

# FORBO MARMOWELD ETU TECHNICAL DATA

## 1. PRODUCT NAME & MANUFACTURER

### 1.1 Product:

Forbo Marmoweld ETU paste weld.

### 1.2 Manufacturer:

Forbo Flooring Systems  
Humboldt Industrial Park  
Hazleton, PA 18202

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### 1.3 Physical Characteristics:

Environment----- FloorScore Certified  
Safety----- 100% Solvent and Ammonia Free  
----- Non-Flammable  
Storage----- Do NOT Freeze  
Shelf Life----- 1 year in unopened container  
VOC Emissions ----- 0 g/L (per SCAQMD Rule 1168)  
Odor ----- Little to no odor  
Spread Rate ----- 1,200 linear feet  
Unit Size ----- 8 oz. (236.59 mL)

### 1.4 Resistance to Bacteria:

Independent testing conducted in accordance to AATCC 174, Test Method for Antimicrobial Activity, shows that Marmoweld ETU demonstrates antimicrobial properties.

## 2. INSTALLATION

### 2.1 General Guidelines:

Forbo Marmoweld ETU is only for use with Forbo Marmoleum products.

Marmoweld ETU is the preferred method of welding seams where seamless or monolithic flooring is required. Marmoweld ETU is a color matching paste weld which can also be used to make minor repairs in Forbo Marmoleum products. Marmoweld ETU should never be diluted or mixed with any other sealants.

Due to the developments and advancements made over the last decades with the combination of Forbo Marmoleum Topshield (Forbo's factory finish for Marmoleum), improvements in water-based adhesives, and with our commitment to education of proper installation, care and maintenance procedures and environmental stewardship, heat welding is **no longer necessary for most applications.**

Material should always be visually inspected prior to installation. If there are any questions regarding the quality of material, contact your Forbo Sales Representative or Forbo Product Support & Education Services PRIOR to installation.

### 2.2 Tools Required:

Marmoweld ETU application card  
Clean, white, lint-free cloths  
Clean buckets  
Clean, cool water  
2-inch Masking Tape

### 2.3 Welding 1.0mm Prepared Seams with Forbo Marmoweld ETU:

Prior to applying Marmoweld ETU, a 1mm seam must be prepared. Set underscrubbers to leave a 1mm gap (which is the width of the Marmoweld ETU applicator card). Apply Marmoweld ETU immediately upon the completion of installed seams. DO NOT DELAY the application of Marmoweld ETU as this increases the chances of seam contamination. Clean all debris and excess adhesive from within the 1.0mm prepared seam before applying Marmoweld ETU. This must be done while the adhesive is still wet and can be accomplished using the edge of the Marmoweld ETU applicator card. Remove all loose debris from the surface of the flooring material by sweeping or vacuuming. Remove any residual adhesive from the surface with a clean, white, lint-free cloth and clean, cool water prior to applying Marmoweld ETU.

Apply 2" (5cm) releasable masking tape (such as FrogTape, blue painter's tape, or equivalent) to both sides and down the entire length of the 1.0mm prepared seam before applying Marmoweld ETU. DO NOT USE any other type of adhesive tape than releasable masking tape. Always refer to and strictly follow the tape manufacturer's recommendations for applying and removing tape.

Apply Marmoweld ETU directly onto the releasable masking tape, working the ETU down into the 1.0mm prepared seam with the applicator card. Work in manageable sections of 3' – 5' (0.91m – 1.5m) at a time by carefully pushing the Marmoweld ETU into and across the seam. Remove excess wet Marmoweld ETU from the releasable masking tape on the sides of the seam with the applicator card. Let the Marmoweld ETU dry for a minimum of 30 minutes.

A general indication of appropriate drying time is that after a minimum of 30 minutes, a touch to the Marmoweld ETU does not produce any transfer to the finger and will not smear when wiped with a damp cloth. Slowly and cautiously, remove the releasable masking tape. Improper removal may cause damage to the factory finish of any resilient flooring product. Always refer to and strictly follow the tape manufacturer's recommendations for applying and removing tape.

**NOTE: UNDER NO CIRCUMSTANCES SHOULD THE RELEASABLE MASKING TAPE BE LEFT ON THE SURFACE OF THE FLOORING BEYOND THE DRYING TIME OF THE MARMOWELD ETU TO AVOID DAMAGE.**

Wipe off any Marmoweld ETU residue from the sides of the welded seam with a clean, white, lint-free damp cloth. Repeat this process as necessary, making sure that only clean cloths and water are being used so residue from unclean water or cloths is not being spread.

**IMPORTANT! Change water and cloths frequently to eliminate spreading weld residue over the surface of the floor. This will also help reduce further cleanup after the Marmoweld ETU has dried.**

After the application and cleaning is complete, carefully inspect that there are no voids or low spots. Reapply Marmoweld ETU as necessary so the final seam is free of voids or low spots. Repeat the steps above for reapplication.

#### 2.4 Repairs:

Marmoweld ETU is intended for minor repairs. It is not intended to fill large gaps or to fix poor installations. The size of the repair will affect the yield of the Marmoweld ETU. Some repairs may require additional applications to ensure there are no low spots or voids. No weld is intended to correct deficient installation issues.

Apply Marmoweld ETU to any areas requiring minor repairs such as gaps at seams or around the perimeters with the Marmoweld ETU applicator card.

Remove any excess Marmoweld ETU from the surface of the floor using the Marmoweld ETU applicator card while it is still wet.

Let the Marmoweld ETU dry for a minimum of 30 minutes.

Carefully wipe off any Marmoweld ETU residue from around the welded area with a clean, white, lint-free damp cloth.

**IMPORTANT! Change water and cloths frequently to eliminate spreading weld residue over the surface of the floor. This will also help reduce further cleanup after the Marmoweld ETU has dried.**

After the application and cleaning is complete, carefully inspect that there are no voids or low spots. Reapply Marmoweld ETU as necessary so the final repair is free of voids or low spots. Repeat the steps above for reapplication.

### 3. WARRANTY

Limited warranty. For complete details, contact Forbo Flooring.

### 4. CARE & CLEANING

Ensure that **ALL** Marmoweld ETU residue is removed from the surface of the material.

Once Marmoweld ETU seams or repairs are completed, allow a minimum of an additional 30 minutes before damp mopping. DO NOT flood the floor or conduct wet maintenance procedures for a minimum of 24 hours. Refer to Forbo's Installation Guidelines for complete installation recommendations of Marmoleum products.

Dried Marmoweld ETU residue on the surface of the material can easily be removed with clean, cool water and a clean, white, lint-free cloth within 8 hours.

To remove residue after 8 hours, mix a cleaning solution by diluting a neutral pH cleaner in strict accordance with the manufacturer's recommendations. Apply the cleaning solution to the floor and allow 10 minutes of dwell time.

Scrub the floor with either a 175 RPM floor machine or an automatic scrubber using a 3M™ Red Pad #5100 or equivalent.

Pick up the cleaning solution with a wet/dry vacuum or an automatic scrubber.

If using a cleaner that requires rinsing, rinse the entire surface with a clean mop using clean, cool water. Pick up the rinse water with wet/dry vacuum or an automatic scrubber.

Allow the floor to dry completely before allowing traffic.

See Forbo's Floor Care Guidelines for complete care recommendations.