



STRUCTURAL CONCRETE[®] ES-60

Fast, High Early Strength, 60-90 Minute Working Time

Permanent Repair Material

PRODUCT DESCRIPTION

Five Star Structural Concrete[®] ES-60 is a high early strength, single component, permanent concrete repair material that provides working times of 60 minutes at 90°F (32°C) and 90 minutes at 70°F (21°C). The extended working times facilitate deep/large volume pours and applications in hot weather or warm ambient temperature environments. Five Star Structural Concrete[®] ES-60 produces a repair which is dimensionally stable, develops an integral bond to existing concrete, and restores structural integrity within hours of placement. Five Star Structural Concrete[®] ES-60 provides increased corrosion protection of steel reinforced structures with migrating corrosion inhibitor technology and very low chloride ion permeability.

ADVANTAGES

- 60-90 minute working times
- Deep, large volume pours
- High six-hour strengths
- Coarse aggregate extension up to 100%
- Excellent freeze/thaw resistance
- High bond strength
- Pumpable
- Provides permanent concrete and equipment/machinery foundation repair
- Can apply grouts and coatings as early as 8 hours after placement
- Facilitates equipment rebuilds as early as 12 hours
- Outstanding corrosion resistance for protection and rehabilitation

USES

- Deep, large-volume repair of concrete structures and machinery foundations
- Concrete floor toppings and overlays
- Hot weather concrete repair
- Warm ambient temperature environments
- Boiler/furnace rooms
- Heavy industrial repairs and retrofits
- Bulk mixing/handling

PACKAGING AND YIELD

Five Star Structural Concrete[®] ES-60 is packaged in heavy-duty polyethylene lined bags or plastic pails and is available in 50 lb. (22.7 kg) units yielding approximately 0.42 cubic feet (11.9 liters) at maximum water, or 0.60 cubic feet (17.0 liters) with a 60% extension using 3/8" pea gravel. Five Star Structural Concrete[®] ES-60 is also available in 800 lb. (364 kg), 1000 lb. (454 kg) and 3000 lb. (1362 kg) bulk bags.

SHELF LIFE

One year (packaged in bags) or two years (packaged in pails) in original unopened packaging when stored in dry conditions; high relative humidity will reduce shelf life.

TYPICAL PROPERTIES AT 70-90°F (21-32°C)

Compressive Strength, ASTM C 109	
6 Hours	3,000 psi (20.7 MPa)
1 Day	4,500 psi (31.0 MPa)
7 Days	6,000 psi (41.4 MPa)
28 Days	7,700 psi (53.1 MPa)
Bond Strength, ASTM C 882	
1 Day	2,000 psi (13.8 MPa)
7 Days	2,500 psi (17.3 MPa)
Length Change, extended with pea gravel, ASTM C 157	
28 Days Wet	+0.05%
28 Days Dry	-0.09%
Thermal Coefficient of Expansion, ASTM C 531	
	6.0 x 10 ⁻⁶ in/in/°F (10.8 x 10 ⁻⁶ mm/mm/°C)
Scaling Resistance, ASTM C 672	
50 cycles	0
Chloride Ion Permeability, ASTM C 1202	
28 Days	Very Low (<1,000 Coulombs)
Working Time	
	60 minutes @ 90°F (32°C)
	90 minutes @ 70°F (21°C)

**The data shown above reflects typical results based on laboratory testing under controlled conditions. Reasonable variations from the data shown above may result. Test methods are modified where applicable.*

