

TECHNICAL DATA SHEET

TERNALLOY 45

Brazing alloys, Cadmium Free

EN ISO 17672:2016

AWS A5.8-92

ISO 3677:1997

DIN 8513

(EN 1044:1999)

AG 145

B-Ag-36

B-Ag45CuZnSn - 640/680

L-Ag45Sn

AG 104

Nominal Composition [%]

Ag	Cu	Zn	Sn	Si	Mn	Ni
45	27	25,5	2,5	-	-	-

Technical Data

Melting Point

c.a. 640 - 680 °C

Working Temperature

c.a. 670 °C

Density

c.a. 9,2 gr/cm³

Tensile strength

350 Mpa

Elongation

10%

Electrical Conductivity

13 m/? mm²

Operating temp. of brazed joint

Applications

This alloy is a low melting silver brazing alloy with excellent characteristics and very good fillet forming quality. It is an excellent substitute to the cadmium-containing filler metals.

Typical applications are in refrigeration and air conditioning, automotive and electric industry. Suitable to manual or machine feeding.

Suggested Flux

BRASFLUX, F16, F62

Base Metals

Copper and copper alloys, nickel and nickel alloys, almost any steel and stainless steel.

Heat Sources

Manual, induction, semi-automatic and automatic.

Bare rods	Fluxcoated	Wire < Ø 1,0	Wire > Ø 1,0	Foil	Preforms	Paste
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