



# Unibraze P20

## Safety Data Sheet

This Safety Data Sheet (SDS) is for welding consumables and related products and may be used to comply with OSHA's Hazard Communication standard, 29 CFR 1910.1200, and Superfund Amendments and Reauthorization Act (SARA) of 1986 Public Law 99-499 and Canadian Workplace Hazardous Materials Information System (WHMIS) per Health Canada administrative policy. The OSHA standard must be consulted for specific requirements. This Safety Data Sheet complies with ISO 11014-1 and ANSI Z400.1.

### SECTION 1 - IDENTIFICATION

<b>Manufacturer/Supplier</b>	<b>Unibraze</b>	Telephone No: (713) 869-6000
<b>Address:</b>	1050 Penner Crest Houston TX USA 77055	Emergency No: (800)364-6900
<b>Website:</b>	<a href="http://www.unibraze.com">www.unibraze.com</a>	
<b>Product Type:</b>	GTAW wire for hardfacing	
<b>Trade Name:</b>	<b>Unibraze P20</b>	
<b>Specification:</b>	AISI P20                      Werkstoff 1.2330	
<b>Restrictions on use:</b>	Use only as indicated.	

### SECTION 2 – IDENTIFICATION OF HAZARDS

**HAZARD CLASSIFICATION** – The products described in Section 1 are not classified as hazardous according to applicable GHS hazard classification criteria as required and defined in OSHA Hazard Communication Standard (29 CFR Part 1910.1200).

**LABEL ELEMENTS:** **Hazard Symbol** – No symbol required  
**Hazard Statement** – Not applicable

**Signal Word** – No signal word required

**Precautionary Statement** – Not Applicable

#### HAZARDS NOT OTHERWISE CLASSIFIED

**WARNING!** Avoid breathing welding fumes and gases, they may be dangerous to your health. Always use adequate ventilation.

Always use appropriate personal protective equipment.

**PRIMARY ROUTES OF ENTRY:** Respiratory System, Eyes and/or Skin.

**ARC RAYS:** The welding arc can injure eyes and burn skin.

**ELECTRIC SHOCK:** Arc welding and associated processes can kill. See Section 8.

**FUMES AND GASES:** Can be dangerous to your health.

Welding fumes and gases cannot be classified simply. The composition and quantity of both are dependent upon the metal being welded, the process, procedures and electrodes used. Most fume ingredients are present as complex oxides and compounds and not as pure metals. When the electrode is consumed, the fume and gas decomposition products generated are different in percent and form from the ingredients listed in Section 3. Decomposition products of normal operation include those originating from the volatilization, reaction or oxidation, plus those from the base metal and coating, etc., of the materials shown in Section 3 of this Safety Data Sheet. Monitor for the component materials identified in the list in Section 3.

Fumes from the use of this product may contain complex oxides or compounds of the following elements and molecules: amorphous silica fume, chromium, manganese and nickel. Other reasonably expected constituents of the fume would also include complex oxides of iron, silicon and molybdenum. Gaseous reaction products may include carbon monoxide and carbon dioxide. Ozone and nitrogen oxides may be formed by the radiation from the arc. 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 or galvanizing), 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). 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 and F1.3, available from the "American Welding Society", 8669 NW 36 Street, # 130, Miami, Florida 33166-6672, Phone: 800-443-9353 or 305-443-9353.

### SECTION 3 - COMPOSITION/INFORMATION ON INGREDIENTS

#### HAZARDOUS INGREDIENTS

**IMPORTANT** - This section covers the hazardous materials from which this product is manufactured. This data has been classified according to the criteria of the Globally Harmonized System of Classification and Labeling of Chemicals (GHS) as required and defined in OSHA Hazard Communication Standard (29 CFR Part 1910.1200). The fumes and gases produced during welding with normal use of this product are addressed in Section 8.

