



ATMOSPHERIC PRODUCTS AND SERVICES (APS)

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SafetyAlert-2 Gaseous Nitrogen

General

Nitrogen makes up the major portion of the atmosphere (78.03% by volume, 75.5% by weight). Gaseous nitrogen is inert, colorless, odorless, tasteless, nontoxic, noncorrosive, and non-flammable. Nitrogen is inert and will not support combustion; however, it is not life supporting.

Nitrogen is inert except when heated to very high temperatures, where it combines with some of the more active metals, such as lithium and magnesium, to form nitrides. It will also combine with oxygen to form oxides of nitrogen and when combined with hydrogen in the presence of catalysts, will form ammonia.

Since gaseous nitrogen is inert, special materials of construction are not required. Vessels and piping should be designed to the American Society of Mechanical Engineers (ASME) standards or Department of Transportation (DOT) codes for the pressure and temperatures involved.

Nitrogen may be compressed into cylinders using water- or oil-lubricated compressors or by dry compression systems.

Physical and chemical properties are listed in Table 1.

Manufacture

Nitrogen is produced at air separation plants, either by liquefaction of atmospheric air and separation of the nitrogen by distillation or by adsorption processes.

Uses

Nitrogen is the largest volume inorganic chemical sold in the world and has a multitude of commercial and technical applications. Nitrogen's properties benefit applications such as heat treating atmospheres, blanketing atmospheres, propellants, pneumatics, purging and pressurizing, and analytical carrier gases.

Health Effects

Being odorless, colorless, tasteless, and non-irritating, nitrogen has no warning properties. Humans possess no senses that can detect the presence of nitrogen. Although nitrogen is nontoxic and largely inert, it can act as a simple asphyxiant

by displacing the oxygen in air to levels below that required to support life. Inhalation of nitrogen in excessive amounts can cause dizziness, nausea, vomiting, loss of consciousness, and death. Death may result from errors in judgment, confusion, or loss of consciousness, which prevents self-rescue. At low oxygen concentrations, unconsciousness and death may occur in seconds and without warning.

Personnel, including rescue workers, should not enter areas where the oxygen concentration is below 19.5%, unless provided with a self-contained breathing apparatus or air-line respirator.

For more information on oxygen-deficient atmospheres, consult APS SafetyAlert-17, "Dangers of Oxygen-Deficient Atmospheres."

Containers

Gaseous nitrogen is shipped and stored in high-pressure cylinders, tubes, or tube trailers depending upon the quantity required by the user. Containers are designed and manufactured according to applicable codes and specifications for the pressures and temperatures involved. The quantity of product a container can hold is determined by its water capacity and pressure rating.

Cylinders

A cylinder (Figure 1) is a hollow tube with a closed concave base that permits the cylinder to stand upright. The opposite end is tapered to a small opening which is threaded to accommodate the installation of a valve. A threaded neck ring is attached to the tapered end to allow a protective cylinder cap to be installed.



Figure 1 Typical Cylinder Shapes and Sizes



Responsible Care
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Cylinders are manufactured according to DOT regulations. These regulations specify the material of construction, method of manufacture, method of testing, what products they are permitted to be filled with, as well as other details.

Cylinders may be used individually or in groups. When used in groups, the cylinders should be piped together, for stationary storage or to form portable banks.

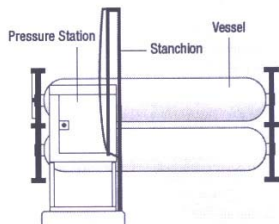


Figure 2 A Typical Tube Container System for Bulk Gas

Tubes

A tube (Figure 2) is a pipe that is tapered at both ends. Each end is then threaded to allow the installation of valves, connections, or relief devices.

Tubes are manufactured according to DOT regulations or they may be made to ASME codes, depending upon whether they are used for transportation or mounted permanently at a site. Tubes are generally mounted on a truck-trailer chassis or railroad car beds, or placed at stationary locations when large amounts of nitrogen are needed.

Valve Connections

The Compressed Gas Association (CGA) recommends three different connections for nitrogen, depending on the pressure of the container. In addition, a high-integrity connection known also as a Diameter Index Safety System (DISS) connection has also been assigned to nitrogen. Cylinders containing nitrogen at pressures up to 3,000 psig use a CGA 580 connection; cylinders

