



This safety data sheet represents a family grouping of all metal mixes that are blended with the same flux. A table is provided that lists all metal groupings. To better serve all of our customers Indium Corporation has generated one SDS, for this product, to be used within the United States as well as internationally. Some of the regulatory information contained within may not be applicable to the customer's individual state or country. Unless otherwise stated the health and safety information provided within is applicable to all products.

SAFETY DATA SHEET

1. PRODUCT AND COMPANY IDENTIFICATION

Product Identifier: INDALLOY WITH INDIUM5.81 FLUX VEHICLE

SDS Number: SDS-4719

Revised Date: 23 AUGUST 2018

Product Use: Industrial Use - No-clean solder paste consisting of a flux vehicle blended with an 83-92 % pre-alloyed metal powder.

MANUFACTURER:

In America:

The Indium Corporation of America®.

34 Robinson Rd., Clinton, NY 13323

Information: (315) 853-4900

nswarts@indium.com

In Europe:

The Indium Corporation of America® (European Operations)

7 Newmarket Ct

Kingston, Milton Keynes, UK, MK 10 OAG

Information: +44 [0] 1908 580400

In Asia:

Indium Corporation of America

Asia-Pacific Operations-Singapore

29 Kian Teck Avenue

Singapore 628908

Information: +65 6268-8678

EMERGENCY PHONE:

CHEMTREC 24 hrs.

USA: 1 (800) 424-9300

Outside USA: +1 (703) 527-3887

In China:

Indium Corporation (Suzhou), Co., Ltd.

No. 428 Xinglong Street

Suzhou Industrial Park

Suchun Industrial Square

Unit No. 14-C

Jiangsu Province, China 215126

Information: (86) 512-6283-4900

<http://www.indium.com>

2. HAZARDS IDENTIFICATION

PRIMARY ROUTES OF ENTRY:

⊕Eye ⊕Inhalation ⊕Skin ⊕Ingestion

CARCINOGEN LISTED IN:

NTP IARC OSHA ⊕Not Listed

GHS:

Lead free products



Signal Word: Warning

Hazard statement(s)

H317 May cause an allergic skin reaction
 H334 May cause allergy or asthma symptoms or breathing difficulties if inhaled
 H335 May cause respiratory irritation
 EUH208 Contains rosin. May produce an allergic reaction

Precautionary statement(s)

P233 Keep container tightly closed
 P261 Avoid breathing dust/fume/gas/mist/vapors/spray
 P270 Do not eat, drink or smoke when using this product
 P273 Avoid release to the environment
 P280 Wear protective gloves/protective clothing/eye protection/face protection
 P362 +P364 Take off contaminated clothing and wash before reuse
 P301 + P314 IF SWALLOWED: Get medical advice/attention if you feel unwell
 P302 +P352 IF ON SKIN: Wash with plenty of soap and water
 P304 + 341 IF INHALED: If breathing is difficult, remove victim to fresh air and keep at rest in a position comfortable for breathing
 P305 + 351 IF IN EYES: Rinse continuously with water for several minutes (15 mins)

Lead containing products



Signal Word: Warning

Hazard statement(s)

H303 May be harmful if swallowed
 H317 May cause an allergic skin reaction
 H334 May cause allergy or asthma symptoms or breathing difficulties if inhaled
 H335 May cause respiratory irritation
 H332 Harmful if inhaled
 H351 Suspected of causing cancer
 H361 Suspected of damaging fertility or the unborn child
 H373 May cause damage to organs through prolonged or repeated exposure
 H410 Very toxic to aquatic life with long lasting effects
 EUH201A Warning! Contains lead. Review listing.
 EUH208 Contains rosin. May produce an allergic reaction

Precautionary statement(s)

P233	Keep container tightly closed
P261	Avoid breathing dust/fume/gas/mist/vapors/spray
P270	Do not eat, drink or smoke when using this product
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Classification:

Carcinogenicity (Category 2) (lead)

Reproductive toxicity (Category 2) (lead)

Skin sensitizer-Category 1B

Respiratory sensitizer-Category 1B

Acute toxicity, oral-Category 5 (lead)

Acute toxicity, inhalation 4 (lead)

Specific target organ toxicity single exposure, respiratory tract- Category 3

Acute aquatic toxicity – Category 1 for lead containing products (H400)

Chronic aquatic toxicity – Category 1 for lead containing products (H410)

POTENTIAL HEALTH EFFECTS:

Eye Contact: Contact with material at room temperature or fume from material at typical re-flow temperatures over 100°C may cause eye irritation.

