


This Safety Data Sheet complies with the guidance on Occupation Safety and Health Act and enforcement regulations.

1. PRODUCT AND COMPANY IDENTIFICATION

- A. Product Name** Welding Material (Flux Cored Welding Electrode for Low Temperature Service Steel)
Dual Shield 7100SM, Dual Shield 7100 Ultra, Dual Shield 7100SR,
Dual Shield 7100SRM, Dual Shield II 71-HI, Dual Shield II 71-SH,
Dual Shield II 80-Ni1, Dual Shield II 71 H5, Dual Shield 80EG
- B. Recommended use of the chemical and restrictions on use**
- 1) Recommended use Rabbet and fillet welding material for 50~60kgf/mm² high tensile strength steel for steel frame, bridge, pressure vessel, penstock, railcar, automotive, heavy equipment, and general structural steel fabrication. Especially, for nuclear power plant, off-shore and shipbuilding
- 2) Restrictions on use Refer to 7. Handling and Storage
- C. Supplier's details**
- 1) Name ESAB SeAH Corporation
- 2) Address 51 Seongju-dong, Seongsan-gu, Changwon, Kyungnam, Korea
- 3) Phone number 055-289-8111
- D. Emergency phone number** 055-289-8111, 055-269-8225

2. HAZARD IDENTIFICATION

- A. Classification of product** Skin sensitizer: category 1
Carcinogenicity: category 2
Specific target organ toxicity (repeated exposure): category 2
- B. GHS Label elements, including precautionary statements**
- 1) Pictograms (Hazard symbols)
- 
- 2) Signal word Warning
- 3) Hazard statements H317 May cause an allergic skin reaction.
H351 Suspected of causing cancer.
H373 May cause damage to organs through prolonged or repeated exposure.
- 4) Precautionary statements
- A) Prevention P201 Obtain special instructions before use.
P202 Do not handle until all safety precautions have been read and understood.
P260 Do not breathe dust/fume/gas/mist/vapours/spray.
P261 Avoid breathing dust/fume/gas/mist/vapours/spray.
P272 Contaminated work clothing should not be allowed out of the workplace.
P280 Wear protective gloves/protective clothing/eye protection/face protection.



SAFETY DATA SHEET

Page: 2(10)
SDS No.: EN ESC 1-6-1
Data revised: 2021.07.16

This Safety Data Sheet complies with the guidance on Occupation Safety and Health Act and enforcement regulations.

- B) Response** P302+P352 If on skin, wash with plenty of water.
P308+P313 If exposed or concerned, get medical advice/attention.
P314 Get medical advice/attention if you feel unwell.
P333+P313 If skin irritation or rash occurs, get medical advice/attention.
P363 Wash contaminated clothing before reuse.
- C) Storage** P405 Store locked up.
- D) Disposal** P501 Dispose of contents/container in accordance with related laws.

C. Other hazards which do not result in classification No available data

D. Hazards During welding

When these products are used in a welding process, the most important hazards are heat, radiation, electric shock and welding fumes.

Heat : Spatter and melting metal can cause burn injuries and start fires.

Radiation : Arc rays can severely damage eyes or skin.

Electricity : Electric shock can kill.

Fumes : Overexposure to welding fume may result in symptoms like metal fume fever, dizziness, nausea, dryness or irritation of the nose, throat or eyes. Chronic overexposure to welding fumes may affect pulmonary function.

- 1) **Prevention** : Welding fumes and gases may be dangerous to your health. Use adequate ventilation to keep fumes from the breathing zone. Arc rays may injure eyes and burn skin. Wear adequate hand, head, eye and body protection.
- 2) **Response** : .Not applicable
- 3) **Storage** : Stored locked up and keep dry
- 4) **Disposal** : Not applicable

