



**INDIUM CORPORATION OF AMERICA®\EUROPE®\ASIA-PACIFIC®  
INDIUM CORPORATION (SUZHOU)®**

**SAFETY DATA SHEET**

This safety data sheet represents a family grouping of all metal mixes that are blended with the same flux. A table is provided at the end of this document that lists all metal groupings. To better serve all of our customers and reduce the paperwork burden, the 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.

**1. PRODUCT AND COMPANY IDENTIFICATION**

**Product Identifier:** INDALLOY WITH RMA-SMQ 51 A/C/AC OR INDALLOY WITH NC-SMQ 51 S/C/SC  
**FLUX VEHICLE** (Specific metal grouping with flux is noted at the end of this document.)

**SDS Number:** SDS-IN 282 **Revised Date:** 5 JULY 2017

**Product Use:** Industrial Use - Rosin-based mildly activated solder paste consisting of a flux vehicle blended with 83-92 weight percent of pre-alloyed metal powder. Used in soldering applications. Review alloy table for metal mixtures with the same flux.

**MANUFACTURER:**

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**2. HAZARDS IDENTIFICATION**

**PRIMARY ROUTES OF ENTRY:**

⊕Eye      ⊕Inhalation      ⊕Skin      ⊕Ingestion      NTP

**Carcinogen listed in**

IARC      OSHA      ⊕Not Listed  
(See Section 11)

GHS:

Lead free:



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      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:



Signal Word: Warning

Hazard statement(s)

- H303      May be harmful if swallowed (lead)
- H317      May cause an allergic skin reaction
- H334      May cause allergy or asthma symptoms or breathing difficulties if inhaled
- H335      May cause respiratory irritation
- H351      Suspected of causing cancer (lead)
- H361      Suspected of damaging fertility or the unborn child (applicable to lead containing product)
- H373      May cause damage to organs through prolonged or repeated exposure (applicable to lead containing

product)  
 H410 Very toxic to aquatic life, will long lasting effects (lead)  
 EUH201A Warning! Contains lead (applicable only to the products listed that contain 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  
 P273 Avoid release to the environment  
 P280 Wear protective gloves/protective clothing/eye protection/face protection  
 P362 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)

Classification:

Specific target organ toxicity- repeated exposure – Category 2  
 Carcinogenicity (Category 2) (lead)  
 Reproductive toxicity (Category 2 ) (lead)  
 Skin sensitization – Category1B  
 Respiratory sensitization- Category1B  
 Acute aquatic toxicity – Category 1 for lead containing products  
 Chronic aquatic toxicity – Category 1 for lead containing products  
 For product containing both lead and antimony the Acute and Chronic Classification is (Category 2)

**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:** Contains metal alloy and organic chemicals. May be harmful.

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

**Skin Contact:** May cause skin irritation. ANTIMONY has been known to 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.

BISMUTH: May cause kidney damage.

INDIUM: May cause damage to respiratory system.

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.

ZINC: Fresh fume inhaled may cause a disease known as "brass founders", throat dryness, cough, weakness, generalized aching, fever, nausea and vomiting.

**WARNING:** This product contains a chemical known to the State of California to cause cancer and/or birth defects (or other reproductive harm). Applicable in California.

**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 solder in making joints or fittings of any private or public water supply system. Keep out of the reach of children. Not intended for household use.

### 3. COMPOSITION / INFORMATION ON INGREDIENTS

Components	%	CAS Registry #/EINECS#	PEL mg/m <sup>3</sup>	TLV-TWA mg/m <sup>3</sup>	TLV-STEL mg/m <sup>3</sup>
<b>TIN</b>	*	7440-31-5/231-141-8			
		(US)	2	2	-
		(EU)	-	2	4
		(Canada)	-	2	4
		(Singapore)	2	-	-
<b>LEAD</b>	*	7439-92-1/231-100-4			
		(US)	0.05	0.05	-
		(EU)	N.E.	0.15	-
		(Canada)	0.05	0.05	-
		(China)	-	0.05(dust) 0.03(fume)	-
		(Mexico)	-	0.15	-
		(Singapore)	0.15	-	-
<b>SILVER</b>	*	7440-22-4/231-131-3			
		(US)	0.01	0.1	-
		(EU)	-	0.1	-