INGREDIENT	% Weight	CAS#	EINECS#	Hazardous Classification	IARC	NTP	Elenco OSHA
Chromium	<10.0	7440-47-3	231-157-5	No	--	--	--
Copper	<0.5	7440-50-8	231-159-6	No	--	--	--
Iron	<80.0	7439-89-6	231-096-4	No	--	--	--
Manganese	<2.0	7439-96-5	231-105-1	No	--	--	--
Carbon	<1.5	7440-44-0	231-153-3	No	--	--	--
Molybdenum	<4.0	7439-98-7	231-107-2	No	--	--	--
Vanadium	<1.0	7440-62-6	231-171-1	No	--	--	--
Titanium	<1.0	7440-32-6		No	--	--	--
Silicon	<1.0	7440-21-3	231-130-8	No	--	--	--

- Dashes indicate the ingredient is not present within the group of products

Evaluation according to the International Agency for Cancer Research

Classification according to the 11<sup>th</sup> Report on Carcinogens, published by the US National Toxicology Program.

Carcinogen listing according to OSHA / Hazard Classification according to Regulation (EC) 1272/2008

**SECTION 4 – FIRST AID MEASURES**

**INGESTION:** Not an expected route of exposure. Do not eat, drink, or smoke while welding; wash hands thoroughly before performing these activities. If symptoms develop, seek medical attention at once.

**INHALATION during welding:** If breathing is difficult, provide fresh air and contact physician. If breathing has stopped, perform artificial respiration and obtain medical assistance at once.

**SKIN CONTACT during welding:** Remove contaminated clothing and wash the skin thoroughly with soap and water. If symptoms develop, seek medical attention at once.

**EYE CONTACT during welding:** Dust or fume from this product should be flushed from the eyes with copious amounts of clean, tepid water until victim is transported to an emergency medical facility. Do not allow victim to rub or keep eyes tightly closed. Obtain medical assistance at once.

*Arc rays can injure eyes.* If exposed to arc rays, move victim to dark room, remove contact lenses as necessary for treatment, cover eyes with a padded dressing and rest. Obtain medical assistance if symptoms persist.

Section 11 of this SDS covers the acute effects of overexposure to the various ingredients within the welding consumable. Section 8 of this SDS lists the exposure limits and covers methods for protecting yourself and your co-workers.

**SECTION 5 – FIRE-FIGHTING MEASURES**

**Fire Hazards:** Welding consumables applicable to this sheet as shipped are nonreactive, nonflammable, non-explosive and essentially nonhazardous until welded.

Welding arcs and sparks can ignite combustibles and flammable products. If there are flammable materials, including fuel or hydraulic lines, in the work area and the worker cannot move the work or the flammable material, a fire-resistant shield such as a piece of sheet metal or fire resistant blanket should be placed over the flammable material. If welding work is conducted within 35 feet or so of flammable materials, station a responsible person in the work zone to act as fire watcher to observe where sparks are flying and to grab an extinguisher or sound the alarm if needed.

Unused welding consumables may remain hot for a period of time after completion of a welding process. See American National Standard Institute (ANSI) Z49.1 for further general safety information on the use and handling of welding consumables and associated procedures.

**Suitable Extinguishing Media:** This product is essentially nonflammable until welded; therefore, use a suitable extinguishing agent for a surrounding fire.

**Unsuitable Extinguishing Media:** None known.

**SECTION 6 - ACCIDENTAL RELEASE MEASURES**

In the case of a release of solid welding consumable products, solid objects can be picked up and placed into a disposal container. If airborne dust and/or fume is present, use adequate engineering controls and, if needed, personal protection to prevent overexposure. Refer to recommendations in Section 8. Wear proper personal protective equipment while handling. Do not discard as general trash.

**SECTION 7 - HANDLING AND STORAGE**

**HANDLING:** No specific requirements in the form supplied. Handle with care to avoid 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 product labels.

**STORAGE:** Keep separate from acids and strong bases to prevent possible chemical reactions.

**SECTION 8 - EXPOSURE CONTROLS AND PERSONAL PROTECTION**

Read and understand the instructions and the labels on the packaging. Welding fumes do not have a specific OSHA PEL (Permissible Exposure Limit) or ACGIH TLV (Threshold Limit Value). The OSHA PEL for Particulates – Not Otherwise Regulated (PNOR) is 5 mg/m<sup>3</sup> – Respirable Fraction, 15 mg/m<sup>3</sup> – Total Dust. The ACGIH TLV for Particles – Not Otherwise Specified (PNOS) is 3 mg/m<sup>3</sup> – Respirable Particles, 10 mg/m<sup>3</sup> – Inhalable Particles. The individual complex compounds within the fume may have a lower OSHA PEL or ACGIH TLV than the OSHA PNOR and ACGIH PNOS. An Industrial Hygienist, the OSHA PELs for Air Contaminants (29 CFR 1910.1000), and the ACGIH TLVs should be consulted to determine the specific fume constituents present and their respective exposure limits. All exposure limits are in milligrams per cubic meter (mg/m<sup>3</sup>).

