Safety, quality, control. Advanced atmosphere control systems for heat treaters.

Air Products has been delivering innovative solutions to the metals industry for over 50 years. Together, our range of high quality technical and industrial gases, including nitrogen-hydrogen blends, and technical expertise have helped customers all over the world to optimise their heat treating processes.

We understand that among the number of challenges you face the need for a controlled process can be critical for your operation. Our experts have worked closely with customers to help them reduce costs, maximise uptime, increase throughput and even improve product quality in order to meet ever changing customer demands. And we are here to help you.

**Environmentally friendly**

Our nitrogen-hydrogen atmospheres eliminate the need for the more traditional exo-generator systems. Nitrogen, typically the main atmosphere component, provides the inert base that prevents undesirable reactions from occurring. Often a reducing agent, such as hydrogen, will be added to adjust this atmosphere-reducing potential. As no carbon-monoxide is produced they are safer and also more environmentally friendly too. The ability to reduce harmful oxidizing components will mean fewer rejects and better yield, resulting in an overall reduction to operating costs.

**Putting you in control**

Air Products nitrogen-hydrogen blending panels are fully automated gas mixing systems for heat treating furnace atmosphere production. Each system enables you to adjust your gas mixture and flow to meet your most exacting conditions - a highly valued operational characteristic. This flexibility makes the system user-friendly even in industrial environments.
**Built-in flow regulator**

The system features a unique differential pressure flow adjustment, and an optional touch screen control. It also includes the option of built-in flow rate measurement and can automatically set the nitrogen and hydrogen flow rates based on a desired % hydrogen concentration. Each panel is fully pre-piped, wired and tested to perform to specific furnace requirements.

**Quality and accuracy**

For superior quality and accuracy, the blending and flow control equipment provides you with an easy way to manage and maintain a consistent atmosphere and precise gas composition without losing operational flexibility.

**Full system range**

Whether you have a constant or variable flow, we will help you adjust the hydrogen composition level or the dew point to ensure the best fit and most economic operating conditions for your needs.

The blending panel can be integrated into annealing, sintering and brazing applications for different types of materials and surface reactions. It can also deliver three gases to produce a defined oxidizing atmosphere, for example the controlled surface oxidation of steel strip.

Available in four sizes – from small to extra large (as shown in fig 1.) – with many additional features, including the ability for data logging and automatic calibration with the advanced system.

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**Figure 1: Flow Rate in Nm³/h based on inlet pressure 13 barg**

![Flow Rate Graph]

<table>
<thead>
<tr>
<th>Type</th>
<th>Inlet Pressure 13 barg</th>
<th>Outlet Pressure 13 barg</th>
</tr>
</thead>
<tbody>
<tr>
<td>S</td>
<td>10 Nm³/h</td>
<td>1.5</td>
</tr>
<tr>
<td>M</td>
<td>100 Nm³/h</td>
<td>2.5</td>
</tr>
<tr>
<td>L</td>
<td>1000 Nm³/h</td>
<td>3.5</td>
</tr>
<tr>
<td>XL</td>
<td>1270 Nm³/h</td>
<td>4.5</td>
</tr>
</tbody>
</table>
Flexible and tailored design

For added peace of mind, whatever your budget, we have a system to suit you. Available as a standard or advanced model both systems have been specifically designed to meet the most basic, yet essential, heat treating requirements with a range of benefits and an affordable price. The advanced system provides additional features such as the ability to link with existing control units.

<table>
<thead>
<tr>
<th>Feature</th>
<th>Standard</th>
<th>Advanced</th>
</tr>
</thead>
<tbody>
<tr>
<td>Reliable low cost base modules to adjust the nitrogen-hydrogen blends</td>
<td></td>
<td>●</td>
</tr>
<tr>
<td>Easy to handle</td>
<td>●</td>
<td></td>
</tr>
<tr>
<td>Low maintenance cost</td>
<td></td>
<td>● ●</td>
</tr>
<tr>
<td>Data acquisition</td>
<td>●</td>
<td></td>
</tr>
<tr>
<td>Closed-loop atmosphere control systems integration capability</td>
<td></td>
<td>●</td>
</tr>
<tr>
<td>Integrated precision hydrogen analyser to measure ( % \text{H}_2 ) in the atmosphere introduced to the furnace</td>
<td></td>
<td>●</td>
</tr>
<tr>
<td>Integrated ( \text{N}_2 ) purge control ①</td>
<td></td>
<td>● ●</td>
</tr>
<tr>
<td>Ability to link to existing process control units ②</td>
<td></td>
<td>●</td>
</tr>
</tbody>
</table>

① EN 746-3 standard equivalent
② Can be used with single or multi-zone furnace

Figure 2: Comparison of system features and benefits

Pure nitrogen-hydrogen blends delivered by technical gases usually have a dew point of more than -65°C, and a residual O\(_2\) level of below 5ppm. For applications such as brazing and sintering, where a humidified atmosphere can deliver significant advantages, our purposefully-designed humidification system can be added to the Air Products blending panel.

Figure 3: System options

Audits

Our experts can undertake a furnace audit and recommend an appropriate system to improve part quality or reduce your furnace maintenance costs. Our application engineers can work with you to recommend custom improvements to help optimise your gas use and improve product quality.

Evaluation

The Air Products team will fully evaluate your furnace equipment, conducting in-depth performance and safety checks to ensure our blending panels enable you to achieve the required quality standards for your products and meet required safety regulations.
Safety

Nothing is more important to us than your safety. Not sales, not production, not profits. And, a safe operation means an efficient operation.

We offer a wide and varied range of high-quality, tailored safety and training programmes to suit any operation and to keep operators confident and in control. Our programmes include:

- Handling of gases
- Gas atmosphere safety
- Thermodynamics of furnace atmospheres

For more information contact your local Air Products office at:

België
Air Products NV
T +32 02 255 28 95
beinfo@airproducts.com
airproducts.be

Belgique
Air Products SA
T +32 02 255 28 95
beinfo@airproducts.com
airproducts.be/fr

Česká republika
AIR PRODUCTS spol. s r.o.
T +420 800 100 700
info cz@airproducts.com
airproducts.cz

Deutschland
Air Products GmbH
T +49 0234 6105 6300
apginfo@airproducts.com
airproducts.de

España
Carburos Metálicos S.A.
T +34 902 13 02 02
F +34 93 290 26 09
oferta@carburos.com
carburos.com

France
Air Products SAS
T +33 0800 480 030
frinfo@airproducts.com
airproducts.fr

United Kingdom
Air Products PLC
T +44 0800 389 0202
F +44 01932 258 652
apukinfo@airproducts.com
airproducts.co.uk

Italia
SAPIO Produzione Idrogeno Ossigeno S.r.l.
T +39 039 8398286
F +39 039 836068
gtm@sapio.it
grupposapio.it

Nederland
Air Products Nederland BV
T +31 020-435 3535
F +31 020-435 4035
nlinfo@airproducts.com
airproducts.nl

Polska
Air Products Sp. z o.o.
T (BULK) +48 0801 081 122
T (PG) +48 0801 100 801
infopl@airproducts.com
airproducts.com.pl

Portugal
GASIN – Grupo Air Products
T +351 229 998 300
F +351 229 998 301
proposta@gasin.com
gasin.com

Slovenská republika
Air Products Slovakia s.r.o.
T +421 0800 100 700
infosk@airproducts.com
airproducts.sk

tell me more
airproducts.com/mp