



*You Build, We Protect!*

# HEGGEL® Fix 844

Early-Water-Tolerant Epoxy Based Repair Filler

**Description:**

**HEGGEL Fix 844** is a two-component, corrosion-protection epoxy-based repair filler formulated without heavy metals, benzyl alcohol, coal tar, anthracene oil, or plasticizers. It is developed for the durable structural restoration and repair of deteriorated industrial components. This single-layer system provides high mechanical strength combined with excellent corrosion protection performance. Its thixotropic properties allow reliable levelling of dimensional tolerances and stability of approximately 10 mm.

**Characteristics:**

- Easy mixing and application
- Highly impact and shock resistance
- Good sandability after curing
- High chemical resistance
- High mechanical strength
- High tolerance to early water exposure
- Very good adhesion to steel substrates
- No shrinkage due to plasticizer migration.
- Inert and non-hazardous after full cure
- High abrasion resistance
- VOC < 1%

**Application Areas:**

**HEGGEL Fix 844** is used for the permanent restoration and repair of damaged plant components, particularly for filling holes and pitting corrosion, levelling steel surfaces, and reprofiling uneven substrates. It is typically applied in thick layers using a trowel and is mainly intended for small areas, repairs, corners, edges, and penetrations.

**Chemical Resistance:**

- Industrial and marine environments
- Water, seawater, and brackish water
- Alkalis and lyes
- Oils, fats, lubricants, and fuels
- Non-oxidizing diluted acids
- Neutral salt solutions

As coating performance depends on service conditions, please consult HEGGEL for further details.

**Application Data:**

<b>Colour</b>	Silk grey (other colours are available on request) <b>Note:</b> Due to variations in raw materials and manufacturing processes, slight colour differences between batches may occur.		
<b>Mixing Ratio</b>	A : B = 7 : 1 (Parts by weight)		
<b>Consumption</b>	~ 1.7 kg/m <sup>2</sup> @ 1 mm DFT		
<b>Temperature</b>	<b>15 °C</b>	<b>23 °C</b>	<b>30 °C</b>
<b>Pot Life</b>	~ 60 min	~ 45 min	~ 30 min
<b>Curing Time (Mechanical Load)</b>	~ 32 hrs	~ 24 hrs	~ 16 hrs
<b>Curing Time (Chemical Load)</b>	7 days	5 days	3 days

**Note:** All above values are approximate and may be used as a guideline for specifications.

**Technical Data:**

Title	Standard	Value
<b>Solids Content</b>	-	~ 100% (volume)
<b>Density (Mix) @ 23 °C</b>	-	~ 1.7 g/cm <sup>3</sup>
<b>Viscosity (Mix) @ 23 °C</b>	-	Thixotropic
<b>Adhesion Strength</b>	DIN EN ISO 4624	> 10 MPa (cohesive failure)
<b>Shore D Hardness</b>	DIN EN ISO 868	80
<b>Elastic Modulus</b>	DIN EN ISO 527	~ 2850 MPa
<b>Tensile Strength</b>	DIN EN ISO 527	~ 25 MPa
<b>Compressive Strength</b>	DIN 197, Part 1	~ 100 MPa
<b>Elongation at Break</b>	DIN EN ISO 527	~ 1.40%
<b>Temperature Resistance</b>	-	Dry heat: up to 100 °C (continuous) up to 150 °C (short-term) Wet heat: up to 50 °C (continuous) up to 70 °C (short-term)

**Note:** The values stated are typical laboratory values and are intended for guidance only.

**Packaging:**

10 kg Pails (8.75 kg Base + 1.25 kg Hardener). Other pails are available on request.

**Storage:**

12 months minimum in unopened containers when maintained between 15 - 25 °C. Exposure to temperatures below 10 °C may lead to crystallization.

