



SAFETY DATA SHEET

Page: 1(5)
SDS Number: 12-F
Date Revised: 12/20/2011

This Safety Data Sheet complies with Regulation (EC) No. 1907/2006, ISO 11014-1 and ANSI Z400.1

1. PRODUCT AND COMPANY IDENTIFICATION

Product Name: ALL-STATE GENERAL PURPOSE PASTE SOLDER P/N: 69070060
Application: Paste Solder
Classification: None
Supplier: THE ESAB GROUP, INC., 801 Wilson Avenue, Hanover, PA 17331
Telephone No.: 1-717-637-8911, 1-800-933-7070
Emergency No.: 1-717-637-8911 and 1-800-424-9300 (CHEMTREC)
Web site: www.esabna.com

2. HAZARDS IDENTIFICATION

Emergency Overview: A silver-white metallic paste. Contact can cause irritation and burns to skin and eyes. If involved in a fire, vapors are irritating and toxic.

May cause irritation and burns to skin and eyes. Vapors are toxic and irritating. Toxic if ingested (contains lead) with potential long term health effects including blood, nervous system damage and potential reproductive toxicity. Vapors are irritating and may cause lung function effects.

Persons with a pacemaker should not go near welding or cutting operations until they have consulted their doctor and obtained information from the manufacturer of the device.

When these products are used in a welding process, the most important hazards are heat, radiation, electric shock and welding fumes.

Heat: Spatter and melting metal can cause burn injuries and start fires.

Radiation: Arc rays can severely damage eyes or skin.

Electricity: Electric shock can kill.

Fumes: Overexposure to soldering fumes may result in symptoms like metal fume fever, dizziness, nausea, dryness or irritation of the nose, throat or eyes. Chronic overexposure to soldering fumes may affect pulmonary function.

Overexposure to lead compounds above safe exposure limits can cause damage to the blood, nervous system and cause reproductive toxicity. Lead is considered to be a suspect carcinogen.

Prolonged inhalation of nickel and chromium compounds above safe exposure limits can cause cancer. Overexposure to manganese and manganese compounds above safe exposure limits can cause irreversible damage to the central nervous system, including the brain, symptoms of which may include slurred speech, lethargy, tremor, muscular weakness, psychological disturbances and spastic gait.

Flame Processing: When used with combustible gas equipment (e.g., oxy-acetylene torch), read the use and safety information for that equipment.

3. COMPOSITION/INFORMATION ON INGREDIENTS

This product is a paste.

Ingredients	Weight %	REACH Reg. #	CAS#	EINECS#	Hazard classification ⁽¹⁾	IARC ⁽²⁾	NTP ⁽³⁾	OSHA List ⁽⁴⁾
Ammonium Chloride	3-7	--	12125-02-9	235-186-4	Xn; R22 Xi; R36 Repr. Cat. 1; R61 Repr. Cat. 3; R62	-- 2B	-- S	-- --
Lead (nonvolatile)	30-45	--	7439-92-1	231-100-4	Xn; R20/22 R33 N; R50-53	--	--	--
Tin	30-45	--	7440-31-5	231-141-8	No	--	--	--
Zinc Chloride	10-30	--	7646-85-7	231-592-0	Xn; R22 C; R34 N; R50-53	--	--	--

⁽¹⁾ Hazard Classification according to European Council Directive 67/548/EEC, for R-phrases, see Section 16.

⁽²⁾ Evaluation according to the International Agency for Research on Cancer.

1 –Carcinogenic to humans. 2A – Probably carcinogenic to humans. 2B – Possibly carcinogenic to humans.

⁽³⁾ Classification according to the 11th Report on Carcinogens, published by the US National Toxicology Program.
K – Known Carcinogen S – Suspect Carcinogen

⁽⁴⁾ Carcinogen listing according to OSHA, Occupational Safety & Health Administration (USA).



