

# Sika® CarboDur® Plates

## Pultruded carbon fiber plates for structural strengthening

### System Description

Sika® CarboDur® plates are pultruded carbon fiber reinforced polymer (CFRP) laminates designed for strengthening concrete, timber and masonry structures.

Sika® CarboDur® plates are bonded onto the structure as external reinforcement using Sikadur®-30 for normal - or Sikadur®-30 LP epoxy resin for elevated application temperatures (for details on the adhesive see the relevant Product Data Sheet).

### Uses

To strengthen structures for:

*Load increase:*

- Increasing the capacity of floor slabs and beams
- Increasing the capacity of bridges to accommodate increase axle loads
- Installation of heavier machinery
- Stabilising vibrating structures
- Changes of building use

*Damage to structural elements:*

- Deterioration of original construction materials
- Steel reinforcement corrosion
- Vehicle impact
- Fire
- Earthquakes

*Service improvements:*

- Reduced deflection
- Stress reduction in steel reinforcement
- Crack width reduction
- Reduced fatigue

*Change in structural system:*

- Removal of walls or columns
- Removal of slab sections for openings

*Change of specification:*

- Earthquakes
- Changed design philosophy

*Design or construction defects:*

- Insufficient / inadequate reinforcement
- Insufficient / inadequate structural depth



<b>Characteristics / Advantages</b>	<ul style="list-style-type: none"> <li>■ Non corrosive</li> <li>■ Very high strength</li> <li>■ Excellent durability</li> <li>■ Lightweight</li> <li>■ Unlimited lengths, no joints required</li> <li>■ Low overall thickness, can be coated</li> <li>■ Easy transportation (rolls)</li> <li>■ Simple plate intersections or crossings</li> <li>■ Very easy to install, especially overhead</li> <li>■ Outstanding fatigue resistance</li> <li>■ Minimal preparation of plate, applicable in several layers</li> <li>■ Combinations of high strength and modulus of elasticity available</li> <li>■ High alkali resistance</li> <li>■ Clean edges without exposed fibers thanks to the pultrusion process</li> <li>■ Approvals from many countries worldwide</li> </ul>
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## Tests

<b>Approval / Standards</b>	<p>Deutsches Institut für Bautechnik Z-36.12-29, 2006: General Construction Authorisation for Sika® CarboDur®.</p> <p>SOCOTEC Rapport No. HX0823, 2000: Rapport d'enquete technique / cahier des charges - Sika® CarboDur® / SikaWrap® (French).</p> <p>NBI Teknisk Godkjenning, NBI Technical Approval, No. 2178, 2001, (Norwegian).</p> <p>ZAG, Technical Approval No. S418/99-620-2, za uporabo nacina ojacitev armirano betonskih in prednapetih elementov konstrukcij z dolepljenjem lamel iz karbonskih vlaken "Sika® CarboDur®" v Republiki Slononiji (Slovenian).</p> <p>TSUS, Building Testing and research institutes, Technical approval No. 5502A/02/0633/0/004, 2003: Systém dodatocného zosilnovania zelezobetonovych a drevenych konstrukcii Sika CarboDur® (Slovak).</p> <p>Institut badawczy drog i mostow, technical approval No. AT/2003-04-0336, System materialow Sika® CarboDur® do wzmacniania konstrukcji obiektow mostowych (Polish).</p> <p>Fib, Technical Report, bulletin 14: Externally bonded FRP reinforcement for RC structures, July 2001 (International).</p> <p>ACI 440.2R-02, Guide for the Design and construction of Externally Bonded FRP Systems for strengthening concrete structures, October 2002, (USA).</p> <p>Concrete Society Technical Report No. 55, Design guidance for strengthening concrete structures using fiber composite material, 2000 (UK).</p> <p>SIA 166, Klebebewehrungen, 2003 /2004 (CH).</p>
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<b>Product Data</b>	Sika® CarboDur® CFRP plates
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<b>Form</b>	
<b>Appearance / Colour</b>	Carbon fiber reinforced polymer with an epoxy matrix, black.
<b>Packaging</b>	Cut to size according parts list in reusable packaging. Supplied in rolls of 250 m in reusable packing boxes.

