

SAFETY DATA SHEET

MAY BE USED TO COMPLY WITH OSHA'S HAZARD COMMUNICATION STANDARD, 29 CFR 1910.1200 AND SUPERFUND AMENDMENTS AND REAUTHORIZATION ACT (SARA) OF 1986 PUBLIC LAW 99-499. STANDARD SHOULD BE CONSULTED FOR SPECIFIC REQUIREMENTS.

SECTION 1: PRODUCT AND COMPANY IDENTIFICATION

NAME OF PRODUCT: SILWELD 1618 PA
SYNONYMS: Eutectic 1618 PA, Eutectic 1618, SilWeld 1618
PRODUCT CODES: XF1618-227G, XF1618-454G, XF1618-907G

**MANUFACTURER/
SUPPLIER:** EUTECTIC CORPORATION
N94 W14355 GARWIN MACE DRIVE
MENOMONEE FALLS, WI 53051 USA

TELEPHONE NUMBER (262) 532-4677
FAX NUMBER: (262) 255-5542
EUTECTIC WEBSITE: www.eutectic.com

PRODUCT USE: Paste Brazing Alloy

SECTION 2: HAZARDS IDENTIFICATION

EMERGENCY OVERVIEW: Chemically stable and inert. Does not pose a fire hazard as shipped. **Non-Flammable:** Flames used for brazing can ignite combustibles. Refer to American National Standard Z49.1 for fire prevention during welding. These products as shipped are non-hazardous, nonflammable, non-explosive, and non-reactive. In case of fire, Use NIOSH/MSHA self contained breathing apparatus.

ROUTES OF ENTRY: Primary route of entry is the respiratory system. Other possible routes are eyes, ingestion, and/or skin contact.

POTENTIAL HEALTH EFFECTS:

EYES: May cause eye damage.
SKIN: Spatter and flames from brazing may cause burns. Flux may cause skin burns.
INGESTION: Danger of serious damage to health if swallowed. Toxic.
INHALATION: Danger of serious damage to health by prolonged exposure through inhalation.

ACUTE HEALTH HAZARDS: see Section 11

CHRONIC HEALTH HAZARDS: see Section 11

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

WARNING: avoid breathing welding fumes and gases; they may dangerous to your health. Always use adequate ventilation and use appropriate personal protection equipment.

CARCINOGENICITY

WELDING FUMES (not otherwise specified) are considered to be carcinogenic defined with no further categorization by NIOSH and IARC.

Package Labeling:

Although this product does not require a hazard warning label in all countries, we recommend that the safety advice should be observed:

Pictogram: GHS05 GHS06 GHS08



Contains: Potassium Bifluoride

Hazard Statements:

- H301 Toxic if swallowed
- H314 Causes severe skin burns and eye damage
- H317 May cause an allergic skin reaction

Precautionary Statements:

- P285 In case of inadequate ventilation wear respiratory protection.
- P314 Get medical advice/attention if you feel unwell.
- P280 Wear protective gloves/protective clothing/eye protection/face protection.
- P202 Do not handle until all safety precautions have been read and understood.
- P260 Do not breathe dust/fume/gas/mist/vapors/spray.
- P501 Dispose of contents/container to waste treatment facility in accordance with local and national regulations.

SECTION 2 NOTES: Before using this product, contact your doctor to determine if exposure to product or use of this product will aggravate your medical conditions. Spatter and flames from brazing may cause burns and start fires.

SECTION 3: COMPOSITION/INFORMATION ON INGREDIENTS

IMPORTANT: This section covers the materials from which these products are manufactured. Any of the chemicals or compounds subject to reporting under Title III, in Section 313, of the Superfund Amendments and Reauthorization Act (SARA) are marked by the symbol #.

