

Please ensure that this SDS is received by the appropriate persons

Review Date: 22/11/2022 v01 Emergency: 0860 02 02 02 **Document Number: AFX-SDS-0100**

1.	PRODUCT	AND COMPANY IDENTIFICATION	
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Product

STAINLESS STEEL WELDING

ELECTRODES

Product Code Trade Name

AWS/ASME SFA 5.4

The following Afrox electrodes are

covered by this SDS: * E307: Afrox 307

* E308L/H: Afrox 308L, Afrox 308H * E309/309L/309LMo: Afrox 309L,

* E310: Afrox 310 * E316L: Afrox 316L * E312: Afrox 312

Afrox 309LMo

* E410NiMo: Afrox E3Cr12

* E347: Afrox 347 * E2209: Afrox 2209

Recommended

Use

Manual Metal Arc (MMA) welding of

stainless steels

Company African Oxygen Limited Identification

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www.afrox.com

Emergency Numbers

0860 02 02 02 (Afrox)

Vapour

Inhalation

Chemical

Biological

Hazards

Hazards

- Hot metal spatter and heat during welding may cause fire if in contact with

combustible materials.

-Fumes produced from the welding consumable, material being welded, and the arc radiation.

- Short term inhalation of these fumes and gases may lead to irritation of the nose, throat and eyes.

- Long term overexposure or inhalation of high levels of fumes may result in harmful effects to the respiratory system, central nervous system and lungs.

- Particulate fume such as complex metal

oxides, fluorides, and silicates from the

weld materials.

-Gaseous fume such as ozone and nitrogen oxides from the action of arc radiation on the atmosphere, and carbon monoxide and dioxide from the dissociation and reaction of some flux constituents during welding.

- Local extraction and/or ventilation should be used to ensure that all hazardous ingredients in the fume are kept below their individual occupational exposure standards in the welder's and other

workers' breathing zones.

- NOTE: If welding is performed on plated or coated materials such as galvanised steel, excessive fume may be produced which contains additional hazardous components and may result in metal fume

fever and other health effects.

Eye Contact

-UV, IR, and light radiation from the arc, which can produce 'arc eye' and possible eve damage to unprotected eyes. Wear

Skin Contact

suitable protective equipment. - No known effect associated with unused welding consumables prior to welding.

- Hot metal spatter and heat can cause burns to the hand and body during

welding.

Ingestion

- Considered unlikely due to product form.

GHS Classification - Not classified as hazardous according to applicable GHS hazard classification

criteria.

GHS Pictogram

-Not applicable

GHS Signal Words

-Not applicable

GHS Hazard Statements

- Not applicable

GHS Precautionary Statements

Storage: Not applicable Prevention:

- Not applicable Response: - Not applicable **Disposal**

- Not applicable

2. HAZARD IDENTIFICATION

Classification

-Classification under South African Hazardous Chemical Substances Regulations subsequently amended.

(HCS)

-Classification under the Globally Harmonized System of classification and

labelling of chemicals (GHS)

Emergency Overview

Colour: Generally greyish, but other colours can be present

Odour: Odourless Taste: Not applicable Physical State: Solid

Form: Metal wire with flux coating

Main Hazards

- When using these electrodes as part of the welding process additional potential hazards are likely.

- Electric shock from the welding equipment or electrode. This can be fatal.

- There are no recognised hazards associated directly with unused welding consumables prior to welding.

Adverse Health **Effects**

- Some low levels of dust may be produced during handling. Do not

breathe the dust.



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Other Hazards that do not result in classification

 Packaged consumables may be heavy and should be handled and stored with care. Follow Manual Handling

Regulations.

3. COMPOSITION OF INGREDIENTS

Chemical name

These electrodes consist of a stainless-steel inner core covered with a flux coating. The stainless-steel inner core is an uncoated solid rod. The flux coatings vary depending on the type of electrode, and contain varying amounts of metal powders, ferro-alloy powders, mineral ores, inorganic oxides, carbonates and fluorides, and other siliceous materials all mixed together with liquid silicate binders.

Specific details of the contents of the core wire and flux coating for the electrode types covered by this Safety Data Sheet are provided in Table 1 and

E300I Mo E3200 E410NiMo Cas No

Table 2 below.

