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TECHNICAL DATA SHEET

TERNALLOY 412

Brazing alloys, Cadmium Free

EN ISO 17672:2016	Ag 212
AWS A5.8-92	--
ISO 3677:1997	
DIN 8513	
(EN 1044:1999)	

Nominal Composition [%]

Ag	Cu	Zn	Sn	Si	Mn	Ni
12	48	40	-	0,2	-	-

Technical Data

Melting Point	c.a. 800 - 830 °C
Working Temperature	c.a. 820 °C
Density	c.a.8,4 gr/cm3
Tensile strength	410 Mpa
Elongation	15%
Electrycal Conductivity	n.a.
Operating temp. of brazed joint	

Applications

For torch brazing on carbon and stainless steel, copper, nickel and its alloys. Used in boiler works for drawed components. The fluidity of this alloy allows good penetration of the alloy and a joint with no porosity.

Suggested Flux

F25

Base Metals

Any steel, copper and copper alloys, nickel and nickel alloys

Heat Sources

For torch brazing

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

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