

SAFETY DATA SHEET

According to Regulation (EC) No. 1907/2006 (REACH) Article 31, Annex II as amended.

SECTION 1: Identification of the substance/mixture and of the company/undertaking

1.1 Product identifier

Product Name: Stay Silv® Powder Brazing Flux

Other means of identification

SDS number: 200000007222

UFI: XGAP-082G-6P4X-0T6D

1.2 Relevant identified uses of the substance or mixture and uses advised against

Identified uses: Metal Brazing

Uses advised against: Not known. Read this SDS before using this product.

1.3 Details of the supplier of the safety data sheet

Manufacturer/Importer/Supplier/Distributor Information

Company Name: The Harris Products Group

Address: 4501 Quality Place
Mason, OH 45040-1971
USA

Telephone: +1 (513) 754-2000

Contact Person: Safety Data Sheet Questions: custservmason@jwharris.com

Company Name: Lincoln Electric Europe B.V.

Address: Nieuwe Dukenburgseweg 20
Nijmegen 6534AD
The Netherlands

Telephone: +31 243 522 911

Contact Person: Safety Data Sheet Questions: www.lincolnelectric.com/sds
Arc Welding Safety Information: www.lincolnelectric.com/safety

1.4 Emergency telephone number:

USA/Canada/Mexico +1 (888) 609-1762

Americas/Europe +1 (216) 383-8962

Asia Pacific +1 (216) 383-8966

Middle East/Africa +1 (216) 383-8969

3E Company Access Code: 333988

SECTION 2: Hazards identification

2.1 Classification of the substance or mixture

The product has been classified according to the legislation in force.

Classification according to Regulation (EC) No 1272/2008 as amended.

Health Hazards

Acute toxicity (Oral)	Category 4	H302
Acute toxicity (Dermal)	Category 4	H312
Acute toxicity (Inhalation - dust and mist)	Category 4	H332
Skin irritation	Category 2	H315
Serious eye irritation	Category 2	H319
Toxic to reproduction	Category 1B	H360FD

2.2 Label Elements

Contains:

Potassium fluoride
Boric acid



Signal Word:

Danger

Hazard Statement(s):

H302+H312+H332: Harmful if swallowed, in contact with skin or if inhaled.
H315: Causes skin irritation.
H319: Causes serious eye irritation.
H360FD: May damage fertility. May damage the unborn child.

Precautionary Statements

Prevention:

P201: Obtain special instructions before use.
P202: Do not handle until all safety precautions have been read and understood.
P261: Avoid breathing dust/fume/gas/mist/vapors/spray.
P264: Wash face, hands and any exposed skin thoroughly after handling.
P280: Wear protective gloves/protective clothing/eye protection/face protection.

Response:

P302+P352: IF ON SKIN: Wash with plenty of soap and water.
P362+P364: Take off contaminated clothing and wash it before reuse.
P312: Call a POISON CENTER or doctor/ physician if you feel unwell.
P305+P351+P338: IF IN EYES: Rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing.
P337+P313: If eye irritation persists: Get medical advice/attention.
P308+P313: IF exposed or concerned: Get medical advice/attention.

Supplemental label information

Restricted to professional users.

2.3 Other hazards

Heat rays (infrared radiation) from flame or hot metal can injure eyes. Overexposure to brazing fumes and gases can be hazardous. Read and understand the manufacturer's instructions, Safety Data Sheets and the precautionary labels before using this product.

Substance(s) formed under the conditions of use:

Fumes produced from use of this product may contain the following constituent(s) and/or their complex metallic oxides as well as solid particles or other constituents from the solder, brazing consumable, flux material or base metal, or base metal coating not listed below. Hydrogen fluoride, a possible decomposition product, is extremely corrosive and a poison by all routes of entry. Hydrogen fluoride can penetrate the skin and produce burns, which may not be immediately painful or visible; the burns impact the lower layers of skin and bone tissue. Hydrogen fluoride exposures involving 20 percent of the body or more can be fatal through systemic fluoride poisoning.

Chemical name	CAS-No.
Carbon dioxide	124-38-9
Carbon monoxide	630-08-0
Nitrogen dioxide	10102-44-0
Ozone	10028-15-6

SECTION 3: Composition/information on ingredients

Reportable Hazardous Ingredients 3.2 Mixtures

Chemical name	Concentration	CAS-No.	EC No.	Classification	Notes	REACH Registration No.
Potassium fluoroborate	50 - <100%	14075-53-7	237-928-2	Not classified	#	01-2119968922-24;
Potassium fluoride	10 - <25%	7789-23-3	232-151-5	Acute Tox.: 3: H331 Acute Tox.: 3: H311 Acute Tox.: 3: H301	#	01-2119555273-40;
Potassium carbonate	10 - <20%	584-08-7	209-529-3	Skin Corr.: 2: H315 Eye Dam.: 2: H319 STOT SE: 3: H335		No data available.
Boric acid	5,5 - <10%	10043-35-3	233-139-2	Repr.: 1B: H360FD	##	01-2119486683-25;

* All concentrations are percent by weight unless ingredient is a gas. Gas concentrations are in percent by volume.

This substance has workplace exposure limit(s).

This substance is listed as SVHC

CLP: Regulation No. 1272/2008.

The full text for all H-statements is displayed in section 16.

