

# SAFETY DATA SHEET

Aluminum Solder Paste



Date Issued : 04/30/2019

SDS No : ZN955P40

Date Revised : 05/08/2019

Revision No : 3

## ALUXCOR® 95/5 Solder Paste

### 1. PRODUCT AND COMPANY IDENTIFICATION

**PRODUCT NAME:** ALUXCOR® 95/5 Solder Paste

**GENERAL USE:** Product Type: An Aluminum paste consisting of powdered filler metal and flux suspended in a binder and used for joining metals by heating the parts to be joined and this product to or above the melting temperature of the filler metal.

**PRODUCT DESCRIPTION:** See Additional Information for explanation of Product Name.

**ALTERNATE TRADE NAME(S):** ZN955P40, ASN-720-XXX, ASN-A031-XXX

#### MANUFACTURER

Harris Products Group (USA)

4501 Quality Place

Mason, OH 45040

**Phone:** +1 (513) 754-2000

**E-Mail:**

HPG\_Consumables\_Quality@LincolnElectric.com

#### 24 HR. EMERGENCY TELEPHONE NUMBERS

In case of:	Contact:	Phone:
Chemical Emergency [spill, leak, fire, exposure or accident]	Harris Products Group [US and Canada]	440-946-3300 {8AM-5PM Eastern std time [Mon-Fri]} 440-220-0981 {After hours}
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# ALUXCOR 95/5 Solder Paste

## 2. HAZARDS IDENTIFICATION

### GHS CLASSIFICATIONS

#### Health:

Acute Toxicity (Oral), Category 4  
 Acute Toxicity (Dermal), Category 4  
 Acute Toxicity (Inhalation), Category 4  
 Skin Irritation, Category 2  
 Eye Corrosion, Category 1  
 Carcinogenicity, Category 1B  
 Reproductive Toxicity, Category 2  
 Target Organ Toxicity (Single exposure), Category 3  
 Target Organ Toxicity (Repeated exposure), Category 2

#### Environmental:

Acute Hazards to the Aquatic Environment, Category 1  
 Chronic Hazards to the Aquatic Environment, Category 1

### GHS LABEL



Exclamation  
mark



Corrosion



Health hazard



Environment

### SIGNAL WORD: DANGER

### HAZARD STATEMENTS

H302 + H312 + H332: Harmful if swallowed, in contact with skin or if inhaled.  
 H315: Causes skin irritation.  
 H318: Causes serious eye damage.  
 H350: May cause cancer.  
 H361: Suspected of damaging fertility or the unborn child.  
 H336: May cause drowsiness or dizziness.  
 H373: May cause damage to organs through prolonged or repeated exposure.  
 H410: Very toxic to aquatic life with long lasting effects.

### PRECAUTIONARY STATEMENTS

#### Prevention:

P201: Obtain special instructions before use.  
 P202: Do not handle until all safety precautions have been read and understood.  
 P260: Do not breathe fumes or vapours.  
 P264: Wash exposed skin thoroughly after handling.  
 P270: Do not eat, drink or smoke when using this product.  
 P271: Use only outdoors or in a well-ventilated area.  
 P273: Avoid release to the environment.  
 P280: Wear protective gloves, clothing, eye protection and face protection.

#### Response:

P310: Immediately call a POISON CENTER or doctor.  
 P305+P351+P338: IF IN EYES: Rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing.  
 P302+P352: IF ON SKIN: Wash with plenty of soap and water.  
 P362+P364: Take off contaminated clothing and wash it before reuse.  
 P304+P340: IF INHALED: Remove person to fresh air and keep comfortable for breathing.  
 P391: Collect spillage.

#### Storage:

P403+P233: Store in a well-ventilated place. Keep container tightly closed.

#### Disposal:

P501: Dispose of container in accordance with local, regional and national regulations.

### EMERGENCY OVERVIEW

## ALUXCOR 95/5 Solder Paste

**IMMEDIATE CONCERNS:** Causes skin and eye irritation and/or burns. Causes respiratory tract irritation.

Fumes from the soldering/brazing process may be irritating to the eyes and respiratory system. Hot metal can cause eye and skin burns. Avoid breathing fumes from the soldering/brazing process. Use only with adequate ventilation.

**ROUTES OF ENTRY:** Potential routes of entry include: eye contact, skin contact, inhalation of metallic fume and decomposition products from heating this material during the soldering/brazing process.