CAS No Various: refer to Table 2 below

UN No Not applicable
ERG No Not applicable
Hazard class Not applicable

TABLE 1: CORE WIRE COMPOSITION DATA

Stainless Steel core	% C	% Si	% Mn	% Cr	% Ni	% Mo	% Cu	% Fe
Ranges	0.01-	0.90	0.3-	0-	0-	0-	0-	Balance
	0.20	max	7.0	32	25	5.2	0.5	

TABLE 2: COATING COMPOSITION DATA (WT %)

Flux coating E2081

Flux coating	E308L, 308H, 309L, 310, 312,347	E309LMo, 316L	E2209	E410NiMo	Cas No.
Limestone and/or Calcium Carbonate	0-20	0-20	5-10	0-22	1317-65-3
Mica (total inhalable dust) (respirable dust)	0-13	0-12	-	0-12	12001-26-2
Kaolin (respirable dust)	0-15	0-15		0-15	1332-58-7
Cellulose (total inhalable dust) (respirable dust)	0-2	0-2	-	-	9004-34-6
Mineral Silicates (total inhalable dust) (respirable dust	0-30	0-30	15-25	0-15	1332-58-7 1344-95-2
Inorganic Fluorides (as F)	0-6	0-6	5-15	0-21	16984-48-8

Flux coating	E308L, 308H, 309L, 310,312 347	E309LMo, 316L	E2209	E410NiMo	Cas No.
Manganese and its Inorganic compounds (as Mn)	0-5	0-5	<3	0.5	7439-96-5 and others
Aluminium (total inhalable dust) (respirable dust)	0-2	0-2	-	0-2	7429-90-5
Rutile/ Titanium oxide (total inhalable dust) (respirable dust)	0-45	0-45	20-40	0-45	13463-67-7
Nickel and its inorganic compounds (soluble, as Ni) (insoluble, as Ni)	0-15	0-15	<5	0-15	
Silicon and Silicon alloys, (as Si) (total inhalable dust) (respirable dust)	0-5	0-5	-	0-5	7440-21-3
Molybdenum compounds (as Mo) (soluble compounds) (insoluble compounds)	-	0-5	-	0.2	
Chromium Chromium III compounds Chromium VI compounds	0-30	0-30	20-30	0-30	7440-47-3
Antimony	0-2	0-2		0-2	7440-36-0
oxide Silicate Binders	0-25	0-25	<5	0-25	1344-09-8
Others			Cu <3		

4. FIRST AID

 No first aid measures should be required for the unused electrode consumables.

GHS Precautionary Statements Storage:
- Not applicable

Prevention:
- Not applicable

Response:
- Not applicable

<u>Disposal</u>
- Not applicable

Other Hazards that do not result in classification

-Packaged consumables may be heavy and should be handled and stored with care. Follow Manual Handling Regulations.



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First aid measures during welding:

Inhalation - If breathing is difficult, bring the patient to an open area with fresh air; breathe in fresh

Submerge affected area in cold water until Skin burns

burning sensation ceases and refer for

immediate medical attention.

For eye effects such as arc eye and dusts Ingestion

- Irrigate eye with sterile water, cover with damp dressing and refer for immediate medical attention if irritation persists.

Ingestion is considered unlikely due to product form. However, if detached flux coating is swallowed do not induce vomiting. Seek medical attention. Advice to

doctor: treat symptomatically.

Electric shock - If necessary, resuscitate and seek

immediate medical attention.

5. FIRE-FIGHTING

Suitable extinguishing media

-No specific measures required for the welding consumable prior to welding. Use extinguishing media appropriate for surrounding fire.

Unsuitable extinguishing media

- None

Specific Hazards - Welding should not be carried out in the presence of flammable materials, vapours, tanks, cisterns and pipes and other containers which have held flammable substances unless these have been checked and certified safe.

Special

fire-fiahtina procedures

Special protective equipment for

firefighters

- Evacuate all personnel from the danger area. Follow fire-fighting procedures appropriate for surrounding fire.

- Firefighters should use standard protective equipment including flame retardant coat, helmet with face shield, gloves, rubber and. in enclosed spaces, hoots Self-contained Breathing Apparatus.

