MATERIAL SAFETY DATA SHEET

SUBMERGED ARC WELDING FLUXES

1. PRODUCT AND COMPANY DESIGNATION

Product Name: Submerged Arc Welding Fluxes
Product Brands: TriMark, McKay
Product Specification: No Specification to cover flux See AWS A5.17 for Electrodes and Fluxes
Product Classification: No Specific classification usually classified as Flux

Received: Submerged Arc Welding of plain carbon steels, Alloy Steels and Stainless Steel

Supplier: Hobart Brothers
Address: 400 Trade Square East, Troy OH, 45373, USA
Telephone number: 091 937 332 4000
Emergency Tel. No.: (24 hour) 091 800 424 9300
Telefax:

2. DETAILS OF COMPOSITION

Specific details of the contents of the flux types covered by this data sheet are given below:

<table>
<thead>
<tr>
<th>Flux</th>
<th>HFP-%/NO3F</th>
<th>HFP-%/AT2</th>
<th>HFP-%/N115x</th>
<th>MK-N</th>
<th>MK-80</th>
<th>CAS No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Alumina Oxide</td>
<td>5-30</td>
<td>5-30</td>
<td>5-30</td>
<td>20-30</td>
<td>35</td>
<td>1344-28-1</td>
</tr>
<tr>
<td>Magnesium Oxide</td>
<td>10-30</td>
<td>10-30</td>
<td>10-30</td>
<td>30-40</td>
<td>-</td>
<td>1109-46-4</td>
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<tr>
<td>Manganese</td>
<td>0-20</td>
<td>0-20</td>
<td>0-20</td>
<td>1-2</td>
<td>-</td>
<td>7439-95-5</td>
</tr>
<tr>
<td>Silica (Amorphous)</td>
<td>0-15</td>
<td>0-15</td>
<td>0-15</td>
<td>10-20</td>
<td>-</td>
<td>14808-66-7</td>
</tr>
<tr>
<td>Silica (Fume)</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>6902-42-2</td>
</tr>
<tr>
<td>Fluorspar</td>
<td>10-15</td>
<td>10-15</td>
<td>10-15</td>
<td>10-20</td>
<td>10</td>
<td>7789-75-5</td>
</tr>
<tr>
<td>Silicon</td>
<td>1-10</td>
<td>1-10</td>
<td>1-10</td>
<td>1-10</td>
<td>1-10</td>
<td>7440-21-3</td>
</tr>
<tr>
<td>Silicate Binders</td>
<td>1-10</td>
<td>1-10</td>
<td>1-10</td>
<td>1-10</td>
<td>1-10</td>
<td>7440-21-3</td>
</tr>
<tr>
<td>Iron</td>
<td>&lt;5</td>
<td>&lt;5</td>
<td>&lt;5</td>
<td>&lt;5</td>
<td>&lt;5</td>
<td>-</td>
</tr>
<tr>
<td>Iron Oxide</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>1309-37-1</td>
</tr>
<tr>
<td>Titanium Dioxide</td>
<td>5</td>
<td>5</td>
<td>5</td>
<td>5</td>
<td>5</td>
<td>13843-67-7</td>
</tr>
<tr>
<td>Zirconium</td>
<td>15</td>
<td>15</td>
<td>15</td>
<td>15</td>
<td>15</td>
<td>7440-67-7</td>
</tr>
</tbody>
</table>

3. HAZARDS IDENTIFICATION

There are no recognised hazards associated directly with unused welding consumables prior to welding. Packaged consumables may be heavy, and should be handled and stored with care. FOLLOW MANUAL HANDLING REGULATIONS.

Some low levels of dust may be produced during handling. DO NOT BREATHE THE DUST.

When using these fluxes as part of the welding process additional potential hazards are likely:

- Electric shock from the welding equipment or electrode. This can be fatal.
- Hot metal spatter and heat, which can cause burns to the hand and body, and may cause fire if in contact with combustible materials.
- UV, IR and light radiation from the arc, which can produce ‘arc eye’ and may cause fire if in contact with combustible materials.
- Gaseous fume such as ozone and nitrogen oxides from the action of arc radiation on the atmosphere, and carbon monoxide and dioxide from the dissociation of some flux constituents during welding.
- Local Exhalation of these Fumes and Gases may lead to irritation of the nose, throat and eyes.

4. FIRST AID MEASURES

No first aid measures should be required for the unused electrode consumables. Should contact be made, possible eye damage to unprotected eyes. WEAR SUITABLE PROTECTIVE EYEWEAR.

5. FIRE PREVENTION MEASURES

No specific measures required for the welding consumable prior to welding. Welding should not be carried out in the presence of flammable materials, vapours, tanks, cisterns and pipes and other containers which have held flammable substances unless these have been checked and certified safe.

