TECHNICAL DATA SHEET

TERNALLOY 7228

Brazing alloys, Cadmium Free

EN ISO 17672:2016	Ag 272
AWS A5.8-92	BAg-8
ISO 3677:1997	
DIN 8513	
(EN 1044:1999)	*AG 401*

Nominal Composition [%]

Ag	Cu	Zn	Sn	Si	Mn	Ni
72	28	-	-	-	-	-

Technical Data

Melting Point	c.a. 780 - 780 °C
Working Temperature	c.a. 780 °C
Density	c.a. 10 gr/cm3
Tensile strength	S235: 340 Mpa; E295:
Elongation	c.a. 17%
Electrycal Conductivity	approx. 46,1 m/Omm2
Operating temp. of brazed joint	approx. -200 °C to +200 °C (without

Applications

TERNALLOY 7228 can be used for brazing unalloyed, low and high alloyed steels, copper and copper based alloys as well as for nickel and nickel based alloys.
It is well suitable for brazing under protective atmosphere and under vacuum. The brazing temperature in the furnace is determined by the parent metals. Brazing procedures under vacuum should be done at temperatures not much above 900 °C to avoid evaporation of silver as far as possible. Typical applications are found e.g. in the electric industry. (Brazing of metallised ceramic)

Suggested Flux

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Base Metals

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

Heat Sources

Induction / Furnace in protected atmosphere

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

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