### 3. COMPOSITION / INFORMATION ON INGREDIENTS

Chemical Name	Wt. %	CAS	Classification according to Regulation (EC) No 1272/2008 [CLP]
C077	--	--	Acute Tox. (I),Cat. 3; Acute Tox. (D),Cat. 3; Acute Tox. (O),Cat. 3; Skin Corr.,Cat. 1B; H301; H311; H314; H331
C576	--	--	Asp. Haz.,Cat. 1; Flam. Liq.,Cat. 4; Acute Tox. (I),Cat. 4; Skin Irr.,Cat. 2; Carc.,Cat. 1B; STOT SE,Cat. 3; STOT RE,Cat. 2; H304; H227; H332; H315; H350-A; H336; H373-1
Zinc	48 - 95	7440-66-6	Aquatic Acute,Cat. 1; Aquatic Chronic,Cat. 1; H410
Aluminum	1 - 20	7429-90-5	Flam. Sol.,Cat. 1; H228

**COMMENTS:** The specific chemical identity of the flux/binder formulation ingredients are being withheld as a trade secret. Disclosure will be provided to medical personnel in the event of an emergency. See Section 8 for exposure limits of hazardous ingredients [where applicable].

**Note:** This SDS is prepared to cover multiple alloys with the same GHS Hazard Classification and may list substances not applicable to the named product. Please see the Specification Sheet for product specific alloy composition and melt point range.

### 4. FIRST AID MEASURES

**EYES:** Remove contact lenses. Hold eyelids apart. Immediately flush eyes with plenty of low-pressure water for at least 15 minutes. Get medical attention if irritation persists.

**SKIN:** Immediately remove contaminated clothing. Do not attempt to remove any material bonded to the skin. Flush area of skin contact immediately with large amounts of water for at least 15 minutes. If irritation persists after flushing, get medical attention promptly. Launder contaminated clothing before reuse.

**INGESTION:** If swallowed: Do not induce vomiting unless instructed to do so by medical personnel. Never give anything by mouth to an unconscious person. Get medical attention immediately.

**INHALATION:** Remove victim to fresh air. If not breathing, trained personnel may give artificial respiration. If breathing is difficult, give oxygen by trained personnel. Seek medical attention.

#### SIGNS AND SYMPTOMS OF OVEREXPOSURE

**EYES:** Eye contact may cause: irritation and/or burning sensation.

**SKIN:** May cause irritation and burns to exposed tissue. Hot molten metal may cause burns to the skin.

**INGESTION:** If swallowed, this product may cause gastrointestinal discomfort, nausea, vomiting.

**INHALATION:** Inhalation of powder, dust or fumes may be irritating to the respiratory system.

Inhalation of some metals may cause Metal Fume Fever: See section 11.

**NOTES TO PHYSICIAN:** Treat symptomatically. Symptoms may be delayed.

### 5. FIRE FIGHTING MEASURES

**GENERAL HAZARD:** During the soldering/brazing process, hazardous decomposition products may be released: See section 10.

**EXTINGUISHING MEDIA:** For fires involving this product, use dry chemical, carbon dioxide, foam, water spray. Do not use water if metal is molten.

**EXPLOSION HAZARDS:** This material is classed as a non-flammable solid. Product will burn under fire conditions. Emits toxic and corrosive fumes under fire conditions.

**FIRE FIGHTING PROCEDURES:** Move container from fire area if it can be done without risk. Avoid inhalation of vapors or mists.

**FIRE FIGHTING EQUIPMENT:** Exposure to decomposition products may be a hazard to health. Do not breathe smoke, gases or vapors generated. Wear goggles if eye protection is not provided. Wash away any material that comes into contact with the body, clothing or equipment. When fighting fires involving this product, wear full protective gear. For fires in enclosed areas, fire fighters must use self-contained breathing apparatus.

**ALUXCOR 95/5 Solder Paste****6. ACCIDENTAL RELEASE MEASURES**

**LARGE SPILL:** Recover spilled material. Reclaim this material whenever possible. Collect material into sealed and labeled containers for reclamation or disposal.

**ENVIRONMENTAL PRECAUTIONS**

**WATER SPILL:** Avoid contamination of water bodies during cleanup and disposal. Do not flush to sewer. Advise relevant authorities if material enters sewers, water sources or low-lying areas.

**LAND SPILL:** No data available

**AIR SPILL:** No data available

**GENERAL PROCEDURES:** Waste disposal method: Scoop up excess material and wash affected areas with soap and water. Avoid contact with skin and eyes. Collect material into sealed and labeled containers for disposal. Clean contaminated surface thoroughly. Dispose in accordance with federal, state and local regulations.

