

# Heat Activated Repair Compound for Hot Surfaces



**BELZONA**  
1251



Belzona 1251 (HA-Metal) is a single component system for the repair and protection of metal surfaces whilst in service.

This heat-activated material can be applied directly onto hot surfaces (70-150°C / 158-302°F) with minimal surface preparation avoiding production downtime. Once cured, this solvent-free repair composite provides outstanding corrosion protection.

Designed to repair and protect metal surfaces suffering from Corrosion under Insulation (CUI), Belzona 1251 (HA-Metal) can be easily applied by spatula, applicator or brush.

TECHNICAL DATA	Volume capacity	401 cm <sup>3</sup> (24.5 in <sup>3</sup> ) / 1 kg		
	Dry heat resistance	210°C (410°F)		
	Shelf Life	2 years		
	Working life	Unlimited - Cure will not commence until product is heated		
	Adhesion (Tensile Shear )	Clean ground steel: 17.1 MPa (2475 psi) at 100°C (212°F) cure	Rusty steel: 8.3 MPa (1,200 psi) at 100°C (212°F) cure	
	Compressive Strength	120.0 MPa (17,400 psi) at 70°C (158°F) cure		
	Heat distortion temperature	105°C (221°F) at 70°C (158°F) cure	117°C (243°F) at 100°C (212°F) cure	
	Corrosion resistance	No visible signs of corrosion after 5,000 hours of exposure		

CURE TIMES	Temperature	70°C (158°F)	85°C (185°F)	100°C (212°F)	115°C (239°F)
	Light loading	75 min	25 min	15 min	15 min
	Full mechanical or thermal loading	5 hours	2 hours	60 min	60 min
	Optimum heat resistance	7 days	5 days	3 days	1 day

\*Please consult the Product Specification Sheet (PSS) and Instructions for Use (IFU) for the latest technical data.



**EXCELLENT  
ADHESION**



**HEAT  
ACTIVATED**



**RAPID CURE**



**EXCELLENT  
CORROSION  
PROTECTION**



**EASY TO APPLY**

## Key Benefits:

- **Heat-activated**

The material has an unlimited working life. The cure will not commence until the product is heated.

- **Rapid cure**

Its fast curing properties allow the equipment to be re-insulated with minimal delay.

- **Simple to use**

The material can be applied in-situ to live equipment operating at high temperature with minimal surface preparation. Belzona 1251 is a single pack system with no weighing or mixing are required.



Oil and hot water pipeline repair

## Application Areas:

- Infill of corrosion pits
- Repair of thin wall defects
- Bonding of doubler plates
- Local repairs
- Leak sealing of pipework
- Load bearing shims
- Weld defect repairs



Plate bonding



Pit filling

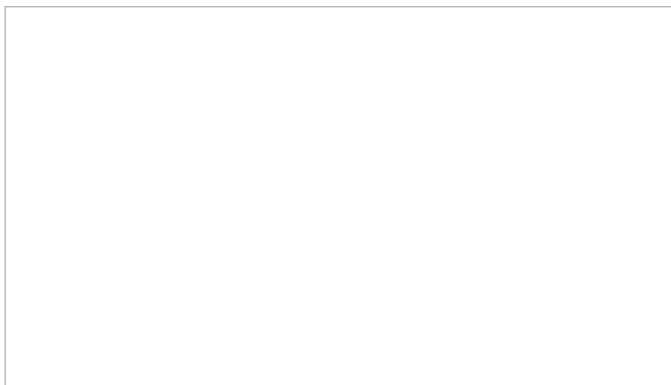


Repair to welds



Leak sealing of pipework

For more information, please contact your local Belzona representative:



### QUALITY PRODUCTS - TECHNICAL SUPPORT

Belzona products are manufactured under an ISO 9001 Registered Quality Management System.

Belzona has a global distribution network of over 140 Distributors operating in 120 countries. Local support is provided by a trained Technical Consultant who will diagnose the problem, recommend the solution and provide 24-hour, on-site application supervision and advice.