6. MEASURES IN CASE OF UNINTENTIONAL RELEASE

No specific actions for welding consumable prior to use. Welding in proximity to stored or used halogenated solvents may produce toxic and irritant gases. Prohibit welding in areas where these solvents are used.

7. HANDLING AND STORAGE (FOR SAFETY)

Welders should not touch live electrical parts, and should insulate themselves from the ground and work. Manufacturer’s guidelines for the use of electrical welding machines should be observed at all times. Welders and co-workers should be educated about the health hazards associated with welding fume, and trained to keep their heads out of the fume plume.

During welding, fumes and gases will be produced and emitted from the welding process. The content of the fume is dependent on the electrode type and base material being welded. The amount and concentration of fume generated is dependent on factors such as current, voltage, welding practices and number of welders in a given area. By following recommended welding practices, fume production can sometimes be minimised.

For carbon steel electrodes, the main constituents of the fume will be iron, manganese, sodium, potassium and calcium oxides, fluorides and silicates, mainly in the form of complex oxides and other compounds. There will also be smaller amounts of other complex metal oxides and silicates.

Gaseous ozone and nitrogen oxides are also formed by arc radiation, and carbon monoxide and carbon dioxide can be also present due to dissolution of some of the flux constituents.

Fume composition data for the major carbon steel electrodes are given below and the individual exposure limits for the constituents (when specified) are also given.

Fume exposure should be limited below the recognised exposure limit for each of the individual constituents, and to below 5 mg/m³ for the total particulate fume.

8. EXPOSURE PREVENTION/CONTROL/PERSONAL PROTECTION

Exposure Protection

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<table>
<thead>
<tr>
<th>Welding fume component</th>
<th>CAS No.</th>
<th>OSHA PEL</th>
<th>ACGIH TLV</th>
</tr>
</thead>
<tbody>
<tr>
<td>Aluminum Oxide</td>
<td>1344-28-1</td>
<td>5 R (fume as Al)</td>
<td>10 (Dust)</td>
</tr>
<tr>
<td>Magnesium Oxide</td>
<td>1309-48-4</td>
<td>15 R</td>
<td>20 (Fume)</td>
</tr>
<tr>
<td>Manganese</td>
<td>7439-95-5</td>
<td>5 (Dust)</td>
<td>10 (Fume)</td>
</tr>
<tr>
<td>Silica (Amorphous Silica Fume)</td>
<td>6900-64-3</td>
<td>0.8 R</td>
<td>2 R</td>
</tr>
<tr>
<td>Fluorspar</td>
<td>7440-21-3</td>
<td>2.5 TLV</td>
<td>4 R</td>
</tr>
<tr>
<td>Silicon</td>
<td>7440-21-3</td>
<td>5 R</td>
<td>10</td>
</tr>
<tr>
<td>Zirconium</td>
<td>13563-67-7</td>
<td>Not Established</td>
<td>Not Established</td>
</tr>
</tbody>
</table>

For skin burns

Submerge affected area in cold water until burning sensation ceases and refer for immediate medical attention.

For eye effects such as arc eye and dusts

Irrigate eye with sterile water, cover with damp dressing and refer for immediate medical attention. Advice to doctor: treat symptomatically.

Electric shock

If necessary resuscitate and seek immediate medical attention.

<table>
<thead>
<tr>
<th>Material</th>
<th>CAS No.</th>
<th>TLV</th>
</tr>
</thead>
<tbody>
<tr>
<td>Iron Oxide</td>
<td>1309-37-1</td>
<td>10</td>
</tr>
<tr>
<td>Titanium Dioxide</td>
<td>13563-67-7</td>
<td>5, 10 STEL (Z &amp; Compounds)</td>
</tr>
</tbody>
</table>

Units are in mg/m³ except when stated otherwise.
The fume analyses for the fluxes covered by this data sheet, and used for welding clean, uncoated plain carbon steels indicate that as long as the 5 mg/m³ total fume exposure limits are met, fume levels of the other constituents will generally be below their respective exposure limits. An exception is manganese, as this has a low exposure limit, and additional controls to this limit may be required.

The fume levels given above were generated under laboratory conditions when welding clean, plain carbon steel under the manufacturers recommended welding parameters and are indicative of reasonably expected fume levels. Actual fume levels will vary in practice, depending on the welding parameters and other conditions, and may be higher or lower than those listed above.

Additional fume may arise when these fluxes are used to weld contaminated base materials, coated or plated steels, other metals and alloys, or when incorrect welding conditions are used.

The only accurate way to determine the composition and quantity of fumes and gases to which workers are exposed is to measure the concentration of these fumes and gases in the worker's breathing zone. Individual fume measurements should be made in these cases using recognised sampling and analysis standards. Based on the results of these measurements, additional fume controls may be required to ensure that all the fume constituents are controlled below their exposure limits.

