

# CROWN ALLOYS

## COMPANY

### MATERIAL SAFETY DATA SHEET

#### Section 1 – COMPANY AND MATERIAL IDENTIFICATION

**PRODUCT TYPE:** Flux cored aluminum alloy for brazing (B).  
**TRADE NAME:** **ROYAL 100 FCo & ROYAL 110 FCo**  
**SPECIFICATION:** N/A  
**CLASSIFICATION:** N/A  
**VENDOR:** Crown Alloys Company  
**ADDRESS:** 30105 Stephenson Hwy.  
 Madison Heights, MI. 48071  
**TELEPHONE:** (248) 588-3790  
**WEBSITE:** www.crownalloys.com  
**DATE:** October 14, 2004

Emergency 24 hour telephone #  
CHEMTREC (800) 424-9300

#### Section 2 - HAZARDOUS INGREDIENTS

**IMPORTANT!** This section covers the material from which these products are manufactured. The fumes and gases produced when welding with normal use of these products are covered in Sections 5 and 6.

Ingredient	CAS No.	OSHA – TWA PEL,mg/m <sup>3</sup>	(ACGIH – TWA) <sup>1</sup> TLV,mg/m <sup>3</sup>	LD <sub>50</sub>	Wt.%
Aluminum	7429-90-5	15 (total dust) 5 (respirable)	10 (Al metal) 2 (soluble salt)	N/A	85.0–95.0
Copper	7440-50-8	0.1 (fume) 1.0 (dust/mist)	0.2 (fume) 1.0 (dust/mist)	35 mg/kg, mouse intrapertoneal	0.30 max
Iron	7439-89-6	10 as Fe (oxide dust & fume)	5 as Fe (oxide dust & fume)	Not Available	1.0 max.
Magnesium	7439-95-4	15 total particulate (oxide fume)	10 (oxide fume)	Not Available	0.10 max
Manganese	7439-96-5	0.1 as dust (ceiling)	0.2 (dust fume)	9,000 mg/kg, rat, oral	0.15 max
Silicon	7440-21-3	15 (total dust) 5 (respirable)	10 (total dust)	3160 mg/kg, rat, oral	3.0 – 13.0
Titanium	7440-32-6	15 as oxide dust (total particulate)	10 as oxide dust	Not Available	0.20 max
Zinc	7440-66-6	5 (oxide fume) 15 (total oxide dust) 5 (respirable oxide dust)	5, 10 (STEL) as oxide fume 10 (total oxide dust)	Not Available	0.20 max
Aluminum Potassium Fluoride	60304-36-1	2.5 (as fluorides)	2.5 (as fluorides)	N/A	5.0–30.0 <sup>2</sup>
Ammonium Fluoroborate	13826-83-0	2.5	2.5	N/A	4.0 max <sup>3</sup>
Aminoethyleth- aneanolamine	111-41-1	NE	NE	N/A	4.0 max <sup>3</sup>
Boron (as B <sub>2</sub> O <sub>3</sub> )	N/A	10.0	10.0	N/A	3.0 max <sup>3</sup>
Fluoride (as F)	N/A	2.5	2.5	N/A	3.0 max <sup>3</sup>
Proprietary Fluorosilicate Compound	N/A	NE	NE	N/A	1.0-5.0 <sup>2</sup>
Triethanolamine	102-71-6	NE	NE	N/A	4.0 max <sup>3</sup>

<sup>1</sup>The ACGIH has an established exposure limit for Welding Fumes, Not Otherwise Classified. That Threshold Limit Value is 5 mg/m<sup>3</sup>.

<sup>2</sup>These flux ingredients are in the **ROYAL 100 FCo** only.

<sup>3</sup>These flux ingredients are in the **ROYAL 110 FCo** only.

NIOSH classifies welding fumes as carcinogens.