## 1. Surface Preparation

To prepare the steel surface for coating, ensure that the substrate is dry and completely free from mill scale, grease, oil, and any contaminants that may impair adhesion. Inspect the surface for invisible contaminants in accordance with DIN Report 28 before proceeding with the coating application. Remove all weld beads and grind weld seams and overlaps smooth in accordance with DIN EN 14879-1 to achieve a uniform surface.

For optimal adhesion, perform abrasive blast cleaning using hard, angular grit in accordance with DIN EN ISO 12944-4 and ISO 8501-1/-2, preparing the surface to cleanliness grade Sa 2½. The blasting process shall create a surface profile exceeding 50 µm, corresponding to profile class Medium (G) as defined in DIN EN ISO 8503-2.

If there is any doubt regarding surface cleanliness, test for soluble contaminants prior to coating application in accordance with EN ISO 8502-6 and EN ISO 8502-9.

## 2. Environmental Conditions

Before, during, and after surface preparation, application, and curing, ensure that the substrate temperature remains at least 3 °C above the dew point and within the range of 15 °C to 30 °C. The material temperature shall be kept between 15 °C and 25 °C prior to and during application. The relative humidity shall not exceed 75% at 15 °C and 85% at temperatures above 23 °C.

## 3. Application Tools

Trowel / Brush

## 4. Mixing

Before mixing, make sure that the temperature of all components is at least 15 °C. Stir each component thoroughly, then mix them in the correct ratio using a suitable low-speed electric mixer (300–400 rpm). Continue mixing for at least 3 minutes, or until a fully homogeneous mixture is achieved.

After initial mixing, transfer the material into a clean container and remix for at least 1 additional minute to ensure complete homogeneity. The product is supplied in pre-proportioned packaging units according to the required mixing ratio; therefore, only full units must be mixed and applied. Do not divide or partially combine components.

**Note:** Under no circumstances should the material be diluted.

## 5. Application

**HEGSEL Fix 844** is primarily intended for small areas, localized repairs, corners, edges, and penetrations. Depending on the extent of damage, defects such as imperfections, insufficient layer thicknesses, or pores must be sanded down to bare substrate or blasted to PSa 2½. The adjacent overlap areas should be sanded or blasted, cleaned of dust, and then coated with **HEGSEL Fix 844**.

Apply the material immediately after surface preparation to prevent contamination or flash rusting. Apply **HEGSEL Fix 844** evenly to the substrate using a trowel, pressing the material firmly

into the surface to ensure proper adhesion. After application, smooth and level the surface with a trowel or brush to achieve the desired finish.

Additional application steps may be required to achieve the specified final layer thickness.

Under conditions of outdoor weathering, **HEGSEL Fix 844** may be subject to surface chalking and discoloration. For projects with increased visual or aesthetic requirements, please consult HEGSEL technical support.

**Note:** Clean all tools immediately after application using HEGSEL Cleaners.

## 6. Safety Measures

Although **HEGSEL Fix 844** is (nearly) solvent-free, proper ventilation is required when applying in enclosed areas. Ensure air circulation during and after application until fully cured. Avoid inhaling vapors and wear appropriate protective clothing, gloves, eye/face protection, and suitable respiratory equipment. In case of skin contact, wash immediately with soap and water; if in contact with eyes, rinse thoroughly with water and seek medical advice. Do not eat, drink, or smoke during use, and keep away from ignition sources. The material safety data sheets of the individual components, the safety instructions on the packing (label) as well as the legal requirements for handling hazardous materials must be observed.

**HEGSEL Fix 844**; Revision No: 0.00 / Last Revision Date: 12.12.2025

All information contained herein is based on the current state of our knowledge and practical experience at the time of release. Therefore, please make sure that this is the latest edition of the Technical Data Sheet. All data are only intended as a guideline for informational purposes and do not constitute a legally-binding warranty of the suitability for a certain purpose of use, due to its dependence on site conditions and possible processing, use and applications. All information contained in this technical datasheet is subject to change without notice.

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