



Material Safety Data Sheet

(Essentially Similar to U.S. Department of Labor Suggested
Form For Hazard Communication Compliance)

I. Product Identification

Product Type - ALL-STATE COPPER BASED BRAZING ALLOYS

Manufacturer - THE ESAB GROUP, INC.

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Product Description: These copper based brazing alloys consist of bare rods and of flux coated (FC) rods cut or cast in standard lengths. No. 11 is intended for joining; No. 13 for surfacing and build-up of many ferrous and non-ferrous materials. Not recommended for "white metals." Bare rods are used with a brazing compatible flux.

APPROXIMATE COMPOSITION OF COPPER BRAZING ALLOYS (Wt. %)

All-State Product Trade Name	All-State® No. 11 Ⓢ	All-State® No. 11FC Ⓢ	All-State® No. 13 Ⓢ	All-State® No. 13FC Ⓢ
Borax Glass, Anhydrous	--	X	--	X
Boric Acid	--	X	--	X
Copper	46-50	40-48	40-55	35-50
Iron	1	1	1	1
Manganese	1.5	1.5	1.5	1.5
Nickel	9-11	5-10	10-15	7-11
Phosphorous	0.2-0.3	0.2-0.3	0.2-0.3	0.2-0.3
Silicon	X	X	X	X
Zinc	38-44	35-40	35-45	30-40

NOTE: X indicates material is present.

Ⓢ See Note 3 in Section VI

THE ESAB GROUP requests the users of these products to study this Material Safety Data Sheet (MSDS) and the product labels and become fully aware of the product hazards and safety information. To promote the safe use of these products a user should (1) notify and train its employees, agents and contractors concerning the information on this MSDS and any product hazards and safety information, (2) furnish this same information to each of its customers for these products, and (3) request that such customers notify and train their employees and customers, for these products, of the same product hazards and safety information.

II. Hazardous Ingredients

IMPORTANT: This section covers the materials from which this product is manufactured. The fumes and gases produced during normal use of these products are covered in Section V. The term **HAZARDOUS** should be interpreted as a term required and defined by Laws, Statutes, or Regulations, and does not necessarily imply the existence of any hazard when the products are used as directed by **THE ESAB GROUP**.

Material	(CAS No.)	SARA	ACGIH TLV (1998)		OSHA - PEL (1993)	
			TWA (mg/m ³)		TWA (mg/m ³)	STEL (mg/m ³)
Borax Glass, Anhydrous	1330-43-4		1		--	--
Boric Acid	10043-35-3		--		--	--
Copper	7440-50-8	*	0.2 (Fume) 1 (Dust as Cu)		0.1 (Fume as Cu) 1 (Dust as Cu)	--
Iron	7439-89-6		5 (Oxide as Fe)		10 (Oxide as Fe)	--
Manganese	7439-96-5	*	0.2		1	3 C
Nickel	7440-02-0	*	1.5 (Elemental) 0.2 (Insoluble Inorganic) 0.1 (Soluble Inorganic)		1 (Elemental) 1 (Insoluble Inorganic) 1 (Soluble Inorganic)	--
Phosphorus	7723-14-0	*	0.1		0.1	--
Silicon	7440-21-3		10 (Total Dust)		15 (Total Dust) 5 (Respirable)	--
Zinc	1314-13-2	*	5 (Oxide Fume) 10 (STEL)		5 (Oxide Fume)	10

NOTE: In the ingredients' table, an asterisk (*) after the CAS number indicates a toxic chemical subject to the reporting requirements of Section 313 of the Emergency Planning and Community Right-To-Know Act of 1986 (SARA) and 40 CFR Part 372.

Some of these products may not contain all of the materials listed. For details of composition, refer to the COMPOSITION TABLE in Section I.

In the table above, "C" indicates "Ceiling Limit."

III. Physical Data

As shipped, these products are nonflammable, nonexplosive, nonreactive, and nonhazardous.

Physical State: GAS () LIQUID () SOLID (X)

Odor And Appearance: Bare and flux coated copper colored rods, no odor.

IV. Fire & Explosion Hazard

Flammable/Explosive: NO (X) YES ()

Under What Conditions? Only the packaging for this product will burn.

Extinguishing Media: This product will not burn. However, welding arcs and sparks can ignite combustible and flammable materials. Use the extinguishing media recommended for the burning materials and fire situation. See ANSI Z49.1 "Safety in Welding and Cutting" and "Safe Practices" Code: SP, published by the American Welding Society, P. O. Box 351040, Miami, FL 33135, and NFPA 512 "Cutting and Welding Processes", published by the National Fire Protection Association, Batterymarch Park, Quincy, MA 02269 for additional fire prevention and protection information.

