

60410-01



MSDS – Ni-Cr Bare Wire and Strip Electrodes and Rods

Revision 6

Issue Date – June, 2006

MATERIAL SAFETY DATA SHEET

SECTION 1: PRODUCT AND COMPANY IDENTIFICATION

Manufacturer/Supplier Name: Sandvik Materials Technology

Address: P.O. Box 1220, Scranton, PA 18501-1220

Phone Number: (570)-585-7500

Trade Name: SANDVIK

Classification: AWS A5.9/ASME SFA 5.9, ASME SFA 5.9 Section III, MIL-E-19333, ABS, CWB-AWS A5.9 Corrosion Resisting Chromium and Chromium Nickel Steel Bare Wire and Strip Welding Electrodes and Welding Rods.

Product Type: Cr-Ni Bare Wire and Strip Electrodes and Rod for manual, semi-automatic, and automatic welding processes.

Product Identifiers: 18Cb, 307,308/308L, 308LSi, 308/308H, 347, 347Si, 347L, 316/316L, 316LSi, 316/316H, 317L, 309L, 309LCb, 309LHF, 309, 309LSi, 309MoL, 310, 310H, 312, 320, 330, 409Cb, 410, 410NiMo, 420, 430, 630,383,385, 20.25.5LCu, 21.11.LNb, 21.13.3.L, 25.22.2.LMn, 27.31.4.LCu, 22.12.HT, 2209, 25.20.L, 25.10.4.L, 16.13CMnW, 442, 439Ti, 439, 19.TiCb, 430LCb

SECTION 2: HAZARDS IDENTIFICATION

Chromium-Nickel bare wire and electrodes and strip are welding consumables which are either solid wire or strip.

EMERGENCY OVERVIEW

Effects of Over-exposure:

Electric arc welding may create one or more of the following health hazards:

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.

LONG-TERM (chronic) OVEREXPOSURE to welding fumes can lead to siderosis (iron deposits in lungs), central nervous system, liver or kidney damage, skin and respiratory sensitization (allergic reaction), and is believed by some investigators to affect pulmonary function.

PRIMARY ROUTE OF ENTRY is the respiratory system.

MEDICAL CONDITIONS AGGRAVATED BY EXPOSURE: Pre-existing eye, respiratory or allergic conditions.

ARC RAYS can injure eyes and burn skin.

ELECTRIC SHOCK can kill.

CARCINOGENICITY:

Certain hexavalent chromium compounds, nickel metal and compounds and respirable crystalline silica are listed in the National Toxicology Program (NTP) Annual Report on Carcinogens, found to be a potential carcinogen in the International Agency for Research on Cancer (IARC) Monographs, or listed by OSHA/ACGIH as potential carcinogens.

Refer to Section 8 for occupational exposure limits.

SECTION 3: COMPOSITION/INFORMATION ON INGREDIENTS

The following is composition information of the product as manufactured.

Hazardous Ingredient	CAS No.	WT %
Chromium (Cr)	7440-47-3	1-30
Copper (Cu)	7440-50-8	0-4
Iron (Fe)	7439-89-6	Bal.
Manganese (Mn)	7439-96-5	1-5
Molybdenum (Mo) ¹⁾	7439-98-7	1-5
Nickel (Ni)	7440-02-0	1-35
Niobium (Nb) ²⁾	7440-03-1	0.5-1
Silicon (Si)	7440-21-3	0.4-2

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The following are typical constituents of welding fumes and gases. When the electrode is consumed, the fume and gas decomposition products generated are different in percent and form than ingredients listed above. Decomposition products of normal operation include those originating from the volatilization reaction, or oxidation of the materials shown above, plus those from the base metal and coating, etc. which may include paint, plating, galvanizing, or phosphate coatings on steels which would produce phosphine gas and other contaminants in the atmosphere (such as chlorinated hydrocarbon vapors from cleaning and degreasing activities which may be decomposed by the arc into toxic gases such as phosgene).

Fume Constituent (Gases)	CAS No.	Fume Constituents (Solids)	CAS No.
Dinitrogen Tetroxide (N ₂ O ₄)	10544-72-6	Chromates (CrO ₃)	1333-82-0
Nitric Oxide (NO)	10102-43-9	Copper Oxide (CuO)	1344-70-3
Nitrogen Dioxide (NO ₂)	10102-44-0	Manganese Oxide (MnO)	11129-60-5
Ozone (O ₃)	10028-15-6	Nickel Oxide (NiO)	1314-06-3
Phosgene (COCl ₂) *	75-44-5	Iron Oxide (Fe ₂ O ₃)	1309-37-1
Phosphine (PH ₃) **	7803-51-2	Molybdenum Trioxide (MoO ₃) ¹⁾	1313-27-5
		Niobium Oxide (NbO) ²⁾	12034-57-0
		Silica (SiO ₂) (quartz)	14808-60-7

* May result from contact with chlorinated hydrocarbon vapors.

** May result from welding on phosphate coated steels.

1) Only in Molybdenum-alloyed grades.