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### Section 3 - PHYSICAL and CHEMICAL CHARACTERISTICS

Appearance:	Silver-Gray Wire w/ white dry powder inside <b>Royal 100 FCo:</b> 18" long <b>Royal 110 FCo:</b> 32" long	pH:	Not Applicable
Freeze-Melt Point:	970 <sup>o</sup> -1215 <sup>o</sup> F (521 <sup>o</sup> -657 <sup>o</sup> C)	Odor:	None
Vapor Pressure (mm):	Not Applicable	Boiling Point:	Not Applicable
Vapor Density (air=1):	Not Applicable	Solubility In Water:	Not Applicable
Specific Gravity:	2.5 – 2.9		

### Section 4 - FIRE and EXPLOSION HAZARD DATA

-FLAMMABLE PROPERTIES: Non-flammable as *shipped*. Small chips and dust from processing may ignite readily. Welding arc and sparks can ignite combustibles and flammables. Refer to American National Standard Z49.1 for fire prevention during the use of welding and allied procedures.

-FIRE/EXPLOSION: May be a potential hazard under the following conditions:

- Dusts or fines dispersed in the air can be explosive.
- Chips, fines and dust in contact with water can generate flammable/explosive hydrogen gas. These gases could present an explosion hazard in confined or poorly ventilated spaces.
- Fines and dust in contact with certain metal oxides (e.g. rust). A thermite reaction, with considerable heat generation, can be initiated by a weak ignition source.
- Molten aluminum in contact with water/moisture can be explosive. Contact of molten aluminum with other metal oxides can initiate a thermite reaction.
- In case of fire in close proximity, fumes of fluorides may be emitted (flux in the core).

-EXTINGUISHING MEDIA: Use fire fighting methods and materials that are appropriate for surrounding fire. Use coarse water spray on chips or turnings. For fines, dust or molten aluminum, use Class D extinguishing agents. DO NOT use halogenated extinguishing agents on small chips/fines. Do not use water in fighting fires around molten aluminum. Fire fighters should wear NIOSH approved, positive pressure, self-contained breathing apparatus and full protective clothing when appropriate.

### Section 5 – STABILITY AND REACTIVITY DATA

#### *Hazardous Decomposition Products*

**STABILITY:** Aluminum is stable under normal conditions of use, storage, and transportation as shipped. Chips, fines, dust and molten aluminum are considerably more reactive ( **See Section 4** ).

**CONDITIONS TO AVOID (STABILITY):** Some components of these products may decompose at elevated temperatures.

**INCOMPATIBILITY (MATERIAL TO AVOID):** Strong acids and strong bases.

Welding/Brazing fumes and gases can not be classified simply. The composition and quantity of both are dependent upon the metal being welded, coatings on the metal being welded (such as paint, plating, or galvanizing), the number of welders, the volume of the work area, the quality and the amount of ventilation, the position of the welder's head with respect to the gas plume, the presence of contaminants in the atmosphere (such as chlorinated hydrocarbon vapors from cleaning and degreasing activities), the process and procedures, as well as the welding consumables.

When the wire is consumed, the fume and gas decomposition products generated are different in percent and form from the ingredients listed in Section 2. Decomposition products of normal operation include those originating from the volatilization, reaction, or oxidation of the materials shown in Section 2, plus those from the base metal, coatings, etc., as noted above.

Reasonably expected decomposition products from normal use of these products include a **complex of the oxides of the materials listed in Section 2, as well as carbon monoxide, carbon dioxide, ozone (TLV 0.1 ppm ceiling and PEL 0.1 ppm), nitric oxide (TLV 25 ppm and PEL 25 ppm) and nitrogen dioxide (TLV 3, 5 ppm STEL and PEL 5 ppm ceiling). The fume limit for hydrogen fluoride, oxides of potassium bifluoride, potassium fluoride, aluminum oxides, silicon oxides, magnesium oxides, and manganese may be reached before the general limit for welding fumes (5 mg/m<sup>3</sup>) is reached.**

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 "Method for Sampling Airborne Particles Generated by Welding and Allied Processes" and "Characterization of Arc Welding Fume" available from the American Welding Society, 550 N.W. LeJeune Road, Miami, FL 33126.