**SPECIAL PROTECTIVE EQUIPMENT:** Avoid inhaling vapor and/or mists. Do not get spilled material on skin, clothing, or in eyes. Wear full protective clothing. See Section 8. Remove all contaminated clothing.

**7. HANDLING AND STORAGE**

**HANDLING:** Keep away from sources of ignition.

**STORAGE:** Keep lid tightly closed except when removing product.

**STORAGE TEMPERATURE:** 5°C (41°F) Minimum to 25°C (77°F) Maximum

**SHELF LIFE:** See specification sheet or container label.

**8. EXPOSURE CONTROLS / PERSONAL PROTECTION****EXPOSURE GUIDELINES**

OSHA HAZARDOUS COMPONENTS (29 CFR1910.1200)				
EXPOSURE LIMITS				
Chemical Name	Type		ppm	mg/m <sup>3</sup>
C077	OSHA PEL	TWA	[1]	2.5 [1]
	ACGIH TLV	TWA	[1]	2.5 [1]
C576	OSHA PEL	TWA	[2]	[2]
	ACGIH TLV	TWA	200	
Zinc	OSHA PEL	TWA	[3]	10 [3]
	ACGIH TLV	TWA	[3]	5 [3]
		STEL	[3]	10 [3]
Aluminum	OSHA PEL	TWA	[4]	15 [4]
	ACGIH TLV	TWA	[5]	1.0 [5]

**Footnotes:**

1. [as F]
2. No data available
3. [zinc oxide fume]
4. [dust]
5. [respirable fraction]

**ENGINEERING CONTROLS:** The use of local ventilation is required to maintain the concentration of fumes evolved from the soldering/brazing process to well below the occupational exposure limits, within the operator's breathing zone and the general vicinity. Use of process enclosures, exhaust systems, and other engineering/administrative controls should be designed in accordance with local conditions. Please refer to the ACGIH document, *Industrial Ventilation, A Manual of Recommended Practices* [most recent edition], for details.

**PERSONAL PROTECTIVE EQUIPMENT**

**EYES AND FACE:** Wear safety glasses with side shields as a minimum level of protection. Consult ANSI Z87.1 for more information.

**SKIN:** Wear chemical resistant gloves. When material is heated, wear thermal-insulated gloves to protect against burns.

## ALUXCOR 95/5 Solder Paste

**RESPIRATORY:** When exposure limits (listed above) are exceeded or ventilation is inadequate, wear a NIOSH or European Standard approved respirator, in accordance with OSHA respirator regulations [29 CFR 1910.134] or European Standards [EN149]. Consult ANSI Z88.2 *American National Standard for Respiratory Protection* for guidance on proper selection, use and care of respirators.

**PROTECTIVE CLOTHING:** Avoid skin contact. Wear chemical resistant clothing ( long-sleeved shirt buttoned at the wrist) as necessary to prevent contact. For soldering/brazing operations where hot metallic parts are handled and molten metal may be present, wear heat-resistant gloves and clothing to protect from burns.

**WORK HYGIENIC PRACTICES:** Minimize exposure in accordance with good hygiene practice. Good general hygienic practices include: Eating, drinking, and smoking should not be permitted in work areas. Wash thoroughly after handling, and before eating, drinking, using tobacco, applying cosmetics, or using the toilet. Keep area clean. Remove contaminated clothing promptly. Launder contaminated clothing before reuse. Avoid contact with eyes, skin, and clothing. Avoid breathing dust, vapor or mist.

**OTHER USE PRECAUTIONS:** Educate and train employees in the safe use and handling of this product.

**COMMENTS:** See American National Standard ANSI Z49.1, *Safety in Welding, Cutting and Allied Processes*, published by the American Welding Society, 8669 NW 36th Street, #130, Miami, FL 33166, OSHA *Safety and Health Standards*, 29 CFR 1910, available from the U.S. Government Printing Office, Superintendent of Documents, P.O. Box 371954, Pittsburgh, PA 15250-7954.

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### 9. PHYSICAL AND CHEMICAL PROPERTIES

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**ODOR:** Characteristic odor.

**APPEARANCE:** Viscous paste

**COLOR:** Gray

**pH:** Not Applicable

**FLASH POINT AND METHOD:** Not Applicable

**FLAMMABLE LIMITS:** LEL/UEL: Not Determined

**AUTOIGNITION TEMPERATURE:** Not Determined

**VAPOR PRESSURE:** >0.1 mm Hg at 68°F/20°C [for C576]

**VAPOR DENSITY:** 4.5 [air=1] [for C576]

**BOILING POINT:** 360 - 480°F [182.22 - 248.89°C] [for C576]

**MELTING POINT:** Alloy Melting Range: 371°C - 482°C (700°F - 900°F). See Product Specification Sheet for the specific melt range.

