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TECHNICAL DATA SHEET

TERNALLOY 49TR

Brazing alloys, Cadmium Free

EN ISO 17672:2016 -
AWS A5.8-92 -
ISO 3677:1997 B-Ag49CuZnMnNi-670/680
DIN 8513
(EN 1044:1999)

Nominal Composition [%]

Ag	Cu	Zn	Sn	Si	Mn	Ni
49	27	21	-	-	2,5	0,5

Technical Data

Melting Point	c.a. 670 - 690 °C
Working Temperature	c.a. 690 °C
Density	c.a. 9,0 gr/cm3
	250 - 300 Mpa
Elongation	-
Electrycal Conductivity	- m/mm²

Applications

TERNALLOY 491 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. It can be used in brazing procedures by flame or induction. The suitable fluxes are F9 paste (suggested during a brazing process by induction) and F4 paste (suggested for all the other applications).
In the form of trimetallic it is supplied both with the ratio 1: 2: 1 and in the more performing 1: 6: 1.

Suggested Flux

F4, F9

Base Metals

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

Heat Sources

Flame, induction

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

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