4. FIRST AID MEASURES

- Inhalation: If breathing has stopped, perform artificial respiration and obtain medical assistance immediately! If breathing is difficult, provide fresh air and call physician.
- Eye contact: Immediately flush with water for at least 15 minutes to remove all residues. Get immediate medical attention.
- Skin contact: Rinse with water for up to 15 minutes. Get medical attention for irritation and/or burns. Remove contaminated clothing and wash before reuse.
- Ingestion: If product is swallowed, call a physician or poison control center immediately. Do not induce vomiting unless directed to do so by a physician.
- Electric shock: Disconnect and turn off the power. Use a nonconductive material to pull victim away from contact with live parts or wires. If not breathing, begin artificial respiration, preferably mouth-to-mouth. If no detectable pulse, begin Cardio Pulmonary Resuscitation (CPR). Immediately call a physician.
- General: Move to fresh air and call for medical aid.

5. FIRE FIGHTING MEASURES

Product is not "flammable". Use CO₂ or dry chemical on surrounding fire. Do not use water on fire where molten metal is present. Firefighters should wear full protective equipment and self-contained breathing apparatus. In extremely high temperature fires or in contact with certain acids, flux may emit toxic fumes. Paste decomposes to form ammonia, hydrogen chloride gas, and zinc chloride fumes. Use self-contained breathing apparatus as fumes or vapors may be harmful.

6. ACCIDENTAL RELEASE MEASURES

Solid objects may be picked up and placed into a container. Liquids or pastes should be scooped up and placed into a container. Wear proper protective equipment while handling these materials. Do not discard as refuse.

Recovered materials should be disposed of as per Section 13.

Personal precautions: refer to Section 8.

Environmental precautions: refer to Section 13.

7. HANDLING AND STORAGE

Handling:

Wear gloves when handling soldering consumables. Do not swallow or breathe vapors produced by use of product. Wash hands after using.

Some individuals can develop an allergic reaction to certain materials. Retain all warning and identity labels.

Storage:

Keep separate from chemical substances like acids, strong bases and oxidizers which could cause chemical reactions.

8. EXPOSURE CONTROL/PERSONAL PROTECTION

Avoid exposure to soldering fumes, radiation, spatter, electric shock, heated materials and dust.

Engineering measures (Soldering operations):

Ensure sufficient ventilation, local exhaust, or both, to keep soldering fumes and gases from breathing zone and general area. Keep working place and protective clothing clean and dry. Train welders to avoid contact with live electrical parts and insulate conductive parts. Check condition of protective clothing and equipment on a regular basis.

Personal protective equipment (Soldering operations):

Use respirator or air supplied respirator when soldering in a confined space, or where local exhaust or ventilation is not sufficient to keep exposure values within safe limits. Use special care when soldering painted or coated steels since hazardous substances from the coating may be emitted. Wear hand, head, eyes, ear and body protection like welders gloves, helmet or face shield with filter lens, safety boots, apron, arm and shoulder protection. Keep protective clothing clean and dry.

Use industrial hygiene monitoring equipment to ensure that exposure does not exceed applicable national exposure limits. The following limits can be used as guidance. For information about soldering fume analysis refer to soldering product SDS, Section 10, for information on soldering fumes.

Substance	CAS#	ACGIH TLV ⁽¹⁾ mg/m ³	OSHA PEL ⁽²⁾ mg/m ³
Ammonium Chloride (fume)	12125-02-9	10, 20 (STEL)	None
Lead (as Pb)	7439-92-1	0.05	0.05
Tin (metal)	7440-31-5	2	2
Zinc Chloride (fume)	7646-85-7	1, 2 (STEL)	1

⁽¹⁾ Threshold Limit Values according to American Conference of Governmental Hygienists, 2011

⁽²⁾ Permissible Exposure Limits according to the Occupational Safety & Health Administration (USA)

Unless noted, all values are for 8 hour time weighted averages (TWA).

* Total dust, ** Respirable fraction, *** Inhalable fraction.



