

Greenfield Industries Inc.
SAFETY DATA SHEET

Date of Issue: March 2025
Supersedes: December 2019

Section 1 – CHEMICAL PRODUCT AND COMPANY IDENTIFICATION

Product Name: High Speed Steel Cutting Tools
Chemical Name: Ferrous Alloys
Synonyms: Tool Steel
Product Use: Metalworking Tools
Manufacturer: Greenfield Industries Inc., 2501 Davis Creek Rd. Seneca SC 29678

EMERGENCY TELEPHONE NUMBER: CHEM-TEL INC. 1-800-255-3924

Section 2 – Hazard(s) Identification

Hazards Not Otherwise Classified:

We do not consider this product in the solid form it is sold to constitute a physical hazard or a health hazard. Subsequent operations such as grinding, melting, welding, cutting or processing in other fashion may produce potential hazards such as dust or fumes which can be inhaled, swallowed or come in contact with the skin or eyes. Consequently, the only foreseeable physical hazard or health hazard is as a result from downstream use, this product may have hazards not otherwise classified.

Health effects listed below are for exposure to metallurgical powders, dust, vapor or mist from altering this tool. If exposure limits described in section 8 are exceeded from the above operations, they should be performed in a well-ventilated area and/or with alternate protective measures.

Inhalation: Irritant/Sensitizer: 250 mg(Cr)/m³ 35 mg(V)/m³ or 10 mg(Co)/m³ is immediately dangerous to life and health.

Acute Overexposure: Symptoms of metal fume fever including chills, fever, sweating, nausea, and cough may appear. Metal fume fever begins 4 to 12 hours after exposure and lasts 24 hours without causing permanent damage. Other effects caused by dust and fume inhalation include metallic taste, eyes, nose, and throat irritation, wheezing, difficulty breathing, and chest pain.

Chronic Overexposure: May cause respiratory irritation, bronchitis, allergic respiratory reaction, obstructed airways, build-up of dust in the lungs, damage to lung tissue, and lung disease, with symptoms as described in acute overexposure, especially inflammation of the respiratory tract, nose and throat irritation, violent coughing, wheezing, rasping, and shortness of breath. There may also be blood changes, liver and kidney damage, and an increased susceptibility to respiratory changes.

Skin Contact: Irritant. Acute Overexposure: May cause irritation. Chronic Overexposure: May cause inflammation and/or rash (irritant or allergic contact dermatitis).

Eye Contact: Irritant. Acute Overexposure: May cause irritation with redness, pain, and itching. Chronic Overexposure: May cause conjunctivitis.

Ingestion: Irritant. Acute Overexposure: Ingestion of large amounts of steel dust is highly unlikely. However, ingestion of small amounts may occur by eating or smoking with contaminated hands. Chronic Overexposure: May produce the same symptoms as for acute overexposure. May also adversely affect the pancreas, thyroid gland, heart, or bone marrow.

No animal derivatives are used in the manufacture of this product.

Section 3 – COMPOSITION/INFORMATION ON INGREDIENTS

Material	CAS Number	%by Weight	OSHA PEL TWA (mg/m ³)	ACGIH TLV TWA (mg/m ³)	NFPA HAZARD RATING SCALE		
					Health	Fire	Reactivity
Iron (Fe)	7439-89-6	50-90	15	2	2	1	1
**Tungsten (W)	7440-33-7	1-20	5	5	0	0	0
Molybdenum (Mo)	7439-98-7	0.5-10	10	3	2	2	0
*Chromium (Cr)	7440-47-3	1-5	1	0.05	3	0	0
Vanadium (V)	7440-62-2	1-5	0.5	0.05	0	0	0
*Cobalt (Co)	7440-48-4	5-10	0.1	0.02	3	1	0

*Identifies substances that are subject to the requirements of Section 313 of Title III of Superfund Amendments and Reauthorization Act of 1986 and 40 CFR Part 372.

**This substance is regulated by OSHA as a Particulate Not Otherwise Regulated (PNOR). The exposure limit listed for OSHA refers to total dust; the OSHA PEL for the respirable fraction is 5 mg/m³.

