

NFPA Ratings

Health: 1, Fire: 0, Reactivity: 0, Special: 1

Hazard Ratings
4 = Extreme
3 = High
2 = Moderate
1 = Slight
0 = Insignificant

Material Safety Data Sheet

(Essentially Similar to U.S. Department of Labor Suggested
Form For Hazard Communication Compliance)

I. Product Identification

Product Type - ALL-STATE FLUX CORED ALUMINUM WELDING ALLOY

Manufacturer - THE ESAB GROUP, INC.
Website: www.esabna.com

Telephone No. - 1-717-637-8911
1-800-933-7070

Address - 801 Wilson Avenue
Hanover, PA 17331

Emergency No. - 1-717-637-8911
(CHEMTREC) 1-800-424-9300

Product Description: A tubular flux cored bare electrode for joining some aluminum alloys.

APPROXIMATE COMPOSITION

All-State Product Trade Name

All-State Sealcor ①

	Maximum %
Aluminum	94
Aminoethylethaneanolamine	4
Ammonium Fluoroborate	4
Copper	0.5
Iron	1.0
Magnesium	6.0
Manganese	1.0
Silicon	6.0
Tin	1
Titanium	0.5
Total Boron As B ₂ O ₃	3
Total Fluoride As F	3
Triethanolamine	4
Zinc	0.5

① See Note in Section VI

THE ESAB GROUP requests the users of these products to study this Material Safety Data Sheet (MSDS) and the product labels and become fully aware of the product hazards and safety information. To promote the safe use of these products a user should (1) notify and train its employees, agents and contractors concerning the information on this MSDS and any product hazards and safety information, (2) furnish this same information to each of its customers for these products, and (3) request that such customers notify and train their employees and customers, for these products, of the same product hazards and safety information.

II. Hazardous Ingredients

IMPORTANT: This section covers the materials from which this product is manufactured. The fumes and gases produced during normal use of these products are covered in Section V. The term **HAZARDOUS** should be interpreted as a term required and defined by Laws, Statutes, or Regulations, and does not necessarily imply the existence of any hazard when the products are used as directed by **THE ESAB GROUP**.

Material	(CAS No.)	SARA	ACGIH TLV		OSHA - PEL	
			TWA (mg/m ³)		TWA (mg/m ³)	STEL (mg/m ³)
Aluminum (metal dust)	(7429-90-5)	*	1**		15*, 5**	
Aminoethylethane-anolamine	(111-41-1)		None Established		None Established	
Ammonium Fluoroborate	(13826-83-0)		2.5		2.5	
Boron	(7440-42-8)		10 (Oxide)		5 (Oxide – Respirable)	
Copper	(7440-50-8)	*	0.2 (Fume)		0.1 (Fume)	
Iron	(7439-89-6)		5 (Oxide Fume)		10 (Total Particulate)	
Magnesium	(7439-95-4)		10		10	
Manganese	(7439-96-5)	*	0.2 (Fume)		1 (Fume)	3
Silicon	(7440-21-3)		Withdrawn		5 (Respirable)	
Tin	(7440-31-5)		2		2	
Titanium	(7440-32-6)		10 (as TiO ₂)		5 (as TiO ₂ – Respirable)	
Total Fluoride As F	N/A		2.5		2.5	
Triethanolamine	(102-71-6)		5		None Established	
Zinc	(7440-66-6)	*	5, (Oxide Fume)	10 (STEL)	5	10

NOTE: In the ingredients table, an asterisk (*) after the CAS number indicates a toxic chemical subject to the reporting requirements of Section 313 of the Emergency Planning and Community Right-To-Know Act of 1986 (SARA) and 40 CFR Part 372.

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

III. Physical Data

As shipped, these products are nonflammable, nonexplosive, nonreactive, and nonhazardous

Physical State: Gas () Liquid () Solid (X)

Odor and Appearance: Bare rod, no odor.

IV. Fire & Explosion Hazard

Flammable/Explosive NO (X) YES ()

Under What Conditions: Only the packaging for this product will burn.

