



TECHNICAL DATA SHEET

TERNALLOY 45

Brazing alloys, Cadmium Free

EN ISO 17672:2016	AG 145
AWS A5.8-92	BAg-36
ISO 3677:1997	B-Ag45CuZnSn - 640/680
DIN 8513	L-Ag45Sn
(EN 1044:1999)	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%
Electrycal Conductivity	13 m/? mm²
Operating temp. of brazed joir	

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
X	X	X	X	X	X	-

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