<u>INGREDIENTS</u>	<u>CAS NUMBER</u>	<u>Exposure Limit (mg/m³)</u>		<u>Percent Ingredients (by weight)</u>
		<u>OSHA PEL</u>	<u>ACGIH-TLV</u>	
Silver #	7440-22-4	0.01	0.1	30 – 60
Copper #	7440-50-8	0.1 (as fume)	0.2 (as fume)	10 – 30
Zinc #	7440-66-6	5 (as fume)	5 (as fume)	10 – 30
Potassium Bifluoride	7789-29-9	2.5 (as F)	2.5 (as F)	10 – 30
Tin	7440-31-5	2	2	3 – 7
Potassium Fluoroborate	14075-53-7	2.5 (as F)	2.5 (as F)	3 – 7
Potassium Pentaborate Tetrahydrate	12229-13-9	Not listed	Not listed	3 – 7
Potassium Tetraborate Tetrahydrate	12045-78-2	Not listed	Not listed	1 – 5
Potassium Silicofluoride	16871-90-2	2.5 (as F)	2.5 (as F)	0.1 – 1

CAS / EINECS NUMBER / HAZARD CLASSIFICATION FOR ABOVE INGREDIENTS

INGREDIENTS	CAS NUMBER	EINECS NUMBER	Hazard Classification per ECD 67/548/EEC
Silver #	7440-22-4	231-131-3	No
Copper #	7440-50-8	231-159-6	No
Zinc #	7440-66-6	231-175-3	No (Zn in solid article form, not powder form)
Potassium Bifluoride	7789-29-9	232-156-2	C ≥ 10% T, R25-34
Tin	7440-31-5	231-141-8	No
Potassium Fluoroborate	14075-53-7	237-928-2	No
Potassium Pentaborate Tetrahydrate	12229-13-9	none	Not listed
Potassium Tetraborate Tetrahydrate	12045-78-2	none	Not listed
Potassium Silicofluoride	16871-90-2	240-896-2	No (C < 1 %)

SECTION 3 NOTES: Exposure limits are subject to change. Contact ACGIH and OSHA for current values. See Section 16 for European Council Directive 67/548/EEC R-phrases

SECTION 4: FIRST AID MEASURES

EMERGENCY & FIRST AID PROCEDURES: Call for medical aid and inform them of the ingredients from Section 3. Employ first aid techniques recommended by The American Red Cross.

EYES: Flush with a large amount of fresh water for at least 15 minutes. Get medical attention.

SKIN: Wash affected area with soap and water to remove dust or particles. If rash develops, see a physician. Get medical attention for irritations that persist.

INGESTION: Seek medical attention immediately.

INHALATION: Remove to fresh air. If breathing is difficult administer oxygen. If breathing has stopped, begin artificial respiration and obtain medical assistance immediately.

GENERAL: Move to fresh air and call for medical aid.

SECTION 4 NOTES: PHYSICIANS OR FIRST AID PROVIDERS: See Section 3 for ingredients.

SECTION 5: FIRE FIGHTING MEASURES

Non-Flammable These products as shipped are non-hazardous, nonflammable, non-explosive, and non-reactive. In case of fire, Use NIOSH/MSHA self contained breathing apparatus.

NFPA HAZARD CLASSIFICATION:

Health: 2 Flammability: 0 Reactivity: 0

Other: In case of fire, Use NIOSH/MSHA self contained breathing apparatus.

HMIS HAZARD CLASSIFICATION:

Health: 2 Flammability: 0 Reactivity: 0

Protection: In case of fire, Use NIOSH/MSHA self contained breathing apparatus.

EXTINGUISHING MEDIA: water, dry chemical extinguisher, CO₂

SPECIAL FIRE FIGHTING PROCEDURES: Low pressure extinguisher. In case of fire, Use NIOSH/MSHA self contained breathing apparatus.

UNUSUAL FIRE AND EXPLOSION HAZARDS: None

HAZARDOUS DECOMPOSITION PRODUCTS: Thermal decomposition may produce smoke and fumes of: ZnO (zinc) and CuO (copper).

SECTION 5 NOTES: None

SECTION 6: ACCIDENTAL RELEASE MEASURES

ACCIDENTAL RELEASE MEASURES: Shovel into a suitable container for proper disposal.

PERSONAL PRECAUTIONS: Breathing apparatus (particle filter) if a dust is formed.

ENVIRONMENTAL PRECAUTIONS: See Section 12 and 13

SECTION 6 NOTES: None

SECTION 7: HANDLING AND STORAGE

HANDLING: Avoid exposure to dust, do not ingest and avoid contact with eyes. Some individuals can develop an allergic reaction to certain materials. Do not breathe dust. Do not eat, drink, or smoke when using this product. Wash thoroughly after using this product.

