



Guide to the Repair of Architectural Terra Cotta

Once considered unreliable and temporary in nature, repair systems for terra cotta have become a mainstream component in historic restoration work. This evolution can be attributed to the development of effective, high quality specialty materials designed specifically for long-term compatibility with terra cotta substrates.

With a record of more than 40 years of successful performance on thousands of architectural Terra Cotta Restoration projects, Edison Coatings offers the most complete, time-proven, compatible terra cotta restoration systems available today. Edison's custom color and formulation capabilities provide the highest levels of aesthetic match and finish as well.

A completely integrated system, Edison's products include the following specialty materials designed specifically for use in terra cotta restoration:

- Composite Patching Mortars
- Casting Mortars
- Re-Profiling Mortars
- Bonding Adhesives
- Crack Repair Resins & Grouts
- Repointing & Rebuilding Mortars
- Coatings For Glaze Replication
- Coatings For Glaze Detail Replication

The following is a brief guide to terra cotta repair system options and preliminary selection criteria. It should be noted that proper investigation and correction of the causes underlying the observed deterioration is prerequisite to undertaking repairs, and repair plans and sequencing must include consideration of the significant quantities of liquid moisture often found within compromised terra cotta building wall systems.



STEP 1: Deep Repair

After proper surface preparation, repairs to spalls greater than 1/4" (6 mm) in depth are best achieved using **Custom System 45 TC** grade. A two-component cementitious system, **Custom System 45** provides higher bond strength, lower shrinkage, and more efficient stress relief than competitive systems. This allows installation of large and deep repairs without cracking, special curing regimens or distress to historic substrates. Low coefficient of thermal expansion ($<4 \times 10^{-6}$ in/in/ $^{\circ}$ F) assures long term thermal compatibility with fired clay substrates, even in areas subject to rapid, wide swings in ambient temperatures.



Figure 1: Replacement finial (right) 20 years after casting using Custom System 45 mixed with Restoration Latex RL-2.

The standard liquid component is **Restoration Latex RL-1** which allows non-sag application for vertical

and overhanging repairs. In cases involving very large and deep areas of loss, **Restoration Latex RL-2** (superplasticized) may be used with **Custom System 45 TC** to form and pour repairs in place or to cast replacement elements. **Restoration Latex RL-3** (Marine Grade) may be used for repairs subject to high constant moisture exposure, such as fountains and planters. In cases requiring higher levels of moisture and moisture vapor permeability, **Restoration Latex RL-4** (Air Entraining) may be used. For hot weather work at temperatures up to 120°F, **Restoration Latex RL-5** may be used to extend working times. **Restoration Latex RL-6** accelerates cure during cold weather, for work performed down to 40°F. **Restoration Latex RL-7** allows higher build application for vertical and overhanging repairs and provides extended carving time.

GRADE	DESCRIPTION	RECOMMENDED USES
RL-1	Non-Sag Grade	General Use: Vertical, Horizontal, Overhead
RL-2	Superplasticized	Formed and poured castings and repairs
RL-3	Marine/Immersion	Fountains, Planters, High Moisture
RL-4	High Permeability	Retaining walls, Ruined Masonry, for Highest Permeability
RL-5	High Temperature	For hot weather work up to 120°F (50°C)
RL-6	Low Temperature	For cold weather work down to 40°F (4°C)
RL-7	High-Build, Sculpting	Deeper overhanging repairs and extended sculpting time

STEP 2: Thin Section Repair

Terra cotta subjected to bulk moisture infiltration often develops thin glaze spalls, in which a section of terra cotta glaze and bisque surface delaminate from an otherwise sound element. Typically, section thickness is no more than 1/16" (1.5 mm).

After abating infiltration, unobtrusive repairs in depths up to 1/8" (3 mm) are achieved by using **Thin-Fill 55** Reprofilling Mortar. There is no **minimum** depth and the mortar is designed for easy sanding and/or polishing to achieve perfectly smooth surfaces, when required to replicate existing glazed terra cotta profiles. The product is also easily filed after initial set to produce fluted profiles, when required to match existing terra cotta.

NOTE: In terra cotta exhibiting high levels of efflorescence and/or moisture flow, bisque should be cut back a minimum of 1/2" (6 mm) in depth and patched with mechanically-keyed **Custom System 45 Type TC** prior to reprofiling with **Thin Fill 55**. Application of **Aquepoxy 250S-30 Primer** is also recommended before patching, in these cases.



Figure 2: Thin-Section glaze spalls are common in terra cotta subjected to bulk moisture infiltration.

A cement-based mortar with low coefficient of thermal expansion, high bond strength, low modulus for efficient stress relief, and positive moisture and moisture vapor permeability, **Thin Fill 55** facilitates achievement of excellent aesthetic finishes for repairs to architectural terra cotta. It is fully compatible with **Custom System 45**, and may be applied over deeper patches, when desired.

Thin Fill 55 can be color-matched to existing unglazed terra cotta as a final finish, or used in a standard formula prior color-matched glaze coating application. For translucent glazes, **Thin Fill** is matched to the bisque color.

STEP 3: Crack Repair

A variety of potential causes of cracking in terra cotta mandates that a variety of repair alternatives be made available. Crack repair details and material selections are best specified by a design professional experienced in the specific properties, assembly details and deterioration mechanisms of terra cotta. Crack width monitoring can help in determining any movement capacity required for the repair system.

