



SAFETY DATA SHEET

1. PRODUCT AND COMPANY IDENTIFICATION

Product Name: Stay-Silv® Black Brazing Flux

Other means of identification

SDS number: 200000007165

Recommended use and restriction on use

Recommended use: Metal Brazing

Restrictions on use: Not known. Read this SDS before using this product.

Manufacturer/Importer/Supplier/Distributor Information

Company Name: The Harris Products Group

Address: 4501 Quality Place
Mason, OH 45040-1971
USA

Telephone: +1 (513) 754-2000

Contact Person: Safety Data Sheet Questions: custservmason@jwharris.com

Company Name: The Lincoln Electric Company of Canada LP

Address: 179 Wicksteed Avenue
Toronto, Ontario M4G 2B9
Canada

Telephone: +1 (416) 421-2600

Contact Person: Safety Data Sheet Questions: www.lincolnelectric.com/sds
Arc Welding Safety Information: www.lincolnelectric.com/safety
SDS@lincolnelectric.com

Emergency telephone number:

USA/Canada/Mexico +1 (888) 609-1762

Americas/Europe +1 (216) 383-8962

Asia Pacific +1 (216) 383-8966

Middle East/Africa +1 (216) 383-8969

3E Company Access Code: 333988

2. HAZARDS IDENTIFICATION

Classified according to the criteria of the Globally Harmonized System of Classification and Labeling of Chemicals (GHS), The United States Occupational Safety and Health Administration's Hazard Communication Standard (29 CFR 1910.1200), Canada's Hazardous Product Regulations and Mexico's Harmonized System for the Identification and Communication of Hazards and Risks from Hazardous Chemicals in the Workplace.

Hazard Classification

Health Hazards

Acute toxicity (Oral) Category 4

Reproductive toxicity Category 2

Label Elements

Hazard Symbol:



Signal Word: Warning

Hazard Statement: Harmful if swallowed.
Suspected of damaging the unborn child.

Precautionary Statements:

Prevention: Obtain special instructions before use. Do not handle until all safety precautions have been read and understood. Wash face, hands and any exposed skin thoroughly after handling. Do not eat, drink or smoke when using this product. Use personal protective equipment as required.

Response: IF SWALLOWED: Call a POISON CENTER/doctor if you feel unwell. Rinse mouth. IF exposed or concerned: Get medical advice/attention.

Storage: Store locked up.

Disposal: Dispose of contents/ container to an approved facility in accordance with local, regional, national and international regulations.

Other hazards which do not result in GHS classification: Heat rays (infrared radiation) from flame or hot metal can injure eyes. Overexposure to brazing fumes and gases can be hazardous. Read and understand the manufacturer's instructions, Safety Data Sheets and the precautionary labels before using this product.

Substance(s) formed under the conditions of use: Fumes produced from use of this product may contain the following constituent(s) and/or their complex metallic oxides as well as solid particles or other constituents from the solder, brazing consumable, flux material or base metal, or base metal coating not listed below. Hydrogen fluoride, a possible decomposition product, is extremely corrosive and a poison by all routes of entry. Hydrogen fluoride can penetrate the skin and produce burns, which may not be immediately painful or visible; the burns impact the lower layers of skin and bone tissue. Hydrogen fluoride exposures involving 20 percent of the body or more can be fatal through systemic fluoride poisoning.

Chemical Identity	CAS-No.
Carbon dioxide	124-38-9
Carbon monoxide	630-08-0
Nitrogen dioxide	10102-44-0
Ozone	10028-15-6

3. COMPOSITION / INFORMATION ON INGREDIENTS

Reportable Hazardous Ingredients Mixtures

Chemical Identity	CAS number	Content in percent (%)*
Potassium difluorodihydroxyborate(1-)	85392-66-1	50 - <100%
Potassium tetraborate tetrahydrate	12045-78-2	20 - <50%
Potassium fluoroborate	14075-53-7	20 - <50%

* All concentrations are percent by weight unless ingredient is a gas. Gas concentrations are in percent by volume.

Composition Comments: The term “Hazardous Ingredients” should be interpreted as a term defined in Hazard Communication standards and does not necessarily imply the existence of a welding or allied process hazard. The product may contain additional non-hazardous ingredients or may form additional compounds under the condition of use. Refer to Sections 2 and 8 for more information.

4. FIRST AID MEASURES

Ingestion: Avoid hand, clothing, food, and drink contact with fluxes, metal fume or powder which can cause ingestion of particulate during hand to mouth activities such as drinking, eating, smoking, etc. If ingested, do not induce vomiting. Contact a poison control center. Unless the poison control center advises otherwise, wash out mouth thoroughly with water. If symptoms develop, seek medical attention at once. Call a POISON CENTER/doctor if you feel unwell. Rinse mouth.

Inhalation: Move to fresh air if breathing is difficult. If breathing has stopped, perform artificial respiration and obtain medical assistance at once.

Skin Contact: Remove contaminated clothing and wash the skin thoroughly with soap and water. For reddened or blistered skin, or thermal burns, obtain medical assistance at once.

Eye contact: Do not rub eye. Any material that contacts the eye should be washed out immediately with water. If easy to do, remove contact lenses. Continue to rinse for at least 15 minutes. Get medical attention promptly if symptoms occur after washing.

Most important symptoms/effects, acute and delayed

Symptoms: Short-term (acute) overexposure to fumes and gases from welding and allied processes may result in discomfort such as metal fume fever, dizziness, nausea, or dryness or irritation of nose, throat, or eyes. May aggravate pre-existing respiratory problems (e.g. asthma, emphysema). Long-term (chronic) overexposure to fumes and gases from welding and allied processes can lead to siderosis (iron deposits in lung), central nervous system effects, bronchitis and other pulmonary effects. Refer to Section 11 for more information.

Hazards: The hazards associated with welding and its allied processes such as soldering and brazing are complex and may include physical and health hazards such as but not limited to electric shock, physical strains, radiation burns (eye flash), thermal burns due to hot metal or spatter and potential health effects of overexposure to fumes, gases or dusts potentially generated during the use of this product. Refer to Section 11 for more information.

