



ANH Refractories Europe Ltd

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Mixing & Using Instructions

LW22

General

Material should be stored in a dry place. For best results, material should be maintained at 10 - 21°C prior to casting.

Porous back-up materials or wood forms should be waterproofed. Absorption of water can result in reduced flow or affect setting of the product. Forms must be stout and water tight.

This product is designed to be mixed with water and may be either gunned or hand cast (poured). All equipment used to mix this product must be clean.

Never mix less than full bags. Add only clean water suitable for drinking, for best results, water should be maintained at 10 - 21°C.

Water Addition and Mixing Requirements

Water addition per 100 Kg 53 Litres

Wet mix for a minimal length of time (typically 1 – 2 minutes). Do not dry mix. Over mixing or dry mixing will crush the lightweight aggregate, resulting in increased density. For best results, wet mix temperature should be maintained at 10 - 21°C. Minor adjustments to the amount of water are permissible to achieve desired flow.

Installation

Place material within 20 minutes after adding water. Do not trowel to slick finish. At temperatures above 15°C, air cure, keeping surfaces damp and / or covered, for 16 – 48 hours typically or until a hard set has developed. Lower temperatures will increase the time before a hard set develops. Keep material from freezing during air cure and preferably until a dryout can be initiated. Freezing of this product prior to water removal can cause structural damage.



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Dryout Schedule

Heating and cooling refractory structures can be a complex procedure and where possible should be delegated to experts. Where this is done by the client they are themselves contractually responsible, and the following is given in good faith for guidance only.

Ambient to 120°C	55°C / hour
Hold at 120°C for 30 mins per 25mm thickness	
120°C to 250°C	55°C / hour
Hold at 250°C for 30 mins per 25mm thickness	

Never enclose a castable in a vapour-tight encasement as a dangerous steam explosion may result.

For thicknesses greater than 230mm or for multi-component linings contact Harbison-Walker Refractories Ltd for further advice.

Please note, the position of the control thermocouples for the heating and holding phase is important and can be critical. Advice can be given in good faith on request.