INGREDIENT	% Weight	CAS#	EINECS#	ACGIH TLV (mg/m <sup>3</sup> )	OSHA PEL (mg/m <sup>3</sup> )
Chromium	<10.0	7440-47-3	231-157-5	0.5	0.5
Copper	<0.5	7440-50-8	231-159-6	1 (d&m); 0.2 (f)	1 (d&m), 0.1 (f)
Iron	<80.0	7439-89-6	231-096-4	5**	10 (f)
Manganese	<2.0	7439-96-5	231-105-1	0.2 (f) -0.1***	5 (ceiling)
Carbon	<1.5	7440-44-0	231-153-3	/	
Molybdenum	<4.0	7439-98-7	231-107-2	3**; 10***	15*
Vanadium	<1.0	7440-62-6	231-171-1	0.1. (ceiling) come V <sub>2</sub> O <sub>5</sub> )	
Titanium	<1.0	7440-32-6			
Silicon	<1.0	7440-21-3	231-130-8	--	15*, 5**

Threshold limit values according to American Conference of Governmental Industrial Hygienists

\*Total Dust \*\*Respirable fraction; \*\*\*Inhalable fraction; (f) fume; (d) dust; (m) mist, (ceiling) ceiling.

**VENTILATION:** Use enough ventilation or local exhaust at the arc or both to keep the fumes and gases below the PEL/TLV in the worker's breathing zone and the general area. Train the welder to keep his head out of the fumes.

**RESPIRATORY PROTECTION:** Use NIOSH-approved or equivalent fume respirator or air supplied respirator when welding in confined space or where local exhaust or ventilation does not keep exposure below the regulatory limits.

**EYE PROTECTION:** Wear helmet or use face shield with filter lens for open arc welding processes. As a rule of thumb begin with Shade Number 14. Adjust if needed by selecting the next lighter and/or darker shade number. Provide protective screens and flash goggles, if necessary, to shield others from the weld arc flash.

**PROTECTIVE CLOTHING:** Wear hand, head and body protection which help to prevent injury from radiation, sparks and electrical shock. See ANSI Z49.1. 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 non-synthetic 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:** Not applicable

**SPECIAL PRECAUTIONS (IMPORTANT):** When welding with electrodes that require special ventilation (such as stainless or hardfacing, or other products which require special ventilation, or on lead- or cadmium-plated steel and other metals or coatings like galvanized steel, which produce hazardous fumes) maintain exposure below the PEL/TLV. Use industrial hygiene monitoring to ensure that your use of this material does not create exposures which exceed PEL/TLV. Always use exhaust ventilation. Refer to the following sources for important additional information: American National Standard Institute (ANSI) Z49.1; Safety in Welding and Cutting published by the American Welding Society, 8669 NW 36 Street, # 130, Miami, Florida 33166-6672, Phone: 800-443-9353 or 305-443-9353; and OSHA Publication 2206 (29 CFR 1910), U.S. Government Printing Office, Washington, DC 20402.

**SECTION 9 – PHYSICAL AND CHEMICAL PROPERTIES**

Welding consumables applicable to this sheet as shipped are nonreactive, nonflammable, non-explosive and essentially nonhazardous until welded.

