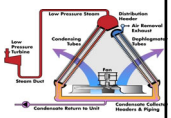
Air Cooled Condenser Users Group

ACCUG Corrosion and Cycle Chemistry Section



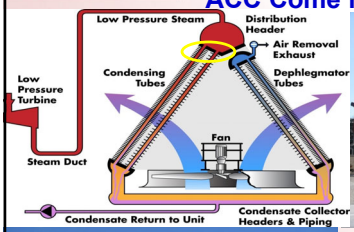
Fossil, Combined Cycle/HRSG and Industrial Plants Review of History over Last 15 Years

Barry Dooley

ACCUG 2023
20th and 21st June 2023
Richmond, Virginia, USA

1

ACC Come in Many Sizes



But the FAC / Corrosion damage is the same worldwide with all chemistries and plant types (Based on assessment/inspection work conducted in Australia, Canada, Chile, China, Cote d'Ivoire, Dubai, India, Ireland, Mexico, Qatar, Abu Dhabi, South Africa, Trinidad, UK and US)

2

Corrosion/FAC in ACC has Serious Consequences

- High concentrations of iron around the cycle
  - Boiler/HRSG deposits (expensive chemical cleaning)
  - Boiler/HRSG Tube Failures (overheating and UDC / HD*)
  - Steam Turbine Deposits (including aluminum)
- Need for Iron Removal Processes
  - Condensate Polishing and/or Filters
- Limitations around the cycle
  - Condensate polishing (may have to change mode to AFO*)
- Overall an ACC "controls" the unit cycle chemistry
  - International Guidelines now available for ACC and two-phase flow (IAPWS Volatile and FFS Guidance)

* UDC / HD – Under-deposit corrosion / hydrogen damage.
* AFO – Ammonium form operation

3

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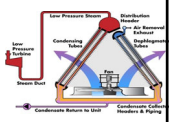
Discussion Items for ACCUG 2023



Reminder of ACC Damage & How Normally Addressed
DHACI provides uniformity for Inspections Worldwide
The Recent Introduction of Film Forming Substances (FFS)
International Experience & Missing Information

June 2023

4

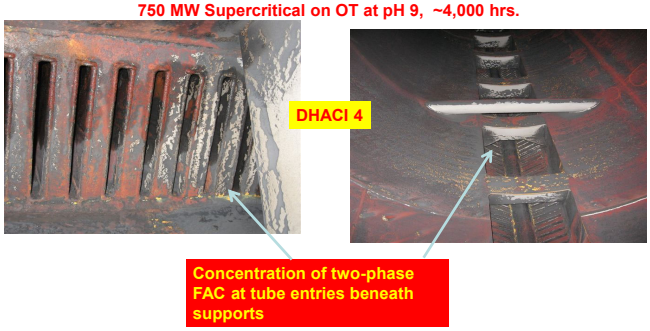
Inspections Worldwide show the same Features

Combined Cycle with ACC after ~ 15,000 hrs, pH 9.1.

5

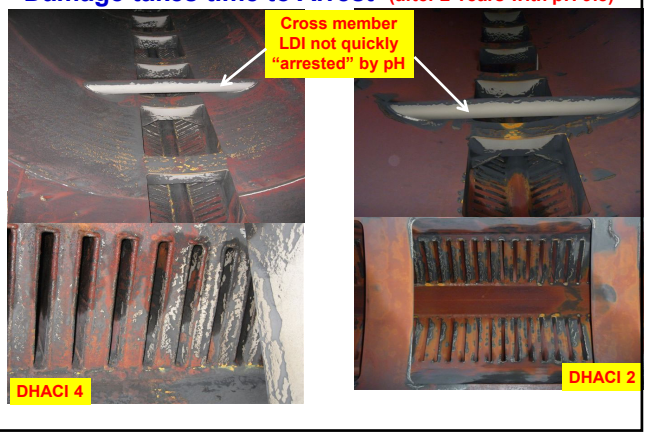
Inspections Worldwide show the same Features

750 MW Supercritical on OT at pH 9, ~4,000 hrs.



6

Damage takes time to Arrest (after 2 Years with pH 9.8)



7

Damage takes time to arrest (15 Months with pH 9.8)

8

August 2011 Outage (2 Years with pH 9.8)

Source: Richardson and Joy, ACCUG 2011

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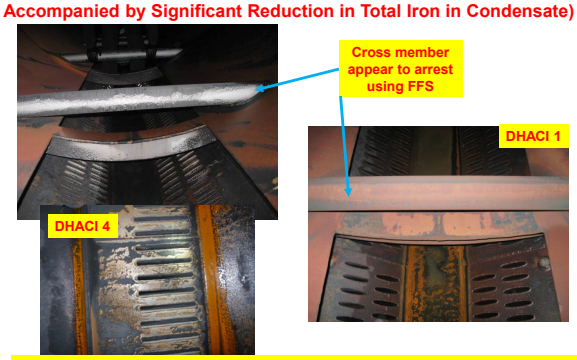
ACC Two-phase FAC can be "Arrested" with FFS