Composition Comments:

The term "Hazardous Ingredients" should be interpreted as a term defined in Hazard Communication standards and does not necessarily imply the existence of a welding hazard. The product may contain additional non-hazardous ingredients or may form additional compounds under the condition of use. Refer to Sections 2 and 8 for more information.

SECTION 4: First aid measures

4.1 Description of first aid measures

- Inhalation:** Move to fresh air if breathing is difficult. If breathing has stopped, perform artificial respiration and obtain medical assistance at once.
- Skin Contact:** Wash skin thoroughly with soap and water. Call a POISON CENTER/doctor if you feel unwell.
- Eye contact:** Remove contact lenses, if present and easy to do. Continue rinsing. Rinse cautiously with water for several minutes. If eye irritation persists: Get medical advice/attention.
- Ingestion:** Avoid hand, clothing, food, and drink contact with fluxes, metal fume or powder which can cause ingestion of particulate during hand to mouth activities such as drinking, eating, smoking, etc. If ingested, do not induce vomiting. Contact a poison control center. Unless the poison control center advises otherwise, wash out mouth thoroughly with water. If symptoms develop, seek medical attention at once. Call a POISON CENTER/doctor if you feel unwell. Rinse mouth.

4.2 Most important symptoms and effects, both acute and delayed:

Short-term (acute) overexposure to fumes and gases from welding and allied processes may result in discomfort such as metal fume fever, dizziness, nausea, or dryness or irritation of nose, throat, or eyes. May aggravate pre-existing respiratory problems (e.g. asthma, emphysema). Long-term (chronic) overexposure to fumes and gases from welding and allied processes can lead to siderosis (iron deposits in lung), central nervous system effects, bronchitis and other pulmonary effects. Refer to Section 11 for more information.

4.3 Indication of any immediate medical attention and special treatment needed

- Hazards:** The hazards associated with welding and its allied processes such as soldering and brazing are complex and may include physical and health hazards such as but not limited to electric shock, physical strains, radiation burns (eye flash), thermal burns due to hot metal or spatter and potential health effects of overexposure to fumes, gases or dusts potentially generated during the use of this product. Refer to Section 11 for more information.
- Treatment:** Treat symptomatically.

SECTION 5: Firefighting measures

- General Fire Hazards:** As shipped, this product is nonflammable. However, welding arc and sparks as well as open flames and hot surfaces associated with brazing and soldering can ignite combustible and flammable materials. Read and understand American National Standard Z49.1, "Safety in Welding, Cutting and Allied Processes" and National Fire Protection Association NFPA 51B, "Standard for Fire Prevention during Welding, Cutting and Other Hot Work" before using this product.

5.1 Extinguishing media

Suitable extinguishing media:	Use fire-extinguishing media appropriate for surrounding materials.
Unsuitable extinguishing media:	Do not use water jet as an extinguisher, as this will spread the fire.
5.2 Special hazards arising from the substance or mixture:	During fire, gases hazardous to health may be formed.
5.3 Advice for firefighters Special fire fighting procedures:	Use standard firefighting procedures and consider the hazards of other involved materials.
Special protective equipment for fire-fighters:	Selection of respiratory protection for fire fighting: follow the general fire precautions indicated in the workplace. Self-contained breathing apparatus and full protective clothing must be worn in case of fire.

SECTION 6: Accidental release measures

6.1 Personal precautions, protective equipment and emergency procedures:	See Section 8 of the SDS for Personal Protective Equipment. Do not touch damaged containers or spilled material unless wearing appropriate protective clothing. Keep unauthorized personnel away.
6.2 Environmental Precautions:	Do not contaminate water sources or sewer. Prevent further leakage or spillage if safe to do so.
6.3 Methods and material for containment and cleaning up:	Absorb spill with vermiculite or other inert material, then place in a container for chemical waste. Dike far ahead of larger spill for later recovery and disposal.
6.4 Reference to other sections:	For further specification, refer to section 8 of the SDS.

SECTION 7: Handling and storage:

7.1 Precautions for safe handling:	Prevent abrading consumable materials or creating dust. Provide appropriate exhaust ventilation at places where fume or dust is formed. Wear appropriate personal protective equipment. Observe good industrial hygiene practices. Read and understand the manufacturer's instruction and the precautionary label on the product. See American National Standard Z49.1, "Safety In Welding, Cutting and Allied Processes" published by the American Welding Society, http://pubs.aws.org and OSHA Publication 2206 (29CFR1910), U.S. Government Printing Office, www.gpo.gov . Avoid contact with eyes, skin, and clothing. Wash hands thoroughly after handling. Do not taste or swallow. Do not handle until all safety precautions have been read and understood. Obtain special instructions before use. Use personal protective equipment as required.
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7.2 Conditions for safe storage, including any incompatibilities: Store locked up.

7.3 Specific end use(s): No data available.

SECTION 8: Exposure controls/personal protection

8.1 Control Parameters

MAC, PEL, TLV and other exposure limit values may vary per element and form - as well as per country. All country-specific values are not listed. If no occupational exposure limit values are listed below, your local authority may still have applicable values. Refer to your local or national exposure limit values.