STORAGE: Keep material sealed before use. After using, keep remaining product sealed and dry in original (labeled) packaging.

SECTION 7 NOTES: none

SECTION 8: EXPOSURE CONTROLS / PERSONAL PROTECTION



Read and understand the manufacturer's instructions and precautionary label on this product.

ENGINEERING CONTROLS: Proper ventilation **must** be maintained.

VENTILATION: Use enough ventilation, local exhaust at the spray area, or both, to keep the fumes and gases below the TLV's in the workers breathing and the general area. Train the worker to keep his head out of the fumes. Monitor fume levels and do not exceed permissible exposure limits or values.

RESPIRATORY PROTECTION: Do NOT breathe fumes. Use respirable fume respirator or air supplied respirator when brazing in a confined space or where local exhaust or ventilation does not keep exposure below the TLV's.

EYE PROTECTION: Wear safety glasses with side shields, faceshield, and/or goggles to protect against airborne dust.

PROTECTIVE CLOTHING: Wear gloves when using or prolonged contact with skin or repeated contact with skin is likely. Wear hand and body protection to prevent injury. See ANSI Z49.1.

SKIN PROTECTION: Individuals having sensitive skin may find it beneficial to use a barrier cream or moisturizer when excessive or prolonged contact with skin is likely.

WORK HYGIENIC PRACTICES: Professionally wash contaminated clothing before re-use. Food and drink should not be consumed or tobacco products used, nor cosmetics applied in area where metal exposures are possible.

EXPOSURE GUIDELINES: Use industrial hygiene monitoring equipment to ensure that exposure does not exceed applicable national exposure limits.

OTHER PROTECTIVE EQUIPMENT: Full protective equipment normally used in soldering / brazing operation so as to prevent any contact. Review operations to avoid contact with hazardous gas, liquid, or solid. See also:

29CFR 1910.132 - 29 CFR 1910.140 Personal Protective Equipment
29 CFR 1910.251 - 29 CFR 1910.257 Welding, Cutting and Brazing

EFFECTS OF OVEREXPOSURE - brazing may create one or more of the following health hazards:

FUMES AND GASES can be dangerous to your health.

PRIMARY ROUTES OF ENTRY is the respiratory system. Other possible routes are eyes, ingestion, and/or skin contact.

PREEXISTING respiratory or allergic conditions may be aggravated in some individuals (i.e. asthma, emphysema).

Brazing fumes cannot be classified simply. The composition and quantity of both are dependent upon the metal being brazed, the process, procedure, and the rod 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 metal being brazed (such as paint, plating, or galvanizing), the volume of the work area, the quality and the amount of ventilation, 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 and degreasing activities).

When the material is consumed, fume and gas decomposition products generated are different in percent and form from the ingredients listed in Section 3. Fume and decomposition products, not the ingredients in the rod, are important. Decomposition products include those originating from the volatilization, reaction, or oxidation of materials in Section 3, plus those from the base metal and coating, etc., as noted above. These components are virtually always present as complex oxides and not as metals (Characterization of Arc Welding Fume: American Welding Society). Reasonably expected fume constituents of the fume could include: complex oxides of copper, silver, and zinc. The table below lists reasonably expected fumes that may be generated:

<u>SUBSTANCE</u>	<u>CAS NUMBER</u>	<u>Exposure Limit (mg/m³)</u>	
		<u>OSHA PEL</u>	<u>ACGIH-TLV</u>
Copper # (as Cu)	7440-50-8	0.1 (as fume)	0.2 (as fume)
Silver #	7440-22-4	0.01	0.1

Gaseous reaction products may include carbon monoxide and carbon dioxide. Reasonably expected fume constituents would include fluorides (in flux coated brazing rods) and complex oxides of zinc and boron oxide, which is hazardous. Gaseous reaction products may include carbon monoxide and carbon dioxide. Monitor fume levels.

SECTION 8 NOTES: Exposure limits are subject to change. Contact ACGIH, OSHA, NIOSH, and IARC for current values.

SECTION 9: PHYSICAL AND CHEMICAL PROPERTIES

Appearance: grey paste, no odor.

Changes in the physical state ~ 1145 – 1205°F (620 - 650°C)

Flash point: n.a.

pH-Value: n.a.

