



MATERIAL SAFETY DATA SHEET (MSDS)
For Welding Consumables and Related Products
Conforms to OSHA Hazard Communication Standard 29CFR 1910.1200
Standard Must Be Consulted for Specific Requirements

SECTION I - IDENTIFICATION

Manufacturer/Supplier: Washington Alloy Company Address: 7010-G Reames Road, Charlotte, NC 28216	Telephone No: 704-598-1325 Emergency No: 704-598-1325
Trade Name: USA 80T1-A1, 80T5-B3L, 80T5-B6, 81T-Ni2, 81T1-1 Ni1, 81T1-A1, 81T1-B2 81T1-Ni2, 81T1-W, 91T1-B3, 91T1-K2, 110T-K3, 110T1-K3, 110T5-K4	Specification: AWS A5.29

SECTION II - HAZARDOUS MATERIALS

IMPORTANT: this section covers the materials from which the product is manufactured. The fumes and gases produced during welding with the normal use of this product are covered under Section V. The term "HAZARDOUS MATERIALS" should be interpreted as a term required and defined in OSHA HAZARD COMMUNICATION STANDARD 29 CFR 1910.1200 however the use of this term does not necessarily imply the existence of any hazard.

Flux or other ingredients	% Weight	CAS No.	Exposure Limit (mg/m3)	
			OSHA PEL	ACGIH TLV
Iron (Fe) (limits as oxide fume)	75-95	7439-89-6	10	5
Manganese (Mn)(limits as fume) ⁽¹⁾	4.00	7439-96-5	1, 3.0**, 5 *	0.2
Nickel (Ni) ⁽¹⁾	4.50	7440-02-0	1	1, 1.5 (inhalable fraction)
Molybdenum (Mo)	2.75	7439-98-7	15	10, 20**
Chromium (Cr) ^{(C) (1)}	11.00	7440-47-3	1 (metal) 0.5 (Cr III) 0.005 (Cr VI)	0.5 (metal) 0.5 (Cr III) 0.05 (Cr VI)
Silicon (Si)	3.75	7440-21-3	15 (dust) 5 (Resp)	10, 20**
Titanium Oxide ⁽¹⁾	10.00	13463-67-7	15, 5 (Resp)	10, 20**
Copper (Cu) ⁽¹⁾	2.00	7440-50-8	1 (dust) 0.1(fume)	1 (dust) 0.2 (fume)
Calcium Fluoride ⁽¹⁾	5.50	7789-75-5	2.5 (as F)	2.5 (as F)

Occupational Safety and Health Administration 29 CFR 1910.1000 Permissible Exposure Limit (PEL). American Conference of Governmental Industrial Hygienists (ACGIH) Threshold Limit Value (TLV[R]). *Ceiling Limit **Short Term Exposure Limit ⁽¹⁾Subject to reporting requirements of Section 302, 304, 311, 312, and 313 of the Emergency Planning and Community Right-To-Know Act of 1986 and 40CFR 370 and 372; ^(C) TLV & PEL for water soluble Cr. III and Cr. VI ,Welding and cutting of products that contain Chromium may produce hexavalent chromium and YOU should read and follow OSHA 's final rules Fed Register # :71:10099-10385 dated 02-28-2006. (Resp) = Respiratory/ Respiration (Mo) Not found in 81T1-Ni2 Single values shown are maximum Other elements or ingredients may be present but in quantities much less than 1%

SECTION III - PHYSICAL DATA

Tubular wire filled with flux, metal, and other ingredient listed in Section II

SECTION IV – FIRE AND EXPLOSION HAZARD DATA

Non-Flammable: Welding arc and sparks can ignite combustibles. See Z-49.1 referenced in Section VI.

SECTION V – REACTIVITY DATA

Hazardous Decomposition Products

Welding fumes and gases cannot be classified simply. The composition and quantity of these fumes and gases are dependent upon the metal being welded, the procedures followed and the electrodes used. Workers should be aware that the composition and quantity of fumes and gases to which they may be exposed, are influenced by: coatings which may be present on the metal being welded (such as paint, plating, or galvanizing), the number of welders in operation and the volume of the work area, the quality and amount of ventilation, the position of the welder'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 procedure). When the electrode is consumed, the fumes and gas decomposition products generated are different in percent and form from the ingredients listed in Section II, The composition of these fumes and gases are the concerning matter and not the composition of the electrode itself. Decomposition products include those originating from the volatilization, reaction, or oxidation of the ingredients shown in Section II, plus those from the base metal, coating and the other factors noted above.

Reasonable expected fume constituents of this product would include: Complex oxides of iron, manganese, silicon, titanium, chromium, nickel and Molybdenum. Fume limit for Cr (VI) may be reached before limit of 5 mg/m3 for general welding fumes is reached. Watch the CR (VI) level.

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Gaseous reaction products may include carbon monoxide and carbon dioxide

Ozone and nitrogen oxides may be formed by the radiation from the arc.

