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Material Safety Data Sheet

Chromium-Nickel-Copper Alloyed Stainless Steel grades

1. Product And Company Identification

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Outokumpu Stainless Bar, Inc.
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Tel. 1-888 458 4600, 1-803 789 5383

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Outokumpu Stainless Coil, Inc.
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Products: Solid stainless steel products, various forms and uses.

Grades and Outokumpu Stainless Trademarks:

303Cu, 304Cu, 904L, 385, 630, 17-4, 631, 17-7, Alloy 20.
This includes all listed grades with letter prefixes and suffixes as well as PRODEC® suffix.

2. Hazards Identification

Caution! Dust and fumes from welding and other processing are eye, skin and respiratory irritants and sensitizers. May cause metal fume fever.

Attention! Cancer hazard. Dust and fumes can cause cancer.

OSHA Regulatory status

Solid stainless steel products covered by this MSDS are shipped as non-flammable, non-explosive, non-reactive articles and do not constitute a hazardous material in solid form under the terms of OSHA Hazard Communications Act. However, some metallic elements from which this product is manufactured are listed in OSHA Hazard Standard (29 CFR 1910.1000).

Solid stainless steel does not contain hexavalent chromium. Chromium as Cr(VI) compound can be found in fumes and dust formed by grinding, polishing, abrasive blasting, hot rolling, hot forging, thermal cutting or welding of stainless steel. Cr(VI)

compounds can also be formed by cleaning stainless steel with strong oxide formers at high pH. Cr(VI) is classified by NTP as "Known to be a human carcinogen" and by ACGIH as A1 "Confirmed Human carcinogen."

Manganese as metal and inorganic compounds in fumes and dust may cause CNS (manganism).

Nickel in alloys is not listed by NTP and classified by ACGIH as A5 "Not suspected as a Human carcinogen."

Potential health effects

No carcinogenic effects resulting from exposure to stainless steel have been reported, either in epidemiological studies or in tests with animals.

Skin contact: If an individual is already sensitized to nickel, prolonged skin contact may result in an allergic reaction.

Inhalation: Dust and fumes which may be produced as a by-product during grinding, polishing, abrasive blasting, hot rolling, hot forging, welding, brazing, thermal cutting, pickling and post-fabrication cleaning or similar processes may contain fumes of chromium (VI) oxides and other welding rod components.

Section 11 discusses health effects in more detail.

3. Components/ Information On Ingredients

Table 1

Component	CAS No.	% by Weight
Iron	7439-89-6	Balance
Silicon	7440-21-3	0 - 1.0
Manganese	7439-96-5	0 - 2.0
Chromium	7440-47-3	15 - 23
Nickel	7440-02-0	3 - 38
Molybdenum	7439-98-7	0 - 5.0
Titanium	7440-32-6	0 - 0.7
Copper	7440-50-8	1.0 - 5.0
Cobalt	7440-48-4	0 - 0.6

Trace elements: All trace elements as cadmium, lead, mercury, hexavalent chromium, antimony, beryllium, and bismuth are below the levels specified in the European ELV and RoHS Directives, the Japanese Green Procurement Standardization Initiative, and the US EIA Joint Industry Guide JIG.

Other elements may be present such as Carbon, Nitrogen, Sulfur, Phosphorous, Boron, Aluminum, Calcium, Columbium, Tantalum and Tungsten. These are either not hazardous or below 0.1% concentration.

4. First Aid Measures

Employ first aid techniques recommended by the American Red Cross.

Eye Contact: In case of irritation from particulate, immediately flush with plenty of water for 15 minutes and call for medical assistance. Austenitic stainless steel particles are not magnetic and will not respond to a magnet over the eye.

Skin contact: In case of skin irritation or laceration, wash thoroughly with plenty of soap and water.

Inhalation: Not applicable to stainless steel in massive form. Inhalation of dust and/or fumes from grinding, cutting and welding operations – If breathing is difficult remove person from exposed area to fresh air.

Ingestion: Accidental ingestion is unlikely. If ingested, call for medical assistance

5. Fire Fighting Measures

Stainless steels are not combustible. There are no special hazards or precautions associated with stainless steels if in vicinity of a fire.

6. Accidental Release Measures

Not applicable.

7. Handling And Storage

There are no special technical measures involved for handling stainless steels. Normal precautions should be taken to avoid physical injury from coiled or bundled products, possibly with sharp edges.