Ingestion: This product contains metal alloy powder and organic chemicals. May be harmful if swallowed.

Inhalation: Vapors or fumes from this material at typical re-flow temperatures over 100°C may cause local irritation to the respiratory system. Rosin may cause occupational asthma.

Skin Contact: May cause skin irritation. Antimony may cause skin irritation. Rosin may cause dermatitis.

Chronic: **LEAD:** Prolonged exposure to vapors or fumes at higher temperatures may cause respiratory irritation and systematic lead poisoning. Symptoms of lead poisoning include headache, nausea, abdominal pain, muscle and joint pain and damage to the nervous system, blood system and kidneys.

SILVER: Chronic skin contact or ingestion of silver dust, salts, or fume can result in a condition known as Argyria, a condition with bluish pigmentation of the skin and eyes.

TIN: Has been shown to increase incidence of sarcoma in animal tests.

COPPER: Overexposure to fumes may cause metal fume fever (chills, muscle aches, nausea, fever; dry throat, cough, weakness, lassitude); metallic or sweet taste; discoloration of skin and hair.

BISMUTH: May cause kidney damage.



WARNING: This product can expose you to chemicals including [lead] which is known to the State of California to cause cancer, and can cause birth defects or other reproductive harm. For more information go to www.P65Warnings.ca.gov

NOTE: The Indium Corporation does not recommend, manufacture, market or endorse any of its products for human consumption.

WARNING: This product may contain lead. Lead may be harmful to your health. US Federal law prohibits the use of leaded solders in making joints and fittings in any private or public water supply system. Keep out of the reach of children.

3. COMPOSITION / INFORMATION ON INGREDIENTS

Components	% wt	CAS Registry #/EINECS#	PEL mg/m ³	TLV-TWA mg/m ³	TLV-STEL mg/m ³	
TIN	*	7440-31-5/231-141-8	(US)	2	2	-
			(EU)	-	2	4
			(Canada)	-	2	4
			(Singapore)	2	-	-
COPPER	*	7440-50-8/231-159-6	(US)	0.1 1(dust)	0.2	-
			(EU)	-	0.2 (fume)	2(dust)
			(Canada)	-	0.2	0.6
			(Singapore)	0.2(fume)	1(dust)	-
			(Mexico)	0.2	-	2
			(China)	-	0.2(fume) 1(dust)	0.6(fume) 2.5(dust)
ANTIMONY	*	7440-36-0/231-146-5	(US)	0.5	0.5	-
			(EU)	0.5	-	-
			(Canada)	-	0.5	1.5
			(Mexico)	N.E.	0.5	-
			(Singapore)	0.5	-	-
			(China)	-	0.5	-
LEAD	*	7439-92-1/231-100-4	(US)	0.05	0.05	-
			(EU)	-	0.15	-

		(Canada)	0.05	0.05	-
		(Singapore)	0.15	-	-
		(Mexico)	0.15	-	-
		(China)	-	0.05(dust)	-
				0.03(fume)	-
SILVER	*	7440-22-4/231-131-3			
		(US)	0.01	0.1	-
		(EU)	-	0.1	-
		(Canada)	-	0.1	0.3
		(Singapore)	0.1	-	-
		(Mexico)	0.1	-	-
BISMUTH	*	7440-69-9/231-177-4	N.E.	N.E.	N.E.
GERMANIUM	*	7440-56-4/231-164-3	N.E.	N.E.	N.E.
ROSIN	3.0-4.0	65997-05-9	N.E.	N.E.	N.E.
		(EU)	0.05	N.E.	0.15 (sensitiser)
PROPRIETARY	4.0-14.0	-	N.E.	N.E.	N.E.

N.E. = Not established * See alloy table

ALLOY TABLE

% Metal in flux (83-92%)

Indalloy (Metal)	%TIN Sn	%SILVER Ag	%COPPER Cu	%ANTIMONY Sb	%BISMUTH Bi	%LEAD Pb	RoHS 2*3* Compliance
100 (Sn62.6/Pb37/Ag 0.4)	52.0-57.6	0.33-0.37	-	-	-	30.7-34.0	No
104 (Sn62)	51.9-57.5	1.2-1.8	-	-	-	29.9-33.2	No
106 (Sn63)	52.3-58	-	-	-	-	30.7-34	No
121 (Sn96.5/Ag3.5)	80.1-88.8	2.9-3.2	-	-	-	-	Yes