**Types****Sika® CarboDur® S**Tensile E-Modulus 165'000 N/mm<sup>2</sup>

Type	Width	Thickness	Cross sectional area
Sika® CarboDur® S1.525/60	15 mm	2.5 mm	37.5 mm <sup>2</sup>
Sika® CarboDur® S2.025/80	20 mm	2.5 mm	50 mm <sup>2</sup>
Sika® CarboDur® S512/80	50 mm	1.2 mm	60 mm <sup>2</sup>
Sika® CarboDur® S613/100	60 mm	1.3 mm	78 mm <sup>2</sup>
Sika® CarboDur® S812/120	80 mm	1.2 mm	96 mm <sup>2</sup>
Sika® CarboDur® S912/140	90 mm	1.2 mm	108 mm <sup>2</sup>
Sika® CarboDur® S1012/160	100 mm	1.2 mm	120 mm <sup>2</sup>
Sika® CarboDur® S1014/180	100 mm	1.4 mm	140 mm <sup>2</sup>
Sika® CarboDur® S1213/200	120 mm	1.3 mm	156 mm <sup>2</sup>
Sika® CarboDur® S1214/220	120 mm	1.4 mm	168 mm <sup>2</sup>
Sika® CarboDur® S1512/240	150 mm	1.2 mm	180 mm <sup>2</sup>

**Sika® CarboDur® M (steel equivalent)**Tensile E-Modulus 210'000 N/mm<sup>2</sup>

Type	Width	Thickness	Cross sectional area
Sika® CarboDur® M614/110	60 mm	1.4 mm	84 mm <sup>2</sup>
Sika® CarboDur® M914/170	90 mm	1.4 mm	126 mm <sup>2</sup>
Sika® CarboDur® M1214/230	120 mm	1.4 mm	168 mm <sup>2</sup>

**Sika® CarboDur® H**Tensile E-Modulus 300'000 N/mm<sup>2</sup>

Type	Width	Thickness	Cross sectional area
Sika® CarboDur® H514/50	50 mm	1.4 mm	70 mm <sup>2</sup>

**Storage****Storage Conditions / Shelf Life**

Unlimited (no exposure to direct sunlight, dry).

**Technical Data****Density** 1.60 g/cm<sup>3</sup>**Temperature Resistance** > 150°C**Fiber Volume Content** > 68% (type S)

## Mechanical / Physical Properties

### Plate Properties

		Sika CarboDur S	Sika CarboDur M	Sika CarboDur H
E-Modulus*	Mean Value	165'000 N/mm <sup>2</sup>	210'000 N/mm <sup>2</sup>	300'000 N/mm <sup>2</sup>
	Min. Value	> 160'000 N/mm <sup>2</sup>	> 200'000 N/mm <sup>2</sup>	> 290'000 N/mm <sup>2</sup>
	5% Fractile-Value	162'000 N/mm <sup>2</sup>	210'000 N/mm <sup>2</sup>	-
	95% Fractile-Value	180'000 N/mm <sup>2</sup>	230'000 N/mm <sup>2</sup>	-
Tensile Strength*	Mean Value	3'100 N/mm <sup>2</sup>	3'200 N/mm <sup>2</sup>	1'500 N/mm <sup>2</sup>
	Min. Value	> 2'800 N/mm <sup>2</sup>	> 2'900 N/mm <sup>2</sup>	> 1'350 N/mm <sup>2</sup>
	5% Fractile-Value	3'000 N/mm <sup>2</sup>	3'000 N/mm <sup>2</sup>	-
	95% Fractile-Value	3'600 N/mm <sup>2</sup>	3'900 N/mm <sup>2</sup>	-
Strain at break* (min. value)		> 1.70%	> 1.35%	> 0.45%
Design strain**		< 0.85%	< 0.65%	< 0.25%

\* Mechanical values obtained from longitudinal direction of fibers.

\*\*These values should be used for design as the maximum strains in the CFRP-plates and must be adapted to local design regulations as necessary. Dependent upon the structure and the load situation, they may also have to be decreased by the responsible Engineer according to requirements and standards.

## System Information

Sika® CarboDur® + Sikadur®-30 or Sikadur®-30 LP

## Application Details

### Consumption

Width of plate	Sikadur®-30
50 mm	0.35 kg/m'
60 mm	0.40 kg/m'
80 mm	0.55 kg/m'
90 mm	0.70 kg/m'
100 mm	0.80 kg/m'
120 mm	1.00 kg/m'
150 mm	1.20 kg/m'

Dependent on the surface plane, profile and roughness of the substrate as well as any plate crossings and loss or wastage, the actual consumption of adhesive may be higher.

