

# Thin Paste-Grade Material for Rebuilding Shallow Pitting



This solvent-free material is specifically formulated to easily fill in areas of metal loss up to 6 mm deep, quickly restoring large areas and avoiding hot work and plate welding. Belzona 1151 (Smoothing Metal) will not corrode and will resist a wide range of chemicals.

This repair composite is ideally suited to be overcoated with epoxy coatings such as Belzona 1321 (Ceramic S-Metal) for long-term protection against the effects of erosion, corrosion and chemical attack.

Belzona 1151 can also be used as a high-strength structural adhesive for metal bonding, creation of irregular load bearing shims and reforming of bearing housings.

TECHNICAL DATA	Mixing ratio (Base : Solidifier)	4 : 1 by volume	10.8 : 1 by weight
	Working life	30 minutes at 25°C (77°F)	
	Shelf life	5 years	
	Dry heat resistance	200°C (392°F)	
	Adhesion (tensile shear)	Mild steel: 19.3 MPa (2,800 psi)	
	Compressive strength	95.1 MPa (13,790 psi) at 20°C (68°F) cure	
	Volume capacity	409 cm <sup>3</sup> (24.95 in <sup>3</sup> ) / 1 kg	1,227 cm <sup>3</sup> (74.9 in <sup>3</sup> ) / 3 kg
	Heat distortion temperature	44°C (111°F) at 20°C (68°F) cure	87°C (189°F) at 100°C (212°F) cure

CURE TIMES	Temperature	5°C (41°F)	15°C (59°F)	25°C (77°F)
	Overcoating	5 hours	3½ hours	2½ hours
	Machining and/or light loading	18 hours	9 hours	4½ hours
	Full mechanical or thermal loading	7 days	2 days	24 hours

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



**FAST APPLICATION**



**EXCELLENT ADHESION**



**HIGH MECHANICAL STRENGTH**



**EROSION/CORROSION RESISTANCE**

## Key Benefits:

- **Versatile**

Can be used for smoothing, bonding, shimming, filling, gluing, patch repairs and many more.

- **Paste/Fluid consistency**

Thinner than Belzona 1111, thicker than Belzona 1321 - it can be used to rebuild larger pitted areas quickly.

- **Effective**

Belzona 1151 has excellent chemical resistance and high mechanical strength.



Pitted pipe



Smooth repair

## Application Areas:

- Bearing housings
- Flange faces
- Heat exchangers
- Hydraulic rams
- Load bearing shims
- Process vessels
- Plate bonding
- Pumps
- Pipes
- Shafts
- Tanks

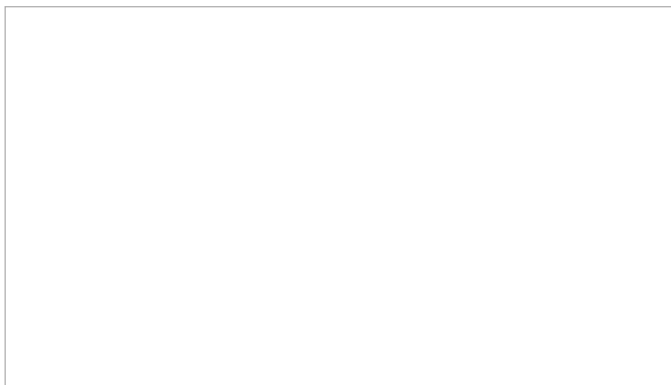


Pitted coupling



Reinstalled repaired coupling

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.