



## PRODUCT SAFETY DATA SHEET – BRAZING FLUXES

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Product Name	Form	Working Range	Ph	Group
Easyflo Flux Powder	White Powder	550 – 800 °C	8	1
Easyflo – Stainless Steel Grade	White Powder	550 – 775 °C	8	1
Easyflo Flux Paste	White Paste	578 – 825 °C	8	1
Easyflo Dipping Grade	White Paste	550 – 750 °C	9	1
Tenacity No 5A	Brown Powder	600 – 900 °C	8	2
Tenacity 125 Powder	White Powder	750 – 1200 °C	7	3
Tenacity 125 Paste	White Paste	750 – 1200 °C	7	3
Tenacity 12 Powder	White Powder	1000 – 1300 °C	Not known	5
Tenacity 12 Paste	White Paste	1000 – 1300 °C	Not known	5
Tenacity 5 Powder	White Powder	600 – 900 °C	Not known	6
Tenacity 10 Powder	White Powder	1000 – 1300 °C	Not known	7
Flux Coating on Rods	White Compact + colorant	550 – 850 °C	8	9
Tenacity 300 Powder	White Powder	800 – 1300 °C	Not known	8
Tenacity 300 Paste	White Paste	800 – 1300 °C	Not known	8
"S" Powder	White Powder	800 – 1300 °C	Not known	8
"S" Paste	White Paste	800 – 1300 °C	Not known	8
Tenacity 500 Paste	White Paste	800 – 1200 °C	Not known	1
Tenacity 600 Powder	White Powder	800 – 1300 °C	Not known	8
Tenacity 600 Paste	White Paste	800 – 1300 °C	Not known	8

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**1 COMPOSITION**

bifluoride, tetraborate, fluoroborate of potassium, boric acid, boric anhydride fluorosilicate of potassium, elemental boron, potassium tetraborate, borax and boric acid, boric oxide, silicofluoride of potassium, potassium bifluoride, bifluoride and organic polymers.

**2 Hazard Identification**

The main hazard with this product occurs in its use. On heating the flux will fume slightly, and with overheating the fume will increase. The fumes produced include hydrogen fluoride and boron trifluoride which can cause irritation of the nasal passages, eyes and throat. The flux is harmful by ingestion and is irritating to the eyes. Contact with skin may cause moderate irritation.

**3 First Aid Measures .**

Severe long term exposure to fume may result in fluorosis. In acute cases there is a danger of pulmonary oedema although this occurrence could also result from inhalation of brazing metal fume or torch gases. Inhalation of fumes will be irritating to the nose and throat and will cause smarting of the eyes. Tests carried out on fluxes indicate they are moderately irritating to the skin and if the skin is broken immediate irritation will occur on contact.

**4 First Aid Treatment**

- Inhalation:** Remove from exposure and allow to rest in fresh air. In acute cases apply artificial respiration and, if necessary summon medical aid.
- Ingestion:** Rinse mouth with water and give patient water or milk to drink. Do not induce vomiting. Summon medical aid.
- Eyes:** Irrigate with water or isotonic saline for up to 20 minutes. Seek medical attention if there is any hint of eye damage.
- Skin:** Remove any contaminated clothing and wash skin with soap and water. Seek medical attention if sores develop.

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**5 Fire Fighting Measures**

Non flammable. Use full protection with breathing apparatus if involved in a fire as harmful fumes may be evolved. Use any extinguishing medium suitable for surrounding fire.

**6 Accidental Release Measures**

**Powder:** Carefully sweep up and collect in suitable container for re-use or disposal.

**Paste:** Either collect in suitable container for re-use or disposal. For large spills, cover with sand or other inert absorbent and collect in suitable container for disposal. Avoid contact with skin or eyes and do not inhale dust.

**7 Handling and Storage**

**Handling:** Use only under conditions of good local ventilation or efficient extraction systems and do not inhale fumes evolved during use. Avoid contact with skin and eyes. Do not eat, drink, smoke or apply cosmetics whilst using this material. Keep away from food, drink and animal feeding stuffs and out of reach of children. Observe good industrial hygiene practices.

**Storage:** Store in a cool, dry place. Keep container closed when not in use.

**8 Exposure Controls and Personal Protection**  
 UK Occupational Exposure Standards are:-

Fume	Long Term (8 hour) *TWA Value	Short Term (10 minutes) *TWA Value
Hydrogen Fluoride	-	2.5 mg/m <sup>3</sup>
Fluoride (as Fluorine)	2.5 mg/m <sup>3</sup>	-
Boron Trifluoride	-	3 mg/m <sup>3</sup>

\* Time Weighted Average

Avoid exposure to fume with good ventilation or local extraction. If a risk of inhalation exists personal respiratory protection should be worn. The use of barrier creams may present skin irritation. If necessary the use of safety glasses should be considered. Wash hands and clean fingernails before meals.

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**9 Physical and Chemical Properties**

- Appearance:** Odourless powder or paste. See page 1
- pH:** See page 1
- Boiling / Melting point:** Becomes fluid on heating; working range – see page 1
- Flash point:** Not applicable
- Flammability:** Non flammable
- Explosive properties:** Not explosive
- Oxidizing properties:** Not oxidizing
- Vapour pressure:** Not known
- Solubility:** Water-low solubility, no specific data
- Partition Coefficient:** No data

**10 Stability and Reactivity**

Containers of powder left open once the seals are broken may absorb moisture and become lumpy. Pastes are water based; and whilst stable, will lose water by evaporation if left open. Do not freeze. No other adverse reactions are known.

**11 Toxicological Data**

Toxicological data for these preparations: LD50 (oral) > 200mg/kg. Classified as moderately irritating, according to Draize skin test.

**12 Ecological Information**

As far as known no threat is posed to the environment by this material.

**13 Disposal Considerations**

Disposal according to local and national regulations.

**14 Transport Information**

None

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**15 Regulatory Information**

**EC Supply:**

Harmful

**Risk Phrases:** 20/22  
36/38

Harmful by inhalation and if swallowed

Irritating to eyes and skin

**Safety Phrases:** 2

Keep out of reach of children

13

Keep away from food, drink and animal feed stuffs

21

When using do not smoke

22

Do not breathe dust

26

In case of eye contact, rinse immediately with water and seek medical advice

28

After contact with skin wash immediately with plenty of water