6. ACCIDENTAL RELEASE

Personal precautions, protective equipment and emergency procedures

- specific actions - No consumable prior to use.
- Welding in proximity to stored or used halogenated solvents may produce toxic and irritant gases. Prohibit welding in areas where these solvents are used.
- Provide adequate ventilation

Precautions

- Environmental Avoid release to the environment. Prevent further leakage or spillage, if safe to do so.
 - -Do not contaminate water sources or sewer

Methods and material for containment and cleaning au

- Absorb with sand or other inert absorbent.
- Clean up spills immediately, observing personal protective equipment precautions. Prevent product from entering any drains, sewers or water

sources

7. HANDLING AND STORAGE

Safe Handling

- No special precautions are required for these welding consumables.
- -Welding electrodes are dense materials and can give rise to a handling hazard when multiple packages of the electrodes are lifted or handled incorrectly or with poor lifting posture. Good practice for handling and storage should be adopted to prevent physical injuries.

Conditions for safe storage, including any incompatibilities

- Technical Measures/ Storage conditions
- Store in closed, original container in a dry place. Store in accordance with local/regional/national regulations
- -Keep out of reach of children
- No special precautions are required for these welding consumables.

8. EXPOSURE CONTROLS

Exposure Hazards

- Occupational Welders should not touch live electrical parts and should insulate themselves from the and the work ground.
 - During welding, fumes and gases will be produced and emitted from the welding process. The content of the fume is dependent on the electrode type and base material being welded. The amount and concentration of fume generated is dependent on factors such as current, voltage, welding practices and number of welders in a given area. By following recommended welding practices, fume production can sometimes be minimised. Refer to Table 3 for Fume Composition Data for some common stainless-steel electrodes and to Table 4 for Hazardous Fume Components.

Engineering Control Measures

For electrical hazard:

Manufacturer's guidelines for the use of electrical welding machines should be observed all times. at

For fume hazard:

-Good general ventilation, and/or local fume extraction at the arc should be used to control the fumes and gases produced during welding to below their individual recognised exposure limits when measured in the welder's and co-workers' breathing

In addition, the ventilation and extraction should also be sufficient to ensure that the



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total particulate fume levels are reduced below 5mg/m3 when measured in the breathing zone.

- In confined spaces, where ventilation is not adequate, an air-fed breathing system should be used. All precautions for working in confined space should be observed. Refer to OHSAct No. 85 of 1993 General Safety Regulation 9. For further information see the American National Standard Z49.1 Safety in Welding and Cutting and SABS 0238 (SANS 10238) Welding and Thermal Cutting Processes Health and Safety.
- Where fume levels exceed the recognised exposure limits, respiratory protection may be required in the form of a Class P2 (metal fume) respirator.
- Welders and co-workers should be educated about the health hazards associated with welding fume and trained to keep their heads out of the fume plume.
- For stainless steel electrodes, the main constituents of the fume will be iron, chromium, manganese, nickel, sodium, potassium and calcium oxides, fluorides and silicates, mainly in the form of complex oxides and other compounds. There will also be smaller amounts of other complex metal oxides and silicates.
- Gaseous ozone and nitrous oxides are also formed by arc radiation, and carbon monoxide and carbon dioxide can also be present due to dissociation of some of the flux constituents.
- -Fume composition data for some common stainless-steel electrodes are provided in Table 3 below, and the individual exposure limits for the constituents (when specified) are provided in Table 4.
- Fume exposure should be controlled to below the recognised exposure limit for each of the individual constituents, and to below 5 mg/m3 for the total particulate fume.

TABLE 3: FUME COMPOSITION DATA (WT%)

Electrode	%	%	%	%	%	%	%	%	%	%	%
Type	Fe	Mn	Si	Cr	Ni	Mo	Cu	Na	K	Ca	F
Typical range for common stainless steel electrodes	4-16	1-12	0-13	4-13	0-6	<1	<0.2	1-15	1-29	1-9	8-23

TABLE 4: HAZARDOUS FUME COMPONENTS

Welding Fume Component	Cas. No.	OEL 8hr TWA	STEL 15min TWA
Total welding fume (particulate)	-	5	
Iron oxide fume (as Fe)	1309-37-1	5	10
Manganese and its inorganic compounds (as Mn)	7439-96-5	1.0	3
Silica, amorphous (total inhalable dust) (respirable dust)	-		
Titanium dioxide (total inhalable dust) (respirable dust)	13463-67-7	10	
Calcium Oxide	1305-78-8	2	
Welding Fume Component	Cas. No.	OEL 8hr TWA	STEL 15min TWA
Calcium Silicate (total inhalable dust) (respirable dust)	1344-95-2		