3. COMPOSITION/INFORMATION ON INGREDIENTS

Unit: wt%

Ingredient	CAS No.	Dual Shield 7100SM	Dual Shield 7100 Ultra	Dual Shield 7100SR	Dual Shield 7100SRM	Dual Shield II 71-HI
Iron (Fe)	7439-89-6	Bal (>80)	Bal (>80)	Bal (>80)	Bal (>80)	Bal (>80)
Magnesium (Mg)	7439-95-4	-	<1	-	-	-
Manganese (Mn)	7439-96-5	1.5~3.5	1.5~3.5	1~4	1~4	1~4
Nickel (Ni)	7440-02-0	<1	-	<1	<1	<1
Silicon (Si)	7440-21-3	-	0.5~1.5	-	-	-
Quartz	14808-60-7	-	0.5~1.5	-	-	-
Titanium Oxide (TiO ₂)	13463-67-7	5~9	6~9	5~9	5~9	5~9
AWS Classification		A5.20 E71T-9M	A5.20 E71T- 1C/1M/9C/9M	A5.20 E71T-1C/9C- J/12C-J	A5.20 E71T-9M- J/12M-J	A5.20 E71T1-9C-J

Ingredient	CAS No.	Dual Shield II 71-SH	Dual Shield II 80-Ni1	Dual Shield II 71 H5	Dual Shield 80EG
Iron (Fe)	7439-89-6	Bal (>80)	Bal (>80)	Bal (>80)	Bal (>80)
Magnesium (Mg)	7439-95-4	-	<1	<1	<1
Manganese (Mn)	7439-96-5	1~4	1~3	1.5~3.5	1~3
Nickel (Ni)	7440-02-0	<1	<1	-	<1



SAFETY DATA SHEET

Page: 3(10)
SDS No.: EN ESC 1-6-1
Data revised: 2021.07.16

This Safety Data Sheet complies with the guidance on Occupation Safety and Health Act and enforcement regulations.

Silicon (Si)	7440-21-3	-	0.3~1.5	<1	0.3~1.5
Quartz	14808-60-7	-	<1	0.5~1.5	<1
Titanium Oxide (TiO ₂)	13463-67-7	5~9	6~10	6~9	6~10
AWS Classification		A5.20 E71T1-9C-J	A5.29 E81T1-NiC	A5.20 E71T-1C/9C	A5.29 E81T1-NiC

4. FIRST AID MEASURES

A. Eye contact

- If irritation persists, obtain medical assistance.
- To remove dusts or fumes flush with water for at least twenty minutes.
- For radiation burns due to arc flash, see physician.

B. Skin contact

- If skin irritation or erythema occurs, see physician.
- Clean the contaminated clothing for reuse.
- For skin burns from arc radiation, promptly flush with plenty of cold water.
- Remove contaminated clothing and shoes, and isolate contaminated area.
- To remove dust or particles wash with mild soap and water for at least twenty minutes.

C. Inhalation

- If exposure, obtain medical assistance immediately.
- Move to safety area.
- If breathing has stopped, perform Cardio Pulmonary Resuscitation (CPR) and obtain medical assistance immediately.
- If breathing is difficult, provide fresh air and call physician.
- Keep warm and stabilize body.

D. Ingestion

- Call a physician or poison control center immediately.
- Do not induce vomiting unless directed to do so by a physician.

E. Others

- If exposure, obtain special medical assistance immediately.
- Recognize materials and do protective action.
- In an electric shock, Disconnect and turn off the power.
- Use a nonconductive material to pull victim away from contact with live parts or wires.
- If not breathing, begin artificial respiration, preferably mouth-to-mouth.
- If no detectable pulse, begin Cardio Pulmonary Resuscitation (CPR).
- Immediately call a physician.

5. FIRE-FIGHTING MEASURES

A. Suitable extinguishing media

- No specific recommendations for welding consumables.
- Welding arcs and sparks can ignite combustible and flammable materials.
- Use the extinguishing media recommended for the burning materials and fire situation (CO₂, water).
- Cover fire site with dried sand or soil.

B. Specific hazards arising from the chemical



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A harmful gas will be produced at high temperature.
When heated, container may explode.
Friction, heat, and spark can ignite materials.
Materials can be re-ignited after extinguishing.

C. Special protective actions for fire-fighters

Wear proper protective equipment.
Keep a certain distance and extinguish the fire.
If not dangerous, remove container.
If impossible extinguish, protect surround and extinguish itself.

6. ACCIDENTAL RELEASE MEASURES

A. Personal precautions, protective equipment and emergency procedures

Avoid inhalation of dust, fume, gas, mist, and spray.
Clean up the spilling and follow the section 8. C. individual protection measures.
Don't touch and don't wake around the spilling.
Remove all ignition sources.
If not dangerous, stop leaking.
Pay attention to the avoiding substances and condition.