Extinguishing Media: This product will not burn. However, welding arcs and sparks can ignite combustible and flammable materials. Use the extinguishing media recommended for the burning materials and fire situation. See ANSI Z49.1 "Safety in Welding and Cutting" and "Safe Practices" Code: SP, published by the American Welding Society, P. O. Box 351040, Miami, FL 33135, and NFPA 51B "Cutting and Welding Processes," published by the National Fire Protection Association, Batterymarch Park, Quincy, MA 02269 for additional fire prevention and protection information.

V. Reactivity Data

Stability: Stable (X) Unstable () Hazardous polymerization will not occur.

Incompatibility (Materials to Avoid): None currently known.

Hazardous Decomposition Products: Brazing fumes and gases cannot be classified simply. The composition and quantity of both are dependent upon the material being worked, the process, procedures and consumables 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 material being worked (such as paint, plating or galvanizing), the number of welding operations and the volume of the work area, the quality and amount of ventilation, the position of the workers head with respect to the fume plume, as well as the presence of contaminants in the atmosphere (such as chlorinated hydrocarbon vapors from cleaning or painting activities). When the materials are consumed, the fume and gas decomposition products generated are different in percent and form from the ingredients listed in Section II. Decomposition products of normal operation include those originating from the volatilization, reaction or oxidation of the ingredients, plus those from the material being worked and the coatings etc. noted above.

Reasonably expected decomposition products from normal use of these products include a complex of the oxides and fluorides of the materials listed in Section II, as well as carbon monoxide, carbon dioxide, ozone and nitrogen oxides (refer to "Characterization of Arc Welding Fume" available from the American Welding Society). THE FUME LIMIT FOR MANGANESE (0.2 mg/m³) MAY BE REACHED BEFORE THE GENERAL LIMIT FOR WELDING FUMES OF 5mg/m³ IS REACHED. MONITOR FUMES FOR MANGANESE LEVELS. The only way to determine the true identity of the decomposition products is by sampling and analysis. The composition and quantity of the fumes and gases to which a worker may be overexposed can be determined from a sample obtained from inside the welder's helmet, if worn, or in the workers breathing zone. See ANSI/AWS F1.1 "Method for Sampling Airborne Particles Generated by Welding and Allied Processes", available from the American Welding Society.

VI. Physical and Health Hazard Data

Welding and Brazing may create one or more of the following health or physical hazards. Fumes and gases can be dangerous to your health. Electric shock can kill you. Arc rays can injure eyes and burn skin. Noise can damage hearing. Brazing alloys are frequently used with a fluoride type flux. If applicable, flux fume should be considered in evaluation of hazards.

Route of overexposure: The primary route of entry of the decomposition products is by inhalation. Skin contact, eye contact, and ingestion are possible. Absorption by skin contact is unlikely. If the fluxing materials are physically liberated, it can burn skin and severely injure eyes. When these products are used as recommended by **THE ESAB GROUP**, and ventilation maintains exposure to the decomposition products below the limits recommended in this section, overexposure is unlikely.

Effects of acute (short-term) overexposure to the gases, fumes and dusts may include irritation of the eyes, lungs, nose and throat. Some toxic gases associated with welding may cause pulmonary edema, asphyxiation, and death. Acute overexposure may include signs and symptoms such as watery eyes, nose and throat irritation, headache, dizziness, difficulty in breathing, frequent coughing, or chest pain. The presence of copper, magnesium and zinc in fume can cause metal fume fever. Short term symptoms may include a metallic taste in the mouth, dryness or irritation of the throat followed by coughing, shortness of breath, nausea, fever, body aches, and chills. Excessive inhalation of zinc oxide fume may produce symptoms known as zinc shakes, an acute self limiting condition without recognized complications. Symptoms usually disappear within 24 hours.

Pre-existing Medical Conditions Aggravated by Overexposure: Individuals with allergies or impaired respiratory function may have symptoms worsened by exposure to welding fumes. However, such reaction cannot be predicted due to the variation in composition and quantity of the decomposition products.

