


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 (Seamless Flux Cored Welding Electrode for Low Temperature Service Steel)  
Dual Shield Prime 81-K2, Dual Shield Prime 81-OS,  
Dual Shield Prime 81-Ni1 H4, Dual Shield Prime 81-Ni1M H4
- B. Recommended use of the chemical and restrictions on use**
- 1) Recommended use Rabbet and fillet welding material for 50~60kgf/mm<sup>2</sup> 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.
- B) Response  
P302+P352 If on skin, wash with plenty of water.



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- 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.
- P405 Store locked up.
- P501 Dispose of contents/container in accordance with related laws.

### C) Storage

### D) Disposal

**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 Prime<br>81-K2 | Dual Shield Prime<br>81-OS | Dual Shield Prime<br>81-NI1 H4 | Dual Shield Prime<br>81-NI1M H4 |
|------------------------------------|------------|----------------------------|----------------------------|--------------------------------|---------------------------------|
| Iron (Fe)                          | 7439-89-6  | Bal (>80)                  | Bal (>80)                  | Bal (>80)                      | Bal (>80)                       |
| Magnesium (Mg)                     | 7439-95-4  | <1                         | <1                         | <1                             | <1                              |
| Manganese (Mn)                     | 7439-96-5  | 1~3                        | 1~3                        | 1.5~4                          | 1.5~4                           |
| Nickel (Ni)                        | 7440-02-0  | 1~2                        | 1~2                        | 0.5~1.5                        | 0.5~1.5                         |
| Silicon (Si)                       | 7440-21-3  | 0.3~1.5                    | 0.3~1.5                    | 0.3~1.5                        | 0.3~1.5                         |
| Quartz                             | 14808-60-7 | <1                         | <1                         | <1                             | <1                              |
| Titanium Oxide (TiO <sub>2</sub> ) | 13463-67-7 | 5~8                        | 5~8                        | 6~10                           | 6~10                            |
| <b>AWS Classification</b>          |            | A5.29<br>E81T1-K2C         | A5.29<br>E81T1-K2C         | A5.29<br>E81T1-Ni1C/M          | A5.29<br>E81T1-Ni1M             |

## 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.



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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 (CO<sub>2</sub>, water).

Cover fire site with dried sand or soil.

### B. Specific hazards arising from the chemical

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.



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Clean up the spilling and follow the section 8. C. individual protection measures.

Don't touch and don't walk 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 read 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.

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



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## A. Control parameters

### 1) Internal and external regulations

| Ingredients                        | CAS No.    | Internal                                   |   | External(ACGIH)                               |   | Notes                        |
|------------------------------------|------------|--|---|---|---|------------------------------|
|                                    |            | TWA <sup>(1)</sup><br>(mg/m <sup>3</sup> ) | STEL <sup>(2)</sup><br>(mg/m <sup>3</sup> ) | TWA <sup>(1)</sup><br>(mg/m <sup>3</sup> )    | STEL <sup>(2)</sup><br>(mg/m <sup>3</sup> ) |                              |
| Iron (Fe)                          | 7439-89-6  | 1  | -   | -   | -   |                              |
| Magnesium (Mg)                     | 7439-95-4  | -  | -   | -   | -   |                              |
| Manganese (Mn)                     | 7439-96-5  | 1  | 3(Fume)                                     | 0.02 <sup>#</sup> ,<br>C5(Fume) <sup>##</sup> | -   |                              |
| 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,<br>Respirable |
| Titanium Oxide (TiO <sub>2</sub> ) | 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

<sup>#</sup>Respirable dust

<sup>##</sup>Ceiling

<sup>###</sup>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 284m<sup>3</sup> 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 of the shelding 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 ventilized with fans and blowers. It is effecive when workplace is a relatively small volume. To remove fume, parallel push-pull ventilation should be considered. It should be designed and installed accordding to the workplace.

## C. Individual protection measures

Use proective equipment cerified by the Korea Occupational Safety and Health agency while welding.

### 1) Respiratory protecton

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.



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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

### 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



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## 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

##### 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



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- 3) Brids 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.

| Ingredient | Occupation Safety and Health Act |                                      |                                    |                            |                              |                     | Toxic Chemicals Control Act | Safety Control of Dangerous Substances Act | Wastes Control Act |
|------------|----------------------------------|--------------------------------------|------------------------------------|----------------------------|------------------------------|---------------------|-----------------------------|--|--------------------|
|            | Control material                 | Work environment monitoring material | Special health monitoring material | Exposure standard material | Acceptable standard material | Permission material |                             |  |                    |
| 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          |
| TiO2       | 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





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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 | TiO2 |
|----------------------------------|----|-------------|----------|---|----|--------|------|
| 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>)

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