Indication of immediate medical attention and special treatment needed

Treatment: Treat symptomatically.

5. FIRE-FIGHTING MEASURES

General Fire Hazards: As shipped, this product is nonflammable. However, welding arcs, sparks, open flames, and hot surfaces associated with welding, brazing, and soldering can ignite combustible and flammable materials. Implement fire protection measures according to the place of use risk assessment, local regulations, and all relevant safety standards. Read and understand the American National Standard Z49.1, "Safety in Welding, Cutting, and Allied Processes," and the National Fire Protection Association NFPA 51B, "Standard for Fire Prevention during Welding, Cutting, and Other Hot Work," before using this product.

Suitable (and unsuitable) extinguishing media

Suitable extinguishing media: Use fire-extinguishing media appropriate for surrounding materials.

Unsuitable extinguishing media: Do not use water jet as an extinguisher, as this will spread the fire.

Specific hazards arising from the chemical: During fire, gases hazardous to health may be formed.

Special protective equipment and precautions for fire-fighters

Special fire-fighting procedures: Use standard firefighting procedures and consider the hazards of other involved materials.

Special protective equipment for fire-fighters: Selection of respiratory protection for fire fighting: follow the general fire precautions indicated in the workplace. Self-contained breathing apparatus and full protective clothing must be worn in case of fire.

6. ACCIDENTAL RELEASE MEASURES

Personal precautions, protective equipment and emergency procedures: 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.

Methods and material for containment and cleaning up: Absorb spill with vermiculite or other inert material, then place in a container for chemical waste. Dike far ahead of larger spill for later recovery and disposal.

Notification Procedures: Dike for later disposal. Prevent entry into waterways, sewer, basements or confined areas. Stop the flow of material, if this is without risk.

Environmental Precautions: Do not contaminate water sources or sewer. Prevent further leakage or spillage if safe to do so.

7. HANDLING AND STORAGE

Precautions for safe handling: Prevent abrading consumable materials or creating dust. Provide appropriate exhaust ventilation at places where fume or dust is formed. Wear appropriate personal protective equipment. Observe good industrial hygiene practices.

Read and understand the manufacturer's instruction and the precautionary label on the product. See ISO/TR 18786:2014, ISO/TR 13392:2014, American National Standard Z49.1, "Safety In Welding, Cutting and Allied Processes" published by the American Welding Society, <http://pubs.aws.org> and OSHA Publication 2206 (29CFR1910), U.S.

Government Printing Office, www.gpo.gov. Do not taste or swallow. Wash hands thoroughly after handling.

Conditions for safe storage, including any incompatibilities: Store in closed original container in a dry place. Store in accordance with local/regional/national regulations. Store away from incompatible materials.

8. EXPOSURE CONTROLS / PERSONAL PROTECTION

Control Parameters

Occupational Exposure Limits: US

Chemical Identity	Type	Exposure Limit Values	Source
Potassium difluorodihydroxyborate(1-) - Inhalable fraction.	STEL	6 mg/m3	US. ACGIH Threshold Limit Values (02 2014)
	TWA	2 mg/m3	US. ACGIH Threshold Limit Values (02 2014)
Potassium difluorodihydroxyborate(1-)	IDLH	250 mg/m3	US. NIOSH. Immediately Dangerous to Life or Health (IDLH) Values (10 2017)
Potassium difluorodihydroxyborate(1-) - as F	TWA	2.5 mg/m3	US. ACGIH Threshold Limit Values (01 2021)
	PEL	2.5 mg/m3	US. OSHA Table Z-1 Limits for Air Contaminants (29 CFR 1910.1000) (01 2017)
Potassium difluorodihydroxyborate(1-) - Dust.	TWA	2.5 mg/m3	US. OSHA Table Z-2 (29 CFR 1910.1000) (01 2017)
Potassium difluorodihydroxyborate(1-)	IDLH	250 mg/m3	US. NIOSH. Immediately Dangerous to Life or Health (IDLH) Values (10 2019)
Potassium fluoroborate - Inhalable fraction.	STEL	6 mg/m3	US. ACGIH Threshold Limit Values (02 2014)
	TWA	2 mg/m3	US. ACGIH Threshold Limit Values (02 2014)
Potassium fluoroborate - as F	REL	2.5 mg/m3	US. NIOSH: Pocket Guide to Chemical Hazards, as amended (2005)
Potassium fluoroborate	IDLH	250 mg/m3	US. NIOSH. Immediately Dangerous to Life or Health (IDLH) Values (10 2017)
Potassium fluoroborate - as F	TWA	2.5 mg/m3	US. ACGIH Threshold Limit Values (01 2021)
Potassium fluoroborate	IDLH	250 mg/m3	US. NIOSH. Immediately Dangerous to Life or Health (IDLH) Values (10 2019)
Potassium fluoroborate - as F	PEL	2.5 mg/m3	US. OSHA Table Z-1 Limits for Air Contaminants (29 CFR 1910.1000) (01 2017)
Potassium fluoroborate - Dust.	TWA	2.5 mg/m3	US. OSHA Table Z-2 (29 CFR 1910.1000) (01 2017)

Occupational Exposure Limits: Canada

Chemical Identity	Type	Exposure Limit Values	Source
Potassium difluorodihydroxyborate(1-) - as F	TWA	2.5 mg/m3	Canada. Alberta OELs (Occupational Health & Safety Code, Schedule 1, Table 2), as amended (07 2009)
Potassium difluorodihydroxyborate(1-) - Inhalable fraction.	STEL	6 mg/m3	Canada. Manitoba OELs (Reg. 217/2006, The Workplace Safety And Health Act), as amended (03 2013)
	TWA	2 mg/m3	Canada. Manitoba OELs (Reg. 217/2006, The Workplace Safety And Health Act), as amended (03 2013)
	TWA	2 mg/m3	Canada. Ontario OELs. (Control of Exposure to Biological or Chemical Agents), as amended (01 2020)
	STEL	6 mg/m3	Canada. Ontario OELs. (Control of Exposure to Biological or Chemical Agents), as amended (01 2020)