One method of determining the composition and quantity of the fumes and gases to which the workers are exposed is to take an air sample from inside the welder's helmet while worn or within the worker's breathing zone. See ANSI/AWS F1.1 publication available from the American Welding Society 550 N.W. LeJeune Road, Miami, Florida 33126.

SECTION VI- HEALTH HAZARD DATA

Threshold Limit Value: The ACGIH recommended general limit for welding fume NOC (Not otherwise classified) is 5 mg/m³. ACGIH-1985 preface states: "The TLC-TWA should be used as guides in the control of health hazards and should not be used as fine lines between safe and dangerous concentrations." See section II and V for specific fume constituents, which may modify this TLV.

Common Entry Is by Inhalation or Through the Eyes and Skin.

Effects of Overexposure: Inhalation of welding fumes and gases can be dangerous to your health. Short-term (acute) overexposure to welding fumes may result in discomfort such as dizziness, nausea, or dryness or irritation of nose, throat, or eyes. Chromium (VI) compounds present in the fume may cause severe irritation of the bronchial tubes and lungs. Ingesting Chromium (VI) salts may cause injury or death. (Chromium (VI) compounds may burn eyes. Chromium compounds may cause allergic reactions in some people. Nickel oxides present in the fume may cause tightness around the chest, fever and allergic reactions in some people.

Manganese – Manganese dioxide (MnO₂): Short-term overexposure should be treated by removal from exposure and applying artificial respiration if needed. Wash eyes and/or skin with water to remove any dust particles. Long-term (chronic) over-exposure to welding fumes can lead to siderosis (iron deposits in lung) and is believed to affect pulmonary function. Constant inhalation of Chromium (VI) compounds may cause an ulceration and perforation of the nasal septum as well as liver and kidney damage. Repetitive overexposure to nickel oxides may lead to lung fibrosis or pneumoconiosis. Workers exposed to Chromium (VI) compounds and/or nickel oxides have a higher incidence of lung fibrosis and nasal cancers. Chromium and nickel compounds are on the IARC (International Agency for Research of Cancer) as posing a carcinogenic risk to human.

Manganese – Manganese dioxide (MnO₂): Long-term overexposure to manganese compounds may have an effect upon the central nervous system. Symptoms such as muscular weakness, body tremors and behavioral changes may appear. Employees exposed to manganese compounds should get medical examinations several times annually for early detection of manganese poisoning.

Arc Rays can injure eyes and burn skin.

Electric shock can kill.

See Section VII.

Emergency and First Aid Procedures: Call for medical assistance. Use first aid procedures recommended by the American Red Cross. If breathing is difficult – give oxygen. If not breathing-use CPR (cardiopulmonary resuscitation). Consult a physician if irritation of the eyes and skin or flash burns develops after exposure.

Carcinogenicity

OSHA (29 CFR 1910.1200) lists Nickel and Chromium VI as a possible carcinogen.

California Proposition 65

These products contain or produces chemicals known to the State of California to cause cancer, and/or birth defects (or other reproductive harm). (Health and Safety Code section 25249.5 et seq.)

SECTION VII – CONTROL MEASURES AND PRECAUTIONS FOR SAFE HANDLING AND USE

Read and understand the manufacturer's instructions and precautionary label on this product and your employer's safety practices. See American Standard Z49.1 Safety in Welding and Cutting, published by the AMERICAN WELDING SOCIETY, 550 N.W. LeJeune Road, Miami, Florida 33126 and OSHA Publication 2206 (29 CFR1910), U.S. Government Printing Office, Superintendent of Documents, P.O. Box 37954, Pittsburg, Pa 15250-7954 for more details on the following topics.

Ventilation: Use plenty of ventilation and/or local exhaust at the arc, to keep the fumes and gases below the threshold limit value within the worker's breathing zone and the general work area. Welders should be advised to keep their head out of the fumes.

Respiratory Protection: Use respirable fume respirator or air supplied respirator when welding in a confined space or general work area where local exhaust and/or ventilation does not keep exposure below the threshold limit value.

Eye Protection: Wear a helmet or face shield with a filter lens shade number 12-14 or darker. Shield other workers by providing screens and flash goggles.

Protective Clothing: Wear approved head, hand and body protection, which help to prevent injury from radiation, sparks and electrical shock. See ANSI Z-49.1. This would include wearing welder's gloves and a protective face shield and may include arm protectors, apron, hats, shoulder protection, as well as dark substantial clothing. Welders should be trained not to allow electrically live parts to contract the skin or wet clothing and gloves. The welders should insulate themselves from the work and ground.

Waste Disposal Method: Discard any product, residue, disposal container, or liner in an environmentally acceptable manner approved by Federal, State and Local regulations.

Washington Alloy Co. Believes that the information contained in this (MSDS) Material Safety Data Sheet is accurate. However, Washington Alloy Co. does not express or implies any warranty with respect to this information.

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