

**Product Data Sheet**

Edition 7.2008

Identification no. 393

Sikadur 31, SBA

# Sikadur 31<sup>®</sup>, SBA

**Segmental Bridge Adhesive, Normal Set**  
High-modulus, high-strength, moisture tolerant, epoxy paste adhesive

Construction

<b>Description</b>	Sikadur 31, SBA is a unique high-modulus 2-component, moisture-tolerant, solvent-free, epoxy resin system available in three application temperature ranges. A unique high-modulus, structural adhesive for bonding hardened concrete to hardened concrete for segmental bridge construction. The mixed material has the consistency of paste and is a concrete gray color. It conforms to the current ASTM C-881, Type VI requirements, and ASBI guidelines.
<b>Where to Use</b>	<ul style="list-style-type: none"> <li>■ Structural bonding of post-tensioned precast concrete bridge segments.</li> <li>■ Sealing joints between concrete segments.</li> <li>■ For use in segment-by-segment erection.</li> <li>■ Supplied in three temperature grades to meet project requirements. (For cold weather conditions, refer to separate technical data sheet on Sikadur 31, SBA [20°-45°F].)</li> </ul>
<b>Advantages</b>	<ul style="list-style-type: none"> <li>■ Moisture tolerant before, during and after cure.</li> <li>■ High-modulus, high-strength, structural paste adhesive.</li> <li>■ Range of curing times to meet assembly and strength gain requirements.</li> <li>■ Easy to apply, non-sag paste for vertical applications.</li> <li>■ Excellent adhesion to concrete, steel and most construction materials.</li> <li>■ Convenient easy to mix ratios. A:B=2:1 by volume.</li> <li>■ Color-coded components to ensure proper mixing control.</li> </ul>
<b>Coverage</b>	Approximately 12 sq. ft./gal. or 36 sq. ft./3 gal. unit.
<b>Packaging</b>	3 gal. units.

**Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.)**

<b>Shelf Life</b>	2 years in original, unopened containers.	
<b>Storage Conditions</b>	Store dry at 40°-95°F (4°-35°C). <b>Condition material to 70°-75°F (21°-24°C) before using.</b>	
<b>Color</b>	Concrete gray	
<b>Consistency</b>	Non-sag paste	
<b>Product name</b>	<b>Temp. Range</b>	<b>Mix Ratio, A:B by volume</b>
Normal Set (40°-60°F)	40°-60°F (4°-15°C)	2:1
Normal Set (55°-95°F)	55°-95°F (13°-35°C)	2:1
Normal Set (80°-115°F)	80°-115°F (27°-46°C)	2:1
<b>Pot Life (1 gallon volume)</b>	Approximately 30 minutes @ 73°F (23°C)	
<b>Open Time (60°F, 95°F, 115°F)</b>	60 minutes	
<b>Compressive Strength (ASTM D-695)</b>		
<b>24 hours</b>	2,000 psi, minimum (13.8 MPa)	
<b>48 hours</b>	7,000 psi, minimum (48.3 MPa)	
<b>Contact Strength (ASTM C-882) 48 hours</b>	1,000 psi, minimum (6.9 MPa)	
<b>Bond Strength (ASTM C-882): Hardened Concrete to Hardened Concrete</b>		
<b>2 day (moist cure)</b>	1,000 psi, minimum (6.9 MPa)	
<b>Heat Deflection Temperature (ASTM D-648)</b>		
<b>7 day (fiber stress loading = 264 psi [1.8 MPa])</b>	120°F (49°C), minimum	



## How to Use

### Surface Preparation

Surface must be clean and sound. It may be dry or damp, but free of standing water and frost. Remove dust, laitance, grease, curing compounds, impregnations, waxes, foreign particles, disintegrated materials and any other contaminants.

### Mixing

**Pre-mix each component.** Wear chemical resistant gloves and safety goggles. Mix all of Part 'A' with all of Part 'B'. Mix thoroughly for a minimum of 3 minutes with a low-speed (400-600 rpm) drill fitted with a mixing Sika paddle until a uniform gray color is achieved. Scrape down the sides of the mixing pail and ensure there are no streaks of unmixed epoxy before applying. Mix only that quantity which can be used within its pot life.