Potassium difluorodihydroxyborate(1-) - Inhalable dust.	TWA	2 mg/m3	Canada. Quebec OELs. (Ministry of Labor - Regulation respecting occupational health and safety), as amended (03 2020)
	STEL	6 mg/m3	Canada. Quebec OELs. (Ministry of Labor - Regulation respecting occupational health and safety), as amended (03 2020)
Potassium difluorodihydroxyborate(1-) - as F	TWA	2.5 mg/m3	Canada. Quebec OELs. (Ministry of Labor - Regulation respecting occupational health and safety), as amended (03 2020)
	TWA	2.5 mg/m3	Canada. Alberta OELs (Occupational Health & Safety Code, Schedule 1, Table 2), as amended (01 2019)
	TWA	2.5 mg/m3	Canada. Ontario OELs. (Control of Exposure to Biological or Chemical Agents), as amended (01 2020)
	15 MIN ACL	5 mg/m3	Canada. Saskatchewan OELs (Occupational Health and Safety Regulations, 1996, Table 21), as amended (06 2016)
	TWA	2.5 mg/m3	Canada. Manitoba OELs (Reg. 217/2006, The Workplace Safety And Health Act), as amended (01 2021)
Potassium difluorodihydroxyborate(1-) - Inhalable	STEL	6 mg/m3	Canada. British Columbia OELs: Table of Exposure Limits for Chemical Biological Substances (Workers Compensation Board); as amended (06 2022)
Potassium difluorodihydroxyborate(1-) - as F	TWA	2.5 mg/m3	Canada. British Columbia OELs: Table of Exposure Limits for Chemical Biological Substances (Workers Compensation Board); as amended (06 2022)
Potassium difluorodihydroxyborate(1-) - Inhalable	TWA	2 mg/m3	Canada. British Columbia OELs: Table of Exposure Limits for Chemical Biological Substances (Workers Compensation Board); as amended (06 2022)
Potassium difluorodihydroxyborate(1-) - as F	8 HR ACL	2.5 mg/m3	Canada. Saskatchewan OELs (Occupational Health and Safety Regulations, 1996, Table 21), as amended (04 2021)
Potassium fluoroborate - as F	TWA	2.5 mg/m3	Canada. Alberta OELs (Occupational Health & Safety Code, Schedule 1, Table 2), as amended (07 2009)
Potassium fluoroborate - Inhalable fraction.	TWA	2 mg/m3	Canada. Manitoba OELs (Reg. 217/2006, The Workplace Safety And Health Act), as amended (03 2013)
Potassium fluoroborate - as F	TWA	2.5 mg/m3	Canada. Alberta OELs (Occupational Health & Safety Code, Schedule 1, Table 2), as amended (01 2019)
	TWA	2.5 mg/m3	Canada. Manitoba OELs (Reg. 217/2006, The Workplace Safety And Health Act), as amended (01 2021)
	TWA	2.5 mg/m3	Canada. Ontario OELs. (Control of Exposure to Biological or Chemical Agents), as amended (01 2020)
	8 HR ACL	2.5 mg/m3	Canada. Saskatchewan OELs (Occupational Health and Safety Regulations, 1996, Table 21), as amended (06 2016)
	15 MIN ACL	5 mg/m3	Canada. Saskatchewan OELs (Occupational Health and Safety Regulations, 1996, Table 21), as amended (06 2016)
	TWA	2.5 mg/m3	Canada. Quebec OELs. (Ministry of Labor - Regulation respecting occupational health and safety), as amended (03 2020)
	TWA	2.5 mg/m3	Canada. British Columbia OELs: Table of Exposure Limits for Chemical Biological Substances (Workers Compensation Board); as amended (06 2022)
	8 HR ACL	2.5 mg/m3	Canada. Saskatchewan OELs (Occupational Health and Safety Regulations, 1996, Table 21), as

			amended (04 2021)
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Occupational Exposure Limits: Mexico

Chemical Identity	Type	Exposure Limit Values	Source
Potassium difluorodihydroxyborate(1-) - as F	VLE-PPT	2.5 mg/m3	Mexico. OELs. (NOM-010-STPS-2014 Chemical Pollutants at the Workplace; Assessment and Control), as amended (04 2014)
Potassium fluoroborate - as F	VLE-PPT	2.5 mg/m3	Mexico. OELs. (NOM-010-STPS-2014 Chemical Pollutants at the Workplace; Assessment and Control), as amended (04 2014)

Biological Limit Values: US

Chemical Identity	Exposure Limit Values	Source
Potassium difluorodihydroxyborate(1-) (Fluoride: Sampling time: Prior to shift.)	2 mg/l (Urine)	ACGIH BEI (01 2021)
Potassium difluorodihydroxyborate(1-) (Fluoride: Sampling time: End of shift.)	3 mg/l (Urine)	ACGIH BEI (01 2021)
Potassium fluoroborate (Fluoride: Sampling time: End of shift.)	3 mg/l (Urine)	ACGIH BEI (01 2021)
Potassium fluoroborate (Fluoride: Sampling time: Prior to shift.)	2 mg/l (Urine)	ACGIH BEI (01 2021)

Biological Limit Values: Mexico

Chemical Identity	Exposure Limit Values	Source
Potassium difluorodihydroxyborate(1-) (fluorides: Sampling time: Prior to shift.)	3 mg/g (Creatinine in urine)	MX IBE (06 2012)
Potassium difluorodihydroxyborate(1-) (fluorides: Sampling time: End of shift.)	10 mg/g (Creatinine in urine)	MX IBE (06 2012)
Potassium fluoroborate (fluorides: Sampling time: End of shift.)	10 mg/g (Creatinine in urine)	MX IBE (06 2012)
Potassium fluoroborate (fluorides: Sampling time: Prior to shift.)	3 mg/g (Creatinine in urine)	MX IBE (06 2012)