Fluoride, inorganic (as F)	16984-48-8	2.5	
Chromium VI compounds (as Cr)		0.05	
Chromium III compounds (as Cr)		0.05	
Nickel and its inorganic compounds (as Ni) water soluble water insoluble		1 0.1 0.2	
Molybdenum compounds (as Mo) soluble insoluble		5	
Nitrogen dioxide (NO ₂)	10102-44-0	5.6	9.4
Ozone (O ₃)	10028-15-6	0.2	
Nitrogen monoxide (NO)	10102-43-9		
Copper Fume	7440-50-8	0.2	

Units are in mg/m3, except when stated otherwise

- The fume analyses for the stainless-steel electrodes covered by this data sheet, when used for welding clean, uncoated stainless steel of matching composition, indicate that as long as the 5 mg/m³ total fume exposure limits are met, fume levels of the other constituents will generally be below their respective exposure limits.
- The exceptions are manganese, chromium and nickel, as these have low exposure limits, and additional controls to their individual limits may be required.
- -The fume levels presented above were generated under laboratory conditions when welding clean stainless steel of similar composition to the electrode being used, and using the manufacturers recommended welding parameters. They are indicative of reasonably expected fume levels. Actual fume levels will vary in practice, depending on the welding parameters and other conditions, and may be higher or lower than those listed above.
- Additional fume may arise when these electrodes are used to weld contaminated base materials, coated or plated steels, other metals and alloys, or when incorrect welding conditions are used.
- -The only accurate way to determine the composition and quantity of fumes and gases to which workers are exposed is to take air samples from inside the welder's helmet, if worn, or in the worker's breathing zones.
- Individual fume measurements should be made in these cases using recognised sampling and analysis standards. Based on the results of these measurements, additional fume controls may be required to ensure that all the fume constituents are controlled below their exposure limits.

Personal Protection

 Welders and co-workers in the vicinity should wear protective clothing and eye protection appropriate to arc welding as specified by local standards.

Eyes

 Welders should wear a welding helmet fitted with the appropriate optical welding filter for the operation. Suitable protective welding screens and goggles should be provided and used by others working in the same area.

Hands

 Welders should wear suitable hand protection such as welding gloves or gauntlets of a suitable standard. Co-workers should also wear suitable hand protection against hot metal, sparks and spatter.

Body protection

-Suitable clothes for welding should be worn such as non-light reflective fireproof overalls,



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leather apron, welding helmet, leather boot

spats and gloves.

Feet -Welders and co-workers should wear safety

shoes / boots while handling

consumables and during welding.

9. PHYSICAL AND CHEMICAL PROPERTIES

STAINLESS STEEL Name WELDING

ELECTRODES

Chemical Symbol Mixture of substances

Physical state Solid

Metal wire with flux Form:

coating

Generally grevish, but Colour:

other colours can be present

Odourless

Odour Threshold: Not applicable

No data available pH:

~1500°C **Melting Point:**

Boiling Point: Not applicable

Sublimation Point: Not applicable

Critical Temp. (°C): Not applicable

Flash Point: Not applicable

Evaporation Rate: Not applicable

Non-flammable solid Flammability (solid, gas):

Flammability limit - upper (%): Not applicable Flammability limit - lower (%): Not applicable Vapour pressure: Not applicable Vapour density (air=1) Not applicable Relative density: No data available

Solubility(ies)

Odour:

Solubility in Water: Insoluble

Partition coefficient No data available (n-octanol/water):

Autoignition Temperature: Not self-igniting **Decomposition Temperature:** No data available

Viscosity

Kinematic viscosity: No data available Dynamic viscosity: No data available **Explosive properties:** Not applicable **Oxidising Properties:** Not applicable

Various, per electrode Molecular weight type

10.STABILITY AND REACTIVITY

Reactivity

- There are no reactivity hazards from

electrodes as supplied.

Chemical -There are no stability hazards from stability

electrodes as supplied.

Possibility of -There is no possibility of hazardous hazardous reactions from electrodes as supplied. reactions

Conditions to - Open flames and high energy ignition avoid

sources.