Indalloy (Metal)	%TIN Sn	%SILVER Ag	%COPPER Cu	%ANTIMONY Sb	%BISMUTH Bi	%LEAD Pb	RoHS 2*3* Compliance
241 (SAC387) (Sn95.5/Ag3.8/ Cu0.7)	79.3-87.9	3.2-3.5	0.58-0.64	-	-	-	Yes
252 (Sn95.5/Ag3.9/ Cu0.6)	79.3-87.9	3.2-3.6	0.50-0.55	-	-	-	Yes
256 (SAC305) (Sn96.5/Ag3/Cu 0.5)	80.1-88.8	2.5-2.8	0.42-0.46	-	-	-	Yes
NS (90Sn/10Sb)	74.7-82.8	-	-	8.3-9.2	-	-	Yes
NS (89Bi/11Ag/ Doped 0.05 Ge)	-	9.13-10	-	-	73.9-81.9	-	Yes

*RoHS2 = Restriction on Hazardous Substances (review for any applicable exemptions) (2011/65/EU)

*RoHS 3 = products do not contain any listed phthalates

NS = Non Standard Alloy Mix

4. FIRST AID MEASURES

- Eye Contact:** Hold eyelids apart and flush eyes with plenty of tepid water for at least 15 minutes. Seek medical attention if irritation persists.
- Ingestion:** If patient is conscious, ONLY induce vomiting as directed by trained personnel. NEVER give anything by mouth to an unconscious person. Seek medical attention immediately.
- Inhalation:** Remove to fresh air. If not breathing, give artificial respiration or oxygen by trained personnel. Seek immediate medical attention.
- Skin Contact:** Remove contaminated clothing. Wash affected area with soap and water. Wash clothing before reuse. If irritation persists, obtain medical attention.

5. FIRE FIGHTING MEASURES

- Flash Point:** Not established. **Method:** Not established.
- Auto-ignition Temperature:** Not established.
- Flammable Limits:** Limits not established.
- Extinguishing Media:** Use extinguishers appropriate for the surrounding fire conditions.
- Special Fire Fighting Procedures:** Firefighters must wear NIOSH approved self-contained breathing apparatus and full protective clothing.

6. ACCIDENTAL RELEASE MEASURES

- Spill or Leak Procedures:** Using a spatula, scoop up paste and place in a plastic or glass jar and tightly cap. Remove traces of paste residue using cloth rags or paper towels moistened

with ethyl or isopropyl alcohol. Dispose contaminated cloth rags or paper towels following all Federal, State and Local regulations. In the EU refer to the Special Waste Regulations.

7. HANDLING AND STORAGE

Handling Precautions: Keep containers tightly closed when not in use. Use care to avoid spills. Use only with production equipment specifically designed for use with solder paste. Wear appropriate personal protective equipment when working or handling solder paste. Always thoroughly wash your hands after handling this product. DO NOT touch or rub eyes until hands are washed.

Storage Precautions: Store product in tightly capped original containers in a cool, dry area. Refer to product label for specific storage temperature requirements. Rotate stock to ensure use before expiration date on the label.

8. EXPOSURE CONTROLS / PERSONAL PROTECTION

Engineering Controls: Use with adequate exhaust ventilation and other safety features specifically designed for use with solder paste. Control concentration of all components so that the permissible exposure levels are not exceeded.

Personal protection:

Eyes: Chemical safety glasses/goggles. Face shield for splash hazards.

Respirator: A NIOSH approved or EU compliant CE marked air-purifying respirator with a fume/organic chemical cartridge is recommended under certain circumstances (i.e. when re-flowing manually on a plate instead of a ventilated re-flow furnace) where airborne concentrations are expected to be elevated or exceed exposure limits.

Skin: Compatible chemical resistant gloves.

Other: Lab coat, eyewash fountain in work area. Avoid the use of contact lenses in high fume areas.

Work/Hygienic Practices: Maintain good housekeeping. Clean up spills immediately. DO NOT allow rags or paper towels contaminated with solder paste to accumulate in the work area. Good personal hygiene is essential. Avoid eating, smoking or drinking in the work area. Wash hands thoroughly with soap and water immediately upon leaving the work area. When working with lead containing products follow standard lead work practices.

9. PHYSICAL AND CHEMICAL PROPERTIES

Appearance:	Grey colored paste.	Boiling Point:	Not applicable.
Odor:	Mild characteristic odor.	Melting Point:	Not applicable
Specific Gravity:	Not applicable.	pH:	Not applicable
Vapor Pressure:	Not applicable.	Solubility in Water:	Insoluble (paste)
Vapor Density:	(air=1) Not applicable.		

Review product data sheet for use and storage information.

