

DOLPHIN 6098

HiThix WeldThru, Aluminum

DESCRIPTION: An air dry, non flowing, oleoresinous sealant formulated for application to vertical steel parts prior to spot weld assembly. This sealant permits welding with conventional spot welders; it prevents moisture and oxygen from entering the joint and provides corrosion protection to the "hidden" joint that cannot be coated with primer. The sealant "disappears" from the area of the weld but remains tightly surrounding the weld spot; weld strengths are unchanged by the use of **DOLPHIN 6098**. This sealant has found wide use on many types of steel, including stainless. If squeezed into an exposed joint, it will not bleed through most primers and paints. **DOLPHIN 6098** has been used on passenger rail cars for more than fifty years. In service, this sealant remains permanently flexible and gives corrosion protection for the life of the vehicle.

APPLICATION: **DOLPHIN 6098** is normally supplied in standard caulking cartridges for use in hand or air powered guns; it can be ordered in ones, fives, and drums for application with putty knives, spreaders or for pumping through dispensing equipment. Welds may be made through the sealer from 10 minutes to 72 hours after application. ("Spitting" may occur if welding is performed before the solvent escapes.) This sealer is unaffected by conventional industrial paint bakes. Excess material may be wiped off with mineral spirits; use mineral spirits to clean tools and equipment.

PROPERTIES:

Specific Gravity:	1.47 - 1.53
Color:	Aluminum
Solids:	88 – 92%
Flash Point, Seta Flash CC: ASTM D 3278	105° - 114° F

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Sag Resistance:	No sag with .625" bead
Dry Time @ 68° F; 50% RH ASTM D 1640	More than 72 hours set to touch Does not dry through

**THE FOLLOWING TESTS WERE PERFORMED
AFTER DRYING 21 DAYS @ 68° F (20° C); 50% RH**

Effects of Heat Aging: ASTM C 792; 336 hours @ 158° F (70° C)	Flexibility maintained No loss of adhesion	
Humidity Resistance: ASTM D 2247; 500 hours @ 100° F (38° C); 100% RH	No corrosion under sealer No loss of adhesion	
Cyclic Salt Fog/UV Exposure: ASTM D 5894; 1000 hours	No corrosion under sealer No loss of adhesion	
Surface Flammability: ASTM E 162		
Avg. Flamespread Factor (FS)	1.00	
Avg. Heat of Evolution (Q)	5.18	
Avg. Flamespread Index (Is)	5.18	
Flamespread Index Range	4.00 to 7.08	
Optical Density of Smoke Generation ASTM E 662	Non-Flaming	Flaming
Ds @ 1.5 min. (average)	0.0	0.4
Ds @ 4.0 min. (average)	0.4	20.6
Dm(corr) (average)	26.1	73.3

LOS090503
Rev: ES040104

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