- Do not use straps or bands, used to secure some products, for lifting. Coil and bundled products (e.g. sections, rods, bars) may spring apart when the banding is removed and the banding itself could cause eye or other injury when tension is released.
- Certain products may, as a result of processing, be brittle or have residual stresses that might cause fracture or significant deformation.
- All products are likely to have sharp edges that could cause lacerations and flying particles may be produced when shearing.
- Adopt suitable work procedures to take account of hazards arising from the risk of fracturing or the release of tension when breaking open banding.
- Use suitable racks to ensure stability when stacking narrow coils or bundled material.

Occupational exposure limits 8-hour TWA mg/m³

Table 2

Component	OSHA PEL	ACGIH TLV	Carcinogenetic listing		
			ACGIH	NTP	IARC
Iron oxide, dust & fume as Fe	10	5	A4	No	NE
Silicon dust	15 5 (R)	10	NE	No	NE
Manganese, inorganic compounds as Mn	5	0.2	No	No	NE
Manganese, fume as Mn	5	NE	No	No	NE
Chromium metal as Cr	1	0.5	A4	No	3
Chromium Cr(II) and Cr(III) compounds as Cr	0.5	0.5	A4	No	3
Cr(VI) compounds, water soluble as Cr	5* µg/m ³	0.05	A1, BEI	A	1
Cr(VI) compounds, insoluble as Cr	5* µg/m ³	0.01	A1	A	1
Nickel, in alloys as Ni	1	1.5 (I)	A5	No	2B
Nickel, elemental metallic as Ni	1	1.5 (I)	A5	B	2B
Nickel, soluble inorganic compounds as Ni	1	0.1 (I)	A4	A	1
Nickel, insoluble inorganic compounds as Ni	1	0.2 (I)	A1	A	1
Nickel, subsulfide as Ni	NA	0.1 (I)	A1	A	1
Nickel, carbonyl as Ni	0.007	NE	No	A	1
Molybdenum, soluble compounds as Mo	5	0.5(R)	A3	No	NE
Molybdenum, metal and insoluble compounds as Mo	15	10(I) 3 (R)	No	No	NE
Titanium in titanium dioxide form	15	10	A4	No	3
Copper, fume, current as Cu	0.1	0.2	No	No	NE
Copper, dusts and mists, current as Cu	1	1	No	No	NE
Copper, elemental/metal and oxides, proposed as Cu	NE	0.1	A4	No	NE
Copper, soluble compounds, proposed as Cu	NE	0.05	A4	No	NE
Cobalt and inorganic compounds as Co	0.1	0.02	A3, BEI	B Cobalt sulfate	2B

TWA=Time Weighted Average, STEL= Short Term Exposure Limit NE=Not Established, R=Respirable fraction I=Inhalable fraction, BEI=Biological Exposure Index ACGIH Ratings: A1=Confirmed Human Carcinogen, A2=Suspected Human Carcinogen, A3=Confirmed Animal Carcinogen with Unknown Relevance to Humans, A4=Not classifiable as a Human Carcinogen, A5=Not suspected a Human Carcinogen. NTP Ratings: A=Known to be a human carcinogen, B=Reasonably anticipated to be a human carcinogen, IARC Groups: 1=Carcinogenic to humans, 2A=Probably carcinogenic to humans, 2B=Possibly carcinogenic to humans, 3=Not classifiable as to carcinogenicity to humans.
 *In effect from May 30, 2006.

8. Exposure Controls/ Personal Protection

Exposure guidelines

There are no occupational exposure limits for stainless steels. Occupational exposure limits apply to some components and certain of their compounds. Table 2 shows limits according to current US legislation.

Engineering controls

Employ appropriate control measures when welding, brazing, thermal cutting, burning, sawing, grinding, or post fabrication cleaning of stainless steel. Use local exhaust and dilution ventilation to control dust and/or fumes.

Welding and related processes: Read and understand the MSDS, manufacturers instruction, and precautionary labels for welding consumables. See American National Standard Z49.1, Safety in Welding and Cutting, published by the American Welding Society, 550 N.W. LeJeune Road, Miami, Florida 33126, and OSHA Publication 2206 (29 CFR 1910), U.S. Government Printing Office, Washington, D.C. 20402, for more details on exposure controls.

Pickling, acid cleaning and neutralization of cleaning wastes:

Read and understand the cleaning product MSDS, manufacturers instruction and precautionary labels for cleaning agents. Unintended use of strong oxidizers (high pH) on stainless steel may cause CrVI compounds to form at ambient temperatures.