10. STABILITY AND REACTIVITY

General:	Stable.
Conditions to Avoid:	Not established.
Incompatible Materials:	Avoid contact with acids, bases or oxidizing agents.
Hazardous Decomposition / Combustion:	Harmful organic fumes and toxic oxide fumes may form at elevated temperatures.
Hazardous Polymerization:	Will not occur.

11. TOXICOLOGICAL INFORMATION

Carcinogenicity:	NTP: No		
	OSHA: No		
	IARC: Yes	Lead and lead compounds are listed as possible carcinogens.	
LD50:	Not established.	LC50:	Not established.

Other: Chronic Toxicity: Prolonged or repeated exposure to rosin flux fume may cause workers to develop occupational asthma. Lead can cause potential harm to the developing fetus.

Product mixture not tested.

RTECS: OF7525000 (lead)

Lead

reproductive toxicity – rat –inhalation

reproductive toxicity – rat – oral

reproductive toxicity – mouse-oral

Teratogenicity

Developmental toxicity – rat- inhalation

Developmental toxicity- rat- oral

Suspected human reproductive toxicant

GHS- Specific target organ toxicity- repeated exposure

May cause damage to organs through prolonged or repeated exposure

Lead- OSHA Hazards- carcinogen/target organ effect/harmful by ingestion/teratogen.

12. ECOLOGICAL INFORMATION

Product not tested.

Lead:

Toxicity to fish:

Rainbow trout- 1.19mg/l-96h

LC50 micropterus dolomieu- 2.2 mg/l-96h

Mortality NOEC-salvelinus fontinalis-1.7 mg/l-10d

Toxicity to algae

Mortality EC50-skeletonema costatum-7.94mg/l-10d

An environmental hazard cannot be excluded in the event of unprofessional handling, use and or disposal of this product.
Contains a substance (lead) that is very toxic to aquatic life with long lasting effects.

13. DISPOSAL CONSIDERATION

Waste Disposal Method: Scrap metal alloy usually has value. Contact a commercial reclaimer for recycling. Otherwise, dispose of in accordance with all Federal, State and Local environmental regulations. In Europe follow the Special Waste Regulations.

14. TRANSPORT INFORMATION

Transport in accordance with applicable international regulations and requirements. Not regulated (US Department of Transportation).

Non hazardous under shipping regulations.

UN - none

North American Emergency Guide Book – Not applicable

15. REGULATORY INFORMATION

The information in this Safety Data Sheet meets the requirements of the United States Occupational Safety and Health Act and regulations promulgated hereunder (29 CFR 1910.1200 ET. SEQ.).

This product has been classified in accordance with the hazard criteria of the Canadian Controlled Products Regulation (CPR).

This product has been classified in accordance with Mexican regulations NOM-018-STPS-2015 and NOM-010-STPS-2014.



WHMIS: D2A-Materials Causing Other Toxic Effects-Very Toxic Material (Chronic) (lead).
D2B Materials Causing Other Toxic Effects (irritant)

This product has been classified in accordance with the guidelines set by the Dept of Industrial Health of the Republic of Singapore.

Malaysia:

This product has been classified in accordance with: Malaysian – OCCUPATIONAL SAFETY AND HEALTH (CLASSIFICATION, LABELING AND SAFETY DATA SHEET OF HAZARDOUS CHEMICALS) REGULATION OCTOBER 2013 – (CLASS). (GHS)

In China:

Decree No. 591: Regulations on the Control over Safety of Hazardous Chemicals
GB 30000.2-29-2013, Rules for classification and labeling of chemicals. (GHS)
GB/T 16483-2008, GB/T 17517-2013

This product has been classified using the Chinese Occupational Limit for Hazardous Agents in the Workplace, GBZ2-2007



WARNING: This product can expose you to chemicals including [lead] which is known to the State of California to cause cancer, and can cause birth defects or other reproductive harm. For more information go to www.P65Warnings.ca.gov

SARA 313 Listing - 40 CFR 372.65

Lead CAS# 7439-92-1 Silver CAS# 7440-22-4 Copper CAS# 7440-50-8 Antimony CAS# 7440-36-0

EPA Genetic Toxicology Program – Lead CAS# 7439-92-1

All ingredients are listed on the EPA TSCA Inventory.

All ingredients are listed on the Canadian Domestic Substance List.

16. OTHER INFORMATION

HMIS Hazard Rating:	Health:	2
	Fire:	1
	Reactivity:	0

Revised Date: 23 AUGUST 2018

Prepared by: Nancy Swarts, Indium Corporation of America

Approved by: Nancy Swarts, Indium Corporation of America

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