V. Reactivity Data

Stability: Stable (X) Unstable () Polymerization will not occur.

Incompatible Products: Strong acids, strong oxidizers, some halogenated compounds.

Hazardous decomposition products: Brazing fumes and gases cannot be classified simply. The composition and quantity of both are dependent upon the material being worked, the process, procedures, and consumables used. Other conditions which also influence the composition and quantity of the fumes and gases to which workers may be exposed include: coatings on the material being worked (such as paint, plating or galvanizing), the number of welding operations and the volume of the work area, the quality and amount of ventilation, the position of the worker's head with respect to the fume plume, as well as the presence of contaminants in the atmosphere (such as chlorinated hydrocarbon vapors from cleaning or painting activities). When the materials are consumed, the fume and gas decomposition products generated are different in percent and form from the ingredients listed in Section II. Decomposition products of normal operation include those originating from the volatilization, reaction, or oxidation of the ingredients, plus those from the material being worked and the coatings etc. noted above.

Reasonably expected decomposition products from normal use of these products include a complex of the oxides of the materials listed in Section II, as well as carbon monoxide, carbon dioxide, ozone and nitrogen oxides (refer to "Characterization of Arc Welding Fume" available from the American Welding Society). THE FUME LIMIT FOR COPPER, NICKEL, AND MANGANESE MAY BE REACHED BEFORE THE GENERAL LIMIT FOR WELDING FUMES OF 5 mg/m³ IS REACHED. MONITOR FUMES FOR COPPER, NICKEL, AND MANGANESE LEVELS. The only way to determine the true identity of the decomposition products is by sampling and analysis. The composition and quantity of the fumes and gases to which a worker may be overexposed can be determined from a sample obtained from inside the welder's helmet, if worn, or in the workers breathing zone. See ANSI/AWS F1.1 "Method for Sampling Airborne Particles Generated by Welding and Allied Processes," available from the American Welding Society.

VI. Physical And Health Hazard Data

Brazing may create one or more of the following health or physical hazards. Fumes and gases can be dangerous to your health. Arc rays can injure eyes and burn skin. Noise can damage hearing. Brazing alloys are frequently used with a fluoride type flux. If applicable, flux fume should be considered in evaluation of hazards.

Route Of Overexposure: The primary route of entry of the decomposition products is by inhalation. Skin contact, eye contact, and ingestion are possible. Absorption by skin contact is unlikely. When these products are used as recommended by THE ESAB GROUP, and ventilation maintains exposure to the decomposition products below the limits recommended in this section, overexposure is unlikely.

Effects Of Acute (Short Term) Overexposure to the gases, fumes and dusts may include irritation of the eyes, lungs, nose and throat. Some toxic gases associated with brazing may cause pulmonary edema, asphyxiation, and death. Acute overexposure may include signs and symptoms such as watery eyes, nose and throat irritation, headache, dizziness, difficulty in breathing, frequent coughing, or chest pain. The presence of copper and zinc in fume can cause metal fume fever. Short term symptoms may include a metallic taste in the mouth, dryness or irritation of the throat followed by coughing, shortness of breath, nausea, fever, body ache, and chills. The presence of nickel compounds in fume can cause metallic taste, nausea, tightness of the chest, fever, and allergic reaction.

Pre-Existing Medical Conditions Aggravated By Overexposure: Individuals with allergies or impaired respiratory function may have symptoms worsened by exposure to brazing fumes. However, such reaction cannot be predicted due to the variation in composition and quantity of the decomposition products.

Effects of chronic (long-term) overexposure to air contaminants may lead to their accumulation in the lungs, a condition which may be seen as dense areas on chest X-rays. The severity of the change is proportional to the length of the exposure. The changes seen are not necessarily associated with symptoms or signs of reduced lung function or disease. In addition, the changes on X-rays may be caused by non-work factors such as smoking, etc. Inhalation of too much iron oxide fume over a long time can cause siderosis, sometimes called "iron pigmentation" of the lung. It can be seen on a chest x-ray but causes little or no disability. Long term exposure to brazing fume, gases or dust may contribute to pulmonary irritation or pneumoconiosis. Nickel (in some products) is considered carcinogenic Long term overexposure to nickel fumes may also cause pulmonary fibrosis and edema. Overexposure to manganese compounds may affect the central nervous system, symptoms of which are languor, sleepiness, muscular weakness, emotional disturbances and spastic gait. The effect of manganese on the central nervous system is irreversible. Copper poisoning has been reported in the literature from exposure to high levels of copper. Liver damage can occur due to copper accumulation in the liver; the damage is characterized by cell destruction and cirrhosis. High levels of copper may cause central nervous system damage characterized by nerve fiber separation and cerebral degeneration. Overexposure to phosphorus may cause brittleness of the long bones and necrosis of the mandible, termed "phossy jaw"

