16/4052 30/31	45 30/31	16 40/42 45	ABS
16/1802 40/42 30/31	16/40/42 3/4/45C 30/31/46C	40/42	16/40/42 3/4/45C 30/31/46C	16 40/42/45 30/31	45 30/31	45 30/31 46C	16 40/42 30/31	16/30/31 40/42/45 46C	40/42 30/31	4784	16/40/42 4052 30/31	45 30/31	16 40/42 45	Acrylic Cell Cast
40/42	40/42	40/42	40/42	40/42 45	45	45	40/42 45	40/42 45	40/42	40/42	40/42 45	45	40/42 45	Acrylic Cross-Linked
16/1802 40/42 30/31	16/40/42 3/4/45C 30/31/46C	40/42	16/40/42 3/4/45C 30/31/46C	16 40/42/45 30/31	45 30/31	30/31 45 46C	16 40/42 30/31	40/42/45 30/31 46C	40/42 30/31	4784	16/40/42 4052 30/31	45 30/31	16 40/42 45	Acrylic Extruded
16/55/58 45/40/42 30/31	16 40/42/45 30/31	40/42 45	16 40/42/45 30/31	3/4/45C/16 2007/55/58 30/31	45 30/31	30/31 45	16/55/58 40/42 30/31	16 55/58 40/42	40/42/45 30/31	4784 55/58	16/55/58 40/42 30/31	4784 45 30/31	40/42 45	Butyrate
45 30/31	45 30/31	45	45 30/31	45 30/31	45 30/31	30/31 45 46C	45 30/31	45 30/31	45 30/31	45	45 30/31	45 30/31	45	Fiberglass
45 30/31	30/31 45 46C	45	30/31 45 46C	45 30/31	45 30/31	30/31 45 46C	30/31 45	45 30/31	45 30/31		45 30/31	45 30/31	45	Metal
16/55/58 40/42 30/31	16 40/42 30/31	40/42 45	16 40/42 30/31	16 55/58 40/42	45 30/31	45 30/31	40/42/55/58 3/4/45C 30/31	55/58 40/42/45 30/31	40/42 45 30/31		40/42 16	45 30/31	16 40/42 45	PETG
16/55/58 40/42 30/31	16/30/31 40/42/45 46C	40/42 45	30/31 40/42/45 46C	16/55/58 40/42 30/31	45 30/31	45 30/31	55/58 40/42/45 30/31	16/55/58 3/4/45C 30/31/46C	40/42/45 30/31		40/42 16 30/31	45 30/31	16 40/42 45	Polycarbonate
40/42 30/31	40/42 30/31	40/42	40/42 30/31	40/42/45 30/31	45 30/31	45 30/31	40/42 45 30/31	40/42/45 30/31	40/42/45 30/31		40/42 30/31	45 30/31	40/42 45	Polyester
4784 55/58	4784	40/42	4784	4784 55/58	45					4784 55/58	4784	4784 45	4784	Polyurethane
16 45/4052 30/31	16/40/42 4052 30/31	40/42 45	16/40/42 4052 30/31	16/55/58 40/42 30/31	45 30/31	45 30/31	16 40/42 30/31	40/42 16 30/31	40/42 30/31	4784	30/31 40/42/46C 2007	2007 45 30/31	16 2007 40/42/45	PVC (Rigid)
45 30/31	45 30/31	45	45 30/31	45/ 4784 30/31	45 30/31	45 30/31	45 30/31	45 30/31	45 30/31	4784 45	2007 45 30/31	2007/45 4784 30/31	2007 45	PVC (Flexible)
16 40/42 45	16 40/42 45	40/42 45	16 40/42 45	16 40/42 45	45	45	16 40/42 45	16 40/42 45	40/42 45	4784	16 2007 40/42/45	2007 45	2007 16 40/42/45	PVC (Foamed)