SECTION 4 - FIRST AID MEASURES

Inhalation: If symptoms of pulmonary involvement develop (coughing, wheezing, shortness of breath), remove from exposure area to fresh air immediately. If breathing has stopped, perform artificial respiration. Keep affected person warm and at rest. Get medical attention immediately.

Skin Contact: If irritation or rash occurs, remove contaminated clothing and shoes immediately. Wash affected area with soap or mild detergent and large amounts of water until no evidence of material remains (approximately 15-20 minutes). Get medical attention.

Eye Contact: If irritation occurs, wash eyes immediately with large amounts of water, occasionally lifting upper and lower lids, until no evidence of material remains (approximately 15-20 minutes). Get medical attention immediately. **Ingestion:** If this material has been swallowed and person is conscious, immediately give person large amounts of water. Do not attempt to make an unconscious person drink or vomit. Get medical attention immediately. Induce vomiting only if specifically instructed by a physician.

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SECTION 5 - FIREFIGHTING MEASURES

Fire and Explosion Hazards: Fine metal particles produced when ground, sawed, etc. can burn. High concentrations of these particles in the air may present an explosion hazard.

Flash Point: None reported.

Extinguishing Media: In solid, finished form, it will not burn. Use water to cool.

Special Firefighting Procedures: Do not release runoff from fire control methods to swales or waterways. Because fire may produce toxic thermal decomposition products, wear a self-contained breathing apparatus (SCBA) with a full-face piece operated in pressure-demand or positive-pressure mode.

SECTION 6 - ACCIDENTAL RELEASE MEASURES

Steps to be taken if Material is Released or Spilled: Sweep up with minimum amount of dust generation and place in suitable clean, dry containers for later disposal or reclamation. Residue should be cleaned up using a high efficiency particulate filter (HEPA) vacuum or wet clean up.

SECTION 7 - HANDLING AND STORAGE

Handling Precautions: Operations such as welding, dust generation, or fume generation can result in hazardous exposure to the elements present in the alloy, if necessary precautions aren't taken. Protect against dust and fume inhalation and skin or eye contact. Use only with local exhaust ventilation. If the steel is contaminated with oil or other compounds, take precautions to prevent additional exposure to the contaminants when handling, welding, cutting, and/or heating or melting.

Storage Requirements: Store in a manner that prevents accidental environmental contamination from traces of industrial lubricants or wetting oils.

SECTION 8 - EXPOSURE CONTROLS/PERSONAL PROTECTION

Employers should complete an assessment of all workplace to determine the need for, and selection of, proper exposure controls and protective equipment for each task performed.

Ventilation: Provide local exhaust ventilation or general dilution to maintain exposure levels below the PEL and TLV.

Respiratory Protection:

0.05 mg (Co)/m³ - Single-use approved dust and mist respirator.

0.5 mg (Co)/m³ - Dust mask, except single-use respirator.

1 mg (Co)/m³ - Dust mask, except single-use and quarter-mask respirator. Fume or high efficiency particulate respirator.

5 mg (Co)/m³ - High efficiency particulate respirator with a full-face piece. Supplied-air respirator with a full Face piece, helmet or hood. Self-contained breathing apparatus with a full-face piece.

20 mg (Co)/m³ - Powered air-purifying respirator with a high efficiency filter with a full face piece. Type "C" supplied-air respirator with a full-face piece operated in pressure-demand or other positive-pressure mode.

Firefighting: Self-contained breathing apparatus with a full face piece operated in pressure-demand or other positive-pressure mode.

Clothing: Employee must wear appropriate protective clothing and equipment to prevent repeated or prolonged skin contact with this substance. Soiled clothing should be laundered separately. Gloves: Employee must wear appropriate protective gloves or barrier creams to prevent contact with this substance.

Eye Protection: Safety glasses with side shields or goggles are recommended. Where there is any possibility that an employee's eyes may be exposed to this substance, the employer should provide an eye wash fountain within the immediate work area for emergency use. Contact lenses should not be worn when handling these materials.

