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TECHNICAL DATA SHEET

TERNALLOY 34

Brazing alloys, Cadmium Free

EN ISO 17672:2016	Ag 134
AWS A5.8-92	
ISO 3677:1997	B-Cu36AgZnSn-630/730
DIN 8513	*L-Ag34Sn*
(EN 1044:1999)	*AG 106*

Nominal Composition [%]

Ag	Cu	Zn	Sn	Si	Mn	Ni
34	36	27,5	2,5	-	-	-

Technical Data

Melting Point	c.a. 630 - 730 °C
Working Temperature	c.a. 610 °C
Density	c.a. 9.0g/cm3
Tensile strength	480 Mpa
Elongation	12%
Electrycal Conductivity	n.a.
Operating temp. of brazed joint	

Applications

Ternalloy 34 is a low melting, cadmium-free, silver brazing alloy with good flow characteristics. It can be used to join ferrous, non ferrous and dissimilar metals and alloys with close joint clearances, such as steel, copper, copper alloys, nickel, nickel alloys.
When brazing in an oxidizing environment a proper flux should be used.
Typical applications are in the automotive, electric, air conditioning and refrigeration industries.

Suggested Flux

F16 - F62

Base Metals

It can be used for brazing any steel, copper and copper based alloy as well as for nickel

Heat Sources

It can be used for flame or induction brazing procedures.

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

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