Control Parameters

Occupational Exposure Limits: Great Britain

Chemical Identity	Type	Exposure Limit Values	Source
Potassium fluoroborate	TWA	2,5 mg/m ³	EU. Indicative Exposure Limit Values in Directives 91/322/EEC, 2000/39/EC, 2006/15/EC, 2009/161/EU (12 2009)
	TWA	2,5 mg/m ³	EU. Scientific Committee on Occupational Exposure Limit Values (SCOELs), European Commission - SCOEL, as amended (2014)
Potassium fluoroborate - as F	TWA	2,5 mg/m ³	UK. EH40 Workplace Exposure Limits (WELs) (01 2020)
Potassium fluoride - as F	TWA	2,5 mg/m ³	UK. EH40 Workplace Exposure Limits (WELs) (2007)
Potassium fluoride	TWA	2,5 mg/m ³	EU. Scientific Committee on Occupational Exposure Limit Values (SCOELs), European Commission - SCOEL, as amended (2014)

Biological Limit Values: Great Britain

Chemical Identity	Exposure Limit Values	Source
Potassium fluoroborate (Fluoride: Sampling time: End of shift.)	8 mg/l (Urine)	EU BLV/BGV (2014)
Potassium fluoride (Fluoride: Sampling time: End of shift.)	8 mg/l (Urine)	EU BLV/BGV (2014)

Biological Limit Values: ACGIH

None of the components have assigned exposure limits.

Additional exposure limits under the conditions of use: Great Britain

Chemical Identity	Type	Exposure Limit Values	Source
Carbon dioxide	TWA	5.000 ppm	UK. EH40 Workplace Exposure Limits (WELs)
	TWA	5.000 ppm	EU. Indicative Exposure Limit Values in Directives 91/322/EEC, 2000/39/EC, 2006/15/EC, 2009/161/EU (Indicative)
	STEL	15.000 ppm	UK. EH40 Workplace Exposure Limits (WELs)
Carbon monoxide	STEL	100 ppm	EU. Indicative Exposure Limit Values in Directives 91/322/EEC, 2000/39/EC, 2006/15/EC, 2009/161/EU (Indicative)

	TWA	20 ppm	EU. Indicative Exposure Limit Values in Directives 91/322/EEC, 2000/39/EC, 2006/15/EC, 2009/161/EU (Indicative)
	STEL	100 ppm	EU. Scientific Committee on Occupational Exposure Limit Values (SCOELs), European Commission - SCOEL, as amended
	TWA	20 ppm	EU. Scientific Committee on Occupational Exposure Limit Values (SCOELs), European Commission - SCOEL, as amended
	STEL	200 ppm	UK. EH40 Workplace Exposure Limits (WELs)
	TWA	30 ppm	UK. EH40 Workplace Exposure Limits (WELs)
	STEL	100 ppm	UK. EH40 Workplace Exposure Limits (WELs)
	TWA	20 ppm	UK. EH40 Workplace Exposure Limits (WELs)
	TWA	30 ppm	UK. EH40 Workplace Exposure Limits (WELs) (The expiration date of this limit: 21 August 2023)
	STEL	200 ppm	UK. EH40 Workplace Exposure Limits (WELs) (The expiration date of this limit: 21 August 2023)
Nitrogen dioxide	TWA	0,5 ppm	EU. Indicative Exposure Limit Values in Directives 91/322/EEC, 2000/39/EC, 2006/15/EC, 2009/161/EU (Indicative)
	STEL	1 ppm	EU. Indicative Exposure Limit Values in Directives 91/322/EEC, 2000/39/EC, 2006/15/EC, 2009/161/EU (Indicative)
	STEL	1 ppm	EU. Scientific Committee on Occupational Exposure Limit Values (SCOELs), European Commission - SCOEL, as amended
	TWA	0,5 ppm	EU. Scientific Committee on Occupational Exposure Limit Values (SCOELs), European Commission - SCOEL, as amended
	TWA	0,5 ppm	UK. EH40 Workplace Exposure Limits (WELs)
	STEL	1 ppm	UK. EH40 Workplace Exposure Limits (WELs)
Ozone	STEL	0,2 ppm	UK. EH40 Workplace Exposure Limits (WELs)

Additional exposure limits under the conditions of use: US

Chemical Identity	Type	Exposure Limit Values		Source
Carbon dioxide	TWA	5.000 ppm		US. ACGIH Threshold Limit Values (12 2010)
	STEL	30.000 ppm		US. ACGIH Threshold Limit Values (12 2010)
	PEL	5.000 ppm	9.000 mg/m3	US. OSHA Table Z-1 Limits for Air Contaminants (29 CFR 1910.1000) (02 2006)
Carbon monoxide	TWA	25 ppm		US. ACGIH Threshold Limit Values (12 2010)
	PEL	50 ppm	55 mg/m3	US. OSHA Table Z-1 Limits for Air Contaminants (29 CFR 1910.1000) (02 2006)
Nitrogen dioxide	TWA	0,2 ppm		US. ACGIH Threshold Limit Values (02 2012)
	Ceiling	5 ppm	9 mg/m3	US. OSHA Table Z-1 Limits for Air Contaminants (29 CFR 1910.1000) (02 2006)
Ozone	PEL	0,1 ppm	0,2 mg/m3	US. OSHA Table Z-1 Limits for Air Contaminants (29 CFR 1910.1000) (02 2006)
	TWA	0,05 ppm		US. ACGIH Threshold Limit Values (03 2014)
	TWA	0,10 ppm		US. ACGIH Threshold Limit Values (03 2014)
	TWA	0,08 ppm		US. ACGIH Threshold Limit Values (03 2014)
	TWA	0,20 ppm		US. ACGIH Threshold Limit Values (02 2020)