**THERMAL DECOMPOSITION:** No data available

**SOLUBILITY IN WATER:** Negligible

**PARTITION COEFFICIENT: N-OCTANOL/WATER:** No data available

**EVAPORATION RATE:** 0.34 [n-butyl acetate=1] [for C576]

**SPECIFIC GRAVITY:** > 1 (water=1)

**OXIDIZING PROPERTIES:** No data available

**COMMENTS:** Not Available

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### 10. STABILITY AND REACTIVITY

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**REACTIVITY:** This material is not expected to be reactive at ambient conditions.

**HAZARDOUS POLYMERIZATION:** Will not occur.

**STABILITY:** Stable under normal conditions of use.

**CONDITIONS TO AVOID:** Avoid contact with incompatible materials. Avoid extreme heat. Avoid prolonged exposure to air and moisture.

**HAZARDOUS DECOMPOSITION PRODUCTS:** Decomposition products may include, but are not limited to: carbon oxides (CO, CO<sub>2</sub>), cesium oxides, highly corrosive and toxic hydrofluoric acid fumes. Metallic decomposition products may include: zinc oxide fumes, metal oxide fumes.

**INCOMPATIBLE MATERIALS:** Materials to avoid: acids (produces HF gas), oxidizing agents, halogens, water, strong oxidizers, alkalis, ammonium nitrate, strong bases, halogenated hydrocarbons, moisture.

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### 11. TOXICOLOGICAL INFORMATION

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#### ACUTE TOXICITY

**ALUXCOR 95/5 Solder Paste**

Chemical Name	ORAL LD <sub>50</sub>	DERMAL LD <sub>50</sub>	INHALATION LC <sub>50</sub>
C077	100 Not established	300 Not established	3 Not established
C576	> 5000 mg/kg [rat]	> 2000 mg/kg [rabbit]	1.78 mg/L/4 hr (Rat, Dust)

**DERMAL LD<sub>50</sub>:** Classified as Acute Toxicity (Dermal), Category 4

The calculation method was used for this evaluation.

**ORAL LD<sub>50</sub>:** Classified as Acute Toxicity (Oral), Category 4

The calculation method was used for this evaluation.

**INHALATION LC<sub>50</sub>:** Classified as Acute Toxicity (Inhalation), Category 4

The calculation method was used for this evaluation.

**NOTES:** If excessive quantities of zinc oxide fume are inhaled, it can result in the condition called metal fume fever. The symptoms of metal fume fever will occur within 3 to 10 hours, and include immediate dryness and irritation of the throat, tightness of the chest, and coughing which may later be followed by flu-like symptoms of fever, malaise, perspiration, frontal headache, muscle cramps, low back pain, occasionally blurred vision, nausea, and vomiting. There are no recognized complications, after effects, or chronic effects that result from this condition.

**SKIN CORROSION/IRRITATION:** Classified as Skin irritation, Category 2

The calculation method was used for this evaluation.

**SERIOUS EYE DAMAGE/IRRITATION:** Classified as Eye Corrosion, Category 1.

The calculation method was used for this evaluation.

**RESPIRATORY OR SKIN SENSITISATION:** Not Classified.

This material was not made with any components known to be skin or respiratory sensitizers.

**GERM CELL MUTAGENICITY:** Not Classified.

This material was not made with components identified as being mutagenic.

**CARCINOGENICITY**

Chemical Name	Other
C576	This material is classified as carcinogenic by the vendor.

**NOTES:** Classified as Carcinogenicity Category 1B

**REPRODUCTIVE TOXICITY:** Classified as Reproductive toxicity Category 2, Oral

**STOT-SINGLE EXPOSURE:** Classified as Target Organ Toxicity (Single exposure), Category 3

The calculation method was used for this evaluation.

**STOT-REPEATED EXPOSURE:** Classified as Target Organ Toxicity (Repeated exposure), Category 2.

The calculation method was used for this evaluation.

**ASPIRATION HAZARD:** Not Applicable

**12. ECOLOGICAL INFORMATION**

**ECOTOXICOLOGICAL INFORMATION:** Material - Expected to be toxic to aquatic organisms.

Material - May cause long-term adverse effects in the aquatic environment.

