*TECHNICAL DATA SHEET*

# TERNALLOY 8515

## Brazing alloys, Cadmium Free

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|---|---|
| **EN ISO 17672:2016** | Ag 485 |
| **AWS A5.8-92** | BAg-23 |
| **ISO 3677:1997** | B-Ag85Mn-960/970 |
| ***DIN 8513*** | *L-Ag85Mn* |
| ***(EN 1044:1999)*** | *AG 501* |

### Nominal Composition [%]

| Ag | Cu | Zn | Sn | Si | Mn | Ni |
|---|---|---|---|---|---|---|
| 85 | - | - | - | - | 15 | - |

### Technical Data

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|---|---|
| **Melting Point** | c.a. 960 - 970° C |
| **Working Temperature** | c.a. 970° C |
| **Density** | c.a. 9,8 gr/cm3 |
| **Tensile strength** | - |
| **Elongation** | n.a. |
| **Electrycal Conductivity** | n.a. |
| **Operating temp. of brazed joint** | |

### Applications

Ternalloy 8515 is a high Silver content alloy with manganese, with excellent penetration characteristics.
It is mainly used for brazing in a protected atmosphere oven; however the presence of a such a percentage of Mn requires that the reducing atmosphere of the furnace reaches a dew point below - 40 ° C, to obtain a good result.
It is widely used for brazing stainless steel joints, when the working environment is characterized by humidity or the operating conditions are in contact with liquids (for example in sea water).
It is also used for brazing ammonia-based refrigeration systems, due to the absence of copper in its formulation, which effectively avoids rapid corrosion.

### Suggested Flux

### Base Metals

Non-ferrous metals, such as steel, copper, bronze and copper

### Heat Sources

Brazing in a controlled atmosphere oven. Induction and resistance brazing.

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

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