



Code: AG-CU-ZN-SILVACOTE  
Date: 18 NOV 2005  
Revised: 1 NOV 2007  
Printed: 1 NOV 2007

WOLVERINE JOINING TECHNOLOGIES, LLC.

MATERIAL SAFETY DATA SHEET

Product: SILVACOTE A45, SILVACOTE A30, SILVACOTE A35, 42011,  
42015, 42020

SECTION 1: CHEMICAL PRODUCT AND COMPANY IDENTIFICATION

Common Name : SILVER-COPPER-ZINC BRAZING ALLOY W/FLUX COATING  
Chemical Name : CHEMICAL MIXTURE  
Formula : CHEMICAL MIXTURE  
Product CAS No.: CHEMICAL MIXTURE  
Product Use : Welding/Brazing/Soldering

Supplier : WOLVERINE JOINING TECHNOLOGIES, LLC.  
Address : 235 KILVERT STREET  
City, St, Zip : WARWICK, RI 02886  
Phone : 1-401-739-9550

FOR CHEMICAL EMERGENCY CALL CHEMTREC (24 HOURS):  
1-800-424-9300 (US, Canada, Puerto Rico, Virgin Islands)  
1-703-527-3887 (Outside Above Area)

SECTION 2: COMPOSITION/INFORMATION ON INGREDIENTS

INGREDIENT	CAS NO.	% Wt.
COPPER	7440-50-8	20-40
SILVER	7440-22-4	30-60
ZINC	7440-66-6	10-40
POTASSIUM BIFLOURIDE	7789-29-9	1-5
POTASSIUM FLUOBORATE	14075-53-7	1-7
BORIC ACID	10043-35-3	1-7
POTASSIUM TETRABORATE	1332-77-0	1-5
POTASSIUM CARBONATE	584-08-7	0-5
ALIPHATIC POLYCARBONATE	- - -	1-5

NOTE: The percentage by weight values reported for the ingredients in this product represent approximate formulation values. See Section 8 for Exposure Limits and Section 11 for Toxicological Information.

### SECTION 3: HAZARDS IDENTIFICATION

#### EMERGENCY OVERVIEW

Silver wire, rod or strip with white or colored flux semi soft coating

Order: Slight

Flash Point: Metal - Not Applicable

Flux - >200 F

Prolonged or repeated exposure may cause damage to the lungs, liver, kidneys, and may cause blood disorders.

May cause respiratory tract irritation. Overexposure to freshly formed fumes may cause a flu-like illness called "metal fume fever".

May cause eye and skin irritation.

Harmful if large amounts are swallowed. May cause gastrointestinal irritation, nausea, vomiting and diarrhea.

Long term exposure to fluorides may cause damage to teeth and bones.

Not a fire or explosion hazard in solid form. Finely divided dust may ignite and burn rapidly when mixed with air in the proper proportions.

Toxic metal fumes may be released in a fire situation.

#### ROUTES OF ENTRY

Eyes? YES

Skin? YES

Inhalation? YES

Ingestion? YES

#### POTENTIAL HEALTH EFFECTS

EYE CONTACT may cause irritation.

SKIN CONTACT may cause irritation. Prolonged contact may cause dermatitis.

INHALATION may cause respiratory tract irritation and coughing. Absorption may cause systemic effects similar to those detailed under ingestion.

INGESTION not normally expected. However, ingestion of large amounts may cause abdominal pain, nausea, vomiting, diarrhea, headache, weakness and dizziness. COPPER poisoning can result in hemolytic anemia and kidney, liver and spleen damage.

NOTE: Inhalation of fumes may cause a flu-like illness called metal fume fever. Typically metal fume fever begins four to twelve hours after sufficient exposure to freshly formed fumes. The first symptoms are a metallic taste, dryness and irritation of the throat. Cough and shortness of breath may occur along with headache, fatigue, nausea, vomiting, muscle and joint pain, fever and chills. The syndrome runs its course in 24-48 hours.

NOTE: The potential health effects described above only apply if dust or fume is formed.

#### CARCINOGENICITY

NTP? NO

IARC? NO

OSHA? NO

#### CHRONIC HEALTH HAZARDS

The absorption of SILVER compounds into the circulation and the subsequent deposition of reduced silver in various tissues of the body may result in the production of a generalized greyish pigmentation of the skin and mucous membrane (argyria). Generalized argyria develops after 2 to 25 years of exposure. There are no systemic effects or symptoms and no physical disability. Once deposited, there is no known means by which this silver can be eliminated; the pigmentation is permanent.

Prolonged exposure to SILVER can cause damage to the nasal septum.