Table 1: Gaseous Nitrogen Physical and Chemical Properties

Chemical Formula	N ₂
Molecular Weight	28.01
Boiling Point @ 1 atm	350.5°F (-195.8°C)
Freezing Point @ 1 atm	-346.0°F (-210°C)
Critical Temperature	-232.5°F (-146.9°C)
Critical Pressure	492.3 psia (33.5 atm)
Density, Liquid @ BP, 1 atm	50.45 lb/scf
Density, Gas @ 68°F (20°C), 1 atm	0.0725 lb/scf
Specific Gravity, Gas (air=1) @ 68°F (20°C), 1 atm	0.967
Specific Gravity, Liquid (water=1) @ 68°F (20°C), 1 atm	0.808
Specific Volume @ 68°F (20°C), 1 atm	13.80 scf/lb
Latent Heat of Vaporization	2,399 Btu/lb mole
Expansion Ratio, Liquid to Gas, BP to 68°F (20°C)	1 to 694

containing pressures between 3,001 and 5,500 psig use a CGA 680 connection; and cylinders containing pressures between 5,501 and 7,500 psig use a CGA 677 connection. The DISS connection assigned to nitrogen is DISS 718.

Pressure-Relief Devices

Nitrogen containers are equipped with pressure-relief devices to protect from overpressurization. Nitrogen cylinders less than 65 inches long use a frangible disk device. Cylinders over 65 inches use a combination device consisting of a frangible disk backed by a fusible alloy. Combination devices require that both the temperature and pressure requirements be reached before the device will relieve. For more information on pressure relief devices, consult APS SafetyAlert-15, "Cylinder Pressure Relief Devices."

Container Stampings

Each cylinder or tube is identified by stampings in the metal of the shoulder. Figure 3 depicts an example of these stampings and what they mean.

Shipment of Gaseous Oxygen

All shipments of compressed nitrogen must comply with DOT regulations. This is true for motor freight, rail, water, and air shipments. The Department of Transportation Regulations, Code of Federal Regulations, Title 49, also describes the labeling and identification required. All packaging used to transport nitrogen must be either "UN/DOT Specification" or "UN/DOT Authorized" and in proper condition for transport.

DOT Shipping Name: Nitrogen, Compressed

DOT Hazard Class: 2.2

DOT Shipping Label: Nonflammable Gas (Figure 4)

Identification Number: UN1066

Safety Considerations

The hazards associated with nitrogen are asphyxiation and the high pressure of the gas in containers and systems.

Buildings

Provide adequate ventilation where nitrogen is being used. Test the atmosphere in confined work areas for oxygen content. A 19.5% oxygen concentration in the air is the minimum recommended for working without special breathing equipment.

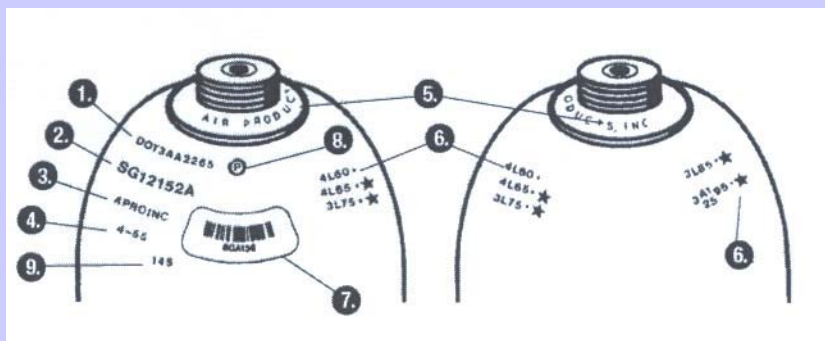
Remember, nitrogen has no warning properties!

Handling and Storage

Cylinders should be stored upright in a well ventilated, dry, cool, secure area that is protected from the weather and preferable fire-resistant. No part of a cylinder should ever be allowed to exceed 125°F (52°C) and areas should be free of combustible materials. Cylinders should be stored away from heavily traveled areas and emergency exits. Avoid areas where salt and other corrosive materials are present.

Do not store full and empty containers together. The valve outlet seal and valve protective cap should be left in place until the cylinder has been secured against a

Figure 3 Key to Cylinder Stampings



1. Cylinder Specification

- DOT-Department of Transportation, which is the regulatory body that governs the use of cylinders
- Specification of the cylinder type or material of construction (e.g., 3AA).
- Service or working pressure in pounds per square inch (e.g., 2,265 psi).

2. Cylinder Serial Number

3. Registered Owner Symbol

- Symbol used to indicate the original owner of the cylinders.
- APROINC is a Registered Owner Symbol

4. Date of Manufacture

- This date (month-year) also indicates the original hydrostatic test.

5. Neck Ring Identification

- The cylinder neck ring displays the name of the current owner of the cylinder.

6. Retest Markings

- The format for a retest marking is: Month-Facility-Year-Plus Rating-Star Stamp
- The + symbol (Plus Rating) indicates that the cylinder qualifies for 10% overfill.
- The ★ symbol (Star Stamp) indicates that the cylinder meets the requirements for 10-year retest.