Boiling point: n.a.

SECTION 9 NOTES: None

SECTION 10: STABILITY AND REACTIVITY

GENERAL: These items are only intended for brazing application.

STABILITY: Product is chemically stable and non-reactive.

CONDITIONS TO AVOID: Keep product away from heat and moisture.

MATERIALS TO AVOID: Non-reactive.

HAZARDOUS POLYMERIZATION: Will not occur.

REACTIVITY: None.

HAZARDOUS DECOMPOSITION OR BY-PRODUCTS: Fumes can be dangerous to your health. See Section 11

SECTION 10 NOTES: In other countries the exposure limits listed in Section 3 may be different and the appropriate country standards should be used.

SECTION 11: TOXICOLOGICAL INFORMATION

Threshold Limit Value: The **ACGIH** recommended general limit for welding fume NOS (not otherwise specified) is 5 mg/m³. The **ACGIH 1999** preface states: "The **TLV-TWA** should be used as guides in the control of health hazards and should not be used as firm lines between safe and dangerous concentrations." See Section 8 for specific fume constituents that may modify the **TLV**. Brazing/welding vapors and fumes from brazing/welding may cause metal fume fever. Symptoms can appear 4 to 12 hours after (headache, dizziness, dryness, cough, nausea and fever).

ACUTE TOXICITY: SHORT TERM (ACUTE) OVEREXPOSURE FUMES AND GASES can be dangerous to your health. Primary routes of entry are the respiratory system, eyes, ingestion, and/or skin. Preexisting respiratory or allergic conditions may be aggravated in some individuals. Individuals with Wilson's Disease are at increased risk of **COPPER** poisoning. Overexposure to fumes may result in discomfort such as dizziness, nausea, or dryness or irritation of nose, throat, or eyes. **EYE CONTACT** causes irritation and may cause burns. **SKIN CONTACT** may cause irritation and possibly fluoride burns which may not be immediately painful or evident, especially on prolonged contact. This material may be absorbed through the skin resulting in systemic poisoning. Symptoms of poisoning are similar to those that occur with ingestion. **INHALATION** may cause respiratory tract and mucous membrane irritation. Symptoms include nasal discharge and nosebleeds, coughing, sore throat and labored breathing. Severe exposure may cause bronchospasm and pulmonary edema. Absorption may cause systemic poisoning similar to that which occurs with ingestion. Inhalations of fumes may cause a flu-like illness called 'metal fume fever'. Typically metal fume fever begins four to twelve hours after sufficient exposure to freshly formed fumes. First symptoms are a metallic taste, dryness, and irritation of the throat. Cough and shortness of breath may occur along with a headache, fatigue, nausea, vomiting, diarrhea, and painful spasms of the limbs. Copper poisoning can result in hemolytic anemia and kidney, liver, and spleen damage.

CHRONIC TOXICITY: LONG-TERM (CHRONIC) OVEREXPOSURE to **FLUORIDES** over years may produce mottling of teeth, embrittlement, and decalcification of bones, and increased calcification of ligaments and vertebrae resulting in spinal stiffness (fluorosis). Excessive **ZINC** intake has been associated with copper deficiency anemia. Prolonged or excessive exposures may result in argyria, a permanent localized blue-grey discoloration of the eye, skin, or mucous membranes. Prolonged absorption of **BORON COMPOUNDS** may cause mild gastrointestinal irritation, loss of appetite, nausea, and erythematous rash. Dryness of skin and mucous membranes, loss of hair, conjunctivitis, and kidney injury have also been observed. Reproductive effects have been observed in laboratory animals. Primary route of entry is the respiratory system.

SECTION 11 NOTES: Avoid direct inhalation of fumes during use. Monitor fume levels.

SECTION 12: ECOLOGICAL INFORMATION

CONTAMINATED PACKAGING: Empty containers should be taken for local recycling, recovery, or waste disposal. Metals may be recycled.

SPILLS: Contain spill and dispose of according to local regulations.

SECTION 12 NOTES: Do not flush into surface water or sanitary sewer system.

SECTION 13: DISPOSAL CONSIDERATION

WASTE DISPOSAL METHOD: Dispose of any rod and waste residues in accordance with EPA or local regulations.