9. PHYSICAL AND CHEMICAL PROPERTIES

Appearance:	Pasty solid. Silver-white metallic paste.
Specific Gravity:	> 1 (H ₂ O = 1)
Boiling Point:	343°C/650°F
Melting Point:	Varies with alloy.
Vapor Pressure:	Not determined (solid).
Vapor Density:	Not determined (solid).
Evaporation Rate:	Not applicable.
Solubility in Water:	Partial (tin and lead components are not soluble).
Flash Point:	Not flammable.
Upper/Lower Flame Limit:	None anticipated.
Auto-ignition Temperature:	None anticipated.

10. STABILITY AND REACTIVITY

General: This product is only intended for normal soldering purposes.

Stability: This product is stable under normal conditions.

Reactivity: Contact with chemical substances like acids, strong bases and oxidizers could cause generation of gas.

When this product is used in a soldering process, hazardous decomposition products would include those from the volatilization, reaction or oxidation of the materials listed in Section 3 and those from the base metal and coating. Fumes from the solder may contain compounds of the following chemical elements: Cl, Pb, Sn and Zn.

Refer to applicable national exposure limits for fume compounds, including those exposure limits for fume compounds found in Section 8. A significant amount of the chromium in the fumes can be hexavalent chromium, which has a very low exposure limit in some countries. Manganese and nickel also have low exposure limits that may be easily exceeded.

Reasonably expected gaseous products would include carbon oxides, nitrogen oxides and ozone. Air contaminants around the soldering area can be affected by the soldering process and influence the composition and quantity of fumes and gases produced.

11. TOXICOLOGICAL INFORMATION

Inhalation of soldering fumes and gases can be dangerous to your health. Classification of soldering fumes is difficult because of varying base materials, coatings, air contamination and processes. The International Agency for Research on Cancer has classified welding fumes as possibly carcinogenic to humans (Group 2B).

Acute toxicity: Overexposure to soldering fumes may result in symptoms like metal fume fever, dizziness, nausea, dryness or irritation of the nose, throat or eyes.

Chronic toxicity: Overexposure to tin and to soldering fumes may affect pulmonary function. Prolonged inhalation of nickel and chromium compounds above safe exposure limits can cause cancer. Overexposure to manganese and manganese compounds above safe exposure limits can cause irreversible damage to the central nervous system, including the brain, symptoms of which may include slurred speech, lethargy, tremor, muscular weakness, psychological disturbances and spastic gait.

Overexposure to lead can cause reproductive, hematological and neurological effects. Lead is a suspect carcinogen.

12. ECOLOGICAL INFORMATION

Contains zinc which may be toxic to aquatic species and is regulated as an environmental hazard in the European Union. This hazard is not anticipated from the handling of soldering consumables, but is relevant if consumables enter natural waterways.

Soldering consumables and materials could degrade/weather into components originating from the consumables or from the materials used in the soldering process. Avoid exposure to conditions that could lead to accumulation in soils or groundwater.

13. DISPOSAL CONSIDERATIONS

Discard any product, residue, disposable container or liner in an environmentally acceptable manner, in full compliance with federal and local regulations. Use recycling procedures if available.

USA RCRA: Unused products or product waste containing lead is considered hazardous waste if discarded, RCRA ID characteristic Toxic Hazardous Waste D008.

Residues from soldering consumables and processes could degrade and accumulate in soils and groundwater.



14. TRANSPORT INFORMATION

No international regulations or restrictions are applicable.

15. REGULATORY INFORMATION

Read and understand the manufacturer's instructions, your employer's safety practices and the health and safety instructions on the label. Observe any federal and local regulations. Take precautions when soldering and protect yourself and others.

WARNING: Soldering fumes and gases are hazardous to your health and may damage lungs and other organs. Use adequate ventilation.

ELECTRIC SHOCK can kill.

ARC RAYS and SPARKS can injure eyes and burn skin.

Wear correct hand, head, eye and body protection.

Canada: WHMIS classification: Class D; Division 2, Subdivision A
Class D; Division 2, Subdivision B

Canadian Environmental Protection Act (CEPA): All constituents of this product are on the Domestic Substance List (DSL).

USA: Under the OSHA Hazard Communication Standard, this product is considered hazardous.

