



resimac Ltd. 

## 305 Wet Bond Paste

Solvent free, high build epoxy paste that bonds to wet metal surfaces with minimal surface preparation, ideal for saturated or adverse conditions.

- Bonds directly to wet or saturated metal surfaces
- Suitable for application in rain or during washdowns
- Minimal surface preparation required
- Solvent free formulation with high build application up to 20mm

2025 Product Sheet

## Typical Applications

305 Wet Bond Paste is a two component, solvent free epoxy repair paste developed for metallic surfaces in wet or water exposed environments. Its surface tolerant formulation allows application during rain or washdowns where traditional repair systems would fail.

- Plate bonding
- Leaking tank seams
- Metallic surface rebuilding
- Pipework repairs

## Characteristics

### Appearance

Base	Dark Brown paste
Activator	Beige paste
Mixed	Dark brown paste

### Solids Content

100%

### Volume Capacity

580cc/kg

### Sag Resistance

Nil at 20mm

### Density

Base	1.93
Activator	1.56
Mixed	1.75

### Mixing Ratio

By weight	1.4:1
By volume	1:1

### Storage Life

2 years if unopened and stored in normal dry conditions, 15–30°C (59–86°F)

## Cure times

### Useable Life

10°C/50°F	60 mins
20°C/68°F	30 mins
30°C/86°F	15 mins
40°C/104°F	7.5 mins

### Hard Dry

10°C/50°F	24 hours
20°C/68°F	12 hours
30°C/86°F	6 hours
40°C/104°F	3 hours

### Full Cure

10°C/50°F	4 days
20°C/68°F	2 days
30°C/86°F	24 hours
40°C/104°F	12 hours

### Overcoating time

The overcoating time should not exceed 24 hours. The applied material can be overcoated as soon as it is touch dry.

## Coverage

1kg (2.21lb) of fully mixed product will give the following coverage rates:

0.194m <sup>2</sup> at 3mm	2ft <sup>2</sup> at 60mil
0.116m <sup>2</sup> at 5mm	1.25ft <sup>2</sup> at 200mil

Please note that the coverage rates quoted are theoretical and do not take into consideration the profile or condition of the surface being repaired.

## Mechanical Properties

### Compressive Strength

Tested to ASTM D695  
735kg/cm<sup>2</sup> (10450psi)

### Corrosion Resistance

Tested to ASTM B117  
Minimum 1000 hours

### Flexural Strength

Tested to ASTM D790  
298kg/cm<sup>2</sup> (4250psi)

### Heat Resistance

Suitable for use in immersed conditions at temperatures up to 70°C (158°F)

Resistant to dry heat up to 150°C (302°F) dependent on load

### Adhesion

Pull off Adhesion to ASTM D4541 on abrasive blasted mild steel with 75 micron profile 221kg/cm<sup>2</sup> (3100psi)

### Heat Distortion

Tested to ASTM D648 at 264psi fibre stress:

20°C (68°F) Cure	58°C (136°F)
100°C (212°F) Cure	61°C (142°F)

### Hardness

Tested to ASTM D2240 Shore D: 82

## Details & Legal

### Chemical Resistance

The product resists attack by a wide variety of inorganic acids, alkalis, salts and organic media. For more detailed information refer to the Resimac Technical Centre for advice.

### Warranty

Resimac warrants that the performance of the product supplied will conform to the typical descriptions quoted within this specification provided material is stored correctly and used according to the procedures detailed in this document.

### Quality

All Resimac Products are supplied under the scope of the company's fully documented quality system.

### Pack Sizes

This product is available in the following pack sizes:  
500gm (1.1lb)  
1kg (2.2lb)  
3kg (6.6lb)

# Application Guide

## A. Surface Preparation

### Metallic Substrates: Hand tools

- 1 All surfaces must be cleaned using metal file, coarse sandpaper etc. Ensure a cross-hatch pattern is made on the metal surface.
- 2 Wipe any ponded or excess water from the surface using an absorbent cloth.

### Metallic Substrates: Mechanical tools

- 1 All surfaces must be mechanically abraded using handheld grinders to *ISO 8501/4 ST3 (SSPC SP3)*. Ensure a cross-hatch pattern is made on the metal surface.
- 2 Wipe any ponded or excess water from the surface using an absorbent cloth.

### Health & Safety

Please ensure good practice is observed at all times during the mixing and application of this product. Protective gloves and other recommended personal protective equipment must be worn during the mixing and application of this product.

Before mixing and applying the material, please ensure you have read and fully understood all information.

## B. Product Preparation

**Prior to mixing, please ensure the following:**

- 1 The base component is at a temperature between 15–25°C (60–77°F).
- 2 The ambient & surface temperature is above 5°C (41°F).

*PLEASE NOTE: From the commencement of mixing, the material should be used within 5 minutes at 20°C (68°F).*

## D. Application

- 1 Remove excess moisture from the surface using a rag or squeegee.
- 2 Using a spatula or applicator tool, force the material to the prepared surface, displacing as much moisture as possible.
- 3 Ensure the product is pressed into any holes, scars or cracks.
- 4 Once the repair has been completed smooth off any imperfections using a gloved hand.

## C. Mixing

**If part mixing the unit of material:**

- 1 Using the spatula provided place 1 equal measure from the base & activator units onto the mixing board provided.
- 2 Ensure to clean the spatula thoroughly after measuring the base component and before measuring the activator component.
- 3 Mix the 2 components together until you have a streak free mix (dark brown) on the mixing board.
- 4 Ensure there is no unmixed material on the spatula or mixing board.

## Quick Application Guide



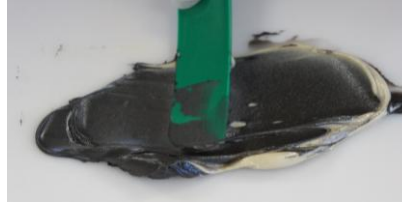
### Step 1

Ensure you have  
1 x base unit  
1 x activator unit  
1 x spatula  
1 x applicator  
1 x clean mixing board



### Step 2

Take equal measures of base and activator material, clean the spatula between measures.



### Step 3

Mix the two components using a spatula, ensure any unmixed material around the edges is mixed.



### Step 4

The material must be a consistent dark brown. Wipe away any unmixed material from the mixing surface.



### Step 5

Once the material is fully mixed use the applicator tool provided to apply the metal repair paste to the surface.

## About Resimac

A UK based manufacturer of epoxy and polyurethane coatings and repair materials.

From our head office in the heart of rural North Yorkshire, England we supply our range of Epoxy, Polyurethane & Silicone coatings and repair materials to the Oil & Gas, Petrochemical, Marine, Paper & Pulp, Water, Power Generation & Chemical Industries.

## Legal Notice

The data contained within this Product Specification is furnished for information only and is believed to be reliable at the time of issue. We cannot assume responsibility for results obtained by others over whose methods we have no control. It is the responsibility of the customer to determine the products suitability for use. Resimac accepts no liability arising out of the use of this information or the product described herein.

## Information & Enquiries

For more information and technical data please visit our website or contact us.

[www.resimacsolutions.com](http://www.resimacsolutions.com)

[info@resimac.co.uk](mailto:info@resimac.co.uk)

+44 (0) 1845 577498

Resimac Ltd,  
Unit B, Park Barn Estate,  
Station Road,  
Topcliffe,  
Thirsk,  
North Yorkshire,  
YO7 3SE,  
United kingdom