Exposure limits for the ingredients are listed in Section II. The ACGIH and the 1989 OSHA TWA for welding fume is 5 mg/m³. At times the limit for a particular hazardous chemical is reached before the limit for welding fumes. TLV-TWAs should be used as a guide in the control of health hazards and not as fine lines between safe and excessive concentrations. As noted in Section V, the brazing fume is a mixture of many components. Therefore, a statutory computation of the *equivalent exposure* is required. The *equivalent exposure* value for the brazing fume mixture shall always be less than one. When these products are used as recommended by **THE ESAB GROUP**, and the preventive measures taught in this MSDS are followed, overexposure to hazardous substances will not occur.

Emergency First Aid Measures: In case of emergency, call for medical aid. Employ first aid technique recommended by the Red Cross. **IF BREATHING IS DIFFICULT**, give oxygen and call for a physician. **FOR ELECTRIC SHOCK**, disconnect and turn off the power. If not breathing, begin artificial respiration, preferably mouth-to-mouth. If no detectable pulse, begin Cardio Pulmonary Resuscitation (CPR). Immediately call a physician. **FOR ARC BURN**, apply cold, clean compresses and call a physician.

Carcinogenic Assessment (NTP Annual Report, IARC Monographs, Other): Nickel must be considered possible carcinogens under OSHA (29 CFR 1910.1200). IARC has indicated Nickel and certain of their compounds are probably carcinogenic for humans, but the compounds cannot be specified precisely. Their conclusions were drawn from operations different from thermal spraying. Regardless, exposure level must be kept below those levels specified in Section II.

⊗ **WARNING:** This product contains or produces a chemical known to the State of California to cause cancer and birth defects (or other reproductive harm). (California Health & Safety Code §25249.5 et seq.)

VII. Precautions for Safe Handling and Use/Applicable Control Measures

Read and understand the manufacturer's instructions and the precautionary label on this product. See American National Standard Z-49.1, "Safety in Welding and Cutting," published by the American Welding Society, P. O. Box 351040, Miami, FL 33135 and OSHA Publication 2206 (29 C.F.R. 1910), U.S. Government Printing Office, Superintendent of Documents, P.O. Box 371954, Pittsburgh, PA 15250-7954 for more detail on many of the following:

Ventilation: Use enough ventilation, local exhaust at the arc, or both, to keep the exposure within legal limits. In the worker's breathing zone and the general area, fumes and gases must be kept below the TLVs and the *equivalent exposure* must compute to less than one. Train the welder to keep his head out of the fumes.

Respiratory Protection: Use respirable fume respirator or air supplied respirator when welding in confined space or where local exhaust or ventilation does not keep exposure below TLVs.

Eye Protection: Wear helmet or use face shield with filter lens. As a rule of thumb, start with a shade which is too dark to see the weld zone. Then go to the next lighter shade which gives sufficient view of the weld zone. Provide protective screens and flash goggles, if necessary, to shield others.

Protective Clothing: Wear head, hand, and body protection which help to prevent injury from radiation, sparks and electrical shock. See ANSI Z-49.1. At a minimum, this includes welder's gloves and a protective face shield and may include arm protectors, aprons, hats, shoulder protection, as well as dark substantial clothing. Train the welder not to touch live electrical parts and to insulate himself from work and ground.

Storage: Store in a cool, dry location. Storage in an atmosphere that is wet, moist or highly humid may lead to corrosion of these products.

Procedure for Cleanup of Spills or Leaks: NOT APPLICABLE

Waste Disposal Method: Prevent waste from contaminating surrounding environment. Discard any product, residue, disposable container, or liner in an environmentally acceptable manner, in full compliance with Federal, State and Local regulations.

The opinions expressed in this MSDS are those of qualified experts within **THE ESAB GROUP**. We believe that the information contained herein is current as of the date of this MSDS. Since the use of this information and these opinions and the conditions of use of these products are not within the control of **THE ESAB GROUP**, it is the user's obligation to determine the conditions of safe use of these products.