

Cera-Kote® and Kaowool® B Cements



Product Description

High temperature cements Cera-Kote, Cera-Kote 322-D, and Kaowool Cement B are air-setting ceramic fiber cements for use with Kaowool products. They may be used for spray, dip, or brush application. These cements set with a strong hard film which will develop a ceramic bond above 1600°F (871°C).

Cera-Kote is an off white, medium viscosity regular grade cement.

Kaowool Cement B is a white, low viscosity premium grade cement.

Cera-Kote 322-D is a white, high viscosity, high strength premium grade cement.

Cera-Kote 624A is a white, high viscosity, high strength premium grade non-RCF and non-crystalline silica containing cement.

Features

- Range of grades with different viscosities
- Develops strong bond on drying
- Long shelf life when properly stored
- Non-RCF and Non-Crystalline silica grade available

Applications

- Adhesive to apply foils (stainless or aluminum) to Kaowool ceramic fiber blanket
- Adhesive to join vacuum formed Kaowool ceramic fiber parts together
- Adhesive and insulation for heating elements
- Fiber surface encapsulation

Handling

High temperature cements must be protected from freezing. Adequate ventilation and precautions against inhalation of particles during spray application should be provided. Normal shelf life is six months in unopened containers that have been properly stored.

Installation Information

The surface to be coated should be clean and dry. For best adhesion, smooth surfaces should be roughened. With a coating of 0.047 in. (1.2 mm), approximately 34 square feet (3.2 square meters) will be covered per gallon.

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Physical Properties

	Cera-Kote	Cera-Kote 322-D	Cera-Kote 624A	Kaowool Cement B
Color	off-white	white	white	white
Continuous Temperature Use Limit, °F (°C)	2150 (1177)	2200 (1204)	2200 (1204)	2200 (1204)
Max. Temperature Rating, °F (°C)	2300 (1260)	2400 (1316)	2400 (1316)	2400 (1316)
Melting Point, °F (°C)	3200 (1760)	3250 (1788)	3250 (1788)	3250 (1788)
Bond Strength-MOR, psi (Mpa)				
After air drying	180 (1.2)	255 (1.8)	-	205 (1.4)
Permanent Linear Change %				
after 24 hr @ 2300°F (1260°C)	3.2	2.5	-	2.5
Drying Temperature, (max) °F (°C)	150 (66)	150 (66)	150 (66)	150 (66)
Shelf Life, months ¹	6	6	6	6

Chemical Analysis, % Weight basis after firing

Alumina, Al ₂ O ₃	39	44	80	44
Silica, SiO ₂	59	55	19	55
Other	2	2	1	2

Chemical Properties

High temperature cements are mildly alkaline and require complete air drying to form a strong set. After drying, they are not soluble in water.

Product Availability

1 gallon pail, 13.5 lbs
 5 gallon pail, 67.5 lbs
 Squeeze bottles (Cera-Kote 624A only), 16 oz.

The values given herein are typical average values obtained in accordance with accepted test methods and are subject to normal manufacturing variations. They are supplied as a technical service and are subject to change without notice. Therefore, the data contained herein should not be used for specification purposes. Check with your Thermal Ceramics office to obtain current information.