Incompatible reaction with any common **Materials**

materials in dry or wet conditions.

Hazardous Decomposition of Products

- Hazardous decomposition products such as metal oxide fumes and gases (see Section 8) are produced during

welding.

11. TOXICOLOGICAL INFORMATION

Acute Toxicity Refer to "Other Relevant

Toxicity Information"

Skin & eye contact Refer to "Other Relevant

Toxicity Information"

Chronic Toxicity Refer to "Other Relevant

Toxicity Information"

Carcinogenicity Refer to "Other Relevant

Toxicity Information"

Mutagenicity Refer to "Other Relevant

Toxicity Information"

Reproductive Hazards Refer to "Other Relevant

Toxicity Information"

Other Relevant Information **Toxicity**

Welding fumes, if inhaled, can potentially produce several differing health effects caused by the metal containing particles and the gases produced during the welding process, both of which are present in the fumes. The exact nature of any likely health effect is dependent on the consumable, the material being welded and the weld process, all of which affect fume quantity and composition, as well as the use of adequate ventilation, respirators or breathing equipment, as circumstances require. Inhalation of the fumes/gases produced during welding may lead to irritation to the nose, throat and eyes. The range of health effects include respiratory effects with symptoms such as asthma, impaired respiratory and lung function, chronic bronchitis, metal fume fever, pneumoconiosis, possible emphysema and acute oedema. pulmonary

Other potential health effects at elevated levels of exposure include central nervous effects, possible lung cancer, bone disease, skin and fertility effects. Which of



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these health effects is potentially likely is related to the fume composition, and this needs to be consulted with the specific toxicity data below to assess the health risk when using any particular welding process

Unprotected skin exposed to UV and IR radiation from the welding arc may burn or redden, and UV radiation is potentially a carcinogen. UV radiation can affect the unprotected eye by producing an acute condition known as 'arc eve'.

Specific effects relevant to major particulate and gaseous fume constituents produced when welding with these electrodes:

Iron

One of the main components of fume generated by welding stainless steels is iron oxide.

Iron oxide is generally considered a nuisance material and unlikely to cause any significant health effects. The fume particles, however, accumulate in the lungs and lead to a benign pneumoconiosis called siderosis.

Manganese

Manganese compounds are also found in stainless steel welding fumes.

Manganese is mainly a systemic chronic toxin, although exposure to high particulate concentrations can cause some respiratory irritation.

Overexposure or inhalation of excessive amounts of manganese has been shown to affect pulmonary function, blood and may cause irreversible central nervous system damage (manganism) which resembles Parkinsons disease. Symptoms of manganism include tremors, impaired speech, facial expression changes, slow clumsy movements and eventually impaired walking. The symptoms are typically not apparent for several years.

Fluorides

The main source of fluorides is from the flux coatings on some stainless-steel welding electrodes, and this produces mainly fluoride particulate fume. Fluorides are respiratory irritants and if absorbed through inhalation can lead to bone disease known as fluorosis.

Silica

Silica is found in welding fumes produced by fluxes and flux coatings and is produced mainly as amorphous silica. This form of silica has not been associated to any significant degree with lung pneumoconiosis which is associated with crystalline forms of silica.

Rutile sand

Mainly present as Titanium dioxide which is a respiratory irritant but in effect mainly a nuisance material of low toxicity.

Chromium

Chromium can exist in differing forms in welding fumes and this can determine the potential health effects. Chromium can produce respiratory effects such as nasal ulceration and possible lung cancer. It can also cause contact skin dermatitis.

The most toxic form of chromium is hexavalent chromium (Cr6+) which is classified as a human carcinogen.

The other main form of chromium found in welding fumes (Cr3+) is considerably less toxic and is not classified as a carcinogen. Both types of chromium are found in the fume from this product.

Nickel

The main health effects of nickel are skin dermatitis (nickel 'itch') and it being classified as a potential human lung carcinogen. It may also cause nasal cancer. Similar to chromium, nickel exists in the fume produced from stainless

Molybdenum

Molybdenum is of low toxicity, and no specific health effects would be expected from exposure to it in welding fume.