Exposure to FLUORIDES over years may produce mottling of tooth enamel, embrittlement and calcification of bones, and increased calcification of ligaments and vertebrae resulting in spinal stiffness (fluorosis).

Prolonged or repeated inhalation may cause a benign pneumoconiosis.

Excessive ZINC intake has been associated with copper deficiency anemia.

Prolonged or repeated overexposure may cause kidney and liver damage.

Refer to Potential Health Effects.

#### MEDICAL CONDITIONS GENERALLY AGGRAVATED BY EXPOSURE

May adversely affect existing medical conditions, such as eye, skin, respiratory, blood, liver and/or kidney ailments.

Individuals with Wilson's Disease are at increased risk of COPPER poisoning.

NOTE: See Section 8 for Exposure Limits, Section 11 for Toxicological Information and Section 12 for Ecological Information.

#### SECTION 4: FIRST AID MEASURES

**EYE CONTACT:** Immediately flush with plenty of water for at least 15 minutes. Hold eyelids open while flushing. If irritation persists, call a physician.

**SKIN CONTACT:** Immediately wash skin with soap and plenty of water. If irritation persists, call a physician.

**INHALATION:** Procedures normally not needed. If exposed to excessive levels of dust or fumes, remove to fresh air and seek medical attention.

**INGESTION:** Procedures normally not needed. If large quantities are ingested, seek medical advice.

## SECTION 5: FIRE-FIGHTING MEASURES

Flash Point: Metal - Not Applicable, Flux/Binder - >200F  
Auto-Ignition: Metal - Not Applicable, Flux/Binder - AP 518 F  
LEL: Not Applicable  
UEL: Not Applicable

### NFPA HAZARD CLASSIFICATION

Health: 1                      Flammable: 0                      Reactivity: 0

### HMIS HAZARD CLASSIFICATION

Health: 1\*                      Flammable: 0                      Reactivity: 0                      Special: B

\* Indicates the possibility of chronic health effects. See  
Chronic Health Hazards in Section 3 for more information.

### EXTINGUISHING MEDIA

Use carbon dioxide, chemical foam or dry chemical. Use any means for  
extinguishing surrounding fire.

Do NOT use water on metal fires.

### SPECIAL FIRE FIGHTING PROCEDURES

Wear NIOSH/MSHA approved positive-pressure self-contained breathing  
apparatus and protective clothing as specified in 29 CFR 1910.156.

### UNUSUAL FIRE AND EXPLOSION HAZARDS

Not a fire or explosion hazard in solid form. Finely divided dust may  
ignite and burn rapidly when mixed with air in the proper proportions.  
Toxic metal fumes may be released in a fire situation.

## SECTION 6: ACCIDENTAL RELEASE MEASURES

Contain spillage and scoop up or vacuum. Notification of the National  
Response Center (800/424-8802) may be required. Refer to EPA, DOT and  
applicable state and local regulations for current response information.

It is recommended that each user establish a spill prevention, control  
and countermeasure plan (SPCC). Such plan should include procedures  
applicable to proper storage, control and clean-up of spills, including  
reuse or disposal as appropriate (see Section 13: Disposal  
Considerations).

**\*\*NOTE\*\*** In the event of an accidental release of this material, the  
above procedures should be followed. Additionally, proper exposure  
controls and personal protection equipment should be used (see Section  
8: Exposure Control/Personal Protection), and disposal of the material  
should be in accordance with Section 13: Disposal Considerations.

SECTION 7: HANDLING AND STORAGE

Wash thoroughly after handling.

Store in a cool, dry location away from incompatible materials.

Avoid breathing any dust, mist or fumes resulting from the use of this product.

Avoid contact with any dusts, mists or fumes resulting from the use of this product.

Use only with adequate ventilation.

Do not eat, drink, or smoke in work area.

SECTION 8: EXPOSURE CONTROLS/PERSONAL PROTECTION

EXPOSURE LIMITS INGREDIENT	PEL-OSHA	TLV-ACGIH
COPPER CAS NO.: 7440-50-8	0.1 mg/m3 (Fume) 1 mg/m3 (Dust)	0.2 mg/m3 (Fume) 1 mg/m3 (Dust)
SILVER CAS NO.: 7440-22-4	0.01 mg/m3	0.1 mg/m3
ZINC (AS OXIDE) CAS NO.: 7440-66-6	15 mg/m3 (Total dust) 5 mg/m3 (Respirable fraction) 5 mg/m3 (Fume)	5 mg/m3 (Fume) 10 mg/m3 (Fume) STEL 10 mg/m3 (Total dust)
POTASSIUM BIFLOURIDE CAS NO. : 7789-29-9	2.5 mg/m3 (as F)	2.5 mg/m3 (as F)
POTASSIUM FLUOBORATE CAS NO.: 14075-53-7	2.5 mg/m3 (as F)	2.5 mg/m3 (as F)
BORIC ACID CAS NO.: 10043-35-3	None Established	None Established
POTASSIUM TETRABORATE CAS NO.: 1332-77-0	None Established	None Established
POTASSIUM CARBONATE CAS NO.: 884-08-7	None Established	None Established
ALIPHATIC POLYCARBONATE CAS NO. -- -- --	None Established	None Established