		(Canada)	-	0.1	0.3
		(Mexico)	-	0.1	-
		(Singapore)	0.1	-	-
<b>INDIUM</b>	*	7440-74-6/231-180-0			
		(US)	0.1	0.1	-
		(EU)	-	0.1	0.3
		(Canada)	-	0.1	0.3
		(China)	-	0.1	0.3
		(Mexico)	-	0.1	0.3
		(Singapore)	0.1	-	-
<b>GOLD</b>	*	7440-57-5/231-165-9	N.E.	N.E.	N.E.
<b>GERMANIUM</b>	*	7440-56-4/231-164-3	N.E.	N.E.	N.E.
<b>BISMUTH</b>	*	7440-69-9 /231-177-4	N.E.	N.E.	N.E.
<b>ANTIMONY</b>	*	7440-36-0/231-146-5			
		(US)	0.5	0.5	-
		(EU)	0.5	-	-
		(Canada)	-	0.5	1.5
		(China)	-	0.5	-
		(Mexico)	-	0.5	-
		(Singapore)	0.5	-	-
<b>COPPER</b>	*	7440-50-8/231-159-6			
		(US)	0.1 (fume)	0.2 (fume)	-
		(EU)	-	0.2 (fume)	-
		(Canada)	-	0.2 (fume)	0.6 (fume)
		(Mexico)	-	0.2(fume)	2
		(China)	-	0.2	0.6
		(Singapore)	0.2(fume)	1(dust)	-
<b>ZINC</b>	*	7440-66-6/231-175-3	N.E.	N.E.	N.E.
<b>ROSIN</b>	5.0-6.0	65997-05-9 (US)	N.E.	N.E.	N.E.
		(EU)	0.05	N.E.	0.15 (sensitiser)

<b>POLYGLYCOL ETHER</b>	2.0 -4.0	9038-95-3	N.E.	N.E.	N.E.
<b>MODIFIED CASTER OIL</b>	1.0 – 7.0	61788-85-0	N.E.	N.E.	N.E.

\*See alloy table at the end of document

N.E. = Not established

#### 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 extinguisher 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 only with production equipment (such as stencil printers and re-flow furnaces) with adequate ventilation and other safety features specifically designed for use with solder paste. Control concentration of all components so that they're permissible exposure levels are not exceeded. Protect workers from potential exposures.

### Personal protection:

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

**Respirator:** An approved or compliant marked air-purifying respirator with a fume/organic chemical cartridge is recommended under certain circumstances (i.e. when re-flowing manually on a hot plate instead of a ventilated re-flow furnace) where airborne concentrations are expected to exceed exposure limits. Lead containing products require that ventilation be provided to ensure workers are protected from potential exposures.

**Skin:** Compatible chemical resistant gloves. Latex gloves are not recommended.

**Other:** Lab coat, eye-wash 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.

## 9. PHYSICAL AND CHEMICAL PROPERTIES

<b>Appearance:</b>	Grey colored paste.	<b>Boiling Point:</b>	Not applicable.
<b>Odor:</b>	Mild characteristic odor.	<b>Melting Point:</b>	Not applicable
<b>Specific Gravity:</b>	Not applicable.	<b>pH:</b>	5 – 8 (flux)
<b>Vapor Pressure:</b>	Not applicable.	<b>Solubility in Water:</b>	Insoluble (paste)
<b>Vapor Density:</b>	(air=1) Not applicable.	<b>Volatile Organics:</b>	<132,700 ug/kg

## 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.







**Fire:** 1  
**Physical Hazard:** 0

**Revised Date:** 5 JULY 2017

**Prepared by:** Nancy Swarts, Indium Corporation of America

**Approved by:** Nancy Swarts, Indium Corporation of America

The information and recommendations contained herein are, to the best of The Indium Corporation of America's knowledge and belief, accurate and reliable as of the date issued. The Indium Corporation of America does not warrant or guarantee their accuracy or reliability, and The Indium Corporation of America shall not be liable for any loss or damage arising out of the user thereof. The information and recommendations are offered for the user's consideration and examination, and it is the user's responsibility to satisfy itself that they are suitable and complete for its particular use. If buyer repackages this product, legal counsel should be consulted to insure proper health, safety and other necessary information is included on the container.

