TECHNICAL DATA SHEET

TERNALLOY 460

Brazing alloys, Cadmium Free

EN ISO 17672:2016	-
AWS A5.8-92	-
ISO 3677:1997	B-Ag60CuZn-695/730
DIN 8513	*L-Ag60*
(EN 1044:1999)	*AG 202*

Nominal Composition [%]

Ag	Cu	Zn	Sn	Si	Mn	Ni
60	26	14	-	-	-	-

Technical Data

Melting Point	c.a. 695 - 730 °C
Working Temperature	c.a. 710 °C
Density	c.a. 9,5 gr/cm3
Tensile strength	430 Mpa
Elongation	c.a. 16%
Electrycal Conductivity	n.a.
Operating temp. of brazed joint	± 200 °C

Applications

Ternalloy 460 is a Cadmium free alloy with a high silver content with good penetration characteristics. It is widely used in step brazing processes, in combination with alloys with a lower melting temperature. Its reduced zinc content makes it very efficient in brazing processes that require long heating cycles, as the risk of zinc vaporization is reduced to a minimum. Its mechanical strength depends on the base metals, the joint design and its interference.
If used in an oxidizing environment it is necessary to use a specific flux.

Suggested Flux

F25 - F16

Base Metals

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

Heat Sources

Manual, induction and resistance brazing.

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

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