Eye/face protection: Wear ANSI Z87.1 approved safety glasses with side shields or goggles where metal dust or fume is present. Use appropriate eye protection, including welding helmets and/or face shields with protective filter lenses when welding, brazing or thermal cutting. Select welding lens shades from the American Welding Society (AWS) publication F2.2. Use appropriate eye/face protection when cleaning and pickling stainless steel.

Skin protection: Wear protective gloves while handling stainless steel to prevent cuts and skin abrasions, and to reduce the risk of sensitization from skin contact. Wear appropriate hand protection when welding, brazing and thermal cutting. Wear acid proof gloves when cleaning and pickling stainless steels.

Respiratory protection: Use a NIOSH-approved respirator for dust and fumes or an air supplied respirator where local exhaust or general dilution ventilation does not keep exposures below the PEL or TLV for air contaminants.

Protective clothing: Wear suitable protective clothing and equipment, such as hand and eye protection to take account of hazards arising from the risk of fracturing or the release of tension when breaking open banding. Safety shoes are recommended. Wear appropriate hand and body protection during welding, brazing, and thermal cutting on stainless steel. Refer to ANSI Z49.1 for more information. Wear appropriate hand and body protection when cleaning and pickling stainless steel.

General Hygiene Considerations: Do not eat, smoke, or drink in

areas where metal dust or fume is present. Utilize good personal hygiene including washing hands and face prior to eating or drinking.

9. Physical And Chemical Properties

Color: Varying from dull very light grey, to shiny metallic light grey to bright mirror-finish

Odor:	Odorless
Odor threshold:	Not applicable
Physical state:	Solid
pH:	Not applicable
Melting point:	2500 – 2760 °F (1370 – 1520°C)
Boiling point:	Not applicable
Flash point:	Not applicable
Evaporation rate:	Not applicable
Flammability:	Not applicable
Explosive limits:	Not applicable
Vapor pressure:	Not applicable
Vapor density:	Not applicable
Specific gravity:	0.27 - 0.30 lbs./in ³ (7.7 – 8.1 kg/dm ³)
Solubility (water):	Insoluble
Partition coefficient:	Not applicable
Auto-ignition temperature:	Not applicable
Decomposition temperature:	Not applicable
Thermal expansion (ambient to 100°C):	10 – 16 x10 ⁶ m/m°C
Thermal conductivity (ambient temperature):	12 – 30 W/ m°C
Magnetic:	Austenitic stainless steels are non-magnetic in most supply conditions, but may be para-magnetic in some supply conditions. Duplex, ferritic and martensitic stainless steels are magnetic.

10. Stability And Reactivity

Chemical stability: Stable and non-reactive under normal ambient atmospheric conditions.

Conditions to avoid: None known

Incompatible materials: May react in contact with strong acids to release gaseous acid decomposition products, e.g. hydrogen, oxides of nitrogen. Use of strong oxidizers (high pH) on stainless steel may cause Cr(VI) compounds to form at ambient temperatures.

Possibility of hazardous by-products – Welding fumes:

Various fumes and gases may be produced when stainless steel is subjected to welding, brazing, thermal cutting, and similar processes at high temperature. Such fumes and gases cannot be simply classified. The composition and quantity of both are dependent upon the composition of the base metal and the process, procedures, and consumables being used. Other conditions which also influence the composition and quantity of the fumes and gases to which workers may be exposed include; coatings on the base metal (such as paint, plating, galvanizing, and phosphate coatings), the number of workers performing welding, brazing, thermal cutting, or other related operations, the volume of the work area, the quantity of consumables used, the design

and amount of ventilation delivered, the position of the worker's head with respect to the fume plume, and the presence of contaminants in the atmosphere (such as chlorinated hydrocarbon vapors from solvent, cleaning, or painting activities) which may decompose by the arc into toxic gases such as phosgene.

Decomposition products from welding, brazing, thermal cutting operations will include those originating from the volatilization, reaction, or oxidation of ingredients in welding rods, fluxes, and fillers, plus those from the base metal and coatings, etc. Possible decomposition products that may be generated during welding, brazing or thermal cutting include complex oxides of the ingredients listed in Section 3. Fumes generated during welding, brazing, or thermal cutting may contain: chromium compounds, including hexavalent chromium (Cr VI); nickel; manganese; iron; molybdenum; and silicon compounds.

