



SAFETY DATA SHEET

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SDS Number: CAN346-C
Date Revised: 04/03/2013

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: OK® SUBMERGED ARC WELDING FLUXES
Application: Arc Welding
Classification:
Supplier: ESAB GROUP CANADA, INC., 6010 Tomken Road, Mississauga, ON L5T 1X9
Telephone No.: (905) 670-0220, 1-877-935-3226
Web site: www.esab.ca

2. HAZARDS IDENTIFICATION

Emergency Overview: Granules in varying colors. These products are normally not considered hazardous as shipped. Gloves should be worn when handling to prevent contaminating hands with product dust.

Some of these products contain nickel, which is classified as toxic by prolonged inhalation, a skin sensitizer and a suspect carcinogen. Nickel powder is harmful for the environment. Some of these products contain titanium dioxide which is possibly carcinogenic. These products contain quartz, but normally not in an inhalable fraction. Quartz can cause silicosis and may cause cancer.

Avoid eye contact or inhalation of dust from these products. Skin contact is normally no hazard but should be avoided to prevent possible allergic reactions.

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: Welding fumes are normally not a hazard with submerged arc welding, unless the arc burns through the flux bedding. Use enough flux to avoid burn-through. Overexposure to welding fumes may result in symptoms like metal fume fever, dizziness, nausea, dryness or irritation of the nose, throat or eyes. Chronic overexposure to welding 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.

3. COMPOSITION/INFORMATION ON INGREDIENTS

These products are agglomerations of calcined minerals.

Ingredients	REACH Reg. #	CAS#	EINECS#	Hazard classification ⁽¹⁾	IARC ⁽³⁾	NTP ⁽³⁾	OSHA List ⁽⁴⁾
Aluminum Oxide	--	1344-28-1	215-691-6	No	--	--	--
Aluminum Silicate	--	12141-46-7	235-253-8	No	--	--	--
Calcium Carbonate	--	1317-65-3	215-279-6	No	--	--	--
Calcium Fluoride	--	7789-75-5	232-188-7	No	--	--	--
Calcium Oxide	--	1305-78-8	215-138-9	No	--	--	--
Calcium Silicate	--	10101-39-0	233-250-6	No	--	--	--
Chromium	--	7440-47-3	231-157-5	No	--	--	--
Iron	01-2119462838-24	7439-89-6	231-096-4	No	--	--	--
Iron Oxide	--	1309-37-1	215-168-2	No	--	--	--
Magnesium Oxide	--	1309-48-4	215-171-9	No	--	--	--
Manganese	--	7439-96-5	231-105-1	No	--	--	--
Manganese Oxide	--	1344-43-0	215-695-8	No	--	--	--
Molybdenum	--	7439-98-7	231-107-2	No	--	--	--
Nickel Powder	--	7440-02-0	231-111-4	Carc. Cat. 3; R40 T; R48/23 R43 R52/53	2B	S	--
Potassium Oxide	--	12136-45-7	235-227-6	No	--	--	--
Silicate Binder (Potassium Silicate)	--	1312-76-1	215-199-1	No	--	--	--
Silicate Binder (Sodium Silicate)	--	1344-09-8	215-687-4	No	--	--	--



Ingredients	REACH Reg. #	CAS#	EINECS#	Hazard classification ⁽¹⁾	IARC ⁽³⁾	NTP ⁽³⁾	OSHA List ⁽⁴⁾
Silicon Dioxide	--	14808-60-7	238-878-4	T; R45	1	K	--
Titanium Oxide	--	13463-67-7	236-675-5	No	2B	--	--

⁽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).

