

# MasterWeld® 622

Multi-purpose, flexible polyurethane adhesive/sealant

FORMERLY DEGASEAL™ 22

## PACKAGING

- 300 mL cartridges,  
12 cartridges per case
- 20 oz. sausages,  
20 sausages per case

## COLORS

White, black, bronze and aluminum gray. For special orders of other colors, contact Customer Service.

## YIELD

- A 300 mL cartridge seals 24 lineal feet in 1/4" by 1/4" (6 by 6 mm) joint

## STORAGE

Protect unopened containers from heat and direct sunshine. In cool or cold weather, store containers at room temperature for at least 24 hours before using.

## SHELF LIFE

- Cartridges: 1 year when stored in unopened containers at 75° F (24° C) and 50% relative humidity.
- Sausages: 1 year when stored in unopened containers at 75° F (24° C) and 50% relative humidity.

## VOC CONTENT

35 g/L or <2.9%, less water and exempt solvents.

## DESCRIPTION

MasterWeld 622 is polyurethane based, one component, moisture-curing adhesive/sealant. It maintains permanent flexibility with high bond strength that provides outstanding durability.

## PRODUCT HIGHLIGHTS

- Permanently flexible for long lasting durability
- Compatible with a variety of paints to achieve desired aesthetic performance
- Primerless adhesion eliminates an installation step to improve the process and application time
- Low VOC for use in all regions

## APPLICATIONS

- Multi-purpose construction grade adhesive
- Various truck, bus, and trailer assemblies
- Rail car and cargo container assemblies

## LOCATION

- Interior and exterior

## SUBSTRATE

- Concrete
- Masonry
- Wood
- Clay & concrete roof tiles
- Aluminum

**Technical Data**

**Composition**

MasterWeld 622 is a multi-purpose polyurethane flexible adhesive/sealant.

**Compliances**

- ASTM C 557-73
- Federal Specification TT-S-00230C, Type II, Class A
- ASTM C 920-87, Type S, Grade NS, Class 25,  
Use NT, M and A

**Test Data**

PROPERTY	RESULTS	TEST METHOD
<b>Base</b>	Synthetic rubber-resin	
<b>Viscosity</b> , poise	2,800 ±500 (trowelable)	ASTM D 2393
<b>Application</b>	Caulking gun or power pump	
<b>Open time</b> , minutes	20 ±5, depending on temperature and humidity	
<b>Density</b> , lbs per gallon	9.85 ±0.1	ASTM D 1475
<b>Solids</b> , %	80 ±2	ASTM D 1259
<b>Lap shear</b> , psi		
Wet lumber	225	ASTM D 1002
Dry lumber	250	ASTM D 1002
Plywood/concrete	140	ASTM D 1002
Plywood/drywall	160	ASTM D 1002
Plywood/aluminum	100	ASTM D 1002
<b>Service temperature range</b> , ° F (° C)	-40 to 200 (-40 to 93)	
<b>Extrudability</b> , seconds	3	ASTM C 603
<b>Rheology</b> , vertical sag, 120° F	No sag	ASTM C 639
<b>Tack-free time</b> , (maximum 72 hrs)	Passes	ASTM C 679
<b>Tensile strength</b> , psi	350	ASTM D 412
<b>Elongation, at break</b> , %	800	ASTM D 412
<b>Hardness</b> , Shore A	25–30	ASTM C 661
<b>Movement capability</b> , %	±25	ASTM C 719
<b>Bond durability</b> , %	±25, no failures	ASTM C 719
Glass, aluminum, concrete		
<b>Accelerated weathering</b>	No elastomeric property change after 3,000 hours	Atlas 6500 xenon arc model
<b>Exterior Perimeter Sealing</b>	Pass	AAMA 808.3

Test results are averages obtained under laboratory conditions. Reasonable variations can be expected.

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## HOW TO APPLY

### SURFACE PREPARATION

1. Surfaces must be dry, clean, free of dirt, moisture, loose particles, oil, grease, asphalt, tar, paint, wax, rust, waterproofings or other contaminants.
2. On metal surfaces, remove scale, rust or other coatings to expose a bright white surface. Aluminum window frames are frequently coated with a clear lacquer that must be removed before the application of MasterWeld 622.
3. Clean concrete, stone and other masonry surfaces by grinding, sandblasting or wire brushing. Expose a sound surface free of contamination and laitance.
4. Wood surfaces must be clean and sound. Scrape away any paint to bare wood.

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## APPLICATION

1. MasterWeld 622 bonds well to a variety of substrates and is ideally suited for use in interior/exterior joints, waterproofing overlap seams, fascia and other structural components. MasterWeld 622 remains permanently elastic for long lasting performance.
2. Surface temperatures above 40° F (4° C) are recommended during application. MasterWeld 622 can be applied below freezing temperatures only if substrates are completely dry, free of moisture and clean.
3. MasterWeld 622 comes ready to use. Do not open cartridges until preparatory work has been completed. Trim nozzle to desired size opening. Place cartridge in dispensing gun and puncture seal inside nozzle.
4. Fill joints from the deepest point to the surface by holding a properly sized nozzle against the back of the joint.
5. Dry tooling is recommended.

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## CURING

- 16 hours: 100° F (38° C), 95% relative humidity
  - 1 day: 70° F (21° C), 55% relative humidity
  - 3 days: 40° F (4° C), 50% relative humidity
- Cure through times are based on a 1/4" (6 mm) diameter bead.

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## CLEAN UP

Immediately after use, clean equipment with the appropriate solvent. Use proper precautions when handling solvents. Cured sealant can be removed by cutting with a sharp-edged tool; thin films by abrading.

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## FOR BEST PERFORMANCE

- Do not apply over freshly treated wood; it must have weathered for at least 6 months.
- MasterWeld 622 should not come into contact with oil-based caulking, silicone sealants, polysulfides or fillers impregnated with oil, asphalt or tar.
- Do not use in joints deeper than 1/2".
- MasterWeld 622 is not recommended for continuous water immersion.
- Make certain the most current versions of product data sheet and SDS are being used; call Customer Service (1-800-433-9517) to verify the most current version.
- Proper application is the responsibility of the user. Field visits by BASF personnel are for the purpose of making technical recommendations only and not for supervising or providing quality control on the jobsite.

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## HEALTH, SAFETY AND ENVIRONMENTAL

Read, understand and follow all Safety Data Sheets and product label information for this product prior to use. The SDS can be obtained by visiting [www.master-builders-solutions.basf.us](http://www.master-builders-solutions.basf.us), e-mailing your request to [basfbcst@basf.com](mailto:basfbcst@basf.com) or calling 1(800)433-9517. Use only as directed.

**For medical emergencies only,  
call ChemTrec® 1(800)424-9300.**

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