**BIOACCUMULATION/ACCUMULATION:** No data available

**DISTRIBUTION:** No data available

**AQUATIC TOXICITY (ACUTE):** No data available

**CHEMICAL FATE INFORMATION:** No data available

**GENERAL COMMENTS:** No data available

**13. DISPOSAL CONSIDERATIONS**

**DISPOSAL METHOD:** Dispose of in accordance with EC, national and local regulations, or sell to refiner.

**PRODUCT DISPOSAL:** Disposal of waste material from the use of this product may be subject to federal, state and local regulations. Waste characterizations and compliance with applicable laws are the sole responsibility of the waste generator. Reclaimed scrap metal has monetary value. Contact a commercial reclaimer for information on recycling scrap metals. All recovered material should be packaged, labeled, transported and disposed or reclaimed in conformance with applicable laws and regulations and in conformance with good engineering practices.

**EMPTY CONTAINER:** Do not reuse empty containers. Dispose of empty container in accordance with EC, national and local regulations.

**EUROPEAN WASTE CATALOGUE:** 16 03 03\*: Inorganic wastes containing dangerous substances

**ALUXCOR 95/5 Solder Paste****14. TRANSPORT INFORMATION****DOT (DEPARTMENT OF TRANSPORTATION)****PROPER SHIPPING NAME:** Environmentally hazardous substances, solid, n.o.s. [Zinc metal powder]**PRIMARY HAZARD CLASS/DIVISION:** 9 Environmentally Hazardous Substance**UN/NA NUMBER:** 3077**PACKING GROUP:** III**BULK FREIGHT CLASS:** Per 49CFR 171.4: For ground, rail or air shipments, Marine pollutants are regulated as a hazardous material in bulk quantities only. Non-bulk shipments are not regulated for shipping.**AIR (ICAO/IATA)****SHIPPING NAME:** Environmentally hazardous substances, solid, n.o.s. [Zinc metal powder]**UN/NA NUMBER:** 3077**PRIMARY HAZARD CLASS/DIVISION:** 9 Environmentally Hazardous Substance**PACKING GROUP:** III**SPECIAL PROVISIONS:** A197: May be shipped as "Not restricted" provided that the net quantity in any receptacle does not exceed 5 kg or 5 L.**VESSEL (IMO/IMDG)****SHIPPING NAME:** Environmentally hazardous substances, solid, n.o.s. [Zinc metal powder]**UN/NA NUMBER:** 3077**PRIMARY HAZARD CLASS/DIVISION:** 9 Environmentally Hazardous Substance**PACKING GROUP:** III**SPECIAL PROVISIONS:** Marine Pollutants having a net quantity of 5 L or less for liquids or a net mass per single or inner packaging of 5 kg or less for solids are not subject to any other provision of the Code relevant to marine pollutants.**COMMENTS:** This product is classified for transport per US DOT, ADR/RID, ICAO/IATA, and IMO/IMDG.**15. REGULATORY INFORMATION****UNITED STATES****SARA TITLE III (SUPERFUND AMENDMENTS AND REAUTHORIZATION ACT)****EPCRA SECTION 313 SUPPLIER NOTIFICATION**

Chemical Name	Wt. %	CAS	Comments
Zinc	48 - 95	7440-66-6	Material subject to reporting requirements of SARA Section 313. Listed as: Zinc Compounds, Zinc (as fume or dust)
Aluminum	1 - 20	7429-90-5	Material subject to reporting requirements of SARA Section 313. Listed as: Aluminum (as fume or dust)

**CERCLA (COMPREHENSIVE ENVIRONMENTAL RESPONSE, COMPENSATION, AND LIABILITY ACT)**

Chemical Name	Wt. %	CERCLA RQ
Zinc	48 - 95	1000 lbs.

**TSCA (TOXIC SUBSTANCE CONTROL ACT)****TSCA STATUS:** The components of this product are included on the TSCA Inventory.**CALIFORNIA PROPOSITION 65:** This product does not contain any components that are regulated under California Proposition 65.**16. OTHER INFORMATION****APPROVED BY:** Regulatory Affairs**PREPARED BY:** R. Henson**Date Revised:** 08/01/19**INFORMATION CONTACT:** Regulatory Affairs**REVISION SUMMARY:** This SDS replaces the proprietary SDS. Revised: **Section 1:** 24 HR. EMERGENCY TELEPHONE NUMBERS. **Section 11:** ACUTE ( ORAL LD<sub>50</sub>, INHALATION LC<sub>50</sub> ). Header and person responsible

## ALUXCOR 95/5 Solder Paste

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