8.2 Exposure controls

Appropriate Engineering Controls

Ventilation: Use enough ventilation and local exhaust at the arc, flame or heat source to keep the fumes and gases from the worker's breathing zone and the general area. Train the operator to keep their head out of the fumes. **Keep exposure as low as possible.**

Individual protection measures, such as personal protective equipment

General information:

Exposure Guidelines: To reduce the potential for overexposure, use controls such as adequate ventilation and personal protective equipment (PPE). Overexposure refers to exceeding applicable local limits, the American Conference of Governmental Industrial Hygienists (ACGIH) Threshold Limit Values (TLVs) or the Occupational Safety and Health Administration's (OSHA) Permissible Exposure Limits (PELs). Workplace exposure levels should be established by competent industrial hygiene assessments. Unless exposure levels are confirmed to be below the applicable local limit, TLV or PEL, whichever is lower, respirator use is required. Absent these controls, overexposure to one or more compound constituents, including those in the fume or airborne particles, may occur resulting in potential health hazards. According to the ACGIH, TLVs and Biological Exposure Indices (BEIs) "represent conditions under which ACGIH believes that nearly all workers may be repeatedly exposed without adverse health effects." The ACGIH further states that the TLV-TWA should be used as a guide in the control of health hazards and should not be used to indicate a fine line between safe and dangerous exposures. See Section 10 for information on constituents which have some potential to present health hazards. Welding consumables and materials being joined may contain chromium as an unintended trace element. Materials that contain chromium may produce some amount of hexavalent chromium (CrVI) and other chromium compounds as a byproduct in the fume. In 2018, the American Conference of Governmental Industrial Hygienists (ACGIH) lowered the Threshold Limit Value (TLV) for hexavalent chromium from 50 micrograms per cubic meter of air ($50 \mu\text{g}/\text{m}^3$) to $0.2 \mu\text{g}/\text{m}^3$. At these new limits, CrVI exposures at or above the TLV may be possible in cases where adequate ventilation is not provided. CrVI compounds are on the IARC and NTP lists as posing a lung cancer and sinus cancer risk. Workplace conditions are unique and welding fume exposures levels vary. Workplace exposure assessments must be conducted by a qualified professional, such as an industrial hygienist, to determine if exposures are below applicable limits and to make recommendations when necessary for preventing overexposures. Good general ventilation (typically 10 air changes per hour) should be used. Ventilation rates should be matched to conditions. If applicable, use process enclosures, local exhaust ventilation, or other engineering controls to maintain airborne levels below recommended exposure limits. If exposure limits have not been established, maintain airborne levels to an acceptable level. An eye wash and safety shower must be available in the immediate work area.

Maximum Dust Exposure Guideline™(MDEG)™ for this product (based on content of Potassium fluoroborate) is $3,4 \text{ mg}/\text{m}^3$. This exposure guideline is calculated using the most conservative value of the ACGIH TLV or OSHA PEL for the stated substance. Handle to minimize generation of airborne dust. Use adequate ventilation and dust collection. Use respiratory protection, if required, to keep exposure below limits. If your local applicable exposure limits are lower than the ACGIH TLV or OSHA PEL for any of the substances listed in Section 3 of this SDS, you must take that into consideration before utilizing or applying this guideline.

Eye/face protection:	Wear helmet, face shield or eye protection with filter lens shade number 2 for torch soldering and 3-4 for torch brazing, and follow the recommendations as specified in ANSI Z49.1, Section 4, based on your process details. Shield others by providing appropriate screens and eye protection. Wear safety glasses with side shields (or goggles).
Skin protection	
Hand Protection:	Wear protective gloves. Suitable gloves can be recommended by the glove supplier.
Other:	Protective Clothing: Wear hand, head, and body protection which help to prevent injury from radiation, open flames, hot surfaces, sparks and electrical shock. See Z49.1. At a minimum, this includes welder's gloves and a protective face shield when welding, and may include arm protectors, aprons, hats, shoulder protection, as well as dark substantial clothing when welding, brazing and soldering. Wear dry gloves free of holes or split seams. Train the operator not to permit electrically live parts or electrodes from contacting the skin . . . or clothing or gloves if they are wet. Insulate yourself from the work piece and ground using dry plywood, rubber mats or other dry insulation. Wear chemical-resistant gloves, footwear, and protective clothing appropriate for the risk of exposure. Contact health and safety professional or manufacturer for specific information.
Respiratory Protection:	Keep your head out of fumes. Use enough ventilation and local exhaust to keep fumes and gases from your breathing zone and the general area. An approved respirator should be used unless exposure assessments are below applicable exposure limits.
Hygiene measures:	Do not eat, drink or smoke when using the product. Always observe good personal hygiene measures, such as washing after handling the material and before eating, drinking, and/or smoking. Routinely wash work clothing and protective equipment to remove contaminants. Determine the composition and quantity of fumes and gases to which workers are exposed by taking an air sample from inside the welder's helmet if worn or in the worker's breathing zone. Improve ventilation if exposures are not below limits. See ANSI/AWS F1.1, F1.2, F1.3 and F1.5, available from the American Welding Society, www.aws.org . Avoid contact with skin. Observe good industrial hygiene practices. Wash hands after handling. Do not handle until all safety precautions have been read and understood. Obtain special instructions before use.