Additional exposure limits under the conditions of use: US

Chemical Identity	Type	Exposure Limit Values	Source
Carbon dioxide	TWA	5,000 ppm	US. ACGIH Threshold Limit Values (12 2010)
	STEL	30,000 ppm	US. ACGIH Threshold Limit Values (12 2010)
	PEL	5,000 ppm 9,000 mg/m3	US. OSHA Table Z-1 Limits for Air Contaminants (29 CFR 1910.1000) (02 2006)
	STEL	30,000 ppm 54,000 mg/m3	US. NIOSH: Pocket Guide to Chemical Hazards, as amended (2005)
	REL	5,000 ppm 9,000 mg/m3	US. NIOSH: Pocket Guide to Chemical Hazards, as amended (2005)
	IDLH	40,000 ppm	US. NIOSH. Immediately Dangerous to Life or Health (IDLH) Values (10 2017)
Carbon monoxide	TWA	25 ppm	US. ACGIH Threshold Limit Values (12

				2010)
	PEL	50 ppm	55 mg/m3	US. OSHA Table Z-1 Limits for Air Contaminants (29 CFR 1910.1000) (02 2006)
	REL	35 ppm	40 mg/m3	US. NIOSH: Pocket Guide to Chemical Hazards, as amended (2005)
	Ceil_Time	200 ppm	229 mg/m3	US. NIOSH: Pocket Guide to Chemical Hazards, as amended (2005)
	IDLH	1,200 ppm		US. NIOSH. Immediately Dangerous to Life or Health (IDLH) Values (10 2017)
Nitrogen dioxide	TWA	0.2 ppm		US. ACGIH Threshold Limit Values (02 2012)
	Ceiling	5 ppm	9 mg/m3	US. OSHA Table Z-1 Limits for Air Contaminants (29 CFR 1910.1000) (02 2006)
	STEL	1 ppm	1.8 mg/m3	US. NIOSH: Pocket Guide to Chemical Hazards, as amended (2005)
	IDLH	20 ppm		US. NIOSH. Immediately Dangerous to Life or Health (IDLH) Values (10 2017)
	IDLH	13 ppm		US. NIOSH. Immediately Dangerous to Life or Health (IDLH) Values (10 2017)
Ozone	PEL	0.1 ppm	0.2 mg/m3	US. OSHA Table Z-1 Limits for Air Contaminants (29 CFR 1910.1000) (02 2006)
	Ceil_Time	0.1 ppm	0.2 mg/m3	US. NIOSH: Pocket Guide to Chemical Hazards, as amended (2005)
	TWA	0.05 ppm		US. ACGIH Threshold Limit Values (03 2014)
	TWA	0.10 ppm		US. ACGIH Threshold Limit Values (03 2014)
	TWA	0.08 ppm		US. ACGIH Threshold Limit Values (03 2014)
	IDLH	5 ppm		US. NIOSH. Immediately Dangerous to Life or Health (IDLH) Values (10 2017)
	TWA	0.20 ppm		US. ACGIH Threshold Limit Values (02 2020)

Additional exposure limits under the conditions of use: Canada

Chemical Identity	Type	Exposure Limit Values		Source
Carbon dioxide	STEL	30,000 ppm	54,000 mg/m3	Canada. Alberta OELs (Occupational Health & Safety Code, Schedule 1, Table 2), as amended (07 2009)
	TWA	5,000 ppm	9,000 mg/m3	Canada. Alberta OELs (Occupational Health & Safety Code, Schedule 1, Table 2), as amended (07 2009)
	TWA	5,000 ppm		Canada. British Columbia OELs: Table of Exposure Limits for Chemical Biological Substances (Workers Compensation Board); as amended (07 2007)
	STEL	15,000 ppm		Canada. British Columbia OELs: Table of Exposure Limits for Chemical Biological Substances (Workers Compensation Board); as amended (07 2007)
	TWA	5,000 ppm		Canada. Manitoba OELs (Reg. 217/2006, The Workplace Safety And Health Act), as amended (03 2011)
	STEL	30,000 ppm		Canada. Manitoba OELs (Reg. 217/2006, The Workplace Safety And Health Act), as amended (03 2011)
	STEL	30,000 ppm		Canada. Ontario OELs. (Control of Exposure to Biological or Chemical Agents), as amended (11 2010)
	TWA	5,000 ppm		Canada. Ontario OELs. (Control of Exposure to Biological or Chemical Agents), as amended (11 2010)
	8 HR ACL	5,000 ppm		Canada. Saskatchewan OELs (Occupational Health and Safety Regulations, 1996, Table 21), as amended (05 2009)