Controls

Good general ventilation, and/or local fume extraction at the arc should be used to control the fumes and gases produced during welding to below their individual recognised exposure limits when measured in the welder’s and co-workers’ breathing zones. In addition ventilation and extraction should also be sufficient to ensure that the total particulate fume levels are reduced below 5 mg/m³ when measured in the breathing zone.

In confined spaces where ventilation is not adequate, an air fed breathing system should be used for arc welding. Fume and gas concentrations should be observed. Where fume levels exceed the recognised exposure limits, respiratory protection may be required in the form of a Class P2 (metal fume) respirator.

Personal Protection

Welders and co-workers in the vicinity should wear protective clothing and eye protection appropriate to arc welding as specified by local standards.

Protection of Body and Skin

Suitable clothes for welding should be worn such as non light reflective fireproof overalls, leather apron, welding helmet, leather boots, spats and gloves.

Protection of Hands

Welders should wear suitable hand protection such as welding gloves or gauntlets of a suitable standard. Co-worker should also wear suitable hand protection against hot metal, sparks and spatter.

Eye Protection

Welders should wear a welding helmet fitted with the appropriate optical welding filter for the operation. Suitable protective welding screens and goggles should be provided, and used by others working in the same area.

9. PHYSICAL AND CHEMICAL PROPERTIES

Physical state: Solid
Colour: Generally greyish or brownish but other colours can be present
Form: Agglomerated Powder
Odour: Odourless
PH: Not available
Vapour pressure: Not relevant
Vapour Density: Not relevant
Boiling point / range: Not relevant
Solubility in water: Soluble
Density: Not available
Explosive / ignition point: Non flammable. No fire or explosion hazard exists

10. STABILITY AND REACTIVITY

There are no stability or reactivity hazards from fluxes as supplied.

Hazardous decomposition products such as metal oxide fumes and gases (see Section 8) are produced during welding.

11. TOXICITY DATA

Welding fumes if inhaled can potentially produce several differing health effects caused by the metal containing particles and oxides produced during the welding process, both of which are present in the ‘fumes’. The exact nature of any likely health effect is dependent on the consumable, material being welded, weld process, all of which affect fume quantity and composition, as well as the use of adequate ventilation, respirators, or breathing equipment as circumstances require.

Inhalation of the fumes/gases produced during welding may lead to irritation to the nose, throat, and eyes. The range of health effects include respiratory effects with symptoms such as asthma, impaired respiratory and lung function, chronic bronchitis, metal fume fever, pneumoconiosis, possible emphysema and acute pulmonary oedema.

Other potential health effects at elevated levels of exposure include central nervous effects possible lung cancer, bone disease, skin and fertility effects. Which of these health effects is potentially likely is related to the fume composition, and this needs to be combined with the specific toxicity data below to assess the health risk when using any particular welding process. Unprotected skin exposed to UV and IR radiation from the welding arc may burn or redden, and UV radiation is potentially a carcinogen. UV radiation can affect the unprotected eye by producing an acute condition known as ‘arc eye’.

Specific effects relevant to major particulate and gaseous fume constituents produced when welding with these electrodes

Iron

The chief component of fume generated by welding carbon steels is iron oxide. Iron oxide is generally considered a nuisance material and unlikely to cause any significant health effects. The fume particles however accumulate in the lungs and lead to a benign pneumoconiosis called siderosis.

Manganese

Manganese compounds are also found in carbon steel welding fumes. Manganese is mainly a systemic chronic toxin, although exposure to high particulate concentrations can cause some respiratory irritation. Overexposure or inhalation of excessive amounts of manganese has been shown to affect pulmonary function, blood and may cause irreversible central nervous system damage (manganism) which resembles Parkinson's disease.

Symptoms of manganism include tremors, impaired speech, facial expression changes, slow clumsy movements and eventually impaired walking. The symptoms are typically not apparent for several years.

Fluorides

Fluorides are respiratory irritants and if absorbed through inhalation can lead to bone disease known as fluorosis.

Silica

Silica is found in welding fumes produced by fluxes and flux coatings and is produced mainly as amorphous silica. This form of silica has not been associated to any significant degree with lung pneumoconiosis which is associated with crystalline forms of silica.

12. ECOLOGICAL DATA

The welding process produces particulate fumes and gases which may cause long term adverse effects in the environment if released directly into the atmosphere. Welding fumes from basic electrodes covered by this data sheet can produce carbon dioxide gas, which is dangerous to the ozone layer.

13. DISPOSAL DATA

Packaging, stub ends and slag residue should be disposed of as general waste or recycled. No special precautions are required for this product.

14. TRANSPORT INFORMATION

No special requirements are necessary in transporting these products

15. REGULATIONS


16. OTHER INFORMATION

The customer should provide this Materials Safety Data Sheet to any person involved in the materials use or further distribution. BOC requests the users (or distributors) of this product to read this Materials Safety Data Sheet carefully before usage.

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BOC Bulk同期和材料安全数据表

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