SECTION 9: Physical and chemical properties

9.1 Information on basic physical and chemical properties

Appearance:	Brazing flux.
Physical state:	Solid
Form:	Powder.
Color:	White
Odor:	No data available.
Odor Threshold:	No data available.
pH:	Not applicable

Melting Point:	No data available.
Boiling Point:	No data available.
Flash Point:	No data available.
Evaporation Rate:	No data available.
Flammability (solid, gas):	No data available.
Flammability Limit - Upper (%):	No data available.
Flammability Limit - Lower (%):	No data available.
Vapor pressure:	No data available.
Relative vapor density:	No data available.
Density:	1,6000 g/cm3
Relative density:	No data available.
Solubility(ies)	
Solubility in Water:	No data available.
Solubility (other):	No data available.
Partition coefficient (n-octanol/water):	No data available.
Autoignition Temperature:	No data available.
Decomposition Temperature:	No data available.
SADT:	No data available.
Viscosity:	No data available.
Explosive properties:	No data available.
Oxidizing properties:	No data available.

9.2 Other information

VOC Content: Not available.

Bulk density: Not available.

Dust Explosion Limit, Upper: Not available.

Dust Explosion Limit, Lower: Not available.

Dust Explosion Description Number Kst: Not available.

Minimum ignition energy: Not available.

Minimum ignition temperature: Not available.

Metal Corrosion: Not available.

SECTION 10: Stability and reactivity

10.1 Reactivity: The product is non-reactive under normal conditions of use, storage and transport.

10.2 Chemical Stability: Material is stable under normal conditions.

10.3 Possibility of hazardous reactions: None under normal conditions.

10.4 Conditions to avoid: Avoid heat or contamination.

10.5 Incompatible Materials: Strong acids. Strong oxidizing substances. Strong bases.

10.6 Hazardous Decomposition Products: Fumes and gases from welding and its allied processes such as brazing and soldering cannot be classified simply. The composition and quantity of both are dependent upon the metal to which the joining or hot work is applied, the process, procedure - and where applicable - the electrode or consumable 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 welded or worked (such as paint, plating, or galvanizing), the number of operators and the volume of the work area, the quality and amount of ventilation, the position of the operator'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.)

In cases where an electrode or other applied material is consumed, the fume and gas decomposition products generated are different in percent and form from the ingredients listed in Section 3. Decomposition products of normal operation include those originating from the volatilization, reaction, or oxidation of the materials shown in Section 3, plus those from the base metal and coating, etc., as noted above. Reasonably expected fume constituents produced during arc welding and brazing include the oxides of iron, manganese and other metals present in the welding consumable or base metal. Hexavalent chromium compounds may be in the welding or brazing fume of consumables or base metals which contain chromium. Gaseous and particulate fluoride may be in the fume of consumables or flux materials which contain fluoride. Gaseous reaction products may include carbon monoxide and carbon dioxide. Ozone and nitrogen oxides may be formed by the radiation from the arc associated with welding.

SECTION 11: Toxicological information

General information: The International Agency for Research on Cancer (IARC) has determined welding fumes and ultraviolet radiation from welding are carcinogenic to humans (Group 1). According to IARC, welding fumes cause cancer of the lung and positive associations have been observed with cancer of the kidney. Also according to IARC, ultraviolet radiation from welding causes ocular melanoma. IARC identifies gouging, brazing, carbon arc or plasma arc cutting, and soldering as processes closely related to welding. Read and understand the manufacturer's instructions, Safety Data Sheets and the precautionary labels before using this product.

Information on likely routes of exposure

Inhalation: Inhalation is the primary route of exposure. In high concentrations, dust, vapors, fumes or mists may irritate nose, throat and mucus membranes.

Skin Contact: Harmful in contact with skin.

Eye contact: HEAT RAYS (INFRARED RADIATION) from flame or hot metal can injure eyes.

Ingestion: Avoid ingestion - wear gloves and other appropriate personal protection - wash hands thoroughly following use or handling. Harmful if swallowed.

Symptoms related to the physical, chemical and toxicological characteristics

Inhalation: Short-term (acute) overexposure to fumes and gases from brazing and soldering may result in discomfort such as metal fume fever, dizziness, nausea, or dryness or irritation of nose, throat, or eyes. May aggravate pre-existing respiratory problems (e.g. asthma, emphysema). Long-term (chronic) overexposure to fumes and gases from brazing and soldering can lead to siderosis (iron deposits in lung), central nervous system effects, bronchitis and other pulmonary effects. Products which contain lead or cadmium have additional specific health hazards - refer to Sections 2, 8 and 11 of this SDS. Depending on specific product composition, some products may produce hazardous concentrations of airborne oxides of cadmium, lead, zinc or fluoride compounds. Use adequate ventilation and respiratory protection during use. Avoid breathing fumes. Avoid ingestion - wear gloves and other appropriate personal protection - wash hands thoroughly following use or handling. Inhalation of fumes may cause upper respiratory tract irritation and systemic poisoning with early symptoms including headache, coughing, and a metallic taste as well as metal fume fever. Chronic cadmium exposure causes lung and kidney damage. Chronic exposure to lead causes damage to lungs, liver, kidney, nervous system as well as blood and musculoskeletal disorders. Exposures to high levels of cadmium or lead dust or fume may be immediately dangerous to life or health and can cause delayed pneumonitis with fever and chest pain, and pulmonary edema resulting in death.