**ALLOY TABLE**

<b>INDALLOY Metal Alloy Mix</b>	%Sn Tin	%Pb Lead	%Ag Silver	%In Indium	%Bi Bismuth	%Sb Antimony	%Cu Copper	%Zn Zinc	%Au Gold	%Ge Germanium	RoHS 2 Compliance
<b>9 (Sn70/Pb18/In12)</b>	58.1- 64.4	14.9-16.6	-	10-11	-	-	-	-	-	-	NO
<b>10 (Pb75/In25)</b>	-	63.3-69	-	20.8-23	-	-	-	-	-	-	NO
<b>42 Bi46/Sn34/Pb20)</b>	28-31.3	17-18.4	-	-	38-42.3	-	-	-	-	-	NO
<b>97 Sn43/Pb43/Bi14)</b>	35.7- 39.6	35.7-39.6	-	-	11.6- 12.9	-	-	-	-	-	NO
<b>100 (Sn62.6/Pb37/ Ag0.4)</b>	52.0- 57.6	30.7-34.0	.33-37	-	-	-	-	-	-	-	NO
<b>104 (Sn62/Pb36/Ag2)</b>	51.9- 57.5	29.9-33.2	1.2-1.8	-	-	-	-	-	-	-	NO
<b>106 (Sn63/Pb37)</b>	52.3-58	30.7-34	-	-	-	-	-	-	-	-	NO
<b>109 (Sn60/Pb40)</b>	49.8- 55.2	33.2-36.8	-	-	-	-	-	-	-	-	NO
<b>111 (Pb55.5/Sn40.5/ Bi4)</b>	33.6- 37.3	46-51	-	-	3.3-3.7	-	-	-	-	-	NO
<b>116 (Sn50/Pb50)</b>	41.5-46	41.5-46	-	-	-	-	-	-	-	-	NO
<b>118 (Sn90/Pb10)</b>	74.7- 82.8	8.3-9.2	-	-	-	-	-	-	-	-	NO
<b>121 Sn96.5/Ag3.5)</b>	80.1- 88.8	-	2.9-3.2	-	-	-	-	-	-	-	YES
<b>122 (Sn95/Pb5)</b>	78.9- 87.4	4.2-4.6	-	-	-	-	-	-	-	-	NO
<b>127 Pb60/Sn37/Ag3)</b>	30.7-34	49.8-55.2	2.5-2.8	-	-	-	-	-	-	-	NO
<b>128 (Sn100)</b>	83-92	-	-	-	-	-	-	-	-	-	YES
<b>129 (Sn99/Sb1)</b>	82.2- 91.1	-	-	-	-	083-0.92	-	-	-	-	YES

Indalloy MetalAlloyMix	%Sn	%Pb	%Ag	%In	%Bi	%Sb	%Cu	%Zn	%Au	%Ge	RoHS 2 Compliance
130 (Pb60/Sn40)	33.2-36.8	49.8-55.2	-	-	-	-	-	-	-	-	NO
131 (Sn97/Sb3)	80.5-89.2	-	-	-	-	2.5-2.8	-	-	-	-	YES
132 (Sn95/Ag5)	78.9-87.4	-	4.2-4.6	-	-	-	-	-	-	-	YES
133 (Sn95/Sb5)	78.9-87.4	-	-	-	-	4.2-4.6	-	-	-	-	YES
141 (Pb70/Sn30)	24.9-27.6	58.1-64.4	-	-	-	-	-	-	-	-	NO
143 (Pb90/Sb10)	-	74.7-82.8	-	-	-	8.3-9.2	-	-	-	-	YES with exemption
145 Pb75/Sn25)	20.8-23	62.3-69	-	--	-	-	-	-	-	-	NO
149 (Pb80/Sn20)	16.6-18.4	66.4-73.6	-	-	-	-	-	-	-	-	NO
150 (Pb81/In19)	-	67.2-74.5	-	15.8-17.5	-	-	-	-	-	-	NO
151 (Pb92.5/Sn5/ Ag2.5)	4.2-4.6	76.8-85	2-2.3	-	-	-	-	-	-	-	YES with exemption
152 (Pb92/Sn5/Sb3)	4.2-4.6	76.4-85.6	-	-	-	2.5-2.8	-	-	-	-	YES with exemption
155 (Pb90/Ag5/Sn5)	4.2-4.6	74.7-82.8	4-4.6	-	-	-	-	-	-	-	YES with exemption
159 (Pb90/Sn10)	8.3-9.2	74.7-82.8	-	-	-	-	-	-	-	-	YES with exemption
160 (Sn97/Cu3)	80.5-89.2	-	-	-	-	-	2.5-2.8	-	-	-	YES
161 (Pb97.5/Ag2.5)	-	80.9-89.7	2-2.3	-	-	-	-	-	-	-	YES with exemption
163 (Pb95.5/Ag2.5/ Sn2)	1.7- 1.9	79.3-87.9	2.1-2.3	-	-	-	-	-	-	-	YES with exemption