	15 MIN ACL	30,000 ppm		Canada. Saskatchewan OELs (Occupational Health and Safety Regulations, 1996, Table 21), as amended (05 2009)
	TWA	5,000 ppm	9,000 mg/m3	Canada. Quebec OELs. (Ministry of Labor - Regulation respecting occupational health and safety), as amended (09 2017)
	STEL	30,000 ppm	54,000 mg/m3	Canada. Quebec OELs. (Ministry of Labor - Regulation respecting occupational health and safety), as amended (09 2017)
Carbon monoxide	TWA	25 ppm	29 mg/m3	Canada. Alberta OELs (Occupational Health & Safety Code, Schedule 1, Table 2), as amended (07 2009)
	TWA	25 ppm		Canada. British Columbia OELs: Table of Exposure Limits for Chemical Biological Substances (Workers Compensation Board); as amended (07 2007)
	STEL	100 ppm		Canada. British Columbia OELs: Table of Exposure Limits for Chemical Biological Substances (Workers Compensation Board); as amended (07 2007)
	TWA	25 ppm		Canada. Manitoba OELs (Reg. 217/2006, The Workplace Safety And Health Act), as amended (03 2011)
	TWA	25 ppm		Canada. Ontario OELs. (Control of Exposure to Biological or Chemical Agents), as amended (07 2010)
	8 HR ACL	25 ppm		Canada. Saskatchewan OELs (Occupational Health and Safety Regulations, 1996, Table 21), as amended (05 2009)
	15 MIN ACL	190 ppm		Canada. Saskatchewan OELs (Occupational Health and Safety Regulations, 1996, Table 21), as amended (05 2009)
	TWA	35 ppm		Canada. Quebec OELs. (Ministry of Labor - Regulation respecting occupational health and safety), as amended (04 2022)
	STEL	175 ppm		Canada. Quebec OELs. (Ministry of Labor - Regulation respecting occupational health and safety), as amended (04 2022)
Nitrogen dioxide	STEL	5 ppm	9.4 mg/m3	Canada. Alberta OELs (Occupational Health & Safety Code, Schedule 1, Table 2), as amended (07 2009)
	TWA	3 ppm	5.6 mg/m3	Canada. Alberta OELs (Occupational Health & Safety Code, Schedule 1, Table 2), as amended (07 2009)
	CEILING	1 ppm		Canada. British Columbia OELs: Table of Exposure Limits for Chemical Biological Substances (Workers Compensation Board); as amended (07 2007)
	TWA	0.2 ppm		Canada. Manitoba OELs (Reg. 217/2006, The Workplace Safety And Health Act), as amended (03 2012)
	STEL	5 ppm		Canada. Ontario OELs. (Control of Exposure to Biological or Chemical Agents), as amended (11 2010)
	TWA	3 ppm		Canada. Ontario OELs. (Control of Exposure to Biological or Chemical Agents), as amended (11 2010)
	8 HR ACL	3 ppm		Canada. Saskatchewan OELs (Occupational Health and Safety Regulations, 1996, Table 21), as amended (05 2009)
	15 MIN ACL	5 ppm		Canada. Saskatchewan OELs (Occupational Health and Safety Regulations, 1996, Table 21), as amended (05 2009)
	TWA	3 ppm	5 mg/m3	Canada. Quebec OELs. (Ministry of Labor - Regulation respecting occupational health and safety), as amended (04 2022)

Ozone	STEL	0.3 ppm	0.6 mg/m ³	Canada. Alberta OELs (Occupational Health & Safety Code, Schedule 1, Table 2), as amended (07 2009)
	TWA	0.1 ppm	0.2 mg/m ³	Canada. Alberta OELs (Occupational Health & Safety Code, Schedule 1, Table 2), as amended (07 2009)
	TWA	0.05 ppm		Canada. British Columbia OELs: Table of Exposure Limits for Chemical Biological Substances (Workers Compensation Board); as amended (07 2007)
	TWA	0.1 ppm		Canada. British Columbia OELs: Table of Exposure Limits for Chemical Biological Substances (Workers Compensation Board); as amended (07 2007)
	TWA	0.08 ppm		Canada. British Columbia OELs: Table of Exposure Limits for Chemical Biological Substances (Workers Compensation Board); as amended (07 2007)
	TWA	0.2 ppm		Canada. British Columbia OELs: Table of Exposure Limits for Chemical Biological Substances (Workers Compensation Board); as amended (07 2007)
	TWA	0.1 ppm	0.2 mg/m ³	Canada. Ontario OELs. (Control of Exposure to Biological or Chemical Agents), as amended (07 2010)
	STEL	0.3 ppm	0.6 mg/m ³	Canada. Ontario OELs. (Control of Exposure to Biological or Chemical Agents), as amended (07 2010)
	15 MIN ACL	0.15 ppm		Canada. Saskatchewan OELs (Occupational Health and Safety Regulations, 1996, Table 21), as amended (05 2009)
	8 HR ACL	0.05 ppm		Canada. Saskatchewan OELs (Occupational Health and Safety Regulations, 1996, Table 21), as amended (05 2009)
	CEILING	0.1 ppm	0.2 mg/m ³	Canada. Quebec OELs. (Ministry of Labor - Regulation respecting occupational health and safety), as amended (12 2008)
	TWA	0.05 ppm		Canada. Manitoba OELs (Reg. 217/2006, The Workplace Safety And Health Act), as amended (03 2014)
	TWA	0.08 ppm		Canada. Manitoba OELs (Reg. 217/2006, The Workplace Safety And Health Act), as amended (03 2014)
	TWA	0.10 ppm		Canada. Manitoba OELs (Reg. 217/2006, The Workplace Safety And Health Act), as amended (03 2014)
	TWA	0.20 ppm		Canada. Manitoba OELs (Reg. 217/2006, The Workplace Safety And Health Act), as amended (02 2020)

Additional exposure limits under the conditions of use: Mexico

Chemical Identity	Type	Exposure Limit Values	Source
Carbon dioxide	VLE-CT	30,000 ppm	Mexico. OELs. (NOM-010-STPS-2014 Chemical Pollutants at the Workplace; Assessment and Control), as amended (04 2014)
	VLE-PPT	5,000 ppm	Mexico. OELs. (NOM-010-STPS-2014 Chemical Pollutants at the Workplace; Assessment and Control), as amended (04 2014)
Carbon monoxide	VLE-PPT	25 ppm	Mexico. OELs. (NOM-010-STPS-2014 Chemical Pollutants at the Workplace; Assessment and Control), as amended (04 2014)
Nitrogen dioxide	VLE-PPT	0.2 ppm	Mexico. OELs. (NOM-010-STPS-2014 Chemical Pollutants at the Workplace; Assessment and Control), as amended

			(04 2014)
Ozone	VLE-P	0.1 ppm	Mexico. OELs. (NOM-010-STPS-2014 Chemical Pollutants at the Workplace; Assessment and Control), as amended (04 2014)

Appropriate Engineering Controls

Ventilation: Use enough ventilation and local exhaust at the arc, flame or heat source to keep the fumes and gases from the worker's breathing zone and the general area. Train the operator to keep their head out of the fumes. **Keep exposure as low as possible.**

Individual protection measures, such as personal protective equipment (PPE)

General information:

Exposure Guidelines: To reduce the potential for overexposure, use controls such as adequate ventilation and personal protective equipment (PPE). Overexposure refers to exceeding applicable local limits, the American Conference of Governmental Industrial Hygienists (ACGIH) Threshold Limit Values (TLVs) or the Occupational Safety and Health Administration's (OSHA) Permissible Exposure Limits (PELs). Workplace exposure levels should be established by competent industrial hygiene assessments. Unless exposure levels are confirmed to be below the applicable local limit, TLV or PEL, whichever is lower, respirator use is required. Absent these controls, overexposure to one or more compound constituents, including those in the fume or airborne particles, may occur resulting in potential health hazards. According to the ACGIH, TLVs and Biological Exposure Indices (BEIs) "represent conditions under which ACGIH believes that nearly all workers may be repeatedly exposed without adverse health effects." The ACGIH further states that the TLV-TWA should be used as a guide in the control of health hazards and should not be used to indicate a fine line between safe and dangerous exposures. See Section 10 for information on constituents which have some potential to present health hazards. Welding consumables and materials being joined may contain chromium as an unintended trace element. Materials that contain chromium may produce some amount of hexavalent chromium (CrVI) and other chromium compounds as a byproduct in the fume. In 2018, the American Conference of Governmental Industrial Hygienists (ACGIH) lowered the Threshold Limit Value (TLV) for hexavalent chromium from 50 micrograms per cubic meter of air (50 µg/m³) to 0.2 µg/m³. At these new limits, CrVI exposures at or above the TLV may be possible in cases where adequate ventilation is not provided. CrVI compounds are on the IARC and NTP lists as posing a lung cancer and sinus cancer risk. Workplace conditions are unique and welding fume exposures levels vary. Workplace exposure assessments must be conducted by a qualified professional, such as an industrial hygienist, to determine if exposures are below applicable limits and to make recommendations when necessary for preventing overexposures.

Eye/face protection:

Wear helmet, face shield or eye protection with filter lens shade number 2 for torch soldering and 3-4 for torch brazing, and follow the recommendations as specified in ANSI Z49.1, Section 4; ISO/TR 18786:2014, based on your process details. Shield others by providing appropriate screens and eye protection.

Skin Protection

Hand Protection:

Wear protective gloves. Suitable gloves can be recommended by the glove supplier.

Other:

Protective Clothing: Wear hand, head, and body protection which help to prevent injury from radiation, open flames, hot surfaces, sparks and electrical shock. See Z49.1, ISO/TR 18786:2014, ISO/TR 13392:2014. At a minimum, this includes welder's gloves and a protective face shield when

welding, and may include arm protectors, aprons, hats, shoulder protection, as well as dark substantial clothing when welding, brazing and soldering. Wear dry gloves free of holes or split seams. Train the operator not to permit electrically live parts or electrodes from contacting the skin . . . or clothing or gloves if they are wet. Insulate yourself from the work piece and ground using dry plywood, rubber mats or other dry insulation.

Respiratory Protection:

Keep your head out of fumes. Use enough ventilation and local exhaust to keep fumes and gases from your breathing zone and the general area. An approved respirator should be used unless exposure assessments are below applicable exposure limits.

Workplace exposure levels should be established by competent industrial hygiene assessments. Unless exposure levels are confirmed to be below the applicable local limit, TLV or PEL, whichever is lower, respirator use is required.

Hygiene measures:

Do not eat, drink or smoke when using the product. Always observe good personal hygiene measures, such as washing after handling the material and before eating, drinking, and/or smoking. Routinely wash work clothing and protective equipment to remove contaminants. Determine the composition and quantity of fumes and gases to which workers are exposed by taking an air sample from inside the welder's helmet if worn or in the worker's breathing zone. Improve ventilation if exposures are not below limits. See ISO 10882-1:2024; ANSI/AWS F1.1, F1.2, F1.3 and F1.5, available from the American Welding Society, www.aws.org. Wash hands after handling.

9. PHYSICAL AND CHEMICAL PROPERTIES

Appearance:	Brazing flux.
Physical state:	Paste
Form:	Paste
Color:	No data available.
Odor:	No data available.
Odor threshold:	No data available.
pH:	8.8
Melting point/freezing point:	No data available.
Initial boiling point and boiling range:	No data available.
Flash Point:	No data available.
Evaporation rate:	No data available.
Flammability (solid, gas):	No data available.
Upper/lower limit on flammability or explosive limits	
Flammability limit - upper (%):	No data available.
Flammability limit - lower (%):	No data available.
Explosive limit - upper:	No data available.
Explosive limit - lower:	No data available.
Vapor pressure:	No data available.
Vapor density:	No data available.
Density:	No data available.
Relative density:	No data available.
Solubility(ies)	
Solubility in water:	No data available.



Solubility (other):	No data available.
Partition coefficient (n-octanol/water):	No data available.
Auto-ignition temperature:	No data available.
Decomposition temperature:	No data available.
Viscosity:	No data available.

10. STABILITY AND REACTIVITY

Reactivity:	The product is non-reactive under normal conditions of use, storage and transport.
Chemical Stability:	Material is stable under normal conditions.
Possibility of hazardous reactions:	None under normal conditions.
Conditions to avoid:	Avoid heat or contamination.
Incompatible Materials:	Strong acids. Strong oxidizing substances. Strong bases.
Hazardous Decomposition Products:	<p>Fumes and gases from welding and its allied processes such as brazing and soldering cannot be classified simply. The composition and quantity of both are dependent upon the metal to which the joining or hot work is applied, the process, procedure - and where applicable - the electrode or consumable 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 or worked (such as paint, plating, or galvanizing), the number of operators and the volume of the work area, the quality and amount of ventilation, the position of the operator'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.)</p> <p>In cases where an electrode or other applied material 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 of the materials shown in Section 3, plus those from the base metal and coating, etc., as noted above. Reasonably expected fume constituents produced during arc welding and brazing include the oxides of iron, manganese and other metals present in the welding consumable or base metal. Hexavalent chromium compounds may be in the welding or brazing fume of consumables or base metals which contain chromium. Gaseous and particulate fluoride may be in the fume of consumables or flux materials which contain fluoride. Gaseous reaction products may include carbon monoxide and carbon dioxide. Ozone and nitrogen oxides may be formed by the radiation from the arc associated with welding.</p>