APPROXIMATE COMPOSITION (Wt. %)

Product Trade Name:	OK Flux 10.05	OK Flux 10.06	OK Flux 10.07	OK Flux 10.10	OK Flux 10.11	OK Flux 10.16	OK Flux 10.63	OK Flux 10.90	OK Flux 10.92	OK Flux 10.93	OK Flux 10.94	OK Flux 10.95
Aluminum Oxide	20-30	--	--	20-30	10-15	20-30	20-30	30-40	--	40-50	30-40	30-40
Aluminum Silicate	20-30	20-30	20-30	--	--	--	--	--	30-40	--	--	--
Calcium Carbonate	--	--	--	--	--	--	5-10	--	--	--	--	--
Calcium Oxide	<1	--	--	--	--	--	--	--	--	--	--	--
Calcium Silicate	--	--	--	1-2	2-5	--	5-10	--	--	--	--	--
Chromium	--	10-15	--	--	--	--	--	1-2	5-10	--	2-5	--
Fluorides	20-30	5-10	10-15	60-70	70-80	50-60	20-30	40-50	5-10	50-60	50-60	50-60
Iron	--	5-10	1-2	--	--	--	--	--	2-5	--	1-2	--
Iron Oxide	1-2	--	--	--	--	<1	--	--	--	--	--	--
Magnesium Oxide	10-15	20-30	20-30	--	--	--	20-30	--	30-40	--	--	--
Manganese	--	--	--	--	--	--	--	5-10	--	--	--	--
Manganese Oxide	--	--	--	--	--	2-5	<1	--	--	--	--	--
Molybdenum	--	5-10	2-5	--	--	--	--	--	--	--	--	--
Nickel	--	5-10	5-10	--	--	--	--	1-2	--	--	--	2-5
Potassium Oxide	--	--	--	--	--	--	--	--	--	--	1-2	--
Silicate Binder	10-15	5-10	5-10	5-15	10-15	5-10	5-10	10-15	5-10	5-10	10-15	5-10
Silicon Dioxide	<1	5-10	5-10	<1	<1	1-2	1-2	<1	5-10	<1	<1	<1
Titanium Oxide	--	--	--	--	--	5-10	--	--	--	--	--	--

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:** For radiation burns due to arc flash, see physician. To remove dusts or fumes flush with water for at least fifteen minutes. If irritation persists, obtain medical assistance.
- Skin contact:** For skin burns from arc radiation, promptly flush with cold water. Get medical attention for burns or irritations that persist. To remove dust or particles wash with mild soap and water.
- 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

No specific recommendations for welding consumables. Welding arcs and sparks can ignite combustible and flammable materials. Use the extinguishing media recommended for the burning materials and fire situation. Wear 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.

Personal precautions: refer to Section 8.

Environmental precautions: refer to Section 13.

7. HANDLING AND STORAGE

Handling:

Handle with care to avoid stings and cuts. Wear gloves when handling welding consumables. Avoid exposure to dust. Do not ingest. Some individuals can develop an allergic reaction to certain materials. Retain all warning and identity labels.

Storage:

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

8. EXPOSURE CONTROL/PERSONAL PROTECTION

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

Engineering measures:

Ensure sufficient ventilation, local exhaust, or both, to keep welding 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:

Use respirator or air supplied respirator when welding or brazing in a confined space, or where local exhaust or ventilation is not sufficient to keep exposure values within safe limits. Use special care when welding 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 welding fume analysis refer to Section 10.

Substance	CAS#	ACGIH TLV ⁽¹⁾ mg/m ³	OSHA PEL ⁽²⁾ mg/m ³
Aluminum Oxide	1344-28-1	1** (as Al)	15*, 5**
Aluminum Silicate (as Al)	12141-46-7	1**	15*, 5**
Calcium Carbonate	1317-65-3	Withdrawn	15*, 5**
Calcium Fluoride (as F)	7789-75-5	2.5	2.5
Calcium Oxide	1305-78-8	2	5
Calcium Silicate	10101-39-0	10	15*, 5**
Chromium Compounds	7440-47-3		
Metal (as Cr)		0.5	1
Cr (VI), inorganic, water insoluble (as Cr)		0.01	0.005
Cr (VI), inorganic, water soluble (as Cr)		0.05	0.005
Iron (as iron oxide)	7439-89-6	5**	10 (fume)
Iron Oxide	1309-37-1	5**	10 (fume)
Magnesium Oxide	1309-48-4	10 ***	15* (fume, total particulate)
Manganese and inorganic compounds (as Mn)	7439-96-5	0.02**, 0.1***	5 Ceiling
Manganese, fume (as Mn)	7939-96-5	0.2	5 Ceiling
Molybdenum (metal and insoluble compounds, as Mo)	7439-98-7	3 **, 10 ***	15*
		0.5 **	5
Nickel, elemental	7440-02-0	1.5***	1
Potassium Oxide	12136-45-7	None	None
Silicate Binder (Potassium Silicate & Sodium Silicate)	1312-76-1 1344-09-8	None None	None None
Silicon Dioxide (amorphous, fume)	60676-86-0	Withdrawn	None
Silicon Dioxide (quartz)	14808-60-7	0.025**	10 mg/m ³ ### %SiO ₂ +2
Titanium Oxide	13463-67-7	10	15*



- (1) Threshold Limit Values according to American Conference of Governmental Hygienists, 2013
(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.