B. Environmental precautions

The spilling can cause pollution.
Block the inflow to waterway, drain, basement, and enclosed area.

C. Method and materials for containment and cleaning up

Absorb the spilling with the Inert materials (dried sand or soil) and put it to chemical waste container.
Wash the contaminated area with water and soap.

7. HANDLING AND STORAGE

A. Precautions for safe handling

Don't treat before reading and understanding all safe precautions.
Avoid inhalation of dust, fume, gas, mist, and spray.
Wash handling part after finishing handling.
Don't eat, drink, and smoke when treating.
Follow MSDS/label precautions when treating empty container.
Use with caution when handling and storing.
Remove the cap with caution.
If no a ventilation system, don't enter the storage area.
Prevent dust generation.
Don't touch products when welding.
Wear the nonconductive gloves.
Don't use damaged or wet gloves.
Wear insulating shoes at workplace.
Don't touch terminal of products, welding cable, and welding machine socket,
Don't wear wet clothing at conductive place.



SAFETY DATA SHEET

Page: 5(10)
SDS No.: EN ESC 1-6-1
Data revised: 2021.07.16

This Safety Data Sheet complies with the guidance on Occupation Safety and Health Act and enforcement regulations.

Keep the instruction manual and precautions before welding.

Use proper welding cable and repair or exchange the damaged cables.

Remove hazardous materials (combustibles or flammable liquid) to prevent spatter from firing, or cover them with nonflammable materials.

Don't weld container or pipe with combustible or flammable materials, or enclosed container or pipe.

Don't put a hot welding material around combustible or flammable materials.

Remove hidden combustible or flammable materials when welding around ceiling, floor, and wall.

Keep extinguisher around workplace.

B. Conditions for safe storage

Keep away food and drink.

Store in a well-ventilated and low humidity place.

8. EXPOSURE CONTROLS/PERSONAL PROTECTION

A. Control parameters

1) Internal and external regulations

Ingredients	CAS No.	Internal		External(ACGIH)		Notes
		TWA ⁽¹⁾ (mg/m ³)	STEL ⁽²⁾ (mg/m ³)	TWA ⁽¹⁾ (mg/m ³)	STEL ⁽²⁾ (mg/m ³)	
Iron (Fe)	7439-89-6	1	-	-	-	
Magnesium (Mg)	7439-95-4	-	-	-	-	
Manganese (Mn)	7439-96-5	1	3(Fume)	0.02 [#] , C5(Fume) ^{##}	-	
Nickel (Ni)	7440-02-0	1	-	1.5	-	Carc. Cat. 2
Silicon (Si)	7440-21-3	10	-	-	-	
Quartz	14808-60-7	0.05	-	-	-	Carc. Cat. 1A, Respirable
Titanium Oxide (TiO ₂)	13463-67-7	10	-	10	-	Carc. Cat. 2
Welding Fume & dust	-	5	-	-	-	Carc. Cat. 2

(1) TWA : Time Weighted Average

(2) STEL : Short Time Exposure Limit

[#]Respirable dust

^{##}Ceiling

^{###}Metal dust

*Inhalable dust

2) Biological limit values

Not available

B. Appropriate engineering controls

To install local ventilation system in the vicinity of welding fume sources is more effective than to deal with fume spreaded at workplace

Natural ventilation : If the concentration is low, the space is 284m³ or more per two workers, and a ceiling height of space is more 5 meter, the natural ventilation is applied. It is also applied to the non-enclosed space with dilution.

Local ventilation : Install the appropriate local ventilation system depending on the nature of processing and welding materials. If the local ventilation is installed newly, the combined type, local air supply and local exhaust, is recommended. Local ventilation system installed closer to the worker as possible is desirable. It must have the ventability lower than the expoosure limit. It is the most effective system to remove fume, but if the exhaust is too larger, welding defects will be occurred because of disturbance



SAFETY DATA SHEET

Page: 6(10)
SDS No.: EN ESC 1-6-1
Data revised: 2021.07.16

This Safety Data Sheet complies with the guidance on Occupation Safety and Health Act and enforcement regulations.

of the shielding gas. Workers should turn on it while working and conduct maintenance.