PLACEMENT GUIDELINES

- 1. SURFACE PREPARATION:** All horizontal and vertical concrete surfaces in contact with Five Star Structural Concrete® ES-60 shall be free of oil, grease, laitance, and other contaminants. All horizontal and vertical concrete surfaces must be clean, sound and rough to ensure a good bond. To maximize bond, concrete surfaces should be prepared by acceptable means to coarse aggregate exposure. Remove all oxidation from exposed reinforcing steel. A perimeter edge and minimum depth of 1/4 inch (6 mm) should be provided for a durable repair. Allow for 1/2 inch (12 mm) for more aggressive traffic. Featheredging is not desirable. Soak concrete surfaces prior to application with liberal quantities of potable water, leaving the concrete saturated and free of standing water, or use Five Star® Bonding Adhesive. Surfaces shall be conditioned to between 40°F and 95°F (4°C and 35°C) at time of placement.
- 2. FORMWORK:** Formwork shall be constructed of rigid non-absorbent materials, securely anchored, liquid-tight and strong enough to resist forces developed during placement. Areas where bond is not desired must be treated with form oil, paste wax or similar material. Joints may be necessary depending on pour dimensions. Any existing joints within the repair area should be maintained. Contact the Five Star Products' Engineering and Technical Service Center for further information.
- 3. MIXING:** Wet down mortar mixer (stationary barrel with moving blades) before using and drain excess water. A drill and paddle mixer is acceptable for single bag mixes. With the mixer running add approximately 80% of the pre-measured potable water (total water content is 2½ to 3 quarts potable water per 50 lb. unit) to the mixer. While mixing, slowly add Five Star Structural Concrete® ES-60 and mix to a uniform consistency for three to four minutes. Adjust consistency if necessary, but do not exceed maximum water content stated on the package or an amount that will cause segregation. Addition of coarse aggregate meeting ASTM C 33 should be used for pours greater than 2 inches (50 mm) in depth; add coarse aggregate before final water adjustment. For larger quantities, a ready-mix concrete truck may be used.
- 4. PLACEMENT PROCEDURES:** Whenever possible, place Five Star Structural Concrete® ES-60 full depth from one side of the repair to the other. To ensure optimal bond development, firmly work material into substrate. Placement should be continuous to prevent cold joints between pours. Finish as necessary. For pumping procedures, contact Five Star Products' Engineering and Technical Service Center.
SPECIAL CONDITIONS: For faster strength gain at cooler temperatures use Five Star Structural Concrete® or Five Star Structural Concrete® ES. Faster strength gain will occur when the Five Star Structural Concrete® ES-60, mixing water, and coarse aggregate have been conditioned to a higher temperature prior to placement. In high temperatures, Five Star Structural Concrete® ES-60 mix temperature should be kept as cool as possible, but not exceeding 95°F (35°C). For lower mix temperature, ice cold water may be used for mixing to help maintain sufficient working time.
- 5. POST-PLACEMENT PROCEDURES:** Wet cure as soon as materials reached final set (surface changes from dark to light), cover surface with clean plastic to retain moisture, or apply approved curing compound meeting water retention properties of ASTM C 309. At colder temperatures, final set will take notably longer and cure by covering with clean plastic or approved curing compound. If capping with grout or coating, cover surface with clean plastic to retain moisture until 30 - 60 minutes before placement. Five Star Structural Concrete® ES-60 shall be cured continuously for a minimum 30 minutes up to 48 hours depending on volume, depth, placement temperature, and application. Ponding and/or circulation will help dissipate heat from large pours when excessively warm.

NOTE: PRIOR TO APPLICATION, READ ALL PRODUCT PACKAGING THOROUGHLY. For more detailed placement procedures, refer to the Five Star® Design-A-Spec™ installation guidelines or call Five Star Products' Engineering and Technical Service Center at 1-800-243-2206.

CONSIDERATIONS

- Never exceed the maximum water content as stated on the package or add an amount that will cause segregation.
- Temperature of surfaces must be between 40°F and 95°F (4°C and 35°C) at time of placement.
- When capping Five Star Structural Concrete® ES-60 with either cement or epoxy grout, surface temperature shall have cooled down to 95°F (35°C) or within 10°F (6°C) of ambient temperature prior to grout placement.
- Cement/epoxy grouting and epoxy coatings may be placed as early as 8 hours after placement.
- When mixing from bulk bags, use of a metered mobile mixer is not recommended. Bulk bags should be mixed as full units. For bulk mixing guidelines, contact Five Star Products' Engineering and Technical Service Center at 1-800-243-2206.

CAUTION

Contains cementitious material and crystalline silica. International Agency for Research on Cancer has determined that there is sufficient evidence for the carcinogenicity of inhaled crystalline silica to humans. Take appropriate measures to avoid breathing dust. Avoid contact with eyes and contact with skin. In case of contact with eyes, immediately flush with plenty of water for at least 15 minutes. Immediately call a physician. Wash skin thoroughly after handling. Keep product out of reach of children. **PRIOR TO USE, REFER TO SAFETY DATA SHEET.**

SKU/PRODUCT CODE	DESCRIPTION	#UNITS/PALLET	UNIT SIZE
29800	Five Star Structural Concrete® ES-60	56	50 lb. (22.7 kg) Bag
29700	Five Star Structural Concrete® ES-60	36	50 lb. (22.7 kg) Pail
29104	Five Star Structural Concrete® ES-60	2	800 lb. (364 kg) Bulk Bag
29101	Five Star Structural Concrete® ES-60	2	1,000 lb. (454 kg) Bulk Bag
29103	Five Star Structural Concrete® ES-60	1	3,000 lb. (1,362 kg) Bulk Bag

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Specifications Subject to Change.

For most current version of datasheet, go to FiveStarProducts.com

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