### Application

Apply the neat mixed Sikadur 31, SBA to the concrete surface using a trowel, spatula or glove protected hand; work into surface, especially if it is damp. Spread to a thickness of 1/8" (3 mm) to one face or 1/16" (1.5 mm) on both faces, depending upon project requirements. Segments must be post-tensioned within the open time of the epoxy.

### Limitations

- Do not thin Sikadur 31, SBA. Solvents will prevent proper cure.
- Use correct temperature range material for prevailing conditions.
- Use correct setting material (normal or slow) depending on method of erection.
- Not for use as an adhesive for fresh, plastic portland cement concrete or mortar.
- Lower temperatures will prolong cure time. Higher temperatures will rapidly accelerate cure time.
- Use of product outside of designated temperature range is not recommended.
- Not an aesthetic product. Color may alter due to variations in lighting and/or UV exposure.

### Caution

**Component 'A' - Irritant, Sensitizer:** Eye/skin/respiratory irritant. Possible sensitization. Allergic reaction possible with prolonged exposure.

**Component 'B' - Irritant, Sensitizer:** Contains amines. Contact with skin and eyes can cause severe burns. Respiratory irritant. Possible sensitization/allergic reaction with prolonged exposure. High concentrations of vapor may cause respiratory irritation. If product is sanded or abraded after curing, crystalline silica dust can be inhaled and cause delayed lung injury (silicosis). Harmful if swallowed.

**The Normal Set 40°-60°F SBA contains nonylphenol. Chronic overexposure to nonylphenol may cause liver injury based on animal studies.**

**WARNING: THIS PRODUCT CONTAINS A CHEMICAL KNOWN TO THE STATE OF CALIFORNIA TO CAUSE CANCER. Deliberate concentration of vapors for inhalation is harmful and may prove fatal.**

### First Aid

**Eyes:** Hold eyelids apart and flush thoroughly with water for 15 minutes. **Skin:** Remove contaminated clothing. Wash skin thoroughly for 15 minutes with soap and water. **Inhalation:** Remove person to fresh air. **Ingestion:** Do not induce vomiting. **In all cases, contact a physician immediately if symptoms persist.**

### Handling and Storage

Avoid direct contact. Wear protective equipment, chemical resistant gloves, goggles, and clothing to prevent direct contact with skin and eyes. Use with adequate general and local ventilation. In absence of adequate ventilation use properly fitted NIOSH respirator. Wash thoroughly after handling product. Remove contaminated clothing and launder before reuse. Store product in closed container in cool dry place.

### Clean Up

Ventilate area. Confine spill. Collect with absorbent material, flush area with water. Dispose of in accordance with current, applicable local, state and federal regulations. Uncured material can be removed with approved solvent. Follow solvent manufacturer's instructions for use and warnings. Cured material (when combined with component 'B') can only be removed mechanically.

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**Product Data Sheet**  
Edition 7.2008  
Identification no. 393(20-45F)  
Sikadur 31, SBA (20°-45°F)

## Sikadur® 31, SBA (20°-45°F)

**Segmental Bridge Adhesive, Normal Set, Cold Weather**  
High-modulus, high-strength, moisture tolerant,  
epoxy paste adhesive

<b>Description</b>	Sikadur 31, SBA (20°-45°F) is a 2-component, cold weather, 100% solids, moisture-tolerant, high-modulus, high strength, structural epoxy paste adhesive for bonding hardened concrete to hardened concrete in segmental bridge construction. It conforms to the current ASTM C-881, Type VI requirements, and ASBI guidelines.
<b>Where to Use</b>	<ul style="list-style-type: none"> <li>■ Structural bonding of post-tensioned precast concrete bridge segments.</li> <li>■ Sealing joints between concrete segments.</li> <li>■ For use in segment-by-segment erection.</li> <li>■ Segmental bridges in cold weather temperatures 20°-45°F (-6°-7°C).</li> </ul>
<b>Advantages</b>	<ul style="list-style-type: none"> <li>■ Moisture tolerant before, during and after cure.</li> <li>■ High-modulus, high-strength, structural paste adhesive.</li> <li>■ Curing times to meet assembly and strength gain requirements.</li> <li>■ Easy to apply, non-sag paste for vertical applications.</li> <li>■ Excellent adhesion to concrete, steel and most construction materials.</li> <li>■ Convenient easy to mix ratios. A:B=2:1 by volume.</li> <li>■ Color-coded components to ensure proper mixing control.</li> </ul>
<b>Coverage</b>	Approximately 12 SF/gal. or 36 SF/3-gal. unit.
<b>Packaging</b>	3 gal. units.