NOTE: Both OSHA and the ACGIH list welding fumes as having an exposure limit of 5 mg/m<sup>3</sup> (total particulate not otherwise classified). However, the ACGIH states that welding fumes must be tested frequently for individual components which are likely to be present to determine whether specific exposure limits are exceeded.

NOTE: The permissible exposure limits (PELs), threshold limit values (TLVs), potential health effects statements and SARA hazard categories may not be applicable as the hazardous ingredients listed are in the solid form. If dust, powder or fume is generated then these statements will be applicable.

Unless otherwise noted, all values are reported as 8-hour Time-Weighted Averages (TWAs) and total dust (particulates only). All ACGIH TLVs refer to the 1998 Standards. All OSHA PELs refer to 29 CFR Part 1910 Air Contaminants: Final Rule, January 19, 1989.

#### RESPIRATORY PROTECTION

If dust or fume is generated, a NIOSH/MSHA approved respirator may be necessary. Follow all requirements for respiratory programs and selection set forth in the OSHA regulations (29 CFR 1910.139).

#### VENTILATION

General; local exhaust ventilation as necessary to control any air contaminants to within their PELs or TLVs during the use of this product.

#### PROTECTIVE EQUIPMENT

Safety glasses (with side shields).

Gloves.

Body protection as necessary to prevent skin contact.

Refer to ANSI/ASC Z49.1-94 (Safety in Welding, Cutting and Allied Processes), published by the American Welding Society, for further information on the selection of personal protective equipment.

#### PERSONNEL SAMPLING PROCEDURE

For COPPER (dust & fume): Refer to NIOSH Manual of Analytical Methods (NMAM), 4th Edition, Method 7029.

For ZINC OXIDE: Refer to NIOSH Manual of Analytical Methods (NMAM), 4th Edition, Method 7502.

For FLUORIDE COMPOUNDS: Refer to NIOSH Manual of Analytical Methods (NMAM), 4th Edition, Methods 7902, 7906.

For METALLIC COMPONENTS: Refer to NIOSH Manual of Analytical Methods (NMAM), 4th Edition, Method 7300.

## SECTION 9: PHYSICAL AND CHEMICAL PROPERTIES

Appearance: Silver wire, rod or strip with flux coating  
Odor: Slight  
Boiling Point: Not Determined  
Specific Gravity (H<sub>2</sub>O=1): 8.5 to 9.5  
Melting Point (F) Metal: 1145-1205 Flux: 600-1050  
Vapor Pressure (mm Hg): Not Applicable  
Vapor Density (Air=1): Not Applicable  
Evaporation Rate: Not Applicable  
% Solubility In Water: Metal: Negligible, Flux: 100%  
pH: Flux - 7 to 8 SU

## SECTION 10: STABILITY AND REACTIVITY

Stability: Generally considered stable.  
Avoid: Temperatures at or above 225°C.

### INCOMPATIBILITY (Materials to Avoid)

Strong acids, alkali, oxidizers, combustible materials.

### HAZARDOUS DECOMPOSITION OR BY-PRODUCTS

Toxic metal oxides are emitted when heated above the melting point. The amount of fume evolved increases as the temperature rises.

Thermal decomposition may produce oxides of carbon, boron, hydrogen fluoride and potassium.

Polymerization: Polymerization is not expected to occur.  
Avoid: Not applicable.

## SECTION 11: TOXICOLOGICAL INFORMATION

CHEMICAL NAME	% Wt.	LD50	LC50
COPPER			
CAS NO.: 7440-50-8	20-40	3.5 mg/kg MOUSE, intraperitoneal	Not Available
SILVER			
CAS NO.: 7440-22-4	30-60	Not Available	Not Available
ZINC (AS OXIDE)			
CAS NO.: 7440-66-6	10-30	7,950 mg/kg MOUSE, oral	2,500 mg/kg MOUSE
POTASIAM BIFLOURIDE			
CAS NO.: 7789-29-9	1-5	Not Available	Not Available

POTASSIUM FLUOBORATE CAS NO.: 14075-53-7	1-7	Not Available	Not Available
BORIC ACID CAS NO.: 10043-35-3	1-7	3,450 mg/kg MOUSE, oral	9,600 ug/m3/4 hr RAT
POTASSIUM TETRABORATE CAS NO.: 1332-77-0	1-5	Not Available	Not Available
POTASSIUM CARBONATE CAS NO.: 584-08-7	0-5	Not Available	Not Available
ALIPHATIC POLYCARBONATE CAS NO. -- -- --	1-3	Not Available	Not Available

NOTE: See Sections 3, 8 and 12 for additional information.

