

F103 - 90S, Flux Core Arc Welding (FCAW) Welding Process Emission Factors

CALCULATION METHODS

Annual Emissions: $E_a = U_a \times EF \text{ (lbs/lb rod)} \times (1-e)$

Hourly Emissions: $E_h = U_h \times EF \text{ (lbs/lb rod)} \times (1-e)$

E_a = Annual emissions of each listed toxic air contaminant per welding rod, (lbs/year)

E_h = Maximum hourly emissions of each listed toxic air contaminant per welding rod, (lbs/hour)

U_a = Annual usage of each welding rod, (lbs/year)

U_h = Maximum hourly usage of each welding rod, (lbs/hour)

EF = Emission Factor (lbs/lb rod)

Emission Factors:

(1) Complete AP-42 information from Final Section 12.19 (1/95): EF = Trace Metal EF (Table 12.19-2)

(2) Incomplete AP-42 Final Section 12.19 (1/95): EF = FGR (Table 12.19-1) x FCF x Ci (MSDS)

(3) No AP-42 information but known welding process: EF = FGR (District Default) x FCF x Ci (MSDS)

(4) District Study or AWMA information: EF = Trace Metal EF

(5) Incomplete District Study information: EF = FGR (District Study) x FCF x Ci (MSDS)

(*) Incomplete AP-42, District, or AWMA Hexavalent Chromium information: EF = Cr (Total Chromium in Fumes) EF x HCR

NOTES:

- Emission factors assume "uncontrolled" releases. Emission control methods and efficiencies reported are be applied within the emission calculations.
- Fume generation rates (FGR) are based on the following:
 - EPA AP-42 Final Section 12.19 (1/95) Table 12.19-1 (PM10 EF)
 - ARB, Richard Bode: 0.01 (GMAW, TIG, MIG), 0.02 (SMAW, FCAW), 0.00005 (SAW), 0.05 (unspecified)
- Fume Correction Factors (FCF) per District engineering discussions with Industry:
 - 0.5464 (GMAW, TIG, MIG), 0.2865 (SMAW, FCAW, SAW), 1.0 (unspecified)
- Trace metal emission factors are based on the following:
 - AWMA Volume 59, 2009, Issue 5 (Pages 619-626) Table 2 and Table 3
 - EPA AP-42 Final Section 12.19 (1/95) Table 12.19-2
 - District engineering estimates using rod compositions (Ci) from MSDS
- Hexavalent chromium conversion rates (HCR) are per District engineering reviews of studies on welding:
 - 0.05 (GMAW, TIG, MIG), 0.55 (SMAW), 0.0005 (SAW), 0.10 (FCAW, unspecified)

| POLLUTANT | DISTRICT EMISSION FACTORS (lbs/lb rod) | REFERENCE DOCUMENT | FACTOR | (UNITS) | COMMENTS |
|-----------|--|-------------------------------------|--------|------------|--|
| NOX | | | | | |
| CO | | | | | |
| SOX | | | | | |
| TOG | | | | | |
| VOC | | | | | |
| TSP | 2.00E-02 | | | | Assume PM10 = TSP |
| PM10 | 2.00E-02 | CARB Welding Recommendations (1993) | 0.02 | lbs/lb rod | Assume PM10 = Fume Generation Rate (FGR) |
| Al | | | | | |
| Al2O3 | | | | | |

| | | | | | |
|---------------------------|----------|--|-------|-----|---|
| Be | | | | | |
| Cd | | | | | |
| Co | | | | | |
| Cr | 1.38E-04 | District Welding Study SDS - Lincoln ER90S-B3 | 2.4 | wt% | District Procedure (3) EF = FGR x FCF x Ci |
| Cr(VI) | 1.38E-05 | AWMA Page 623 | 10 | % | District Procedure (*) EF = Cr EF x HCR |
| Cu | 4.58E-06 | District Welding Study SDS - Lincoln ER90S-B3 | 0.08 | wt% | District Procedure (3) EF = FGR x FCF x Ci |
| Mn | 3.32E-05 | District Welding Study SDS - Lincoln ER90S-B3 | 0.58 | wt% | District Procedure (3) EF = FGR x FCF x Ci |
| Ni | 2.29E-06 | District Welding Study SDS - Lincoln ER90S-B3 | 0.04 | wt% | District Procedure (3) EF = FGR x FCF x Ci |
| P | 2.73E-07 | District Welding Study SDS - Lincoln ER90S-B3 | 0.005 | wt% | District Procedure (3) EF = FGR x FCF x Ci |
| Pb | | | | | |
| Crystalline Silica | | | | | |
| V | | | | | |
| Zn | | | | | |

REFERENCES:

EPA AP-42 Chapter 12.19: <https://www.epa.gov/sites/production/files/2020-11/documents/c12s19.pdf>

AWMA: <https://www.tandfonline.com/doi/abs/10.3155/1047-3289.59.5.619>