2) Only in Niobium-alloyed grades.

SECTION 4: FIRST AID MEASURES

Eye: If eye irritation occurs, flush eyes immediately with water while holding open eyelids. Get medical attention if irritation persists.

Skin: None normally needed. Get immediate medical attention for treatment of burns.

Inhalation: Remove victim to fresh air. Give artificial respiration if needed. If breathing is difficult, oxygen should be administered by qualified personnel. Get immediate medical attention.

SECTION 5: FIRE FIGHTING MEASURES

(Nonflammable) – Welding arc and sparks can ignite combustibles and flammables. Refer to American National Z49.1 for fire prevention during the use of welding and allied procedures.

SECTION 6: ACCIDENTAL RELEASE MEASURES

Pick up and return to container for use.

SECTION 7: HANDLING AND STORAGE

Avoid breathing welding fumes. Keep your head out of the fumes. Use with enough ventilation or exhaust at the arc, or both, to keep fumes and gases below the occupational exposure limits in your breathing zone and the general area. Use air sampling to determine the need for corrective action. (Refer to Section 10 for additional information)

Work in a confined space only if it is well ventilated, or while wearing an air-supplied respirator. Fumes from welding and oxygen depletion can alter the air quality causing injury or death.

Take appropriate precautions to prevent fires and explosion.

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Read and understand the manufacturer's instructions and the precautionary label on the product. See American National Standard Z49.1, Safety in Welding and Cutting, published by the American Welding Society, P.O. Box 351040, Miami, FL 33135; and OSHA Publication 2206 (29CFR 1910), U.S. Government Printing Office, Washington, DC 20402, for more information. Assure compliance with the OSHA Standard on Chromium (VI), 29CFR 1910.1026.

Storage: Store in a clean dry area.

SECTION 8: EXPOSURE CONTROLS/PERSONAL PROTECTION

The following are the occupational exposure limits for the components of the product as manufactured.

<u>Ingredient</u>	<u>PEL (mg/m3)</u>	<u>TLV (mg/m3)</u>	<u>STEL (mg/m3)</u>
Chromium (Cr)	1	0.5	-
Copper (Cu)	1	1	-
Iron (Fe)	10	5	-
Manganese (Mn)	5 Ceiling Limit	0.2	3
Molybdenum (Mo) ¹⁾	None Established	3 (respirable fraction)	-
Nickel (Ni)	1	1.5	-
Niobium (Nb) ²⁾	None Established	None Established	-
Silicon (Si)	None Established	None Established	-

The following are the occupational exposure limits for the typical decomposition products.

GASES

<u>Fume Constituent</u>	<u>PEL</u>	<u>TLV</u>	<u>STEL</u>
Dinitrogen Tetroxide (N ₂ O ₄)	None Established	None Established	-
Nitric Oxide (NO)	25ppm	25ppm	-
Nitrogen Dioxide (NO ₂)	5 ppm Ceiling Limit	3ppm	5 ppm
Ozone (O ₃)	0.1 ppm	0.1 ppm ***	-
Phosgene (COCl ₂) *	0.1 ppm	0.1 ppm	-
Phosphine (PH ₃) **	0.3 ppm	0.3 ppm	1 ppm

SOLIDS

<u>Fume Constituents</u>	<u>PEL (mg/m3)</u>	<u>TLV (mg/m3)</u>	<u>STEL (mg/m3)</u>
Chromates (CrO ₃)	0.005 (as Cr) 0.0025 action level	0.05 (as Cr)	-
Copper Oxide (CuO)	0.1 (fume)	0.1 (fume)	-
Iron Oxide	5 (as Fe)	10 (as Fe)	-
Manganese Oxide (MnO)	5 (fume) Ceiling Limit	0.2	-
Molybdenum Trioxide (MoO ₃) ¹⁾	None Established	3 (respirable fraction)	-
Nickel Oxide (NiO)	1	0.1	-
Niobium Oxide (NbO) ²⁾	None Established	None Established	-
Silica (SiO ₂) (quartz)	10 (respirable %SiO ₂ +2 fraction)	0.05	-

1. Only in Molybdenum-alloyed grades.

2. Only in Niobium-alloyed grades.

Definitions:

PEL/TLV/STEL values are mg/m³, except where indicated as ppm (parts per million).

Permissible Exposure Limit (mg/m³) OSHA (29CFR 1910) – An exposure limit that is published and enforced by OSHA as a legal standard.

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Threshold Limit Value (mg/m³) – American Conference of Governmental Industrial Hygienists – Time weighted average concentration for a normal 8-hour work day and a 40-hour work week to which nearly all workers may be repeatedly exposed, day after day, without adverse effect.

Short Term Exposure Limit (mg/m³) OSHA (29CFR 1910) – A 15-minute time weighted average exposure which should not be exceeded at any time during a work day.

Ceiling Limit – The concentration that should not be exceeded during any part of the working exposure.

- * May result from contact with chlorinated hydrocarbon vapors.
- ** May result from welding on phosphate coated steels.
- *** For light work: 0.1ppm; for moderate work: 0.08ppm; and for heavy work: 0.05ppm of O₃.