Effects of chronic (long-term) overexposure to air contaminants may lead to their accumulation in the lungs, a condition which may be seen as dense areas on chest X-rays. The severity of the change is proportional to the length of the exposure. The changes seen are not necessarily associated with symptoms or signs of reduced lung function or disease. In addition, the changes on X-rays may be caused by non-work factors such as smoking, etc. Long term exposure to welding and brazing fume, gases or dust may contribute to pulmonary irritation or pneumoconiosis. Chronic fluoride absorption can cause sclerosis of the bones and mottled teeth. Overexposure to manganese compounds can affect the central nervous system, symptoms of which are languor, sleepiness, muscular weakness, emotional disturbances, and spastic gate. The effect of manganese on the nervous system is irreversible. Chronic exposure to high levels of airborne or ingested lead may result in anemia, nausea and constipation.

Exposure limits for the ingredients are listed in Section II. The 1989 OSHA TWA for welding fume is 5 mg/m³. TLV-TWAs should be used as a guide in the control of health hazards and not as fine lines between safe and excessive concentrations. As noted in Section V, the welding fume is a mixture of many components. Therefore, a statutory computation of the *equivalent exposure* is required. The *equivalent exposure* value for the welding fume shall always be less than one. When these products are used as recommended by **THE ESAB GROUP**, and the preventive measures taught in this MSDS are followed, overexposure to hazardous substances will not occur.

Emergency First Aid Measures: In case of emergency, call for medical aid. Employ first aid technique recommended by the Red Cross. IF BREATHING IS DIFFICULT, give oxygen and call for a physician. If breathing has stopped, perform artificial respiration. Summon medical aid immediately. FOR ARC BURN, apply cold, clean compresses and call a physician.

Carcinogenic Assessment (NTP Annual Report, IARC Monographs, Other): None.

● **WARNING:** This product, when used for welding or cutting, produces fumes or gases which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health & Safety Code §25249.5 et seq.)

VII. Precautions for Safe Handling and Use/Applicable Control Measures

Read and understand the manufacturer's instructions and the precautionary label on this product. See American National Standard Z-49.1, "Safety in Welding and Cutting," published by the American Welding Society, P. O. Box 351040, Miami, FL 33135 and OSHA Publication 2206 (29 C.F.R. 1910), U.S. Government Printing Office, Washington, D.C. 20402 for more detail on many of the following:

Respiratory Protection: Use respirable fume respirator or air supplied respirator when welding in confined spaces or where local exhaust or ventilation does not keep exposure below TLVs.

Eye Protection: Wear helmet or use face shield with filter lens. As a rule of thumb, start with a shade which is too dark to see the weld zone. Then go to the next lighter shade which gives sufficient view of the weld zone. Provide protective screens and flash goggles, if necessary, to shield others.

Ventilation: Use enough ventilation, local exhaust at the arc, or both, to keep the exposure within legal limits. In the worker's breathing zone and in the general area, fumes and gases must be kept below the TLVs and the *equivalent exposure* must compute to less than one.. Train the welder to keep his head out of the fumes.

Protective Clothing and Equipment: Wear head, hand and body protection which help to prevent injury from radiation, sparks and electrical shock. See ANSI Z-49.1. At a minimum, this includes welder's gloves and a protective face shield and may include arm protectors, aprons, hats, shoulder protection, as well as dark substantial clothing. Train the welder not to touch live electrical parts and to insulate himself from work and ground.

Procedure for Cleanup of Spills or Leaks: Recyclable/solid. Vacuuming recommended for accumulated dusts. Conform with Federal, State, Local and OSHA regulatory statutes.

Waste Disposal Methods: Prevent waste from contaminating surrounding environment. Discard any product, residue, disposable container, or liner in an environmentally acceptable manner, in full compliance with Federal, State, and Local regulations.

Precautions to be Taken in Handling and Storage: Dust should be kept to a minimum. Dry storage. Ambient temperatures.

The opinions expressed in this MSDS are those of qualified experts within **THE ESAB GROUP**. We believe that the information contained herein is current as of the date of this MSDS. Since the use of this information and these opinions and the conditions of use of these products are not within the control of **THE ESAB GROUP**, it is the user's obligation to determine the conditions of safe use of these products.