TECHNICAL DATA SHEET

TERNALLOY 49 MN

Brazing alloys, Cadmium Free

EN ISO 17672:2016 Ag 449
AWS A5.8-92
ISO 3677:1997 BAg-22
DIN 8513
(EN 1044:1999)

Nominal Composition [%]

Ag	Cu	Zn	Sn	Si	Mn	Ni
49	16	23	-	-	7,5	4,5

Technical Data

Melting Point	c.a. 680 - 705 °C
Working Temperature	c.a. 690 °C
Density	8,88 gr/cm3
Tensile strength	250 - 300 Mpa
Elongation	n.a.
Electrycal Conductivity	5,70 m/? mm²
Operating temp. of brazed joint	

Applications

TERNALLOY 49 MN is a low melting silver brazing alloy with excellent flow characteristics and high mechanical resistance. It is mainly employed for brazing of cemented carbides and materials difficult to wet such as tungsten, chromium, tantalum and titanium. Typical applications are in tool industry. The suitable fluxes are F9 paste (suggested during a brazing process by induction) and F4 paste (suggested for all the other applications).

Suggested Flux

F9 PS - F4 PS

Base Metals

Steels, plain and alloyed. Also tungsten, molybdenum, tantalum and chromium; cemented

Heat Sources

It can be used in brazing procedures by flame or induction.

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

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