



Material Safety Data Sheet

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

Hazard Ratings
4 = Extreme
3 = High
2 = Moderate
1 = Slight
0 = Insignificant

I. Product Identification

Product Type - SUBMERGED ARC WELDING FLUXES

Manufacturer - THE ESAB GROUP, INC. **Telephone No.** - 1-717-637-8911
1-800-933-7070

Website: www.esabna.com

Address - 801 Wilson Avenue, P. O. Box 517 **Emergency No.** - 1-717-637-8911
(CHEMTREC) 1-800-424-9300
Hanover, PA 17331

APPROXIMATE FLUX COMPOSITIONS (Weight %)

Fused Grades ❶ *	MnO	Al ₂ O ₃	CaO	FeO	Fluorides	MgO	SiO ₂	TiO ₂	ZrO ₂
OK Flux									
20	--	X	X	X	X	X	X	--	--
50	40	X	X	X	X	--	X	--	--
55	45	X	--	X	X	--	X	X	--
80	8	X	X	X	X	X	X	--	--
852	--	X	X	--	X	--	X	--	X

Bonded Grades ❷ *	Mn	MnO	Al ₂ O ₃	SiO ₂	CaO	MgO	TiO ₂	ZrO ₂	Si Alloys	Silicate Binder	Fluorides
OK Flux											
231	<1	12	X	X	--	--	X	--	X	X	X
281	2	10	X	X	X	X	X	X	X	X	X
282	<1	15	X	X	--	--	X	X	X	X	X
350	3	15	--	X	--	X	X	--	X	X	X
350M	3	21	--	X	--	X	--	--	X	X	X
429	<1	10	X	X	--	X	--	--	X	X	X
601	<1	--	X	X	--	X	--	--	X	X	X

Note: X indicates material is present
* A5.17 and A5.23 Specifications

❶ See Note in Section VI
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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 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		OSHA - PEL	
			TWA (mg/m ³)		TWA (mg/m ³)	STEL (mg/m ³)
Aluminum Oxide (Al ₂ O ₃)	(1344-28-1)		10		5 (Respirable)	--
Calcium Oxide (CaO)	(1305-78-8)		2		5	--
Fluorspar (CaF ₂)	(7789-75-5)		2.5 (as F)		2.5 (as F)	--
Iron Oxides (Fe ₂ O ₃)	(7439-89-6)		5 (Oxide Fume)		10 (Total Particulate)	--
Magnesium Oxide (MgO)	(1309-48-4)		10 (Fume)		15 (Fume, Total Particulate)	--
Manganese (Mn)	(7439-96-5)	*	0.2 (Fume)	C 5 (STEL)	1 (Fume)	3
Manganese Oxide (MnO)	(1344-43-0)	*	0.2		C5	--
Silica, Use Quartz Formula (SiO ₂)	(14808-60-7)		0.1		0.05 (Respirable Dust)	--
Silicate Binder (H ₂ O ₃ Si 2Na) & (1312-76-1) (H ₂ O ₃ Si 2K)	(1344-09-8)		10		5 (Respirable)	--
Silicon (Si)	(7440-21-3)		10 (Dust)		5 (Respirable)	--
Sodium Aluminum Fluoride (F ₆ Si 2Na)	(15096-52-3)		2.5 (as F)		2.5 (as F)	--
Titanium Dioxide (TiO ₂)	(13463-67-7)		10 (Dust)		5 (Respirable)	--
Zirconium Compounds	(7440-67-7)		5 (as Zr)	10 (STEL)	5 (as Zr)	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, non-explosive, non-reactive, and non-hazardous.

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

Odor and Appearance: Fused Fluxes are granulated glass-like particles. Odorless.

Bonded fluxes are agglomerated mineral and alloy particles. Odorless.

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 51B "Standard for Fire Prevention During Welding, Cutting, and Other Hot Work," 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: None currently known.

Hazardous decomposition products: Welding 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 and fluorides of the materials listed in Section II, as well as carbon monoxide, carbon dioxide, and nitrogen oxides (refer to "Characterization of Arc Welding Fume" available from the American Welding Society). THE TLV FOR MANGANESE (0.2 mg/m³) MAY BE REACHED BEFORE THE GENERAL LIMIT FOR WELDING FUMES OF 5 mg/m³ IS REACHED. 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 F1.5, "Methods for Sampling and Analyzing Gases from Welding and Allied Processes," and 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

Electric arc working may create one or more of the following health or physical hazards. Fumes and gases can be dangerous to your health. Electric shock can kill you. Arc rays can injure eyes and burn skin. Noise can damage hearing. An additional detailed description of the Health and Physical Hazards and their consequences may be found in ESAB's publications F52-529 "Precautions and Safe Practices for Electric Welding and Cutting" and 17982 "Precautions and Safe Practices for Gas Welding, Cutting and Heating." You may obtain copies from your local supplier or by writing to the address in Section I.

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 welding 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. Dust generated from pouring or otherwise handling the flux may also cause irritation of the eyes, lungs, nose and throat. Ingestion of barium oxide can result in severe pain, vomiting, paralysis, and death.

Pre-existing Medical Conditions Aggravated by Overexposure: Individuals with allergies or impaired respiratory function may have symptoms worsened by exposure to welding 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. Chronic fluoride absorption can cause sclerosis of the bones and mottled teeth. Overexposure to manganese compounds can affect the central nervous system, symptoms of which are languor, sleepiness, muscular weakness, emotional disturbances, and spastic gait. The effect of manganese on the nervous system is irreversible. Overexposure to respirable crystalline silica may result in silicosis, a disabling lung disease.

Exposure limits for the ingredients are listed in Section II. The 1989 OSHA TWA for welding fume is 5 mg/m³. 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 welding fume is a mixture of many components. Therefore, a statutory computation of the equivalent exposure is required. The equivalent exposure value for the welding 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): Respirable crystalline silica, which may be in bonded fluxes, must be considered a possible carcinogen under OSHA (29CFR1910.1200). Exposure level must be kept below those levels specified in Section II.

- ⓘ **WARNING:** This product, when used for welding or cutting, produces fumes or gases which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health & Safety Code §25249.5 et seq.)
- ⓘ **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 the TLVs.

Eye Protection: Wear correct eye protection such as safety glasses and eye shields for protection from sparks, spatter and radiation.

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.

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.