TECHNICAL DATA SHEET

TERNALLOY 420

Brazing alloys, Cadmium Free

EN ISO 17672:2016	Ag 220
AWS A5.8-92	--
ISO 3677:1997	
DIN 8513	*L-Ag20*
(EN 1044:1999)	*Ag 206*

Nominal Composition [%]

Ag	Cu	Zn	Sn	Si	Mn	Ni
20	44	36	-	0,15	-	-

Technical Data

Melting Point	c.a. 690 - 810 °C
Working Temperature	c.a. 810 °C
Density	c.a. 8,7 gr/cm3
Tensile strength	145 Mpa
Elongation	n.a.
Electrycal Conductivity	n.a.
Operating temp. of brazed joint	

Applications

TERNALLOY 420 is a silver brazing alloy with very good flow characteristics. It is used for joining copper and copper alloys, nickel and nickel alloys, almost any steels.
Typical applications are in automotive and in the electric industry.

Suggested Flux

F25 e F16

Base Metals

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

Heat Sources

It can be used for flame or induction brazing procedures.

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

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