The employer is required by OSHA to limit the worker's level of exposure to chemicals for which OSHA has established a PEL in 29 CFR 1910 Subpart Z. The only way to determine a worker's exposure to welding, brazing or thermal cutting decomposition products is by sampling and analyses using accepted industrial hygiene techniques. The composition and quantity of the fumes and gases to which a worker is exposed can be established from an air sample(s) obtained from inside the welder's helmet, if worn, or in the worker's breathing zone. Review ANSI/AWS F1.1 and F1.3 standards for further information on air sampling for welding decomposition products.

11. Toxicology Information

Acute effects

In its solid form stainless steel does not present an inhalation, absorption, or ingestion hazard.

Short-term over-exposure to the fumes generated by hot rolling, hot forging, welding, brazing, or thermal cutting on stainless steel may result in dizziness; nausea; and irritation of the eyes, skin, lungs, nose and throat. Metal fume fever, a flu-like illness lasting about 24 hours with chills, ache, cough, and fever can be caused by overexposure to metal fumes, including iron, chromium, manganese and copper.

Metal dust particles may cause eye, skin and/or respiratory system irritation. Acute asthma attacks may be experienced by asthmatics when metal dust or fume is inhaled.

Chronic effects, inhalation or ingestion

Dust and fumes

Grinding, polishing, abrasive blasting, hot rolling, hot forging, thermal cutting or welding may produce stainless steel dust or fumes containing complex or mixed oxides (spinels) of its components. Over long periods, inhalation of excessive airborne levels may have long term health effects, primarily affecting the lungs, e.g. lung fibrosis, or pneumoconiosis. Overexposure to iron oxide can cause siderosis (deposits of iron in the lungs) which may affect pulmonary function. However, studies of workers

exposed to nickel powder and dust and fumes generated in the production of nickel alloys and stainless steels have not indicated a respiratory cancer hazard.

Nickel

For stainless steels there is no direct evidence of carcinogenic effects in man, nor indirect evidence from animals tested by relevant routes, i.e. inhalation or ingestion. In other studies, using non-relevant routes in animals, alloys with up to 40% nickel caused no significant increase in cancer.

The National Toxicology Program modified its classification of nickel in the 10th Report on Carcinogens, 2002. Nickel alloys, e.g. stainless steels were reviewed but were excluded due to inadequate human data and insufficient rodent cancer data to list. NTP regards metallic nickel as "Reasonably anticipated to be a carcinogen" and nickel compounds are "Known human carcinogens."

California Proposition 65 has adopted the same distinctions as NTP.

ACGIH is now classifying elemental nickel as A5 "Not suspected as a Human carcinogen."

OSHA has not made a distinction and lists "nickel metal and insoluble compounds" in 29 CFR 1910.1000.

Chromium

Grinding, polishing, abrasive blasting, hot rolling and hot forging dust, welding fumes and thermal cutting fumes may contain Cr(VI) hexavalent chromium compounds. Studies have shown that some hexavalent chromium compounds can cause cancer.

Chromium as Cr(VI) hexavalent compound in fumes and dust is classified by NTP as "Known to be a human carcinogen" and by ACGIH as A1 "Confirmed Human carcinogen."

Chromium as metal or Cr(II) and Cr(III) oxides is not listed by NTP and is classified by ACGIH as A4 "Not classifiable as a human carcinogen." However, epidemiological studies amongst welders indicate no extra risk of cancer when welding stainless steels, compared to the slightly increased risk when welding steels that do not contain chromium.

Manganese

Overexposure to manganese can result in central nervous system effects referred to as manganism, including symptoms of muscular weakness, impaired speech and tremors similar to Parkinson's disease. However, a new study of 49,488 male welders compared to 489,572 men from the general Swedish population did not reveal any statistically significantly increased risks for Parkinson's disease or other basal ganglia and movement disorders for welders compared with an age and geographically matched general population comparison cohort.

Molybdenum and Copper

Both molybdenum and copper are necessary nutritional elements. High doses of molybdenum may antagonize absorption of copper. Likewise, high doses of copper may antagonize absorption of molybdenum.

Overexposure to molybdenum causes anemia, gout-like syndrome and increases uric acid levels. In experimental animals molybdenum toxicity causes weight loss, harmful changes of the liver, kidneys, and bones and impaired reflexes.