11.1 Information on toxicological effects

Acute toxicity (list all possible routes of exposure)

Oral

Product:	ATEmix: 1.007,81 mg/kg
Specified substance(s):	
Potassium fluoride	LD 50 (Rat): 245 mg/kg
Potassium carbonate	LD 50 (Rat): 1.870 mg/kg
Boric acid	LD 50 (Rat): 2.660 mg/kg

Dermal

Product:	ATEmix: 1.304,35 mg/kg
Specified substance(s):	
Potassium carbonate	LD 50 (Rabbit): > 2.000 mg/kg

Inhalation

Product:	ATEmix: 2,22 mg/l
Specified substance(s):	
Potassium fluoride	LC 50 (Rat, 4 h): 1 mg/l

Repeated dose toxicity

Product:	No data available.
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Skin Corrosion/Irritation

Product:	No data available.
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Serious Eye Damage/Eye Irritation

Product: No data available.

Respiratory or Skin Sensitization

Product: Respiratory Sensitization: Not classified
 Skin Sensitization: Not classified

Carcinogenicity

Product: Not classified

IARC Monographs on the Evaluation of Carcinogenic Risks to Humans:

Specified substance(s):
 Potassium fluoride Overall evaluation: 3. Not classifiable as to carcinogenicity to humans.

Germ Cell Mutagenicity

In vitro

Product: Not classified

In vivo

Product: Not classified

Reproductive toxicity

Product: May damage fertility or the unborn child.

Specified substance(s):
 Boric acid EU RA R2

Specific Target Organ Toxicity - Single Exposure

Product: Not classified

Specific Target Organ Toxicity - Repeated Exposure

Product: Not classified

Aspiration Hazard

Product: Not applicable

Symptoms related to the physical, chemical and toxicological characteristics under the condition of use

Additional toxicological Information under the conditions of use:

Acute toxicity

Inhalation

Specified substance(s):
 Carbon dioxide LC Lo (Human, 5 min): 90000 ppm
 Carbon monoxide LC 50 (Rat, 4 h): 1300 ppm
 Nitrogen dioxide LC 50 (Rat, 4 h): 88 ppm
 Ozone LC Lo (Human, 30 min): 50 ppm

Other effects:

Specified substance(s):
 Carbon dioxide Asphyxia
 Carbon monoxide Carboxyhemoglobinemia
 Nitrogen dioxide Lower respiratory tract irritation

SECTION 12: Ecological information

12.1 Ecotoxicity

Acute hazards to the aquatic environment:

Fish

Product:	Not classified
Specified substance(s):	
Potassium carbonate	LC 50 (Fathead minnow (<i>Pimephales promelas</i>), 96 h): < 750 mg/l
Boric acid	LC 50 (<i>Pimephales promelas</i> , 96 h): 79,7 mg/l

Aquatic Invertebrates

Product:	Not classified
Specified substance(s):	
Potassium carbonate	LC 50 (Water flea (<i>Ceriodaphnia dubia</i>), 48 h): 580 - 670 mg/l
Boric acid	LC 50 (<i>Hyaella azteca</i> , 96 h): 64 mg/l

Chronic hazards to the aquatic environment:

Fish

Product:	Not classified
Specified substance(s):	
Potassium fluoride	NOAEL (<i>Oncorhynchus mykiss</i> , 21 d): 4 mg/l

Aquatic Invertebrates

Product:	Not classified
Specified substance(s):	
Potassium fluoride	NOAEL (<i>Daphnia magna</i> , 21 d): 14,1 mg/l NOAEL (<i>Daphnia magna</i> , 21 d): 3,7 mg/l

Toxicity to Aquatic Plants

Product:	No data available.
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12.2 Persistence and Degradability

Biodegradation

Product:	No data available.
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12.3 Bioaccumulative potential

Bioconcentration Factor (BCF)

Product:	No data available.
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12.4 Mobility in soil: No data available.

12.5 Results of PBT and vPvB assessment: No data available.

12.6 Other adverse effects: No data available.

12.7 Additional Information: No data available.

SECTION 13: Disposal considerations

13.1 Waste treatment methods

General information:	The generation of waste should be avoided or minimized whenever possible. When practical, recycle in an environmentally acceptable, regulatory compliant manner. Dispose of non-recyclable products in accordance with all applicable Federal, State, Provincial, and Local requirements.
Disposal instructions:	Discharge, treatment, or disposal may be subject to national, state, or local laws.
Contaminated Packaging:	Dispose of contents/container to an appropriate treatment and disposal facility in accordance with applicable laws and regulations, and product characteristics at time of disposal.

SECTION 14: Transport information

ADR

14.1 UN number or ID number:	
14.2 UN Proper Shipping Name:	NOT DG REGULATED
14.3 Transport Hazard Class(es)	
Class:	NR
Label(s):	—
Hazard No. (ADR):	—
Tunnel restriction code:	
14.4 Packing Group:	—
Limited quantity	
Excepted quantity	
14.5 Marine Pollutant	No

ADN

14.1 UN number or ID number:	
14.2 UN Proper Shipping Name:	NOT DG REGULATED
14.3 Transport Hazard Class(es)	
Class:	NR
Label(s):	—
Hazard No. (ADR):	—
14.4 Packing Group:	—
Limited quantity	
Excepted quantity	
14.5 Marine Pollutant	No