The following systems are used in the repair of cracks in terra cotta:

□ **Thin Fill 55** is often used to repair cracks determined to be stationary, or non-working. The crack is typically cut open with a narrow blade on a Dremel tool to approximately 1/8" width x 1/4" depth, and is then filled with a matching **Thin Fill 55**.

□ **Flexi-Fill 530**, a 2-component flexibilized acrylate epoxy paste filler allows less invasive repairs with higher tensile strength and elongation, for cracks exhibiting some limited movement. A Dremel tool may be used to slightly open the face of the crack to a nominal 1/16" x 1/4" depth, and the narrow opening is then filled with the color-matched **Flexi-Fill 530** paste grade filler. At initial cure stage (typically 30 – 90 minutes) the product cures to a soft rubber which is easily trimmed with a razor or utility knife.



Figure 3 (left): **Pump-X53** was used to fill voids between terra cotta band courses and rubble masonry backup on this project in New York City. Figure 4 (right): Injection points are marked on an interior wall surface; **Pump-X53i** was injected through the back-up wall into the masonry exterior veneer to fill cracks and voids in the stonework.

□ **Pump-X53-Series** cement and lime-based injection mortars are also used in certain repair

situations. Although injection of cracks in hollow masonry units is impractical when using epoxy injection resins, cement and lime-based compositions are more compatible and can be used to fill voids and cracks without distress to the terra cotta. A variety of grades is available, including **Pump-X53 Masonry Grout** for filling of large voids and cracks (>1/4"), **Pump-X53i Microinjection Grout** for fine cracks down to 1/16" (1.5 mm), **Pump-X53iE Expanding Microinjection Grout** for filling of cracks where slight expansion of the grout is desired (+2%) and **Pump-X53iL Pozzolan-Lime Injection Grout** where softer, self-healing performance is desired.

STEP 4: Rebonding Masonry Units



Figure 5: Column base, before/after bonding with **Flexi-Weld 520T**.



Fractured terra cotta elements can often be salvaged and repaired rather than replaced. The use of **Flexi-Weld 520T** masonry adhesive permits cleanly broken pieces to be quickly and cleanly re-bonded, without creating a gap between the surfaces. When a

narrow gap between the pieces must be filled by the adhesive, use color-matched ***Flexi-Fill 530***.

Both two-component, 100% solids acrylate-epoxy adhesives can be used under a wide range of temperatures to quickly grab and re-bond all types of broken masonry elements. Variable mix ratio allows users to adjust working times and consistencies under varying working conditions.

STEP 5: Glaze Replication

Once the appropriate repairs have been made and the correct surface profiles restored, specialty coatings are generally used to replicate the color, reflectance and density of the original glaze. Although in some cases a color-matched repair mortar, top-coated with a clear finish, may provide the most visually compatible repair, use of a color-matched glaze replication coating generally provides the best match and better capacity to vary colors as needed from unit to unit. Several systems may be used:

□ ***Sil-Quathane 222*** is now the most commonly used glaze replication coating. A low VOC waterborne aliphatic polyurethane-silicone hybrid coating, it offers primerless adhesion to clean, existing glazed surfaces and can be provided in gloss, satin or flatted finishes.

□ ***Aquathane UA210 Type E*** is used to achieve the finest finishes, as it allows tight control of gloss level (from XFlat to High Gloss) and translucence (from Opaque to Clear). Clear topcoats may also be used to provide higher gloss and depth of finish. It is generally applied over ***240 Primer*** to assure tenacious adhesion to smooth, non-porous existing glaze surfaces.

□ ***Elastowall 351*** is an internally plasticized 100% acrylic coating that is used to both provide an aesthetic matte finish and to aid in exclusion of water from terra cotta exhibiting small working cracks. It offers a high rate of moisture vapor permeability, the ability to bond to less aggressively prepared surfaces and to a wide variety of existing materials. Luster can be imparted to ***Elastowall 351***

coatings by applying a clear top coat of ***Aquathane UA210 Type E***.

All products are offered in a wide range of standard colors, or can be matched to major manufacturers' color fan decks. Custom color matching service is also available, and is most frequently done when excellent matches to original materials are desired.



Figure 6: Application of Sil-Quathane 222 to a replacement unit cast with Custom System 45.

STEP 6: Glaze Detail Replication

A particular challenge in terra cotta restoration work is the replication of complex details frequently found in original glazes. These may include speckles, smears, mottling or multiple layers of different colors.

These special finishes can often be recreated using multiple applications of ***Aquathane UA210 Type E***, ***LiquiDirt 94*** and/or ***Sil-Quathane 222***, employing various faux finishing techniques.

In addition, ***AquaSpex 220*** may be used to provide speckles of specific size, concentration and color. ***AquaSpex 220*** incorporates color-matched flakes in a clear binder, permitting close control of speckle color, density and size.



*Figure 7: Terra Cotta fragment sits atop a precast panel base-coated with light grey ***Aquathane UA210 E*** and top-coated with ***AquaSpex 220***, incorporating 1500-micron Charcoal Grey flakes. The combination closely matches the original material.*

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