Portable local ventilation : It is applied when working in a confined space such as ship-body assembly or in the tank. Local air supply and local exhaust takes place at the same time. If necessary, run all the time. If welding fume exhausts to other workplace, portable dust collection equipment should be installed.

Full ventilation : Workplace is ventilated with fans and blowers. It is effective when workplace is a relatively small volume. To remove fume, parallel push-pull ventilation should be considered. It should be designed and installed according to the workplace.

C. Individual protection measures

Use protective equipment certified by the Korea Occupational Safety and Health agency while welding.

1) Respiratory protection

To prevent fume or hazardous gases, wear a mask while welding as below.

Dust mask : Wear it in a bad ventilation condition while welding.

Remove dust or dry frequently after using.

Gas mask : Wear a gas mask when ventilation is not sufficient such as inside the tank or in a narrow place.

Select a gas mask that can be used to combined with protective goggles

Use the proper canister according to hazardous substance.

Air-supplied respirator : Use air-line mask with compressed air.

2) Eye protection

Use a facial mask with filter screen from the ultraviolet of arc or spatter. There are face shield helmet or hand shielded helmet.

Use shielding grade as welding type.

Welding type	Shielding grade
Shielded metal arc welding	10-12
Gas metal arc welding	11-12
Gas tungsten arc welding	12
Flux cored arc welding	11-12

3) Hand protection

Wear the nonconductive gloves.

Don't use damaged or wet gloves.

4) Body protection

Wear leather apron and welding gloves to prevent burns and take insulating shoes at workplace.

9. PHYSICAL AND CHEMICAL PROPERTIES

A. Appearance

1) Physical state

Solid

2) Colour

Silver or gray

B. Odour

Not available

C. Odour threshold

Not available

D. pH

Not available

E. Melting point/freezing point

Not available

F. Initial boiling point and boiling range

Not available

G. Flash point

Not available

H. Evaporation rate

Not available



SAFETY DATA SHEET

Page: 7(10)
SDS No.: EN ESC 1-6-1
Data revised: 2021.07.16

This Safety Data Sheet complies with the guidance on Occupation Safety and Health Act and enforcement regulations.

I. Flammability (Solid, Gas)	Not available
J Upper/lower flammability or explosive limits	Not available
K. Vapour pressure	Not available
L. Vapour density	Not available
M. Relative density	Not available
N. Solubility	Not available
O. Partition coefficient: n-octanol/water	Not available
P. Auto-ignition temperature	Not available
Q Decomposition temperature	Not available
R. Viscosity	Not available
S. Molecular weight	Not available

10. STABILITY AND REACTIVITY

A. Reactivity, chemical stability, and possibility of hazardous reactions

Although may be burnt, ignition is difficult.

During fire, irritant gases and fume will be produced.

B. Conditions to avoid

Ignition sources (heat, spark, blaze)

C. Incompatible materials

Combustible or flammable materials, chemical substances like acids and strong bases

D. Hazardous decomposition products

May produce irritant gases and fume

11. TOXICOLOGICAL INFORMATION

A. Information on the likely routes of exposure	Not available
B. Health hazard information	
1) Acute toxicity	Not available
A) Oral	Not available
B) Dermal	Not available
C) Inhalation	Not available
2) Skin corrosion/irritation	Not available
3) Serious eye damage/irritation	Not available
4) Respiratory sensitization	Not available
5) Skin sensitization	May cause an allergic skin reaction.
6) Carcinogenicity	Suspected of causing cancer(welding fume)
A) Occupation safety and health acts	Not available
B) The ministry of employment and labor	Not available
C) IARC	Not available
D) OSHA	Not available
E) ACGIH	Not available
F) NTP	Not available



SAFETY DATA SHEET

Page: 8(10)
SDS No.: EN ESC 1-6-1
Data revised: 2021.07.16

This Safety Data Sheet complies with the guidance on Occupation Safety and Health Act and enforcement regulations.

