



# MODEL 31

## NITROGEN BACK PURGING FLOWMETER REGULATOR

Allows for a low controlled flow of gas through the copper tube to prevent internal oxidation during brazing processes.



**\$33.00**  
EACH

### NO QUANTITY LIMITS

Offer Good September 1 - 30th, 2021

### PLACE ORDERS

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### SETUP

Connect a hose or tube from the nitrogen cylinder to one end of the pipe. The cylinder will be equipped with a regulator or flow control valve such as a Harris Model 31 HVAC purging regulator.

### FLOW

The goal is to use low volume/pressure to displace the oxygen. A suggested starting point is 2 -3 CFH or 1.5 - 2 PSI. Some users will set pressure until they feel a slight flow at the exit point on the back of their hand. It's good practice to initiate flow before heating and continue to flow nitrogen until the part has cooled. A small hole in a cap at the end of the line will allow the nitrogen to escape.

### TIPS

Avoid an excessive flow rate that builds pressure inside the tube. A high flow rate will tend to cool the tube reducing brazing heat efficiency. Excess nitrogen pressure can build up inside the tube and reduce braze alloy penetration.

### WHY NITROGEN PURGE



Without nitrogen purge

With nitrogen purge