RID

14.1 UN number or ID number:	
14.2 UN Proper Shipping Name:	NOT DG REGULATED
14.3 Transport Hazard Class(es)	
Class:	NR
Label(s):	—
14.4 Packing Group:	—
14.5 Marine Pollutant	No

IMDG

14.1 UN number or ID number:	
14.2 UN Proper Shipping Name:	NOT DG REGULATED
14.3 Transport Hazard Class(es)	

Class: NR
Label(s): –
EmS No.: –
14.4 Packing Group: –
Limited quantity
Excepted quantity
14.5 Marine Pollutant No

IATA

14.1 UN number or ID number:
14.2 Proper Shipping Name: NOT DG REGULATED
14.3 Transport Hazard Class(es):
Class: NR
Label(s): –
14.4 Packing Group: –
Cargo aircraft only :
Passenger and cargo aircraft :
Limited quantity:
Excepted quantity
14.5 Marine Pollutant No
Cargo aircraft only: Allowed.

14.7 Transport in bulk according to Annex II of MARPOL and the IBC Code: Not applicable

SECTION 15: Regulatory information

15.1 Safety, health and environmental regulations/legislation specific for the substance or mixture:

EU Regulations

Regulation 1005/2009/EC on substances that deplete the ozone layer, Annex I, Controlled Substances: None

Regulation 1005/2009/EC on substances that deplete the ozone layer, Annex II, New Substances: None

EU. REACH Annex XIV, Substances Subject to Authorization: None

EU. Regulation 2019/1021/EU on persistent organic pollutants (POPs) (recast), as amended: None

Regulation (EU) No. 649/2012 concerning the export and import of dangerous chemicals, Annex I, Part 1 as amended: None

Regulation (EU) No. 649/2012 concerning the export and import of dangerous chemicals, Annex I, Part 2 as amended: None

Regulation (EU) No. 649/2012 concerning the export and import of dangerous chemicals, Annex I, Part 3 as amended: None

Regulation (EU) No. 649/2012 concerning the export and import of dangerous chemicals, Annex V as amended: None

EU. REACH Candidate List of Substances of Very High Concern for Authorization (SVHC):

Chemical name	CAS-No.	Concentration	Additional
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			Information
Boric acid	10043-35-3	1,0 - 10%	Not Regulated

Regulation (EC) No. 1907/2006 Annex XVII Substances subject to restriction on marketing and use:

The packaging shall be visibly, legibly and indelibly marked as follows:
Restricted to professional users.

Chemical name	CAS-No.	Concentration
Boric acid	10043-35-3	1,0 - 10%

Directive 2004/37/EC on the protection of workers from the risks related to exposure to carcinogens and mutagens at work.: None

Directive 92/85/EEC: on the safety and health of pregnant workers and workers who have recently given birth or are breast feeding.:

Chemical name	CAS-No.	Concentration
Boric acid	10043-35-3	1,0 - 10%

EU. Directive 2012/18/EU (SEVESO III) on major accident hazards involving dangerous substances, Annex I:

Not applicable

EU. Regulation No. 166/2006 PRTR (Pollutant Release and Transfer Registry), Annex II: Pollutants:

Chemical name	CAS-No.	Concentration
Potassium fluoroborate	14075-53-7	50 - 60%
Potassium fluoride	7789-23-3	20 - 30%

Directive 98/24/EC on the protection of workers from the risks related to chemical agents at work:

Chemical name	CAS-No.	Concentration
Potassium fluoride	7789-23-3	20 - 30%
Boric acid	10043-35-3	1,0 - 10%

National Regulations

Water Hazard Class (WGK): WGK 3: severely water-endangering.

TA Luft, Technical Guidance Air:

Potassium fluoroborate	Number 5.2.2 Class III, Inorganic dust-forming substance
Potassium fluoride	Number 5.2.2 Class III, Inorganic dust-forming substance Number 5.2.4 Class II, Inorganic gas-forming substance

INRS, maladies professionnelles, table of work-related illnesses

Listed: A
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15.2 Chemical safety assessment:

No Chemical Safety Assessment has been carried out.

International regulations

Inventory Status:

Canada DSL Inventory List:	On or in compliance with the inventory
EINECS, ELINCS or NLP:	On or in compliance with the inventory
Japan (ENCS) List:	One or more components are not listed or are exempt from listing.
China Inv. Existing Chemical Substances:	On or in compliance with the inventory
Korea Existing Chemicals Inv. (KECI):	On or in compliance with the inventory
Canada NDSL Inventory:	One or more components are not listed or are exempt from listing.
Philippines PICCS:	On or in compliance with the inventory
US TSCA Inventory:	On or in compliance with the inventory
New Zealand Inventory of Chemicals:	One or more components are not listed or are exempt from listing.
Japan ISHL Listing:	On or in compliance with the inventory
Japan Pharmacopoeia Listing:	One or more components are not listed or are exempt from listing.
Mexico INSQ:	On or in compliance with the inventory
Ontario Inventory:	On or in compliance with the inventory
Taiwan Chemical Substance Inventory:	On or in compliance with the inventory
Australia AICS:	One or more components are not listed or are exempt from listing.

