TECHNICAL DATA SHEET

TERNALLOY 5614

Brazing alloys, Cadmium Free

EN ISO 17672:2016	Ag 456a
AWS A5.8-92	-
ISO 3677:1997	-
DIN 8513	-
(EN 1044:1999)	*AG 403*

Nominal Composition [%]

Ag	Cu	Zn	Sn	Si	Mn	Ni
56	27,25	-	-	-	-	14,5 2

Technical Data

Melting Point	600 - 710 °C
Working Temperature	c.a. 650 °C
Density	9,5 gr/cm3
Tensile strength	
Elongation	25 % c.a.
Electrycal Conductivity	n.a.
Operating temp. of brazed joint	c.a. 720°C

Applications

TERNALLOY 5614 is suggested for in-air brazing of Stainless Steel joints exposed to water or moisture in Service. It is designed to prevent interfacial (crevice) corrosion, which may result in rapide failure of joint made in stainless steel when exposed to water. It has long melting ranges are not free flowing or easy to use. The most appropriate flux for in-air brazing is flouride flux compliant to FH 10 (DIN8511), also if the residues are virtually insoluble in water and have to be mechanically removed.

Suggested Flux

F4, F20

Base Metals

non-ferrous metals, steels, stainless steels; hard metals in general (Widia, tungsten

Heat Sources

manual, induction or oven in atmosphere or vacuum

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

Our information about our products and equipment as well as our systems and procedures are based on comprehensive research and application technological experience. We communicate these results, but take no liability for respective single contracts that are exceeding thereof. We reserve the right to make technical changes in the process of product development in spoken and written terms to the best of our knowledge. Only as an exception do we give guarantees for appearance and workmanship or durability that has been specifically documented in an individual contract. Furthermore, our application technology services are available at your convenience for more detailed consultation such as the involvement in solving manufacturing and application technology problems. This does not however, release the user from their own responsibility for checking the input and recommendations we give for their own use prior to using that input or recommendation. This is especially applicable for foreign deliveries. This also applies to the trade mark rights of third parties, for applications and procedures that are not specifically given by us. In the event of damage or loss our liability is limited to indemnification of the same admeasurements as is foreseen in our general terms of sales and delivery in reference to deficiencies in quality.