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### Section 6 - HEALTH HAZARD DATA

- **Medical conditions aggravated by exposure to this product:** Chronic lung disease, skin rashes, asthma, bronchitis, COPD, and emphysema.
- **EYES:** Explosion/fire hazards may be present (**See Section 4**). Welding/Brazing fumes can cause irritation. Ultraviolet radiation from welding can cause flash burns.
- **SKIN:** Explosion/fire hazards may be present (**See Section 4**). Aluminum can cause irritation. Ultraviolet radiation and infrared heat rays from flames and hot metal can burn skin.
- **INHALATION:** Welding/Brazing fumes can be a cancer hazard, cause respiratory tract irritation, cause metal fume fever and other health effects listed below:
  - *Chronic overexposure* to the **powder flux** can cause bone and dental fluorosis, bronchitis or chronic dermatitis.
  - Welding processes generate fumes and an intense ultraviolet radiation that results in the formation of ozone and oxides of nitrogen. Exposure to *low* levels of **ozone** can cause irritation of the eyes, nose and throat. Inhalation can cause chest tightness, headache, shortness of breath, cough, wheeze and narrowing of airways. Symptoms disappear when removed from exposure.
  - Exposure to *high* levels of **ozone** may cause acute respiratory distress with shortness of breath, pulmonary changes, hemorrhage and pulmonary edema (fluid in lungs). Symptoms of pulmonary edema may be delayed for one or more hours. Exposure of test animals and human tissue to high concentrations has shown chromosomal changes, reproductive effects, blood changes, and death from lung congestion.
  - **Oxides of nitrogen** can cause irritation of the eyes, skin (when moist), and respiratory tract. Exposure to *high* levels of **nitrogen oxides** can cause delayed pulmonary edema (fluid in the lungs) which may be fatal. **Nitric oxide** can cause formation of methemoglobin, which decreases the blood's ability to carry oxygen. *Chronic overexposure* can cause pulmonary fibrosis (scarring of the lungs).
  - **Aluminum dust/fines and fumes** are a low risk by inhalation. For standard operations (milling, cutting, grinding), **aluminum dust** should be treated as a nuisance dust as defined by the ACGIH.
  - *Overexposure* to **magnesium oxide** fumes can cause respiratory tract irritation and fever, chills, shortness of breath and malaise (metal fume fever). *Temporary symptoms* can include fever, chills, nausea, vomiting, and muscular pain. *Chronic exposure* to high levels of **manganese dust or fumes** can cause nervous system disorders, pneumonitis (inflammation of lung tissue), and may cause fibrosis (scarring of lung tissue) and reproductive disorders in males.
  - *Chronic exposure* to inert **dusts of silicon** can cause increased airway resistance and contributes to chronic bronchitis. Intratracheal administration of **silicon** in rabbits produced significant pulmonary lesions.
  - *Exposure* to **zinc oxide fumes** subsequent to burning, welding, and molten metal work can result in fever, chills, shortness of breath, malaise (metal fume fever), and upper respiratory tract irritation. *Temporary symptoms* can include fever, chills, nausea, vomiting and muscular pain. *Exposure* to dust or fines presents a low health risk by inhalation.
  - *Overexposure* to **copper fume** may exist when welding, flame cutting, etc. *Overexposure* to **copper dust/ mists** can cause irritation of the eyes, skin, and upper respiratory tract. *Chronic overexposure* may result in blood disorders (anemia), and skin and hair discoloration. *Overexposure* to **copper fume** can result in respiratory tract irritation, nausea, fever, chills, shortness of breath and malaise (metal fume fever).