#### SECTION 12: ECOLOGICAL INFORMATION

##### ECOTOXICITY

No data available.

##### ENVIRONMENTAL FATE

No data available.

#### SECTION 13: DISPOSAL CONSIDERATIONS

US EPA Waste Number: D011

If disposed of by itself, this product should be considered a hazardous waste on the basis of Toxicity Characteristic Leaching Procedure (TCLP) under EPA hazardous waste regulations. Waste mixtures containing this product should be tested for Toxicity Characteristics (TC) under the current regulations test procedures (40 CFR 261 et seq).

Federal, state and local disposal laws and regulations will determine the proper waste disposal/recycling/reclamation procedure. Disposal requirements are dependent on the hazard classification and will vary by location and the type of disposal selected.

**\*\*NOTE\*\*** Chemical additions, processing or otherwise altering this material may make the waste management information presented above incomplete, inaccurate or otherwise inappropriate.

As local regulations may vary; all waste must be disposed/recycled/reclaimed in accordance with federal, state, and local environmental control regulations.

#### SECTION 14: TRANSPORT INFORMATION

##### INTERNATIONAL

UN Number: Not Regulated

UNITED STATES

EPA Waste Number: D011  
DOT Classification: Not Regulated

CANADA

PIN Number: Not Regulated  
TDG Class: Not Regulated

EC

DGL: Not Regulated

SECTION 15: REGULATORY INFORMATION

US FEDERAL REGULATIONS

TSCA: IN TSCA

SARA 311 AND 312 HAZARD CATEGORIES

IMMEDIATE (Acute) Health Hazard: YES  
DELAYED (Chronic) Health Hazard: YES  
FIRE Hazard: NO  
REACTIVITY Hazard: NO  
Sudden Release of PRESSURE: NO

SARA SECTION 313 NOTIFICATION

This product contains a toxic chemical (or chemicals) subject to the reporting requirements of Section 313 of Title III of the Superfund Amendments and Reauthorization Act of 1986 and 40 CFR Part 372.

CHEMICAL NAME	CAS Number	% Wt.
COPPER	7440-50-8	5-75
SILVER	7440-22-4	15-70
ZINC (AS OXIDE)	7440-66-6	2-35

OZONE DEPLETING SUBSTANCES (ODS)

This product neither contains nor is manufactured with an ozone depleting substance subject to the labeling requirements of the Clean Air Act Amendments 1990 and 40 CFR Part 82.

VOLATILE ORGANIC COMPOUNDS (VOC)

Not Determined

US STATE REGULATIONS

VOLATILE ORGANIC COMPOUND (CARB): Not Determined

CANADIAN REGULATIONS

"This product has been classified in accordance with the hazard criteria of the *Controlled Products Regulations* and the MSDS contains all the information required by the *Controlled Products Regulations*."

DSL/NDSL: DSL

WHMIS Classification: Class D Division 2 Subdivision B

EUROPEAN REGULATIONS

EINECS: Yes

OTHER REGULATIONS

MITI (Japan): Yes

AICS (Australia): Yes

SECTION 16: OTHER INFORMATION

REVISIONS

Revision Number: 3

PREPARATION INFORMATION

Prepared By: Wolverine Joining Technologies, and Wolverine Tube Inc. Corporate Environmental, Health and Safety Group.

Phone Number/Address: See Section 1

---

This Material Data Sheet is offered pursuant to OSHA's Hazard Communication Standard (29 CFR 1910.1200). Other government regulations must be reviewed for applicability to these products. The information in this Material Safety Data Sheet should be provided to all who will use, handle, store, transport, or otherwise be exposed to this product. This information has been prepared for the guidance of plant engineering, operations, and management and for persons working with or handling these products. The information presented in the MSDS is premised upon proper handling and anticipated uses and is for the material without chemical additions/alterations. We believe this information to be reliable and up-to-date as of the date of publication, but make no warranty that it is. Additionally, if this Material Safety Data Sheet is more than three years old, please contact the supplier at the phone number listed in Section 1 to make certain that this sheet is the most current. Copyright Wolverine Joining Technologies, LLC. License granted to make unlimited copies for internal use only.