### Typical Data

<b>Shelf Life</b>	2 years in original, unopened containers	
<b>Storage Conditions</b>	Store dry at 40°-95°F (4°-35°C). <b>Condition material to 20°-45°F (-6°-7°C) before using.</b>	
<b>Color</b>	Concrete gray	
<b>Consistency</b>	Non-sag paste	
<b>Product Name</b>	<b>Temp. Range</b>	<b>Mix Ratio, A:B by volume</b>
Normal Set (20°-45°F)	20°-45°F (-6°-7°C)	2:1
<b>Pot Life</b> (1 gallon mass)	Less than 3 minutes @ 73°F (23°C). Approximately 20 minutes @ 45°F (7°C).	
<b>Open Time</b>	60 minutes @ 45°F (7°C).	
<b>Compressive Strength (ASTM D-695)</b> [conditioned at 45°F [7°C]; cured at 20°F (-6°C)]		
3 day	2,000 psi, minimum (13.8 MPa)	
7 day	6,000 psi, minimum (41.4 MPa)	
<b>Contact Strength (ASTM C-882)</b>		
48 hours at 45°F (7°C)	1,000 psi, minimum (6.9 MPa)	
<b>Bond Strength (ASTM C-882): Hardened Concrete to Hardened Concrete</b>		
2 day [moist cure @ 45°F (7°C)]	1,000 psi, minimum (6.9 MPa)	
<b>Heat Deflection Temperature (ASTM D-648) @ 73°F (23°C)</b>		
7 day [fiber stress loading = 264 psi (1.8 MPa)]	120°F (49°C), minimum	

Construction



## How to Use

<b>Surface Preparation</b>	Surface must be clean and sound. It may be dry or damp, but free of standing water and frost. Remove dust, laitance, grease, curing compounds, impregnations, waxes, foreign particles, disintegrated materials, ice and any other contaminants.
<b>Mixing</b>	<b>Pre-mix each component.</b> Mix all of Part 'A' with all of Part 'B' until a uniform gray color is achieved. Mix thoroughly for a minimum of 3 minutes with a Sika paddle on low-speed (400-600 rpm) drill until uniform in color. Scrape down the sides of the mixing pail and ensure there are no streaks of unmixed epoxy before applying. Mix only that quantity which can be used within its pot life. Leaving the mixture of Component 'A' and 'B' in container longer than 20 minutes (pot life) will allow mixture to begin the curing process in the container. Spread mixture onto intended surface as soon as properly mixed. Leaving curing product in mixing container will affect the consistency and workability of the adhesive.
<b>Application</b>	Apply the neat mixed Sikadur 31, SBA to the concrete surface using a trowel, spatula or glove protected hand. Spread to a thickness of 1/8" (3 mm) to one face or 1/16" (1.5 mm) to both faces, depending upon project requirements. Segments must be post-tensioned within the open time of the epoxy.
<b>Limitations</b>	<ul style="list-style-type: none"> <li>■ Mixed material must be applied within the specified pot life.</li> <li>■ Do not thin Sikadur 31, SBA. Solvents will prevent proper cure.</li> <li>■ Use correct temperature range material for prevailing conditions.</li> <li>■ Use correct setting material (normal or slow) depending on method of erection.</li> <li>■ Not for use as an adhesive for fresh, plastic portland cement concrete or mortar.</li> <li>■ Not an aesthetic product. Color may alter due to variations in lighting and/or UV exposure.</li> <li>■ <b>Do not apply onto concrete if frost is present.</b></li> <li>■ <b>Do not use in temperatures greater than 45°F (7°C). Pot life, open time and consistency will be greatly affected.</b></li> </ul>
<b>Caution</b>	<p><b>Component 'A' - Irritant; Sensitizer</b> - Contains epoxy resins. Can cause skin sensitization after prolonged or repeated contact. Skin and eye irritant. Avoid skin contact. High concentrations of vapor may cause respiratory irritation. Chronic overexposure to nonyl phenol may cause liver injury, based on animal studies. Use only with adequate ventilation. Use of safety goggles and chemical resistant gloves is recommended. Remove contaminated clothing.</p> <p><b>Component 'B' - Corrosive; Sensitizer</b> - Contains amines. Contact with eyes or skin may cause severe burns. Can cause skin and/or respiratory sensitization after prolonged or repeated contact. High concentrations of vapor may cause respiratory irritation. Avoid skin contact. Use only with adequate ventilation. Use of safety goggles and chemical resistant gloves is recommended. In case of exceedance of PELs, use an appropriate, properly fitted NIOSH approved respirator. Remove contaminated clothing.</p>
<b>First Aid</b>	<b>Eyes:</b> Hold eyelids apart and flush thoroughly with water for 15 minutes. <b>Skin:</b> Remove contaminated clothing. Wash skin thoroughly for 15 minutes with soap and water. <b>Inhalation:</b> Remove person to fresh air. <b>Ingestion:</b> Do not induce vomiting. <b>In all cases, contact a physician immediately if symptoms persist.</b>
<b>Clean Up</b>	In case of spills or leaks, wear suitable protective equipment, contain spill, collect with absorbent material and transfer to suitable container. Ventilate area. Avoid contact. Dispose of in accordance with current, applicable local, state and federal regulations.