Respirable dust

NOTE: Some of these products may not contain all of the materials listed. For details of composition, refer to the COMPOSITION TABLES in Section 3.

9. PHYSICAL AND CHEMICAL PROPERTIES

Appearance: Granules, non-volatile with varying color.

Melting Point: >1000°C/>1800°F

10. STABILITY AND REACTIVITY

General: These products are only intended for normal welding purposes.

Stability: These products are stable under normal conditions.

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

When these products are used in a welding 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 are normally not generated in submerged arc welding, provided that a sufficient flux bedding is used to prevent the arc from burning through. If the arc burns through the flux bedding, reasonably expected fume constituents of these products would include fluorides and oxides of metals such as iron, manganese, chromium, nickel, magnesium, calcium, sodium, potassium, aluminum, silicon, molybdenum and titanium.

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, in some countries, that may be easily exceeded.

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

11. TOXICOLOGICAL INFORMATION

Inhalation of welding fumes and gases can be dangerous to your health. Classification of welding 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 welding fumes may result in symptoms like metal fume fever, dizziness, nausea, dryness or irritation of the nose, throat or eyes.

Chronic toxicity: Overexposure to welding 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. Prolonged inhalation of titanium dioxide above safe exposure limits can cause cancer. Inhalable quartz is a respiratory carcinogen; however, the process of welding converts crystalline quartz to the amorphous form which is not considered to be a carcinogen.

12. ECOLOGICAL INFORMATION

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

Nickel powder is harmful for the environment. Harmful to aquatic organisms, may cause long-term adverse effects in the aquatic environment.

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 residue containing chromium is considered hazardous waste if discarded, RCRA ID characteristic Toxic Hazardous Waste D007.

Residues from welding consumables and processes could degrade and accumulate in soils and groundwater. Welding slag from these products typically contain mainly the following components: Fe, O, Mn, Cr, Ni, F, Na, Si, K, Ca, Al, Mg, Mo and Ti.

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 welding and protect yourself and others.

WARNING: Welding 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

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

USA: Under the OSHA Hazard Communication Standard, these products are considered hazardous.

These products contain or produce 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 these products 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)
Chromium	5000	--
Nickel	100	--

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 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
Chromium	1.0% de minimis concentration
Manganese	1.0% de minimis concentration
Nickel	0.1% de minimis concentration

According to EC Directive 88/379/EEC, some of these products are classified with the following risk and safety phrases due to their content of nickel.

Symbols:



Harmful:

- R-phrases:**
- R40 –** Limited evidence of a carcinogenic effect.
 - R43 –** May cause sensitization by skin contact.
 - R48/20 –** Harmful danger of serious damage to health by prolonged exposure through inhalation.
- S-phrases:**
- S2 –** Keep out of the reach of children.
 - S22 –** Do not breathe dust.
 - S24 –** Avoid contact with skin.
 - S37 –** Wear suitable gloves.



16. OTHER INFORMATION

This Safety Data Sheet has been revised due to modifications to Section 8. This SDS supersedes CAN346-B.

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".

These products have 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: R40 – Limited evidence of a carcinogenic effect.

R43 – May cause sensitization by skin contact.

R45 – May cause cancer.

R48/23 – Toxic: danger of serious damage to health by prolonged exposure through inhalation.

R52/53 – Harmful to aquatic organisms, may cause long-term adverse effects in the aquatic environment.

ESAB requests the users of these products to study this Safety Data Sheet (SDS) and become aware of product hazards and safety information. To promote safe use of these products 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 these products.
- request such customers to notify employees and customers for the same product hazards and safety information.

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