**PHYSICAL STATE:** Solid

**COLOR:** Gray

**ODOR THRESHOLD:** Not Applicable

**MELTING POINT/FREEZING POINT:** Not Available

**FLASH POINT:** Not Available

**FLAMMABILITY (SOLID, GAS):** Not Available

**VAPOR PRESSURE:** Not Applicable

**RELATIVE DENSITY:** Not Available

**PARTITION COEFFICIENT: N-OCTANOL/WATER:** Not Applicable

**DECOMPOSITION TEMPERATURE:** Not Available

**APPEARANCE:** Round, solid wire or rod

**ODOR:** Not Applicable

**pH:** Not Applicable

**INITIAL BOILING POINT AND BOILING RANGE:** Not Available

**EVAPORATION RATE:** Not Applicable

**UPPER/LOWER FLAMMABILITY OR EXPLOSIVE LIMITS:** Not Available

**VAPOR DENSITY:** Not Applicable

**SOLUBILITY(IES):** Not Available

**AUTO-IGNITION TEMPERATURE:** Not Available

**VISCOSITY:** Not Applicable

**SECTION 10 – STABILITY AND REACTIVITY**

**GENERAL:** Welding consumables applicable to this sheet are solid and nonvolatile as shipped. This product is only intended for use per the welding parameters it was designed for. When this product is used for welding, hazardous fumes may be created. Other factors to consider include the base metal, base metal preparation and base metal coatings. All of these factors can contribute to the fume and gases generated during welding. The amount of fume varies with the welding parameters.

**STABILITY:** This product is stable under normal conditions.

**REACTIVITY:** Contact with acids or strong bases may cause generation of gas.

**SECTION 11 – TOXICOLOGICAL INFORMATION**

**SHORT-TERM (ACUTE) OVEREXPOSURE EFFECTS: Welding Fumes** - May result in discomfort such as dizziness, nausea or dryness or irritation of nose, throat or eyes.

**Manganese** - Metal fume fever characterized by chills, fever, upset stomach, vomiting, irritation of the throat and aching of body. Recovery is generally complete within 48 hours of the overexposure.

**LONG-TERM (CHRONIC) OVEREXPOSURE EFFECTS: Welding Fumes** - Excess levels may cause bronchial asthma, lung fibrosis, pneumoconiosis or "siderosis." Studies have concluded that there is sufficient evidence for ocular melanoma in welders. **Chromium** - Ulceration and perforation of nasal septum. Respiratory irritation may occur with symptoms resembling asthma. Studies have shown that chromate production workers exposed to hexavalent chromium compounds have an excess of lung cancers. Chromium (VI) compounds are more readily absorbed through the skin than chromium (III) compounds. Good practice requires the reduction of employee exposure to chromium (III) and (VI) compounds. **Copper** - Copper poisoning has been reported in the literature from exposure to high levels of copper. Liver damage can occur due to copper accumulating in the liver characterized by cell destruction and cirrhosis. High levels of copper may cause anemia and jaundice. High levels of copper may cause central nervous system damage characterized by nerve fiber separation and cerebral degeneration. **Iron, Iron Oxide Fumes** - Can cause siderosis (deposits of iron in lungs) which some researchers believe may affect pulmonary function. Lungs will clear in time when exposure to iron and its compounds ceases. Iron and magnetite (Fe<sub>3</sub>O<sub>4</sub>) are not regarded as fibrogenic materials. **Manganese** - Long-term overexposure to manganese compounds may affect the central nervous system. Symptoms may be similar to Parkinson's disease and can include slowness, changes in handwriting, gait impairment, muscle spasms and cramps and less commonly, tremor and behavioral changes. Employees who are overexposed to manganese compounds should be seen by a physician for early detection of neurologic problems. 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. **Molybdenum** - Prolonged overexposure may result in loss of appetite, weight loss, loss of muscle coordination, difficulty in breathing and anemia. **Nickel, Nickel Compounds** - Lung fibrosis or pneumoconiosis. Studies of nickel refinery workers indicated a higher incidence of lung and nasal cancers. **Niobium** - No adverse long term health effects have been reported in the literature. **Silica (Amorphous)** - Research indicates that silica is present in welding fume in the amorphous form. Long term overexposure may cause pneumoconiosis. Non-crystalline forms of silica (amorphous silica) are considered to have little fibrotic potential.

**MEDICAL CONDITIONS AGGRAVATED BY EXPOSURE:** Persons with pre-existing impaired lung functions (asthma-like conditions). Persons with a pacemaker should not go near welding and cutting operations until they have consulted their doctor and obtained information from the manufacturer of the device. Respirators are to be worn only after being medically cleared by your company-designated physician.

**EMERGENCY AND FIRST AID PROCEDURES:** Call for medical aid. Employ first aid techniques recommended by the American Red Cross. If irritation or flash burns develop after exposure, consult a physician.