7. Bar Code Label

- The bar code label provides a unique cylinder identifier and is used by computer systems to track cylinders throughout the fill process.

8. Cylinder Manufacturer's Inspection Marking

9. Cylinder Tare (Empty) Weight

wall or bench, or placed in a cylinder stand and is ready for use. When returning empty cylinders, insure the valve is closed and that some positive pressure remains in the cylinder. Replace any valve outlet and protective caps originally shipped with the container and label the cylinder as "Empty." Never tamper with the safety devices on valves or cylinders.

Never drop, drag, roll, or slide cylinders. Use a specifically designed hand-truck for cylinder movement. Wrenches should never be used to open or close a valve equipped with a hand-wheel. If difficulty is experienced operating the container valve or using the container connections, discontinue use and contact the gas supplier. Use only the proper connections on the container.

DO NOT USE ADAPTERS!

Never attempt to lift a cylinder by its cap. **NEVER** insert an object (e.g., wrench, screw driver, pry bar, etc.) into the opening of the cylinder cap. Doing so may damage or inadvertently open the valve. Use only a specially designed strap-wrench to remove over-tightened or rusted caps. Always open a compressed gas cylinder valve slowly to avoid rapid system pressurization.

Use piping and equipment designed to withstand the maximum pressures encountered. Use a pressure-reducing regulator or separate control valve along with properly designed pressure relief devices to safely discharge gas to working systems.

Use a check valve to prevent reverse gas flow into the containers. Never deliberately over-heat a cylinder to increase the pressure or discharge rate. It is recommended that all vents be piped to the exterior of the building and are in accordance with local regulations.

Refilling or shipping a compressed gas cylinder without consent of the owner is a violation of federal law.



**Figure 4
Nonflammable Gas
Shipping Label**

**Personal Protective
Equipment (PPE)**

Personnel must be trained in the properties and safety considerations before being allowed to handle nitrogen and/or its associated equipment. The use of safety glasses, safety shoes, and leather work gloves is recommended when handling cylinders. In emergency situations, self-

contained breathing apparatus (SCBA) must be worn.

First Aid

Persons suffering from a lack of oxygen should be moved to fresh air. If the victim is not breathing, administer artificial respiration. If breathing is difficult, administer oxygen. Obtain immediate medical attention.

Self-contained breathing apparatus (SCBA) may be required to prevent asphyxiation of rescue personnel.

Fire Fighting

Since nitrogen is nonflammable, special fire fighting equipment and instructions are not needed. However, upon exposure to intense heat or flame, a nitrogen cylinder may vent rapidly and/or rupture violently. Although most cylinders are designed to vent contents when exposed to elevated temperatures, note that pressure in a container can build up due to heat and it may rupture if a pressure relief device should fail to function.

Information Sources

- Compressed Gas Association
1725 Jefferson Davis Highway, Suite 1004
Arlington, VA 22202-4102
Phone: 1-703-412-0900
- National Fire Protection Association
1 Batterymarch Park, P.O. Box 9101
Quincy, MA 02269-9101
Phone: 1-800-344-3555

Emergency Response Telephone Numbers

USA

CHEMTRAC

1-800-424-9300 (Toll Free in the U.S., Canada, and U.S. Virgin Islands)
703-527-3887 for calls originating elsewhere (Collect calls are accepted)

CHEM-TEL, INC.

1-800-255-3924 (Toll Free in the U.S., Canada, and U.S. Virgin Islands)
813-248-0585 for calls originating elsewhere (Collect calls are accepted)

INFOTRAC

1-800-535-5053 (Toll Free in the U.S., Canada, and U.S. Virgin Islands)
352-323-3500 for calls originating elsewhere (Collect calls are accepted)

3E COMPANY

1-800-451-8346 (Toll Free in the U.S., Canada, and U.S. Virgin Islands)
760-602-8703 for calls originating elsewhere (Collect calls are accepted)

NATIONAL RESPONSE CENTER (NRC)

Call NRC (24 Hours)

1-800-424-8802 (Toll Free in the U.S., Canada, and U.S. Virgin Islands)
202-267-2675 in the District of Columbia

MILITARY SHIPMENTS

703-697-0218 Explosives/Ammunition Incidents (Collect calls accepted)
1-800-851-8061 All other dangerous goods incidents

NATIONWIDE POISON CONTROL CENTER (United States Only)

1-800-222-1222 (Toll Free in the U.S.)

CANADA

CANUTEC

613-996-6666 (Collect calls are accepted)
*666 Cellular (In Canada only)

Visit Web Site: www.apsusa.biz for further information

or

Call 410-833-7170

or

Ask your local sales representative