### Substrate Quality

Evenness / plane or level: (according to FIB14)  
 The surface to be strengthened must be levelled, with variations and formwork marks not greater than 0.5 mm. Plane and level of the substrate to be checked with a metal batten. Tolerance for 2 m length max. 10 mm and for 0.3 m length 4 mm. These tolerances shall be adapted to local guidelines if there are any. They might be more restrictive.

Substrate strength (concrete, masonry, natural stone) must be verified in all cases): Mean adhesive tensile strength of the prepared concrete substrate should be 2.0 N/mm<sup>2</sup>, min. 1.5 N/mm<sup>2</sup>. If these values can not be reached, then see the SikaWrap® Fabric Product Data Sheets for alternative Sika® solutions.

Concrete must be older than 28 days (dependent on environment and strengths).

## Substrate Preparation

### Concrete and masonry:

Substrates must be sound, dry, clean and free from laitance, ice, standing water, grease, oils, old surface treatments or coatings and any loosely adhering particles.

Concrete must be cleaned and prepared to achieve a laitance and contaminant free, open textured surface.

Repairs and levelling must be undertaken with structural repair materials such as Sikadur®-41 repair mortar or Sikadur®-30 adhesive, filled max. 1 : 1 by weight with Sikadur®-501 quartz sand. The prior wetting of the substrate with Sikadur®-30 improves the bond (wet in wet). If levelling has been conducted more than 2 days before applying the plates, the levelled surface has to be ground again to ensure a proper bond between Sikadur®-41 and Sikadur®-30 (see the relevant Product Data Sheets).

### Timber surfaces:

Must be prepared by planing, grinding or sanding. Dust must be removed by vacuum.

### Steel surfaces:

Must be prepared by blastcleaning to Sa 2.5 free from grease, oil, rust and any other contaminants which could reduce or prevent adhesion.

Use the correct primer (see table).

Be careful to avoid water condensation on the surfaces (dew point conditions).

Priming can be done with Icosit-277 or with Sikagard®-63 N as temporary corrosion protection; or Icosit-EG1 as permanent corrosion protection.

	+10°C	+20°C	+30°C
1) Maximum waiting time between - Blastcleaning of steel and - Primer / or Sikadur®-30 (application without priming possible, if no corrosion protection is needed)	48 hours	48 hours	48 hours
2) Minimum waiting time between - Primer and - Sikadur®-30 application ( <b>without</b> additional preparation of the Primer)	48 hours	24 hours	12 hours
3) Maximum waiting time between - Primer and - Sikadur®-30 application ( <b>without</b> additional preparation of the Primer)	7 days	3 days	36 hours
4) Waiting time between - Primer and - Sikadur®-30 application ( <b>with</b> additional preparation of the Primer)*	> 7 days	> 3 days	> 36 hours

\*If additional preparation of the primer is necessary (4), it shall be done at earliest the day before application. After preparation of the Primer, the surface has to be cleaned / vacuumed free from dust.

### Plate preparation:

Prior to the application of Sikadur®-30, solvent wipe the bonding surface with Sika® Colma Cleaner to remove contaminants. Wait until the surface is dry before applying the adhesive (> 10 minutes).

