TECHNICAL DATA SHEET

TERNALLOY 552

Brazing alloys, Cadmium Free

EN ISO 17672:2016	Ag155Si
AWS A5.8-92	-
ISO 3677:1997	
DIN 8513	
(EN 1044:1999)	

Nominal Composition [%]

Ag	Cu	Zn	Sn	Si	Mn	Ni
55	21	22	2	0,2	-	-

Technical Data

Melting Point	c.a. 630 - 660 °C
Working Temperature	c.a. 660 °C
Density	c.a. 9,4 gr/cm3
Tensile strength	430 Mpa
Elongation	n.a.
Electrycal Conductivity	n.a.
Operating temp. of brazed joint	

Applications

TERNALLOY 552 is a variant of Ternalloy 55 specifically designed for certain types of applications, which require an accentuated flowability (capillarity) of the filler material due to the type of joint to be welded or the viscosity of the base metals. Much appreciated in the production of taps and welding torches. The presence of silicon reduces electrical conductivity and mechanical resistance. With these alloys it is possible to carry out all those brazing of parts that will then come into contact with food or pharmaceutical products. They also guarantee greater workplace hygiene because, being insensitive to overheating, they do not release volatile substances during brazing. If the joint design requires a prolonged heating time then as an alternative use the flux F25.

Suggested Flux

F62/F25

Base Metals

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

Heat Sources

Oxyacetylene torch with reducing flame

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

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