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# Sikadur® 31, SBA Slow-Set

## Segmental Bridge Adhesive

High-modulus, high-strength, moisture tolerant, epoxy paste adhesive

<b>Description</b>	Sikadur 31, SBA Slow-Set is a unique high-modulus 2-component, moisture-tolerant, solvent-free, epoxy-resin system available in three application temperature ranges. A unique high-modulus, structural adhesive for bonding hardened concrete to hardened concrete for segmental bridge construction. The mixed material has the consistency of paste and is a concrete gray color. It conforms to the current ASTM C-881, Type VII requirements, and ASBI guidelines.
<b>Where to Use</b>	<ul style="list-style-type: none"> <li>■ Structural bonding of post-tensioned precast concrete bridge segments.</li> <li>■ Sealing joints between concrete segments.</li> <li>■ Slow-set version for span-by-span erection.</li> <li>■ Supplied in three temperature grades to meet project requirements.</li> </ul>
<b>Advantages</b>	<ul style="list-style-type: none"> <li>■ Moisture tolerant before, during and after cure.</li> <li>■ High-modulus, high-strength, structural paste adhesive.</li> <li>■ Range of curing times to meet assembly and strength gain requirements.</li> <li>■ Easy to apply, non-sag paste for vertical applications.</li> <li>■ Excellent adhesion to concrete, steel and most construction materials.</li> <li>■ Convenient easy to mix ratios.</li> <li>■ Color-coded components to ensure proper mixing control.</li> </ul>
<b>Coverage</b>	Approximately 12 sq. ft./gal. or 36 sq. ft./3 gal. unit.
<b>Packaging</b>	3 gal. units.

**Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.)**

<b>Shelf Life</b>	2 years in original, unopened containers.	
<b>Storage Conditions</b>	Store dry at 40°-95°F (4°-35°C). Condition material to 70°-75°F (21°-24°C) before using.	
<b>Color</b>	Concrete gray.	
<b>Consistency</b>	Non-sag paste.	
<b>Product Name</b>	<b>Temp. Range</b>	<b>Mix Ratio, A:B by Volume</b>
Slow Set (40°-61°F)	40°-61°F (4°-16°C)	2:1
Slow Set (55°-75°F)	55°-75°F (13°-24°C)	2:1
Slow Set (70°-90°F)	70°-90°F (21°-32°C)	2:1

Property	SBA SS 40°-61°F	SBA SS 55°-75°F	SBA SS 70°-90°F
Pot life, 1 gallon	2 hours	2 hours	2 hours
Compressive Strength			
36 hr., psi	2000	4000	8500
72 hr., psi	7000	7000	9500
Open Time			
Contact strength after open time, 14 day, psi	8 hours - 2100	8 hours - 2250	8 hours - 2250
Bond strength, 14 day, psi	2000	2200	3000
Heat deflection Temp., °F	122	124	124