G) EU CLP	Not available
7) Germ cell mutagenicity	Not available
8) Reproductive toxicity	Not available
9) STOT-single exposure	Not available
10) STOT-repeated exposure	May cause damage to organs through prolonged or repeated exposure.
11) Aspiration hazard	Not available

12. ECOLOGICAL INFORMATION

A. Toxicity	
1) Fish	Not available
2) Crustacea	Not available
3) Birds	Not available
B. Persistence and degradability	
1) Persistence	Not available
2) Degradability	Not available
C. Bioaccumulative potential	
1) Bioconcentration factor	Not available
2) Biodegradation	Not available
D. Mobility in soil	Not available
E. Other adverse effects	Not available

13. DISPOSAL CONSIDERATIONS

A. Disposal method	Disposal contents and container as wastes control act.
B. Precautions	Disposal contents and container as wastes control act.

14. TRANSPORT INFORMATION

A. UN number	Not available
B. UN proper shipping name	Not available
C. Transport hazard class	Not available
D. Packing group	Not available
E. Environmental hazards	Not available
F. Special precautions for user	
1) Fire emergency action	Not available
2) Leak emergency action	Not available

15. REGULATORY INFORMATION

A. Internal regulation	No available internal regulation against products.
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Ingredient	Occupation Safety and Health Act	Toxic	Safety	Wastes
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SAFETY DATA SHEET

Page: 9(10)
SDS No.: EN ESC 1-6-1
Data revised: 2021.07.16

This Safety Data Sheet complies with the guidance on Occupation Safety and Health Act and enforcement regulations.

	Control material	Work environment monitoring material	Special health monitoring material	Exposure standard material	Acceptable standard material	Permission material	Chemicals Control Act	Control of Dangerous Substances Act	Control Act
Fe	O	X	X	O	X	X	X	500kg	specified
Mg	X	X	X	X	X	X	X	500kg	X
Mn	O	O	O	O	O	X	X	500kg	X
Ni	O	O	O	O	O	X	X	X	specified
Si	X	X	X	O	X	X	X	X	specified
Quartz	X	O	O (24Mth)	O	X	X	X	X	specified
TiO ₂	O	O	X	O	X	X	X	X	X

Work environment monitoring material : unless noted, measure every 6 months.

Special health monitoring material : unless noted, measure every 12 months.

O : included

X : not included

B. Other internal or external regulations

No available other internal or external regulation against products.

Ingredient	Fe	Mg	Mn	Ni	Si	Quartz	TiO ₂
Internal regulation							
Persistent Organic Pollutant Act	X	X	X	X	X	X	X
External regulation							
OSHA	X	X	X	X	X	X	X
CERCLA	X	X	X	45.3599kg	X	X	X
EPCRA 302	X	X	X	X	X	X	X
EPCRA 304	X	X	X	X	X	X	X
EPCRA 313	X	X	included	included	X	X	X
Rotterdam convention material	X	X	X	X	X	X	X
Stockholm convention material	X	X	X	X	X	X	X
Montreal protocol material	X	X	X	X	X	X	X
EU classification (result)	X	F: R15-17	X	Carc. Cat. 3; R40 R43 T; R48/23, R52, R53	X	X	X
EU classification (R-phrase)	X	R15 R17	X	R40 R43 R48/23 R52/53	X	X	X
EU classification (S-phrase)	X	S2 S7/8 S43	X	S2 S36/37/39 S45 S61	X	X	X

X : not included.

16. OTHER INFORMATION

A. References

EU REGULATION (EC) No 1272/2008

EU DIRECTIVE 2009/2/EC

The Ministry of Employment and Labor notification No. 2020-48 & 2020-130

Threshold Limit Values according to American Conference of Governmental Hygienists, 2012

Permissible Exposure Limits according to the Occupational Safety & Health Administration (USA)

Chemical Information System (<http://ncis.nier.go.kr/ncis>)

Korea Occupational Safety & Health Agency (<http://www.kosha.or.kr>)



SAFETY DATA SHEET

Page: 10(10)
SDS No.: EN ESC 1-6-1
Data revised: 2021.07.16

This Safety Data Sheet complies with the guidance on Occupation Safety and Health Act and enforcement regulations.

National Emergency Management Agency (<http://www.nema.go.kr>)

B. First issued date 2013. 06. 11

C. Revision

1) Revision No. 4

2) Date revised 2021.07.16