11. TOXICOLOGICAL INFORMATION

General information:

The International Agency for Research on Cancer (IARC) has determined welding fumes and ultraviolet radiation from welding are carcinogenic to humans (Group 1). According to IARC, welding fumes cause cancer of the lung and positive associations have been observed with cancer of the kidney. Also according to IARC, ultraviolet radiation from welding causes ocular melanoma. IARC identifies gouging, brazing, carbon arc or plasma arc cutting, and soldering as processes closely related to welding. Read and understand the manufacturer's instructions, Safety Data Sheets and the precautionary labels before using this product.

Information on likely routes of exposure

- Inhalation:** Inhalation is the primary route of exposure. In high concentrations, vapors, fumes or mists may irritate nose, throat and mucus membranes.
- Skin Contact:** Moderately irritating to skin with prolonged exposure.
- Eye contact:** HEAT RAYS (INFRARED RADIATION) from flame or hot metal can injure eyes.
- Ingestion:** Avoid ingestion - wear gloves and other appropriate personal protection - wash hands thoroughly following use or handling. Harmful if swallowed.

Symptoms related to the physical, chemical and toxicological characteristics

- Inhalation:** Short-term (acute) overexposure to fumes and gases from brazing and soldering may result in discomfort such as metal fume fever, dizziness, nausea, or dryness or irritation of nose, throat, or eyes. May aggravate pre-existing respiratory problems (e.g. asthma, emphysema). Long-term (chronic) overexposure to fumes and gases from brazing and soldering can lead to siderosis (iron deposits in lung), central nervous system effects, bronchitis and other pulmonary effects. Products which contain lead or cadmium have additional specific health hazards - refer to Sections 2, 8 and 11 of this SDS. Depending on specific product composition, some products may produce hazardous concentrations of airborne oxides of cadmium, lead, zinc or fluoride compounds. Use adequate ventilation and respiratory protection during use. Avoid breathing fumes. Avoid ingestion - wear gloves and other appropriate personal protection - wash hands thoroughly following use or handling. Inhalation of fumes may cause upper respiratory tract irritation and systemic poisoning with early symptoms including headache, coughing, and a metallic taste as well as metal fume fever. Chronic cadmium exposure causes lung and kidney damage. Chronic exposure to lead causes damage to lungs, liver, kidney, nervous system as well as blood and musculoskeletal disorders. Exposures to high levels of cadmium or lead dust or fume may be immediately dangerous to life or health and can cause delayed pneumonitis with fever and chest pain, and pulmonary edema resulting in death.

Information on toxicological effects

Acute toxicity (list all possible routes of exposure)

Oral

Product: ATEmix: 940.64 mg/kg

Specified substance(s):

Potassium LD 50 (Rat): 875 mg/kg

difluorodihydroxyborate(1

-)

Dermal

Product:

**Inhalation
Product:****Repeated dose toxicity****Product:** No data available.**Skin Corrosion/Irritation****Product:** No data available.**Serious Eye Damage/Eye Irritation****Product:** No data available.**Respiratory or Skin Sensitization****Product:** No data available.**Carcinogenicity****Product:** No data available.**IARC Monographs on the Evaluation of Carcinogenic Risks to Humans:**

No carcinogenic components identified

US. National Toxicology Program (NTP) Report on Carcinogens:

No carcinogenic components identified

US. OSHA Specifically Regulated Substances (29 CFR 1910.1001-1053), as amended:

No carcinogenic components identified

Germ Cell Mutagenicity**In vitro****Product:** No data available.**In vivo****Product:** No data available.**Reproductive toxicity****Product:** Suspected of damaging fertility or the unborn child.**Specific Target Organ Toxicity - Single Exposure****Product:** No data available.**Specific Target Organ Toxicity - Repeated Exposure****Product:** No data available.**Aspiration Hazard****Product:** No data available.**Symptoms related to the physical, chemical and toxicological characteristics under the condition of use****Additional toxicological information under the conditions of use:****Acute toxicity****Inhalation****Specified substance(s):**

Carbon dioxide	LC Lo (Human, 5 min): 90000 ppm
Carbon monoxide	LC 50 (Rat, 4 h): 1300 ppm
Nitrogen dioxide	LC 50 (Rat, 4 h): 88 ppm
Ozone	LC Lo (Human, 30 min): 50 ppm

Other effects:

Specified substance(s):

Carbon dioxide	Asphyxia
Carbon monoxide	Carboxyhemoglobinemia
Nitrogen dioxide	Lower respiratory tract irritation

12. ECOLOGICAL INFORMATION

Ecotoxicity

Acute hazards to the aquatic environment:

Fish

Product: No data available.

Aquatic Invertebrates

Product: No data available.

Chronic hazards to the aquatic environment:

Fish

Product: No data available.

Aquatic Invertebrates

Product: No data available.

Specified substance(s):

Potassium fluoroborate NOEC (Daphnia magna): 188 mg/l NOEC : 188 mg/l

Toxicity to Aquatic Plants

Product: No data available.

Persistence and Degradability

Biodegradation

Product: No data available.

Bioaccumulative potential

Bioconcentration Factor (BCF)

Product: No data available.

Mobility in soil:

No data available.

13. Disposal considerations

General information:

The generation of waste should be avoided or minimized whenever possible. When practical, recycle in an environmentally acceptable, regulatory compliant manner. Dispose of non-recyclable products in accordance with all applicable Federal, State, Provincial, and Local requirements.

Disposal instructions:

Discharge, treatment, or disposal may be subject to national, state, or local laws.

Contaminated Packaging:

Dispose of contents/container to an appropriate treatment and disposal facility in accordance with applicable laws and regulations, and product characteristics at time of disposal.