Montreal protocol

Not applicable

Stockholm convention

Not applicable

Rotterdam convention

Not applicable

Kyoto protocol

Not applicable

SECTION 16: Other information

Definitions:

The Maximum Dust Exposure Guideline™ (MDEG)™ is provided to assist with the management of workplace exposures where granular solid welding products or other materials are being utilized. It is derived from relevant compositional data and estimates the lowest level of total airborne dust exposure, for a given product, at which some specific constituent might potentially exceed its individual exposure limit. The specific exposure limits referenced are the American Conference of Governmental Industrial Hygienists (ACGIH) Threshold Limit Value (TLV®) and the U. S. OSHA Permissible Exposure Limit (PEL), which ever value is the lowest. If local applicable limits for any of the substances listed in Section 3 of this SDS are lower than the TLV or PEL this must be taken into consideration before utilizing or applying this guideline. The MDEG™ is never greater than 10 mg/m³ as this is the airborne exposure guideline for total particulate (total dust). **The MDEG™ is intended to serve as a general guideline to assist in the management of workplace exposure and does not replace the regular measurement and analysis of worker exposure to individual airborne dust constituents in accordance with recommended industrial hygiene practice.**

Combustible Dust Hazard Rating:

This material will not burn and has the Lincoln Electric Combustible Dust Hazard Rating: 0-CS. For additional information contact the Lincoln Electric EHS Department (216) 383-2669.

Combustible Dust Hazard Rating Information:

Lincoln Electric's Combustible Dust Rating System is as follows:

- 3: Fine solid powders or dusts which can ignite with contact with air, or have a Kst value ≥ 300 , and/or would have an ignition flame front faster than the speed of sound.
- 2: Fine solid powders or dusts which can ignite with contact with air, have an MIE < 3 mJ, or have a Kst value > 200 & ≤ 299 , and/or would have an ignition flame front faster than the speed of sound.
- 1.3: Fine solid powders or dusts which have an MIE > 3 mJ < 500 mJ, and a Kst ≥ 25 < 200 mJ.
- 1.2: Fine solid powders or dusts which have an MIE > 3 mJ < 500 mJ, and a Kst < 25 , or MIE > 500 mJ and Kst ≥ 25 but < 200 mJ.
- 1.1: Fine solid powders or dusts which have an MIE > 10 J and a positive Kst value < 25 .
- 0-CS: Materials that will not burn.

References

PBT
vPvB

PBT: persistent, bioaccumulative and toxic substance.
vPvB: very persistent and very bioaccumulative substance.

Key literature references and sources for data:

According to Regulation (EC) No. 1907/2006 (REACH) Article 31, Annex II as amended.

Wording of the H-statements in section 2 and 3

H301	Toxic if swallowed.
H302	Harmful if swallowed.
H311	Toxic in contact with skin.
H312	Harmful in contact with skin.
H315	Causes skin irritation.
H319	Causes serious eye irritation.
H331	Toxic if inhaled.
H332	Harmful if inhaled.
H335	May cause respiratory irritation.
H360FD	May damage fertility. May damage the unborn child.

Classification according to Regulation (EC) No 1272/2008 as amended.

Acute Tox. 4, H302

Acute Tox. 4, H312
Acute Tox. 4, H332
Skin Irrit. 2, H315
Eye Irrit. 2, H319
Repr. 1B, H360FD

Other information:

Additional information is available by request.

Issue Date:

12.08.2021

Disclaimer:

The Lincoln Electric Company urges each end user and recipient of this SDS to study it carefully. See also www.lincolnelectric.com/safety. If necessary, consult an industrial hygienist or other expert to understand this information and safeguard the environment and protect workers from potential hazards associated with the handling or use of this product. This information is believed to be accurate as of the revision date shown above. However, no warranty, expressed or implied, is given. Because the conditions or methods of use are beyond Lincoln Electric's control, we assume no liability resulting from the use of this product. Regulatory requirements are subject to change and may differ between various locations. Compliance with all applicable Federal, State, Provincial, and local laws and regulations remain the responsibility of the user.

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Annex to the extended Safety Data Sheet (eSDS)

Exposure Scenario:

Read and understand the “**Recommendations for Exposure Scenarios, Risk Management Measures and to identify Operational Conditions under which metals, alloys and metallic articles may be safely welded**”, which is available from your supplier and at <http://european-welding.org/health-safety>.

Welding/Brazing produces fumes which can affect human health and the environment. Fumes are a varying mixture of airborne gases and fine particles which, if inhaled or swallowed, constitute a health hazard. The degree of risk will depend on the composition of the fume, concentration of the fume and duration of exposure. The fume composition is dependent upon the material being worked, the process and consumables being used, coatings on the work such as paint, galvanizing or plating, oil or contaminants from cleaning and degreasing activities. A systematic approach to the assessment of exposure is necessary, taking into account the particular circumstances for the operator and ancillary worker that can be exposed.

Considering the emission of fumes when welding, brazing or cutting of metals, it is recommended to (1) arrange risk management measures through applying general information and guidelines provided by this exposure scenario and (2) using the information provided by the Safety Data Sheet, issued in accordance with REACH, by the welding consumable manufacturer.

The employer shall ensure that the risk from welding fumes to the safety and health of workers is eliminated or reduced to a minimum. The following principle shall be applied:

- 1- Select the applicable process/material combinations with the lowest class, whenever possible.
- 2- Set welding process with the lowest emission parameter.
- 3- Apply the relevant collective protective measure in accordance with class number. In general, the use of PPE is taken into account after all other measures is applied.
- 4- Wear the relevant personal protective equipment in accordance with the duty cycle.

In addition, compliance with the National Regulations regarding the exposure to welding fumes of welders and related personnel shall be verified.