## How to Use

<b>Surface Preparation</b>	Surface must be clean and sound. It may be dry or damp, but free of standing water and frost. Remove dust, laitance, grease, curing compounds, impregnations, waxes, foreign particles, disintegrated materials and any other contaminants.
<b>Mixing</b>	<b>Pre-mix each component.</b> Wear chemical resistant gloves and safety goggles. Mix all of Part 'A' with all of Part 'B'. Mix thoroughly for a minimum of 3 minutes with a low-speed (400-600 rpm) drill fitted with a mixing Sika paddle until a uniform gray color is achieved. Scrape down the sides of the mixing pail and ensure there are no streaks of unmixed epoxy before applying. Mix only that quantity which can be used within its pot life.
<b>Application</b>	Apply the neat mixed Sikadur 31, SBA Slow-Set to the concrete surface using a trowel, spatula, or glove protected hand; work into surface especially if it is damp. Spread to a thickness of 1/8" (3 mm) to one face or 1/16" (1.5 mm) on both faces, depending upon project requirements. Segments must be post-tensioned within the open time of the epoxy.
<b>Limitations</b>	<ul style="list-style-type: none"> <li>■ Do not thin Sikadur 31, SBA Slow-Set. Solvents will prevent proper cure.</li> <li>■ Use correct temperature range material for prevailing conditions.</li> <li>■ Use correct setting material (normal or slow) depending upon method of erection.</li> <li>■ Not for use as an adhesive for fresh, plastic, portland cement concrete or mortar.</li> <li>■ Lower temperatures will prolong cure time. Higher temperatures will rapidly accelerate cure time.</li> <li>■ Use of product outside of designated temperature range is not recommended.</li> <li>■ Not an aesthetic product. Color may alter due to variations in lighting and/or UV exposure.</li> </ul>
<b>Caution</b>	<p><b>Component 'A' - Irritant, Sensitizer:</b> Eye/skin/respiratory irritant. Possible sensitization. Allergic reaction possible with prolonged exposure.</p> <p><b>Component 'B' - Irritant, Sensitizer:</b> Contains amines. Contact with skin and eyes can cause severe burns. Respiratory irritant. Possible sensitization/allergic reaction with prolonged exposure. High concentrations of vapor may cause respiratory irritation. If product is sanded or abraded after curing, crystalline silica dust can be inhaled and cause delayed lung injury (silicosis). Harmful if swallowed.</p> <p><b>Slow Set 55-75F contains nonylphenol. Chronic overexposure to nonylphenol may cause liver injury based on animal studies.</b></p> <p><b>WARNING: THIS PRODUCT CONTAINS A CHEMICAL KNOWN TO THE STATE OF CALIFORNIA TO CAUSE CANCER.</b></p> <p><b>Deliberate concentration of vapors for inhalation is harmful and may prove fatal.</b></p>
<b>First Aid</b>	<b>Eyes:</b> Hold eyelids apart and flush thoroughly with water for 15 minutes. <b>Skin:</b> Remove contaminated clothing. Wash skin thoroughly for 15 minutes with soap and water. <b>Inhalation:</b> Remove person to fresh air. <b>Ingestion:</b> Do not induce vomiting. <b>In all cases, contact a physician immediately if symptoms persist.</b>
<b>Handling and Storage</b>	Avoid direct contact. Wear protective equipment, chemical resistant gloves, goggles, and clothing to prevent direct contact with skin and eyes. Use with adequate general and local ventilation. In absence of adequate ventilation use properly fitted NIOSH respirator. Wash thoroughly after handling product. Remove contaminated clothing and launder before reuse. Store product in closed container in cool dry place.
<b>Clean Up</b>	(Material Spills). Ventilate area. Confine spill. Collect with absorbent material, flush area with water. Dispose of in accordance with current, applicable local, state, and federal regulations. Uncured material can be removed with approved solvent. Follow solvent manufacturer's instructions for use and warnings. Cured material (when combined with component 'B') can only be removed mechanically.

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