### Section 7 - PRECAUTIONS FOR SAFE HANDLING & USE/APPLICABLE

#### CONTROL MEASURES

Read and understand the manufacturer's instructions and the precautionary label on the product. See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society, 550 N.W. LeJeune Road, Miami, FL 33126 and OSHA Publication 2206 (29CFR1910), US Government Printing Office, Washington, D.C. 20402 for more details on many of the following. **Aluminum** should be kept dry. Avoid generating dust (**See Section 4**). Avoid contact with sharp edges or heated metal. Hot and cold aluminum are not visually different.

**VENTILATION:** Provide local ventilation suitable for the dust risk and the fluoride by-products. Use enough ventilation, exhaust at the (flame) arc, or both, to keep the fumes and gases below TLV's in the worker's breathing zone and general area. Train the welder to keep his head out of the fume plume.

**RESPIRATORY PROTECTION:** Use respirable fume respirator or air supplied respirator when welding/brazing in confined space or where local exhaust or ventilation does not keep exposure below TLV. Workers in the immediate vicinity of the welding operations shall be protected as necessary by local exhaust ventilation or airline respirators.

***FOR MAXIMUM SAFETY, BE CERTIFIED FOR AND WEAR A RESPIRATOR AT ALL TIMES WHEN WELDING, BRAZING OR SOLDERING!***

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### **Section 7 - PRECAUTIONS FOR SAFE HANDLING & USE/APPLICABLE CONTROL MEASURES (continued)**

**EYE PROTECTION:** Wear helmet or use face shield with correct shade of filter lens. As a rule of thumb, start with a shade that is too dark to see the weld/braze zone. Then go to the next lighter shade which gives sufficient view of the weld/braze zone. Provide protective screens and flash goggles, to shield others.

**PROTECTIVE CLOTHING:** Wear head, hand, and body protection which help to prevent injury from radiation, sparks, and electrical shock. See ANSI Z49.1. As a minimum this includes welder's gloves, protective face shield, dark substantial clothing, and may include arm protectors, aprons, hats, and shoulder protection. Train the welder not to touch live electrical parts and to insulate him or herself from work and ground.

**HANDLING AND STORAGE:** Keep away from strong acids and strong bases.

**WORK PRACTICES AND HYGIENE PRACTICES:** As with all chemicals, avoid getting these products ON YOU or IN YOU. Wash hands after handling these products. Do not eat or drink while handling these products. FOOD AND DRINK SHOULD NOT BE CONSUMED OR TOBACCO PRODUCTS USED NOR COSMETICS APPLIED IN AREAS WHERE EXPOSURES EXIST!

**WASTE DISPOSAL METHOD:** 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.

### **Section 8 – FIRST AID MEASURES**

- **EYES:** Flush eyes with plenty of water or saline for at least 15 minutes. Consult a physician.
- **SKIN:** Wash thoroughly with soap and water. Consult a physician if irritation persists.
- **INHALATION:** Remove to fresh air. Check for clear airway, breathing, and presence of pulse. Provide CPR for persons without pulse or respirations. Consult a physician immediately.

### **Section 9 - TOXICOLOGICAL INFORMATION**

Inorganic fluoride compounds have been demonstrated to induce mutagenic changes in mammalian cells in culture. The significance of these findings to human health is unknown.

### **Section 10 – DEFINITIONS**

CAS No.	Chemical Abstracts Service Number	PEL	Permissible Exposure Level
TLV	Threshold Limit Value	STEL	Short Term Exposure Limit
LD <sub>50</sub>	Lethal Dose (50 percent kill)	IARC	International Agency for Research on Cancer

### **Section 11 - SARA TITLE III SECTION 313 SUPPLIER NOTIFICATION**

Welding and brazing rod contains chemicals subject to the reporting requirements of Section 313 of Title III of the Superfund Amendments and Reauthorization Act of 1986 and 40 CFR Part 372.

**311/312 HAZARD CATEGORIES:** Immediate (acute), delayed (chronic) if particulates/fumes are generated during processing.

**313 REPORTABLE INGREDIENTS:** Aluminum (fume/dust).

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