

SET® 45 AND SET® 45 HW

Chemical-action repair mortar

PRODUCT DATA

3 03930

**Concrete
Rehabilitation**

Description

Set® 45 is a one-component magnesium phosphate-based patching and repair mortar. This concrete repair and anchoring material sets in approximately 15 minutes and takes rubber-tire traffic in 45 minutes. It comes in two formulations: Set® 45 Regular for ambient temperatures below 85° F (29° C) and Set® 45 Hot Weather for ambient temperatures ranging from 85 to 100° F (29 to 38° C).

Yield

A 50 lb (22.7 kg) bag of mixed with the required amount of water produces a volume of approximately 0.39 ft³ (0.011 m³); 60% extension using 1/2" (13 mm) rounded, sound aggregate produces approximately 0.58 ft³ (0.016 m³).

Packaging

50 lb (22.7 kg) multi-wall bags

Color

Dries to a natural gray color

Shelf Life

1 year when properly stored

Storage

Store in unopened containers in a clean, dry area between 45 and 90° F (7 and 32° C).

Features

- Single component
- Reaches 2,000 psi compressive strength in 1 hour
- Wide temperature use range
- Superior bonding
- Very low drying shrinkage
- Resistant to freeze/thaw cycles and deicing chemicals
- Only air curing required
- Thermal expansion and contraction similar to Portland cement concrete
- Sulfate resistant

Benefits

- Just add water and mix
- Rapidly returns repairs to service
- From below freezing to hot weather exposures
- Bonds to concrete and masonry without a bonding agent
- Improved bond to surrounding concrete
- Usable in most environments
- Fast, simple curing process
- More permanent repairs
- Stable where conventional mortars degrade

Where to Use

APPLICATION

- Heavy industrial repairs
- Dowel bar replacement
- Concrete pavement joint repairs
- Full-depth structural repairs
- Setting of expansion device nosings
- Bridge deck and highway overlays
- Anchoring iron or steel bridge and balcony railings
- Commercial freezer rooms
- Truck docks
- Parking decks and ramps
- Airport runway-light installations

LOCATION

- Horizontal and formed vertical or overhead surfaces
- Indoor and outdoor applications

How to Apply

Surface Preparation

1. A sound substrate is essential for good repairs. Flush the area with clean water to remove all dust.
2. Any surface carbonation in the repair area will inhibit chemical bonding. Apply a pH indicator to the prepared surface to test for carbonation.
3. Air blast with oil-free compressed air to remove all water before placing Set® 45.

Mixing

1. Set® 45 must be mixed, placed, and finished within 10 minutes in normal temperatures (72° F [22° C]). Only mix quantities that can be placed in 10 minutes or less.
2. Do not deviate from the following sequence; it is important for reducing mixing time and producing a consistent mix. Use a minimum 1/2" slow-speed drill and mixing paddle or an appropriately sized mortar mixer. Do not mix by hand.
3. Pour clean (potable) water into mixer. Water content is critical. Use a maximum of 4 pts (1.9 L) of water per 50 lb (22.7 kg) bag of Set® 45. Do not deviate from the recommended water content.



Technical Data

Composition

Set® 45 is a magnesium-phosphate patching and repair mortar.

Test Data

PROPERTY	RESULTS				TEST METHODS
Typical Compressive Strengths* , psi (MPa)					ASTM C 109, modified
	Plain Concrete 72° F (22° C)	Set® 45 Regular 72° F (22° C)	Set® 45 Regular 36° F (2° C)	Set® 45 HW 95° F (35° C)	
1 hour	—	2,000 (13.8)	—	—	
3 hour	—	5,000 (34.5)	—	3,000 (20.7)	
6 hour	—	5,000 (34.5)	1,200 (8.3)	5,000 (34.5)	
1 day	500 (3.5)	6,000 (41.4)	5,000 (34.5)	6,000 (41.4)	
3 day	1,900 (13.1)	7,000 (48.3)	7,000 (48.3)	7,000 (48.3)	
28 day	4,000 (27.6)	8,500 (58.6)	8,500 (58.6)	8,500 (55.2)	
NOTE: Only Set® 45 Regular formula, tested at 72° F (22° C), obtains 2,000 psi (13.8 MPa) compressive strength in 1 hour.					
Modulus of Elasticity , psi (MPa)				ASTM C 469	
		7 days	28 days		
Set® 45 Regular		4.18 x 10 ⁶ (2.88 x 10 ⁴)	4.55 x 10 ⁶ (3.14 x 10 ⁴)		
Set® 45 Hot Weather		4.90 x 10 ⁶ (3.38 x 10 ⁴)	5.25 x 10 ⁶ (3.62 x 10 ⁴)		
Freeze/thaw durability test , % RDM, 300 cycles, for Set® 45 and Set 45® HW	80			ASTM C 666, Procedure A (modified**)	
Scaling resistance to deicing chemicals , Set® 45 and Set 45® HW				ASTM C 672	
5 cycles	0				
25 cycles	0				
50 cycles	1.5 (slight scaling)				
Sulfate resistance				ASTM C 1012	
Set® 45 length change after 52 weeks, %	0.09				
Type V cement mortar after 52 weeks, %	0.20				
Typical setting times , min, for Set® 45 at 72° F (22° C), and Set® 45 Hot Weather at 95° F (35° C)				Gilmore ASTM C 266, modified	
Initial set	9 – 15				
Final set	10 – 20				
Coefficient of thermal expansion ,*** both Set® 45 Regular and Set® 45 Hot Weather coefficients	7.15 x 10 ⁻⁶ /° F (12.8 x 10 ⁻⁶ /° C)			CRD-C 39	
Flexural Strength , psi (MPa), 3 by 4 by 16" (75 by 100 by 406 mm) prisms, 1 day strength,				ASTM C 78, modified	
Set® 45 mortar	550 (3.8)				
Set® 45 mortar with 3/8" (9 mm) pea gravel	600 (4.2)				
Set® 45 mortar with 3/8" (9 mm) crushed angular noncalcareous hard aggregate	650 (4.5)				