Cobalt

Cobalt in stainless steel is an alloy. None of the classifications of cobalt is valid for alloys. Cobalt dust may cause an asthma-like disease. Based on hard-metal workers, IARC has made a difference between cobalt metal with (2A) and without (2B) tungsten. NTP's 11th report on Carcinogens classifies cobalt sulfate as "Reasonably anticipated to be carcinogen." ACGIH classifies cobalt as A3 Confirmed Animal Carcinogen with Unknown Relevance to Humans.

Dermatological effects

Stainless steels do not cause nickel sensitization by prolonged skin contact in human. However, nickel is classified as a skin sensitizer. It causes skin sensitization in susceptible individuals through prolonged intimate contact with the skin (e.g. wearing jewelry).

Numerous patch tests have established that most stainless steels do not cause sensitization. However, studies have shown that, in some individuals already sensitized to nickel, close and prolonged skin contact with the re-sulfurized free-machining types of stainless steels with 0.15 – 0.35% S (416, 430F, 303, 303Cu) may cause an allergic reaction.

Other observations

Long-term experience of stainless steels in the most varied

applications has demonstrated that these very resistant materials are eminently suitable where hygiene is of paramount importance (e.g. food processing and food preparation). NIOSH lists Welding exposure as the 10th largest cause of work-related asthma, but makes no distinction between stainless and carbon steel welding. There are some reports indicating that there is a risk of developing asthma from chromium (VI) compounds and nickel in welding fumes. In the European Union, stainless steel welding fume did not meet the classification criteria required to be listed as a "substance causing asthma."

12. Ecological Information

No known harmful effects. No special precautions are required.

13. Disposal Considerations

If discarded, the material is classified as RCRA hazardous waste due to the chromium, manganese, nickel, and copper contents.

Recycle if possible. Surplus and scrap (waste) stainless steel is valuable and in demand for the production of prime stainless steel. Recycling routes are well established, and recycling is therefore the preferred disposal route.

14. Transport Information

Stainless steel products in the solid form are not classified as HAZMAT. No Label is required during transport.

15. Regulatory Information

See Table 3 for EPCRA/SARA information. For solid stainless steel products the required Label may be transmitted to the customer at the time of the initial shipment, see 29 CFR 1910.1200 (f)(2)(i).

Inventories

OSHA	United States	Included
TSCA	United States	Included

EPCRA / SARA Section 302, 304, 311/312 and 313

Table 3

Component	CAS #	Section 302 EHS	Section 304 Spill	Section 311/312 Hazard classes	Section 312 SARA Tier II	Section 313 Form R
			Reporting Quantity, lbs.		Threshold Planning Quantity, lbs.	By weight %
Chromium	7440-47-3	Not applicable	5,000	Chronic health hazard	10,000	15 - 23
Nickel	7440-02-0	Not applicable	100	Chronic health hazard	10,000	3 - 38
Manganese compounds	N450	Not applicable	No RQ established	Chronic health hazard	10,000	0 – 2.0
Copper	7440-50-8	Not applicable	5,000	Chronic health hazard	10,000	1.0 – 5.0

California Safe Drinking Water and Toxic Enforcement Act (Proposition 65)

WARNING: This product contains or produces chemicals known to the State of California to cause cancer. (California Health and Safety Code §25249.5 et seq.)

16. Other Information

Basic information used to draw up this information:

References to key data:

OSHA, Standards 29 CFR.1910.1000 –1200

ANSI Z49.1:2005, Safety in Welding and Cutting

EPA Consolidated List of Chemicals Subject to the Emergency Planning and Community-Right-to-Know Act (EPCRA) and section 112(r) of the Clean Air Act.

DOT, Standards 49 CFR.172.101-102

National Toxicology Program, 11th Report on Carcinogens, 2005
ACGIH, TLVs and BEIs, 2006 edition

International Agency for Research on Cancer. 'IARC
Monographs on the Evaluation of Carcinogenic Risks to
Humans', vol. 1- 88

N. Becker: Cancer mortality among arc welders exposed to fumes
containing chromium and nickel. Results of a third follow-up:
1989-1995

IMOA, International Molybdenum Institute
Outokumpu Stainless MSDS, European version, 1005EN:2,
March 2004.

C.M. Fored: Parkinson's Disease and other Basal Ganglia or
Movement disorders in a large nationwide cohort of Swedish
welders. Occupational and Environmental Medicine, February
2006.

This MSDS replaces:

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Availability

All Outokumpu Stainless US MSDS are available at the Outokumpu website. To find them go to <http://www.outokumpu.com/stainless/na> and click on the MSDS sidebar.