<b>Indalloy</b>		%Sn	%Pb	%Ag	%In	%Bi	%Sb	%Cu	%Zn	%Au	%Ge	RoHS 2 Compliance
<b>Metal Alloy Mix</b>												
<b>164 (Pb92.5/In5/Ag2.5)</b>		-	76.8-85.1	2.1-2.3	4.2-4.6	-	-	-	-	-	-	YES with exemption
<b>165 (Pb97.5/Ag1.5/ Sn1)</b>		0.8-0.9	80.9-89.7	1.2-1.4	-	-	-	-	-	-	-	YES with exemption
<b>171 (Pb95/Sn5)</b>		4.2-4.6	78.9-87.4	-	-	-	-	-	-	-	-	YES with exemption
<b>175 (Pb95/Ag5)</b>		-	78.9-87.4	4.2-4.6	-	-	-	-	-	-	-	YES with exemption
<b>182 (Au80/Sn20)</b>		16.6-18.4	-	-	-	-	-	-	-	66.4-73.6	-	YES
<b>183 (Au88/Ge12)</b>		-	-	-	-	-	-	-	-	73-81	10-11	YES
<b>201 (Sn91/Zn9)</b>		75.5-83.7	-	-	-	-	-	-	7.5-8.3	-	-	YES
<b>206 (Pb60/In40)</b>		-	49.8-55.2	-	33.2-36.8	-	-	-	-	-	-	NO
<b>209 (Sn65/Ag25/Sb10)</b>		54-59.8	-	20.8-23	-	-	8.3-9.2	-	-	-	-	YES
<b>227 (Sn77.2/In20/ Ag2.8)</b>		64-71	-	2.3-2.6	16.6-18.4	-	-	-	-	-	-	YES
<b>228 (Pb88/Sn10/Ag2)</b>		8.3-9.2	73-81	1.7-1.8	-	-	-	-	-	-	-	YES with exemption
<b>233 (Pb85/Sb10/Sn5)</b>		4.2-4.6	70.6-78.2	-	-	-	8.3-9.2	-	-	-	-	YES with exemption
<b>236 (Pb83/Sb10/Sn5/ Ag2)</b>		4.2-4.6	68.9-76.4	1.7-1.8	-	-	8.3-9.2	-	-	-	-	NO
<b>238 (Sn90/Au10)</b>		74.7-82.8	-	-	-	-	-	-	-	8.3-9.2	-	YES

Indalloy Metal Alloy Mix	%Sn	%Pb	%Ag	%In	%Bi	%Sb	%Cu	%Zn	%Au	%Ge	RoHS 2 Compliance
240 (Sn46/Pb46/Bi8)	38.2-42.3	38.2-42.3	-	-	6.6-7.4	-	-	-	-	-	NO
241 (Sn95.5/Ag3.8/ Cu0.7)	79-87.9	-	3.2-3.5	-	-	-	0.58-0.64	-	-	-	YES
244 (Sn99.3/Cu0.7)	82.4-91.4	-	-	-	-	-	0.58-0.64	-	-	-	YES
249 (Sn91.8/Bi4.8/ Ag3.4)	76.2-84.5	-	2.8-3.1	-	4-4.4	-	-	-	-	-	YES
255 (Bi55.5/Pb44.5)	-	36.9-40.9	-	-	46-51	-	-	-	-	-	NO
256 (96.5Sn/3Ag/ 0.5Cu)	80-88.8	-	2.5-2.8	-	-	-	0.42-0.46	-	-	-	YES
259 (Sn90/Sb10)	74.7-82.8	-	-	-	-	8.3-9.2	-	-	-	-	YES
264 (91.5Sn/8.5Sb)	75.9-84.2	-	-	-	-	7.06-7.8	-	-	-	-	YES
266 (93.5Pb/5Sn/1.5Ag )	4.2-4.6	77.6-86	1.2-1.4	-	-	-	-	-	-	-	YES with exemption
281 (Bi58/Sn42)	34.9-38.6	-	-	-	48.1-53.4	-	-	-	-	-	YES
281-338 (Sn60/Bi40)	49.8-55.2	-	-	-	33.2-36.8	-	-	-	-	-	YES
NS (Sn25/Au75)	20.8-23	-	-	-	-	-	-	-	62-69	-	YES
NS (Sn30/Au70)	24.9-27.6	-	-	-	-	-	--	-	58-64.4	-	YES
NS (Sn5/Pb93.5/Ag1.5)	4.2-4.6	77.6-86	1.2-1.4	-	-	-	-	-	-	-	YES with exemption
NS (Sn15/Pb82.5/ Ag2.55)	12.5-13.8	68.5-75.9	2.1-2.3	-	-	-	-	-	-	-	NO

<b>NS</b> <b>(Sn20/Pb77/Ag3)</b>		16.6-18.4	63.9-70.8	2.5-2.8	-	-	-	-	-	-	-	NO
<b>NS</b> <b>(Sn96/Ag4)</b>		79.7-88.3	-	3.3-3.7	-	-	-	-	-	-	-	YES
<b>NS</b> <b>(Sn3.5/Pb84.5/Sb12)</b>		2.9-3.2	70.1-78.2	-	-	-	9.5-10.6	-	-	-	-	NO

**NS = Non Standard Alloy Mix**

RoHS2 = Restriction of Hazardous Substances (2011/65/EU). Please review any applicable exemptions that may apply. This information is provided as information only. It is the responsibility of the customer to determine compliance with their particular specifications and restrictions.