WEBER 4601 INDUSTRY BASE EXTRA

- Coating with epoxy or acrylic coating after 1-3 days
- Fiber-reinforced
- Nearly crack-free floors without elevations on the edge
- Low alkaline pH 10.5-11 – Protects against alkaline degradation of floor adhesives (min. 5 mm thickness) -> healthy indoor air
- Certified EPD environmental product description
- The product is listed in the portal for building products that can be used in Nordic Swan Ecolabelled buildings.

ABOUT THIS PRODUCT

Pumpable, fast setting and enables fast covering, cementitious levelling screed for industrial floors. Layer thickness 5-30 mm.

AREA OF USE

Floor levelling in industrial spaces with light loads (pallet jacks, pedestrian, etc.) and where surface finishing is done with epoxy or polyurethane coatings. The product is suitable for medium load flooring as a levelling screed for weber 4650, weber 4655 and weberfloor 4630.

SUBSTRATE

Suitable substrates are cementitious substrates with a tensile strength of > 1.0 MPa. There are separate instructions for treating the substrate, see weber MD 16 Primer product datasheet.

MIXING

The product is mixed in clean water using a Weber-approved automatic mixer. A suitable amount of water is 20% (dry weight of the screed) equivalent to 4.0 litres / 20 kg sack. Mixing can also be done using a powerful drill whisk for at least 1 minute. The water content can be increased by a maximum of 0.2 litres / 20 kg sack. Pot life in normal conditions is approx. 20 min after adding water. The temperature of the screed must be at least +10 °C. In low temperatures, use warm water (max. +35 °C). The flow properties of the screed are checked before

PRODUCT SPECIFICATION

Material consumption	approx. 1.8 kg/m²/1 mm layer
Recommended layer thickness	5-30 mm (thicker layers possible, extends covering time)
Layer thickness in floating constructions	≥ 20mm
Recommended water content	4.0 l/20 kg (20% of dry weight)
Application temperature	+10...+25 °C. Optimal +15...+20 °C.
Curing time for covering	Ready for coating in 1-3 days depending on the layer thickness and drying conditions up to 30 mm; covering time is longer for thicker layers (+23 °C, 50% RH).
Curing time for pedestrian traffic	approx. 1-3 h (+23 °C, 50% RH)
Curing time for light traffic load	approx. 1 day (+23 °C, 50% RH)
Curing time for full traffic load	approx. 1 week (+23 °C, 50% RH)
Binder	Special cement mixture
Filler	Natural sand and limestone powder
Additive	Additives to improve adhesion and spreadability properties. Casein-free.
Adhesion strength 28 days	≥ 2.0 N/mm². Adhesion to concrete (K30)
Compressive strength class	C 30 (EN 13813)
Flexural strength class	F 7 (EN 13813)
Shrinkage 28 days	< 0.4 mm/m (EN 13454-2)
Reaction to fire (for exposive situations)	$A2_{FL}$-s1 (EN 13501-1)
Fire resistance classification	EI 15 requirements are met with a layer thickness of 25 mm and EI 30 requirements with a layer thickness of 35 mm.
Covering class (against ignition)	Can be used as a floor covering (protection against ignition) that replaces the $K_2$10 cover when the layer thickness is at least 25 mm and that replaces the $K_2$30 cover when the layer thickness is at least 35 mm.
Wear resistance to rolling wheel of screed material for wearing layer (RWA)	RWA10 (EN 13813)
Durability	Water resistant
Water vapour diffusion coefficient (μ)	10 (dry) 6 (wet) (EN 12524:2001)
The pH of the cured material	10.5-11. Low alkaline.
Thermal conductivity	1 W/mK (EN 12524:2001)
Specific thermal capacity (Cp)	1 J/(g*C) (EN 12524:2001)
Storage conditions	Shelf life is 12 months (20 kg) or 6 months (1000 kg sack) from the date of manufacture (unopened package, dry space). 3 months (bulk delivery).
Package	20 kg sack. 1000 kg large sack. Bulk in a silo.
GTIN-codes	6415910032098 (20 kg)
Certifications	CE, M1, EC1+, EPD, Key Flag Symbol

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and during pumping (further instructions from Weber). Excess water causes segregation and weakens the strength of the screed surface, so an excessive amount of water must not be used.

WORK INSTRUCTIONS

The building must have a roof, and windows and doorways must be closed. The substrate and air temperature during the levelling and for one week after should be between +10...+ 25 °C. Draught on the floor surface should be avoided during levelling and for three days after the work. The relative humidity of the substrate must be <90%. The maximum width of the pumped area is 6-8 m depending on the pump power and the thickness of the screed. Wider areas are divided into sections using temporary dividers. The pumping is carried out in sections so that the new section is pumped as quickly as possible partially to the previous one. Connecting sections while casting is aided using a wide steel trowel or by "wobbling". When spreading by hand use a steel trowel. Tools must be cleaned with water immediately after use. Hardened screed is removed from the tools mechanically.

Movement joints:
At the structural movement joints of the substrate, the levelling layer is cut off and movement joint profiles are recommended for movement joints. The joints are filled with elastic sealing material. The joints must be taken into account in architectural and structural plans.

COATING

Setting time before using epoxy or acrylic coatings:
When the 4601 levelling is done in good working conditions - temperature approx. +23 °C and humidity 50% - coating can be done when the screed strength is at least 1.5 MPa. This strength is usually reached in 1-3 days. It is important to remember that the 4601 does not balance an already damp substrate. The surface of the levelling surface is sandblasted or sanded with coarse sandpaper before coating. The hardened screed is suitable as a floor surface for light-load industrial spaces and / or as a base for the Weber industrial floor system or, for example, water-soluble solvent-free epoxy surfaces (for example weberfloor 4736 Epoxy paint and paint priming with weberfloor 4712 Sealing epoxy - the suitability of other paints must be checked with the paint manufacturer). In the latter case, the layer thickness must be minimum 5 mm. Moisture measurement and drying evaluation should be performed for the entire structure (substrate and screed) and the coating capacity should be evaluated accordingly.

Resin floors (PU, epoxy and acrylic-based): The suitability of the product must be checked from the manufacturer. weberfloor 4712 Sealing Epoxy should be used as a primer with acrylic products, unless otherwise instructed by the surface material manufacturer.

It is recommended to grind the screed surface before coating to remove any contaminants or other substances that weaken adhesion to the substrate.

PLEASE OBSERVE

Water resistance:
The hardened screed can withstand water. The strength of the completely wet screed decreases, but returns again when the material is completely dried.

Chemical resistance:
The chemical resistance of the product is comparable to compact concrete. Floors exposed to ordinary chemicals, oils, cutting and cleaning fluids, etc. should be treated with a surface finish. Surface treatment is also recommended for the food industry, slaughterhouses, dairies, fish processing plants, etc.

DISCLAIMER

As there are different conditions at every opportunity, Weber can not be held responsible for anything other than the information provided under the heading "Product Specification". Examples of information and circumstances, which are outside Saint-Gobain (whether specifically stated or not) include storage, construction, processing, interoperability with other products, workmanship and local conditions.

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