SECTION 9 - PHYSICAL AND CHEMICAL PROPERTIES

• Appearance (physical state, color, etc.)	Solid
• Odor	Odorless
• Odor threshold	NA
• pH	NA
• Melting point/Freezing point	2,500 deg F
• Initial boiling point/boiling range	5,000 deg F
• Solubility in H ₂ O	Insoluble
• Specific Gravity	7.8 – 8.2

SECTION 10 - STABILITY AND REACTIVITY

Stability: Stable under normal temperatures and pressure.

Decomposition: Thermal oxidative decomposition of steel can produce metallic and carbon oxides.

Incompatibilities: Reacts with strong acids.

Hazard decomposition products: metallic oxides

SECTION 11 - TOXICOLOGICAL INFORMATION

Molybdenum: Molybdenum is an eye and mucous membrane irritant. Individuals with a history of kidney, chronic respiratory or liver disease may be at increased risk from exposure.

Rat Intraperitoneal LDLo: 114 mg/kg.

Rabbit Intratracheal LDLo: 70 mg/kg

Chromium: Carcinogenic status: There is evidence of increased incidence of lung cancer among chromium alloy workers. However, according to the International Agency for Research on Cancer (IARC), the chromium compounds responsible cannot be specified.

Cobalt: Carcinogenic status: IARC lists Cobalt and Cobalt compounds as Category 2B carcinogens (Possibly Carcinogenic to Humans). Cobalt fumes or dust may cause pulmonary, skin, or eye irritation. Cobalt may be a sensitizing agent for skin and respiratory system. Chronic exposure may affect the heart, pancreas, thyroid gland, or bone marrow.

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| Rat Oral LDLo: 1500 mg/kg. | Rat Intraperitoneal LDLo: 250 mg/kg |
| Rat Intravenous LDLo: 100 mg/kg | Rabbit Oral LDLo: 20 mg/kg |
| Rabbit Intratracheal LDLo: 100 mg/kg | |

Contact the phone number listed on the first page of the SDS for toxicological information on the material and its components.

SECTION 12 - ECOLOGICAL INFORMATION

No data is available. Solids and dust should be recycled, if possible, instead of sending to a landfill. We do not consider this product in the form it is sold to constitute an ecological hazard. Subsequent operations such as grinding, melting, welding, cutting or process in any other fashion may produce potentially hazard dust which can be hazardous for water. Do not allow any product to reach ground water, water course or sewage system, even in small quantities.

SECTION 13 - DISPOSAL CONSIDERATIONS

Waste Disposal Method: This is a valuable material that should be sent to an appropriate reclamation facility if available. If material cannot be sent to a reclamation facility, disposal should be made in compliance with federal, provincial/state, and local environmental regulations.

SECTION 14 - TRANSPORT INFORMATION

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| • UN-Number: DOT, ADN, IMDG, IATA | Not regulated |
| • UN proper shipping name: DOT, ADN, IMDG, IATA | Not regulated |
| • Transport hazard class(es): DOT, ADN, IMDG, IATA Class | Not regulated |
| • Packing group: DOT, IMDG, IATA | Not regulated |
| • Environmental hazards: Marine pollutant: | Not applicable |
| • Special precautions for user | Not applicable |
| • Transport in bulk according to Annex II of MARPOL73/78 and the IBC Code | Not applicable |
| • UN "Model Regulation": | Not applicable |

SECTION 15 - REGULATORY INFORMATION

Some ingredients in Greenfield products, including Tungsten, Cobalt, Nickel, Copper, Chromium and Chromium Compounds, are subject to the requirements of Section 313 of Title III of Superfund Amendments and Reauthorization Act of 1986 and 40 CFR Part 372.

SECTION 16 - OTHER INFORMATION

Although Greenfield Industries Inc. has attempted to provide current and accurate information herein, Greenfield Industries Inc. makes no representations regarding the accuracy or completeness of the information and assumes no liability for any loss, damage, or injury of any kind which may result from or arise out of the use of or reliance on the information by any person.

For technical information contact Greenfield Industries Inc., 864-654-4922 or fax 864-654-8126. For additional SDSs, contact Greenfield Industries Inc., Customer Service at 800-348-2885.

Prepared by: Greenfield Industries Inc. Quality and EHS Department