## Application Conditions / Limitations

**Substrate Temperature** See the Product Data Sheets of Sikadur®-30 and Sikadur®-30 LP.

**Ambient Temperature** See the Product Data Sheets of Sikadur®-30 and Sikadur®-30 LP.

**Substrate Moisture Content** See the Product Data Sheets of Sikadur®-30 and Sikadur®-30 LP.

**Dew Point** See the Product Data Sheets of Sikadur®-30 and Sikadur®-30 LP.

## Application Instructions

<b>Mixing</b>	See the Product Data Sheets of Sikadur <sup>®</sup> -30 and Sikadur <sup>®</sup> -30 LP.
<b>Mixing Time</b>	See the Product Data Sheets of Sikadur <sup>®</sup> -30 and Sikadur <sup>®</sup> -30 LP.
<b>Application Method / Tools</b>	<p>Place the Sika<sup>®</sup> CarboDur<sup>®</sup> plate on a table and clean the unlabelled side with Colma Cleaner using a white rag. Wait &gt; 10 minutes to allow the surface to dry completely. Apply the well-mixed Sikadur<sup>®</sup>-30 adhesive with a special "dome" shaped spatula onto the cleaned CarboDur<sup>®</sup> laminate. Apply the Sikadur<sup>®</sup>-30 adhesive carefully to the properly cleaned and prepared substrate, with a spatula to form a thin layer for substrate wetting.</p> <p>Within the open time of the adhesive, place the Sikadur<sup>®</sup>-30 coated Sika<sup>®</sup> CarboDur<sup>®</sup> plate onto the Sikadur<sup>®</sup> coated concrete surface. Using a Sika<sup>®</sup> rubber roller, press the plate into the adhesive until the material is forced out on both sides of the laminate. Remove surplus adhesive.</p> <p>Intersections / multiple layers: Where there are to be plate intersections or crossovers, the first Sika<sup>®</sup> CarboDur<sup>®</sup> plate should be cleaned with Sika<sup>®</sup> Colma Cleaner before overlaying with adhesive and then the second plate applied. If more than one plate is to be bonded together, they all have to be cleaned on both sides with Sika<sup>®</sup> Colma Cleaner - use Sikadur<sup>®</sup>-330 or Sikadur<sup>®</sup>-30 adhesive in these instances (for details see the Product Data Sheets of Sikadur<sup>®</sup>-330 and Sikadur<sup>®</sup>-30).</p> <p>Quality assurance: For quality control of curing rate and strength, samples may be made up on site if requested by code or project engineer.</p> <p>Average standard values after curing 7 days at +23°C are:</p> <ul style="list-style-type: none"><li>- Compressive strength &gt; 75 N/mm<sup>2</sup></li><li>- Flexural tensile strength &gt; 35 N/mm<sup>2</sup></li></ul> <p>These values can differ by up to 20% dependent on the circumstances. The following are the most important factors which can have an influence on the mechanical properties of the samples:</p> <ul style="list-style-type: none"><li>- Mixing ratio (A : B = 3 : 1 exactly)</li><li>- Air entrapment in the sample (from mixing or filling into the mould!)</li><li>- Curing temperature / time</li><li>- Contamination of the adhesive!</li></ul> <p>Therefore care should be taken to avoid these situations.</p> <p>When the Sikadur<sup>®</sup>-30 has cured, test for voids by tapping the surface of the plate with metallic object or impuls-thermography.</p> <p>Application Tools: Sika<sup>®</sup> Colma Cleaner: For cleaning of Sika<sup>®</sup> CarboDur<sup>®</sup> plate before bonding, cleaning of application tools. In 1 and 5 kg pails, 20 kg mini drum and 160 kg drum.</p> <p>Sika<sup>®</sup> CarboDur<sup>®</sup> Rubber Roller: For pressing the Sika<sup>®</sup> CarboDur<sup>®</sup> plate onto the surface. Sales unit 1 pce.</p> <p>Sika<sup>®</sup> Mixing Spindle: For minimizing air entrapment. Sales unit 1 pce.</p>
<b>Cleaning of Tools</b>	Clean all tools and application equipment with Sika <sup>®</sup> Colma Cleaner immediately after use. Cured material can only be removed mechanically.
<b>Potlife</b>	See the Product Data Sheets of Sikadur <sup>®</sup> -30 and Sikadur <sup>®</sup> -30 LP.

**Notes on Application / Limitations**

A suitably qualified Engineer must be responsible for the design of the strengthening works.

**This application is structural and great care must be taken in selecting suitably experienced and trained specialist labour.**

Only apply plates within the open time of Sikadur®-30.

Site quality control should be supported / monitored by an independent testing authority.

Care must be taken when cutting plates. Use suitable protective clothing, gloves, eye protection and respirator.

The Sika® CarboDur® system must be protected from permanent exposure to direct sunlight.

**Coating:**

The exposed plate-surface can be painted with a coating material such as Sikagard®-550 W Elastic or Sikagard®-ElastoColor W for UV protection.

Maximum permissible service temperature is approx. +50°C.

Note: When using the Sika® CarboHeater together with Sikadur®-30 LP this can be increased to max. +80°C (see the Sika® CarboHeater Product Data Sheet).

The instructions in the Technical Data Sheet must be followed when applying Sikadur®-30 adhesive.

**Note:**

Detailed advice on the above must always be obtained from Sika® Services AG.

**Fire Protection**

If required Sika® CarboDur® plates may be protected with fire resistant material.

**Value Base**

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

**Health and Safety Information**

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Material Safety Data Sheet containing physical, ecological, toxicological and other safety-related data.

**Legal Notes**

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

