



Product Trade Name	CaCO ₃	CaF ₂	Cr	Cu	Fe	Mn	Mineral Silicates	Mo	Ni	Si & SO ₂	Silicon Binder	TiO ₂	V	AWS Classification
T	6-11	5-10	<0.5	-	65-80	2-3	1-3	<1	1-2	1-3	1-3	1-3	-	E11018-M*
12018	6-11	5-10	<1	-	65-80	2-3	1-3	<1	1-2	1-3	1-3	1-3	-	E12018-M*
12018-602	6-11	5-10	-	-	65-80	2-3	1-3	<1	2-3	1-3	1-3	1-3	-	None
4130	6-11	5-10	<0.5	-	65-80	1-2	1-3	<1	1	1-3	1-3	1-3	-	None
4040	5-10	5-10	<1	-	65-80	1-2	1-3	<1	1-2	1-3	1-3	1-3	-	None

APPROXIMATE COMPOSITION OF THE COATING (WL %)

*The core wire type is mild steel.

Product Trade Name	CaCO ₃	CaF ₂	Cr	Cu	Fe	Mn	Mineral Silicates	Mo	Ni	Si & SO ₂	Silicon Binder	TiO ₂	V	AWS Classification
OKS														
48.88	30-40	15-20	-	-	30-40	2-5	2-5	-	-	4-10	5-15	5-10	-	E7018
55.88	25-30	15-20	-	-	30-40	2-5	1-2	-	-	4-10	5-10	5-10	-	E7018-1*

* Also includes HRR designator.

4. FIRST AID MEASURES

- Inhalation:** If breathing has stopped, perform artificial respiration and obtain medical assistance immediately! If breathing is difficult, provide fresh air and call physician.
- Eye contact:** For radiation burns due to arc flash, see physician. To remove dusts or fumes flush with water for at least fifteen minutes. If irritation persists, obtain medical assistance.
- Skin contact:** For skin burns from arc radiation, promptly flush with cold water. Get medical attention for burns or irritations that persist. To remove dust or particles wash with mild soap and water.
- Electric shock:** Disconnect and turn off the power. Use a non-conductive material to pull victim away from contact with live parts or wires. If not breathing, begin artificial respiration, preferably mouth-to-mouth, if no detectable pulse, begin Cardio Pulmonary Resuscitation (CPR). Immediately call a physician.
- General:** Move to fresh air and call for medical aid.

5. FIRE FIGHTING MEASURES

No specific recommendations for welding consumables. Welding arcs and sparks can ignite combustible and flammable materials. Use the extinguishing media recommended for the burning materials and fire situation. Wear self-contained breathing apparatus as fumes or vapors may be harmful.

6. ACCIDENTAL RELEASE MEASURES

Solid objects may be picked up and placed into a container. Liquids or pastes should be scooped up and placed into a container. Wear proper protective equipment while handling these materials. Do not discard as refuse.

- Personal precautions: refer to Section 8.
- Environmental precautions: refer to Section 13.

7. HANDLING AND STORAGE

- Handling:** Handle with care to avoid stings and cuts. Wear gloves when handling welding consumables. Avoid exposure to dust. Do not ingest. Some individuals can develop an allergic reaction to certain materials. Retain all warning and identity labels.
- Storage:** Keep separate from chemical substances like acids and strong bases, which could cause chemical reactions.

8. EXPOSURE CONTROL/PERSONAL PROTECTION

Avoid exposure to welding fumes, radiation, spatter, electric shock, heated materials and dust.

- Engineering measures:** Ensure sufficient ventilation, local exhaust, or both, to keep welding fumes and gases from breathing zone and general area. Keep working place and protective clothing clean and dry. Train welders to avoid contact with live electrical parts and insulate conductive parts. Check condition of protective clothing and equipment on a regular basis.
- Personal protective equipment:** Use respirator or air supplied respirator when welding or brazing in a confined space, or where local exhaust or ventilation is not sufficient to keep exposure values within safe limits. Use special care when welding painted or coated steels since hazardous substances from the coating may be emitted. Wear hand, head, eyes, ear and body protection like welders gloves, helmet or face shield with filter lens, safety boots, apron, arm and shoulder protection. Keep protective clothing clean and dry.

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David Baud



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