SECTION 13 NOTES: Review U.S. Federal Hazardous Waste Regulations §40 CFR261 to determine if this is hazardous in USA. Please be advised that state and local requirements, or other country requirements, for waste disposal may be more restrictive or otherwise different than U.S. Federal regulations. It is not possible to give this product a waste code number according to the European waste catalogue because only the intended use of the user consents the assignment of a specific code number.

SECTION 14: TRANSPORTATION INFORMATION

DOMESTIC TRANSPORT REGULATIONS (USA): DOT - not regulated.

DOMESTIC TRANSPORT REGULATIONS (CANADA): TDG - not regulated.

DOMESTIC TRANSPORT REGULATIONS (MEXICO): MEX - not regulated.

INTERNATIONAL TRANSPORT REGULATIONS:

ICAO – not regulated

IATA – not regulated

IMDG / IMO – not regulated

OTHER AGENCIES: No international regulations or restrictions are applicable.

SECTION 14 NOTES: Handle with care to avoid damaging the product. Do not remove product identification label or warning label. Keep material from freezing and away from heat.

SECTION 15: REGULATORY INFORMATION

Read and understand the manufacturer's Safety Data Sheet before handling or disposing of this product.

U.S. EPA TSCA (TOXIC SUBSTANCE CONTROL ACT): All constituents of these products are on the TSCA inventory list or are excluded from listing.

Spills or releases resulting in the loss of any ingredient at or above its RQ require immediate notification to the National Response Center and to our Local Emergency Planning Committee.

EPCRA/SARA TITLE III 313 TOXIC CHEMICALS:

The following metallic components are listed as SARA 313 “TOXIC CHEMICALS” and are potentially subject to annual SARA 313 reporting. See Section 3 if the ingredient is present and for percent.

<u>INGREDIENT NAME</u>	<u>CAS NUMBER</u>	<u>DISCLOSURE THRESHOLD</u>
Chromium & chromium compounds	7440-47-3	1.0 % de minimis concentration
Chromium VI	Not listed	0.1 % de minimis concentration
Barium compounds	Not listed	1.0 % de minimis concentration
Cobalt	7440-48-4	0.1 % de minimis concentration
Copper	7440-50-8	1.0 % de minimis concentration
Manganese	7439-96-5	1.0 % de minimis concentration
Nickel	7440-02-0	0.1 % de minimis concentration
Aluminum (fume or dust)	7429-90-5	1.0 % de minimis concentration
Silver	7440-22-4	1.0 % de minimis concentration

Package Labeling:

Additional advice on labeling:

As a finished article the product does not need to be labeled in accordance with EC-directives or respective national laws.

SECTION 15 NOTES: International rules may vary and the appropriate regulations should be followed as defined by the country where the product is used.

SECTION 16: OTHER INFORMATION

This Safety Data Sheet has been revised due to modifications to several paragraphs.
Prepared by Eutectic Corporation. USA.

Potassium Bifluoride

R25 : Toxic if swallowed

R34 : Causes burns

S1/2 : Keep locked up and out of reach of children.

S22: Do not breathe dust

S26 : In case of contact with eyes, rinse immediately with plenty of water and seek medical advice.

S37 : Wear suitable gloves.

S45 : In case of accident or if you feel unwell, seek medical advice immediately (show label where possible).

Read and understand the manufacturer's instructions and precautionary label on this product.

See American National Standard Z49.1, Safety in Welding and Cutting, published by the "American Welding Society," 550 N.W. LeJeune Road, Miami, FL 33126 and OSHA Publication 2206 (29CFR 1910), U.S. Government Printing Office, Superintendent of Documents, P.O. Box 371954, Pittsburgh, PA 15250-7954 for more detail on safe use of product.

SUPPLEMENTAL INFORMATION – DEFINITIONS:

IARC: International Agency for the Research on Cancer

NIOSH: National Institute for Occupational Safety and Health

OSHA: U.S. Occupational Safety and Health Administration

ACGIH: American Conference of Governmental Industrial Hygienists

CAS: Chemical Abstracts Service Registry Number

EINECS: European Inventory of Existing Chemical Substances

PEL: Permissible Exposure Limit

NTP: National Toxicology Program

TLV: Threshold Limit Value

ECD: European Council Directive

GHS: Globally Harmonized System

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