**CARCINOGENICITY:** Chromium VI compounds and nickel compounds are classified as IARC Group 1 and NTP Group K carcinogens. Welding fumes are classified as IARC Group 2B carcinogens.

**CALIFORNIA PROPOSITION 65:** WARNING: 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 Section 25249.5 et seq.)

INGREDIENT	% Weight	CAS#	EINECS#	IARC (E)	NTP (Z)	OSHA (H)	65 (Θ)
Chromium	<10.0	7440-47-3	231-157-5	--	--	--	--
Copper	<0.5	7440-50-8	231-159-6	--	--	--	--
Iron	<80.0	7439-89-6	231-096-4	--	--	--	--
Manganese	<2.0	7439-96-5	231-105-1	--	--	--	--
Carbon	<1.5	7440-44-0	231-153-3	--	--	--	--
Molybdenum	<4.0	7439-98-7	231-107-2	--	--	--	--
Vanadium	<1.0	7440-62-6	231-171-1	--	--	--	--
Titanium	<1.0	7440-32-6		--	--	--	--
Silicon	<1.0	7440-21-3	231-130-8	--	--	--	--

E – International Agency for Research on Cancer (1 – Carcinogenic to Humans, 2A – Probably Carcinogenic to Humans, 2B – Possibly Carcinogenic to Humans, 3 – Not Classifiable as to its Carcinogenicity to Humans, 4 – Probably Not Carcinogenic to Humans) Z – US National Toxicology Program (K – Known Carcinogen, S – Suspected Carcinogen) H – OSHA Designated Carcinogen List Θ – California Proposition 65 (X – On Proposition 65 list) Σ – Chromium Metal and Chromium III Compounds ΣΣ – Chromium VI β – Nickel metal and alloys ββ -- Nickel compounds --- Dashes indicate the ingredient is not listed with the IARC, NTP, OSHA or Prop 65

**SECTION 12 – ECOLOGICAL INFORMATION**

Welding processes can release fumes directly to the environment. Welding wire can degrade if left outside and unprotected. Residues from welding consumables and processes could degrade and accumulate in the soil and groundwater.

**SECTION 13 – DISPOSAL CONSIDERATIONS**

Use recycling procedures if available. Discard any product, residue, packaging, disposable container or liner in an environmentally acceptable manner, in full compliance with federal, state and local regulations.

**SECTION 14 – TRANSPORT INFORMATION**

No international regulations or restrictions are applicable. No special precautions are necessary.

**SECTION 15 – REGULATORY INFORMATION**

Read and understand the manufacturer's instructions, your employer's safety practices and the health and safety instructions on the label and the safety data sheet. Observe all local and federal rules and regulations. Take all necessary precautions to protect yourself and others.

**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)
Products on this SDS are a solid solution in the form of a solid article.	---	---

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 potentially subject to annual SARA 312 reporting: Chromium, , Copper, Manganese and Nickel. See Section 3 for weight percentage.

**CANADIAN WHMIS CLASSIFICATION:** Class D; Division 2, Subdivision A

**CANADIAN CONTROLLED PRODUCTS REGULATION:** This product has been classified in accordance with the hazard criteria of the CPR and the SDS contains all of the information required by the CPR.

**CANADIAN ENVIRONMENTAL PROTECTION ACT (CEPA):** All constituents of these products are on the Domestic Substance List (DSL).

**SECTION 16 – OTHER INFORMATION**

**For additional information please refer to the following sources:**

**USA:** American National Standards Institute (ANSI) Z49.1 "Safety in Welding and Cutting", ANSI/American Welding Society (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, 8669 NW 36 Street, # 130, Miami, Florida 33166-6672, Phone: 800-443-9353 or 305-443-9353. 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.

**Threshold Limit Values and Biological Exposure Indices**, American Conference of Governmental Industrial Hygienists (ACGIH), 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.

**Canada:** CSA Standard CAN/CSA-W117.2-01 "Safety in Welding, Cutting and Allied Processes".

*UNIBRAZE strongly recommends the users of this product study this SDS, the product label information and become aware of all hazards associated with welding. UNIBRAZE believes this data to be accurate and to reflect qualified expert opinion regarding current research. However, UNIBRAZE cannot make any expressed or implied warranty as to this information.*