Ventilation: Use enough ventilation, local exhaust at the arc, or both, to keep the fumes and gases below TLV/PEL in the workers' breathing zone and the general area. Train each welder to keep his/her head out of the fumes. Refer to ANSI Z49.1 and Section 10 for additional information.

Respiratory Protection: Use respirable fume respirator or air-supplied respirator when welding in confined area, or where local exhaust or ventilation does not keep exposure below TLV/PEL. Respirator selection and use should be based on contaminant type, form and concentration. Follow OSHA 1910.134, OSHA 1910.1026, ANSI Z88.2 and good Industrial Hygiene practice.

Protective Clothing: Wear head, hand, and body protection to help prevent injury from radiation, sparks, and electric shock. See ANSI Z49.1 and OSHA 1910.1026. At a minimum, this includes welder's gloves and a protective face shield, and may include arm protectors, aprons, hats, shoulder protection, and dark substantial clothing. Train each welder not to touch live electrical parts, and to insulate his/her person from work and ground.

Eye Protection: Wear helmet or use face shield with filter lens. Lens filter should be as dark as possible without obstructing view of the weld zone. Provide protective screens and flash goggles, if necessary, to shield others.

SECTION 9: PHYSICAL AND CHEMICAL PROPERTIES

Chromium-Nickel bare wire and electrodes and strip are welding consumables which are either solid wire or strip.

SECTION 10: STABILITY AND REACTIVITY

Stability: Stable under normal conditions of storage or use.

Incompatibility/Conditions to Avoid: None known. Welding arc and sparks can ignite combustibles and flammables. Refer to American National Z49.1 for fire prevention during the use of welding and allied procedures.

Hazardous Decomposition Product

Welding fumes and gases cannot be classified simply. The composition and quantity of both are dependent upon the metal being welded, and the process, procedures, and electrodes 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 (such as paint, plating, galvanizing, or phosphate coatings on steels which would produce phosphine gas), the number of welders 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 activities which may be decomposed by the arc into toxic gases such as phosgene).

When the electrode is consumed, the fume and gas decomposition products generated are different in percent and form than ingredients in the manufactured product. Typical decomposition are also 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.

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One recommended way to determine the composition and quantity of fumes and gases to which workers are exposed is to take an air sample inside the welder's helmet, if worn, or in the worker's breathing zone. See ANSI/AWS F1.1, available from the American Welding Society, P.O. Box 351040, Miami, FL 33135.

SECTION 11: TOXICOLOGICAL INFORMATION

No acute toxicity data is available, however, these products are not expected to be acutely toxic. See Section 2 for information on human health effects.

SECTION 12: ECOLOGICAL INFORMATION

No specific data is available. These products are not expected to present an environmental hazard.

SECTION 13: DISPOSAL INFORMATION

WASTE DISPOSAL METHOD: Prevent waste from contaminating the surrounding environment. Discard any product, residue, disposable container, or liner in an environmentally accepted manner, in full compliance with federal, state, and local regulations.

SECTION 14: TRANSPORT INFORMATION

These products are not regulated for transportation under DOT, IATA or IMDG.

SECTION 15: REGULATORY INFORMATION

CERCLA 103 Reportable Quantity: These products are not subject to CERCLA reporting requirement.

SARA TITLE III:

Hazard Category for Section 311/312: Acute Health, Chronic Health

Section 313 (40CFR 372) Toxic Chemicals: This product contains the following chemicals subject to SARA Title III Section 313 Reporting requirements:

Chromium*	7440-47-3	1-30%
Copper*	7440-50-8	0-4%
Manganese*	7440-96-5	1-5%
Nickel*	7440-02-0	1-35%

* This includes all compounds of these elements.

Section 302 Extremely Hazardous Substances (TPQ): None

EPA Toxic Substances Control Act (TSCA) Status: All of the components of this product are listed on the TSCA inventory.

California Proposition 65: This product contains chromium and nickel, which are known to the State of California to cause cancer.

Canadian Environmental Protection Act: All of the ingredients are listed on the Canadian Domestic Substances List.

Canadian WHMIS Classification: Class D-2-A (Very Toxic Material causing other toxic effects)

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This MSDS has been prepared according to the criteria of the Controlled Products Regulation (CPR) and the MSDS contains all of the information required by the CPR.

EU RoHS: Sandvik Stainless Steel Welding Products contain Chromium. When welded Sandvik Stainless Steel Welding Products will produce Cr VI (hexavalent chrome), however, the weld deposit does not contain Cr VI as it will all be in the zero valent state or as Cr III as an oxide. Finished products manufactured using Sandvik Stainless Steel Welding Products will not contain Cr VI.

SECTION 16: OTHER INFORMATION

HMIS Ratings:	Health – 1*	Flammability - 0	Reactivity - 0
NFPA Ratings:	Health - 1	Flammability - 0	Reactivity - 0

* indicates the potential for chronic health effects.

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The information herein is given in good faith, but no warranty, expressed or implied, is made.