14. TRANSPORT INFORMATION

DOT

UN number or ID number:



UN Proper Shipping Name: NOT DG REGULATED
Transport Hazard Class(es)
Class: NR
Label(s): –
Packing Group: –
Marine Pollutant: No

IMDG

UN number or ID number:
UN Proper Shipping Name: NOT DG REGULATED
Transport Hazard Class(es)
Class: NR
Label(s): –
EmS No.:
Packing Group: –
Marine Pollutant: No

IATA

UN number or ID number:
Proper Shipping Name: NOT DG REGULATED
Transport Hazard Class(es):
Class: NR
Label(s): –
Packing Group: –
Marine Pollutant: No
Cargo aircraft only: Allowed.

TDG

UN number or ID number:
UN Proper Shipping Name: NOT DG REGULATED
Transport Hazard Class(es)
Class: NR
Label(s): –
Packing Group: –
Marine Pollutant: No

15. REGULATORY INFORMATION**US Federal Regulations****TSCA Section 12(b) Export Notification (40 CFR 707, Subpt. D)**

None present or none present in regulated quantities.

US. OSHA Specifically Regulated Substances (29 CFR 1910.1001-1053), as amended

None present or none present in regulated quantities.

CERCLA Hazardous Substance List (40 CFR 302.4):

None present or none present in regulated quantities.

Superfund Amendments and Reauthorization Act of 1986 (SARA)**Hazard categories**

Immediate (Acute) Health Hazards

Delayed (Chronic) Health Hazard

Acute toxicity (any route of exposure)

Reproductive toxicity

SARA 302 Extremely Hazardous Substance

None present or none present in regulated quantities.

**SARA 304 Emergency Release Notification**

None present or none present in regulated quantities.

SARA 311/312 Hazardous Chemical**Chemical Identity****Threshold Planning Quantity****SARA 313 (TRI Reporting)**

None present or none present in regulated quantities.

Clean Water Act Section 311 Hazardous Substances (40 CFR 117.3)

None present or none present in regulated quantities.

Clean Air Act (CAA) Section 112(r) Accidental Release Prevention (40 CFR 68.130):

None present or none present in regulated quantities.

US State Regulations**US. California Proposition 65**

No ingredient requiring a warning under CA Prop 65.

WARNING: This product contains or produces 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.)

WARNING: Cancer and Reproductive Harm – www.P65Warnings.ca.gov

US. New Jersey Worker and Community Right-to-Know Act**Chemical Identity**

Potassium difluorodihydroxyborate(1-)

Potassium fluoroborate

Potassium tetraborate tetrahydrate

Boron and compounds (as B)

US. Massachusetts RTK - Substance List

No ingredient regulated by MA Right-to-Know Law present.

US. Pennsylvania RTK - Hazardous Substances**Chemical Identity**

Potassium difluorodihydroxyborate(1-)

Potassium fluoroborate

US. Rhode Island RTK**Chemical Identity**

Potassium difluorodihydroxyborate(1-)

Potassium fluoroborate

Canada Federal Regulations**List of Toxic Substances (CEPA, Schedule 1)****Chemical Identity**

Potassium fluoroborate

Export Control List (CEPA 1999, Schedule 3)

Not Regulated

National Pollutant Release Inventory (NPRI)**Canada. National Pollutant Release Inventory (NPRI) Substances, Part 5, VOCs with Additional Reporting Requirements**

NPRI PT5

Not Regulated

Canada. National Pollutant Release Inventory (NPRI) (Schedule 1, Parts 1-4)

NPRI

Not Regulated

**Greenhouse Gases**

Not Regulated

Controlled Drugs and Substances Act

CA CDSI Not Regulated

CA CDSII Not Regulated

CA CDSIII Not Regulated

CA CDSIV Not Regulated

CA CDSV Not Regulated

CA CDSVII Not Regulated

CA CDSVIII Not Regulated

Precursor Control Regulations

Not Regulated

Mexico. Substances subject to reporting for the pollutant release and transfer registry (PRTR): Not applicable**Inventory Status:**

Australia Industrial Chem. Act (AIC):	On or in compliance with the inventory
Canada DSL Inventory List:	One or more components are not listed or are exempt from listing.
Canada NDSL Inventory:	One or more components are not listed or are exempt from listing.
Ontario Inventory:	One or more components are not listed or are exempt from listing.
China Inv. Existing Chemical Substances:	On or in compliance with the inventory
Japan (ENCS) List:	One or more components are not listed or are exempt from listing.
Japan ISHL Listing:	One or more components are not listed or are exempt from listing.
Japan Pharmacopoeia Listing:	One or more components are not listed or are exempt from listing.
Korea Existing Chemicals Inv. (KECI):	One or more components are not listed or are exempt from listing.
Mexico INSQ:	One or more components are not listed or are exempt from listing.
New Zealand Inventory of Chemicals:	On or in compliance with the inventory
Philippines PICCS:	One or more components are not listed or are exempt from listing.
Taiwan Chemical Substance Inventory:	One or more components are not listed or are exempt from listing.
US TSCA Inventory:	One or more components are not listed or are exempt from listing.
Switzerland New Subs Notified/Registered:	One or more components are not listed or are exempt from listing.
Thailand Existing Chemical Inv. List:	One or more components are not listed or are exempt from listing.
Vietnam National Chemical Inventory:	On or in compliance with the inventory
EINECS, ELINCS or NLP:	One or more components are not listed or are exempt from listing.

16. OTHER INFORMATION**Definitions:****Revision Date:** 09/11/2025**Further Information:** Additional information is available by request.**Disclaimer:** The Lincoln Electric Company urges each end user and recipient of this SDS to study it carefully. See also www.lincolnelectric.com/safety. If necessary, consult an industrial hygienist or other expert to understand this information and safeguard the environment and protect workers from potential hazards associated with the handling or use of this product. This information is believed to be accurate as of the revision date shown above. However, no warranty, expressed or implied, is given. Because the conditions or methods



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