* All tests were performed with neat material (no aggregate)

**Method discontinues test when 300 cycles or an RDM of 60% is reached.

***Determined using 1 by 1 by 11" (25 mm by 25 mm by 279 mm) bars. Test was run with neat mixes (no aggregate).
 Extended mixes (with aggregate) produce lower coefficients of thermal expansion.

Test results are averages obtained under laboratory conditions. Expect reasonable variations.

4. Add the powder to the water and mix for approximately 1 – 1-1/2 minutes.
5. Use neat material for patches from 1/2 – 2" (6 – 51 mm) in depth or width. For deeper patches, extend a 50 lb (22.7 kg) bag of Set® 45 HW by adding up to 30 lbs (13.6 kg) of properly graded, dust-free, hard, rounded aggregate or noncalcareous crushed angular aggregate, not exceeding 1/2" (6 mm) in accordance with ASTM C 33, #8. If aggregate is damp, reduce water content accordingly. Special procedures must be followed when angular aggregate is used. Contact your local Degussa representative for more information. (Do not use calcareous aggregate made from soft limestone. Test aggregate for fizzing with 10% HCL).

Application

1. Immediately place the mixture onto the properly prepared substrate. Work the material firmly into the bottom and sides of the patch to ensure good bond.
2. Level the Set® 45 and screed to the elevation of the existing concrete. Minimal finishing is required. Match the existing concrete texture.

Curing

No curing is required, but protect from rain immediately after placing. Liquid-membrane curing compounds or plastic sheeting may be used to protect the early surface from precipitation, but never wet cure Set® 45.

For Best Performance

- Color variations are not indicators of abnormal product performance.
- Regular Set® 45 will not freeze at temperatures above -20° F (-29° C) when appropriate precautions are taken.
- Do not add sand, fine aggregate, or Portland cement to Set® 45.
- Do not use Set® 45 for patches less than 1/2" (13 mm) deep. For deep patches, use Set® 45 Hot Weather formula extended with aggregate, regardless of the temperature. Consult your Degussa representative for further instructions.
- Do not use limestone aggregate.
- Water content is critical. Do not deviate from the recommended water content printed on the bag.
- Precondition these materials to approximately 70° F (21° C) for 24 hours before using.
- Protect repairs from direct sunlight, wind, and other conditions that could cause rapid drying of material.
- When mixing or placing Set® 45 in a closed area, provide adequate ventilation.
- Do not use Set® 45 as a precision nonshrink grout.
- Never featheredge Set® 45; for best results, always sawcut the edges of a patch.
- Prevent any moisture loss during the first 3 hours after placement. Protect Set® 45 with plastic sheeting or a curing compound in rapid-evaporation conditions.
- Do not wet cure.
- Do not place Set® 45 on a hot (90° F [32° C]), dry substrate.
- When using Set® 45 in contact with galvanized steel or aluminum, consult your local Degussa sales representative.
- Make certain the most current versions of product data sheet and MSDS are being used; call Customer Service (1-800-433-9517) to verify the most current versions.
- Proper application is the responsibility of the user. Field visits by Degussa personnel are for the purpose of making technical recommendations only and not for supervising or providing quality control on the jobsite.

Health and Safety

SET® 45

Caution

Risks

Eye irritant. Skin irritant. Lung irritant. May cause delayed lung injury.

Precautions

KEEP OUT OF THE REACH OF CHILDREN. Avoid contact with eyes. Wear suitable protective eyewear. Avoid prolonged or repeated contact with skin. Wear suitable gloves. Wear suitable protective clothing. Do not breathe dust. In case of insufficient ventilation, wear suitable respiratory equipment. Wash soiled clothing before reuse.

First Aid

Wash exposed skin with soap and water. Flush eyes with large quantities of water. If breathing is difficult, move person to fresh air.

Waste Disposal Method

This product when discarded or disposed of is not listed as a hazardous waste in federal regulations. Dispose of in a landfill in accordance with local regulations.

For additional information on personal protective equipment, first aid, and emergency procedures, refer to the product Material Safety Data Sheet (MSDS) on the job site or contact the company at the address or phone numbers given below.

Proposition 65

This product contains materials listed by the state of California as known to cause cancer, birth defects, or reproductive harm.

VOC Content

0 lbs/gal or 0 g/L.

**For medical emergencies only,
call ChemTrec (1-800-424-9300).**

Degussa Building Systems

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Form No. 1019335A 9/03 (Replaces 1/02)
Printed on recycled paper including 10% post-consumer fiber.

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