Copper

Copper is one of the main causes of any metal fume fever observed during welding. Metal fume fever is a delayed respiratory effect produced by the inhalation of fume. Symptoms include sweating, chills, fever, muscle aches, and high temperature. These acute symptoms normally alleviate within 24-48 hours

Ozone and Nitrogen oxides

These gases are formed due to interactions of the arc with the surrounding air of the welding arc. Both gases can produce eye, respiratory and lung irritation and also can produce longer term lung effects such as decreased lung capacity, chronic bronchitis, and emphysema. Of particular concern with both gases is that exposure to high levels (e.g. due to build up in confined spaces) can result in acute lung effects such as delayed pulmonary oedema.

Carbon monoxide and carbon dioxide

Carbon monoxide (CO) is a chemical asphyxiant and its toxicity is due to its affinity for oxygen carrying blood haemoglobin causing fatigue, weakness, dizziness and eventual unconsciousness and possible death. Carbon dioxide (CO_2) is mainly an asphyxiant but can exert some toxic properties by increasing pulse and heart rate. These gases are mainly formed through decomposition of some electrodes' components (cellulose and carbonates).

12. ECOLOGICAL INFORMATION

Toxicity
Persistence

No relevant information available.No relevant information available.

and degradability

Mobility in soil

- No relevant information available.

Ecology - soil

- No relevant information available.

Results of PBT and vPvB assessment

Not classified as persistent,
bioaccumulating and toxic (PBT).
Not classified as persistent, very persistent and very bioaccumulating

(vPvB).



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Other adverse effects

- Water hazard (self-assessment). Slightly

hazardous for water.

Effect on ozone layer

- The welding process produces particulate fumes and gases which may cause long term adverse effects in the environment if released directly into the atmosphere. Welding fumes from the electrodes covered by this Safety Data Sheet can produce carbon dioxide gas, which is dangerous to the ozone layer.

Effect on the global warming

- No relevant information available.

13. DISPOSAL CONSIDERATIONS

Disposal Methods

- Stub ends and slag residue should be disposed of as general waste.

- No special precautions are required for this product.

Disposal of

- Packaging can be recycled. **Packaging**

14. TRANSPORT INFORMATION

Road Transportation

UN No. Not applicable **Shipping Name** Welding consumables

ERG No. Not applicable Not applicable Class Not applicable **Subsidiary Risk** Hazchem Warning Not applicable

No special requirements are necessary in transporting these

products.

Sea Transportation

IMDG Not applicable **Shipping Name** Welding consumables

ERG No. Not applicable Not applicable Class **Subsidiary Risk** Not applicable Not applicable Label

No special requirements are necessary in transporting these

products.

Air Transportation

ICAO/IATA Code Not applicable Class Not applicable Not applicable Subsidiary risk

Packaging No special requirements are instructions necessary in transporting these

products.

Maximum quantity

allowed

No special requirements are necessary in transporting these

products.

15. REGULATORY INFORMATION

SANS 11014:2010 **Edition 1**

Safety Data Sheet for chemical products - Content and order of sections

SANS 10228:2012 The identification and classification **Edition 6** of dangerous goods for transport by

road and rail modes

SANS 10234:2019 Globally Harmonized System of Classification and Labelling of **Edition 2**

Chemicals (GHS)

SUPPLEMENT TO SANS 10234 Edition 1

List of classification and labelling of chemicals in accordance with the Globally Harmonized System (GHS)

SANS 10238 Welding and Thermal Cutting Processes – Health and Safety

16. OTHER INFORMATION

- Ensure all national/local regulations are observed.
- Regularly check supplier's information sources for updated versions of SDS's.
- The customer should provide this Safety Data Sheet to any person involved in the materials use or further distribution.
- The information contained in this Safety Data Sheet relates only to the specific materials designated and may not be valid for such material used in combination with any other material or in any process.
- Further information can be obtained from the American National Standard Z49.1 Safety in Welding and Cutting.
- SANS 10234-Globally Harmonized System of Classification and Labelling of Chemicals data book

Revision Date 22/11/2022 v01

Bibliography

- National Institute for Standards and Technology (NIST) Standard Reference Database Number 69.
- The ESIS (European chemical Substances 5 Information System) platform of the former European Chemicals Bureau (ECB) ESIS (http://ecb.jrc.ec.europa.eu/esis/).
- The European Chemical Industry Council ERICards.
- United States of America's National Library of Medicine's toxicology data network
- TOXNET (http://toxnet.nlm.nih.gov/index.html)

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