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

United States EPA Toxic Substance Control Act: All constituents of this product are on the TSCA inventory list or are excluded from listing.

CERCLA/SARA Title III

Reportable Quantities (RQs) and/or Threshold Planning Quantities (TPQs):

Ingredient name	RQ (lb)	TPQ (lb)
Lead (only for particles with a diameter <0.004")	10	None
Zinc (only for particles with a diameter <0.004")	1000	None

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 your Local Emergency Planning Committee.

Section 311 Hazard Class

As shipped: Immediate delayed In use: Immediate delayed

EPCRA/SARA Title III 313 Toxic Chemicals

The following metallic components are listed as SARA 313 "Toxic Chemicals" and potential subject to annual SARA 313 reporting. See Section 3 for weight percent.

Ingredient name	Disclosure threshold
Lead	100 lbs
Zinc (fume or dust)	1.0% de minimis concentration

16. OTHER INFORMATION

This Safety Data Sheet has been revised due to modifications to Sections 1, 2, 3, 8 and 16. This SDS supersedes 12-E.

Refer to ESAB "Welding and Cutting - Risks and Measures", F52-529 "Precautions and Safe Practices for Electric Welding and Cutting" and F2035 "Precautions and Safe Practices for Gas Welding, Cutting and Heating" available from ESAB, and to:

USA: Contact ESAB at www.esabna.com or 1-800-ESAB-123 if you have questions about this SDS.

American National Standard Z49.1 "Safety in Welding and Cutting", ANSI/AWS F1.5 "Methods for Sampling and Analyzing Gases from Welding and Allied Processes", ANSI/AWS F1.1 "Method for Sampling Airborne Particles Generated by Welding and Allied Processes", AWSF3.2M/F3.2 "Ventilation Guide for Weld Fume", American Welding Society, 550 North Le Jeune Road, Miami, Florida, 33135. Safety and Health Fact Sheets available from AWS at www.aws.org.

OSHA Publication 2206 (29 C.F.R. 1910), U.S. Government Printing Office, Superintendent of Documents, P.O. Box 371954, Pittsburgh, PA 15250-7954.

American Conference of Governmental Hygienists (ACGIH), Threshold Limit Values and Biological Exposure Indices, 6500 Glenway Ave., Cincinnati, Ohio 45211, USA.

NFPA 51B "Standard for Fire Prevention During Welding, Cutting and Other Hot Work" published by the National Fire Protection Association, 1 Batterymarch Park, Quincy, MA 02169.



- UK: WMA Publication 236 and 237, "Hazards from Welding Fume", "The arc welder at work, some general aspects of health and safety".
- Germany: Unfallverhütungsvorschrift BGV D1, "Schweißen, Schneiden und verwandte Verfahren".
- Canada: CSA Standard CAN/CSA-W117.2-01 "Safety in Welding, Cutting and Allied Processes".
- This product has been classified according to the hazard criteria of the CPR and the SDS contains all the information required by the CPR.

Explanation of risk phrases mentioned in this SDS:

- R-phrases R20/22 – Harmful by inhalation and if swallowed.
- : R22 – Harmful if swallowed.
- R33 – Danger of cumulative effects.
- R34 – Causes burns.
- R36 – Irritating to eyes.
- R50 – Very toxic to aquatic organisms.
- R53 – May cause long-term adverse effects in the aquatic environment.
- R61 – May cause harm to the unborn child.
- R62 – Possible risk of impaired fertility.

ESAB requests the users of this product to study this Safety Data Sheet (SDS) and become aware of product hazards and safety information. To promote safe use of this product a user should:

- notify its employees, agents and contractors of the information on this SDS and any product hazards/safety information.
- furnish this same information to each of its customers for this product.
- request such customers to notify employees and customers for the same product hazards and safety information.

The information herein is given in good faith and based on technical data that ESAB believes to be reliable. Since the conditions of use are outside our control, we assume no liability in connection with any use of this information and no warranty, expressed or implied is given. Contact ESAB for more information.