

PRODUCT DATA SHEET

weberset 383

(Formerly known as E.MIX TILE FIX 383)

Extra strength, highly flexible, high performance, deformable polymerized thin bed tile adhesive for interior and exterior wall tile fixing complied with C2TE class of EN 12004 and S1 class of EN 12002 (S2 class can be achieved by adding **webertec EVA**)

PRODUCT

weberset 383 is a deformable, highly flexible, water resistant, and single component cementitious tile adhesive. It is designed simply to mix with water to give strong, non-slip, extended open time, and highly workable adhesive mortar for both interior and exterior applications. Ideal designed for installation of different kinds of tiles and especially for tile on tile and renovation application. Suitable substrates are concrete, cement plasters, gypsum boards, brickworks and ALC blockwalls. It is also applicable on wood and metal substrate. The product is highly flexible, extra flexibility (S2 class of EN 12002) can be achieved by adding **webertec EVA**.

Uses

- Tiling for large sized tiles and stones
- Tiling on old tiles
- Can be tiled on wood and metal substrate with less adhesive strength compared to cementitious substrate
- Tiling on underfloor heating system
- Floor tiling subject to heavy stress
- Interior and exterior wall tiling on renders or cement mortar
- Interior and exterior wall tiling on concrete. The concrete should be sufficiently well aged or cured
- Tiling on gypsum board, cement board, dry wall, gypsum support and substrate should be primed before hand with **weberprim moisture sealer**
- Tiling on cementitious waterproofing material such as **weber waterproofing series**

Features and Benefits

- Formulated to comply with European Norm, American Standard and Chinese Standard
- Specially formulated for renovation and application on old tile
- Extra adhesion under exterior weather conditions, especially for exterior condition
- Single component: fixed mixing proportion, ensure the quality of work
- Thixotropic and easy-to-trowel, good workability
- Extended open time of 30 minutes
- Non-slip

TECHNICAL DATA

Colour	Grey, White
Component	Portland cement, non-reactive aggregate, graded sand and other chemical additives

Max. aggregate size	1.0 mm	
Water demand	Grey : Approx. 24 – 27% (9.6 – 10.8 L/40 kg bag) White : Approx. 27 – 30% (10.8 – 12.0 L/40 kg bag)	
Density	Grey : 1.3 kg/L (dry) Grey : 1.4 kg/L (wet) for 26% water demand	White : 1.2 kg/L (dry) White : 1.4 kg/L (wet) for 27% water demand
Pot life	Approx. 3 hours	
Coverage	Grey : Approx. 1.15 kg/m ² /mm	White : Approx. 1.15 kg/m ² /mm

THICKNESS AND THEORETICAL CONSUMPTION

Tile size (mm x mm x mm)	Recommend notch size (mm x mm)	Back buttering thickness (mm)	Total thickness (mm)	weberset 383 Grey consumption (kg/m ²)	weberset 383 White consumption (kg/m ²)
45 x 45 x 6	6 x 6	Nil	2.5	2.9	2.9
95 x 45 x 6	6 x 6	Nil	2.5	2.9	2.9
100 x 100 x 7	6 x 6	Nil	2.5	2.9	2.9
200 x 200 x 7	6 x 6	1	3.5	4.0	4.0
300 x 300 x 10	6 x 6	2	4.5	5.2	5.2
600 x 300 x 10	10 x 10	2	6	6.9	6.9
600 x 600 x 15	10 x 10	2	6	6.9	6.9
1000 x 1000 x 20	10 x 10	2	6	6.9	6.9

Consumption (kg/m²) = Total thickness of **weberset 383** (mm) x Coverage (kg/m²/mm)

PHYSICAL PROPERTIES

Adhesion to concrete	EN 1348 • Initial adhesion strength • Adhesion strength after heat aging • Adhesion strength after water immersion • Adhesion strength after freeze-thaw cycles	2.4 N/mm ² 2.7 N/mm ² 1.3 N/mm ² 1.7 N/mm ²
Open time	EN 1346	30 minutes with ≥ 0.5 N/mm ² adhesive strength
Slip resistance	EN 1308	≤ 0.5 mm
Deformability	EN 12002	S1 deformable S2 deformability can be achieved by addition of webertec EVA
VOC Content	ASTM D3960	< 10 g/L

Unless specified, all technical data are average values and refer to 28 days curing time.

Above physical data are taken on laboratory tests. In situ material performance may vary according to environmental & workmanship conditions beyond manufacturer control.

Complied Standards

European Norm	:	EN 12004 : 2007 Class C2TE, EN 12002 : 2002 Class S1 or S2 (if webertec EVA is added)
American Standard	:	ASTM D3960
Chinese Standard	:	JC/T 547 : 2017 Class C2TE S1

PROCEDURE

Substrate Preparations

Substrate must be free from grease, mould oil, rust, rusty metal, wood peels, paints, plastics, loose particles, contamination on any traces of foreign materials affecting the adhesion of **weberset 383**.

Mixing and Installation

weberset 383 can be applied at least 7 days after the application of render.

Before application, dampen the surface with clean water and allow excess water to drain away.

Mix a bag of dry mix powder (40 kg) with appropriate amount of water by using an electrical mixer. Add approx. 24 – 27% (9.6 – 10.8 L) of water; for **weberset 383** White, add 10.8 – 12.0 L (27 – 30%) of water.

Stir the mixture thoroughly for 5 – 7 minutes to obtain a creamy paste without lumps. Then let the mixture stand for 10 minutes for the additives to dissolve, and then mix again before use.

Apply **weberset 383** by using a notched trowel directly onto substrate, over which tiling can be achieved within 30 minutes under normal temperature and humidity condition. Unfavourable weather conditions such as strong sunshine, low humidity, high wind speed, or highly water-absorbed substrates reduce the open time of tile adhesive.

When the surface of tile adhesive is dried, do not use water to wet the surface. It will form a very weak and non-adhesive layer.

It is recommended to use **webergROUT Series** for grouting 1 day after tiling.

Please refer to our method statement for procedures in details.

Curing

Natural air curing is enough for **weberset 383**.

STORAGE AND PACKING

weberset 383 is delivered in 40 kg bag. Storage life is 12 months if the product is kept in a dry place.

HEALTH AND SAFETY

Recommend to wear NIOSH approved or equivalent particulate face mask when mixing the material.

Material contains cement, which may produce an allergic effect.

Keep out of reach of children.

Material may cause irritation to eyes and skin. In case of contact with eyes, rinse immediately with plenty of water and seek medical assistance. After contact with skin, wash immediately with plenty of soap and water.

Please refer to Material Safety Data Sheet (MSDS) for health, safety and handling of the product.

CLEANING & DISPOSAL OF WASTE

Cured material can be removed mechanically, if uncured, material can be removed with water. Dispose of waste in accordance with legislation.

* Note: The information and physical data in this catalogue is given to the best of our knowledge under standard testing method and controlled environment. The results may vary with different weather / site conditions, workmanship or substrates. This is beyond our control that we shall not be liable for any faults or consequences arising or associated with this. We suggest comprehensive tests to be conducted before final application. Unless specified, all technical data are average values with curing time of 28 days. We reserve the right to update or amend the contents in the light of new findings during the course of research and development.