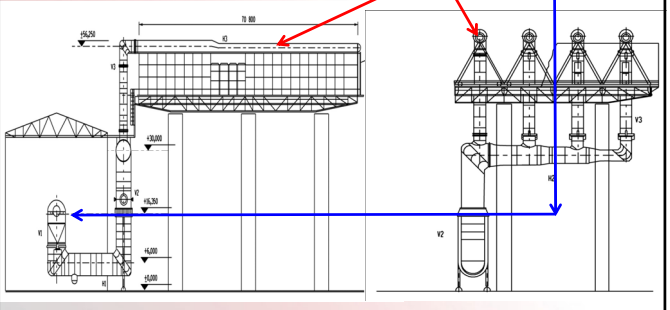
(Significant Reduction in DHACI for FAC at Tube Entries in ACC Accompanied by Significant Reduction in Total Iron in Condensate)



For ACC the FAC / Corrosion damage is the same worldwide with all chemistries and plant types (Based on assessment / inspection work conducted in Australia, Canada, Chile, China, Cote d'Ivoire, Dubai, India, Ireland, Mexico, Qatar, Abu Dhabi, UAE, South Africa, Trinidad, UK and US)

10

To Understand the Corrosion here we need to Understand the Environment in the PTZ



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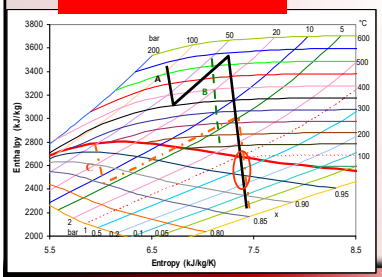
The PTZ Environment in the LP Steam Turbine is Completely Understood

Mollier Diagram
A.Fossil Reheat Turbine
B. Backpressure Turbine
C. Reheat Turbine in a nuclear LWR plant



Generation of the ACC Environment

Heterogeneous droplet Nucleation and Liquid Films on ST Blades

(Droplets and Liquid Films in the ACC vary from 0.1 – 50 microns and don't contain any oxygen until during shutdown)

Source: IAPWS Technical Guidance Document on Steam Purity

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Moisture Nucleation/Early Condensate

- Nucleation around ions and oxides
  - Seeds 10^5 -10^{13}/kg
- Concentration ratios up to 100x
  - Increases with decreasing moisture
- Effect of plant cycle chemistry
  - AVT and PT > OT
  - << 5ppb O_2 in the moisture
- Droplets are charged

Adapted from Dooley and Rieger, 2001

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Liquid Films on Turbine Surfaces

- Range up to 100 - 120 µm
  - Very variable profile on surfaces
  - Dependent on chemistry
  - OT < AVT and PT
- Concentration factors 10x > Droplets
- < 5ppb O_2 in LF
- LF are charged

Adapted from Dooley and Rieger, 2001

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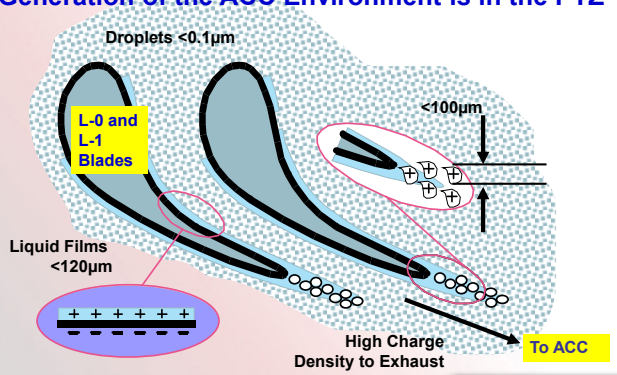
Generation of the ACC Environment is in the PTZ



Adapted from Dooley and Dooley and Rieger, 2001

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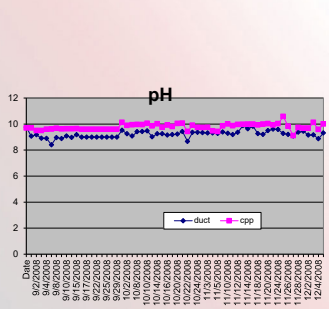
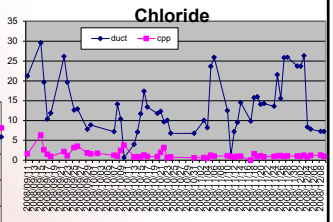
The Liquid in ACC Upper Ducts

(Lower pH and higher chlorides)





Validated and Courtesy: Setsweke Phala, Eskom

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There is an ACC Corrosion Index to Categorize Corrosion and Track Improvments

DHACI

(Dooley, Howell, Air-cooled Condenser, Corrosion Index)

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DHACI for Tube Inlets

1. Tube entries in relatively good shape (maybe some dark deposited areas)
2. Various black/grey deposits on tube entries as well as flash rust areas, but no white bare metal areas
3. Few white bare metal areas on a number of tube entries. Some black areas of deposit
4. Serious white bare metal areas on/at numerous tube entries. Lots of black areas of deposition adjacent to white areas
5. Most serious. Holes in the tubing or welding. Obvious corrosion on many tube entries

Examples included on previous slides

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DHACI for Steam Transport Ducts

A. Ducting shows no general signs of two-phase damage
B. Minor white areas on generally grey ducting. Maybe some tiger striping with darker grey/black areas of two-phase damage
C. Serious white bare metal areas in the hot box and at numerous changes of direction (eg. at intersections of exhaust ducting to vertical riser). White areas are obvious regions of lost metal.

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Air Cooled Condenser Users Group

http://acc-usersgroup.org/

ACC.01

Original Issue: May 12, 2015

Revision due: May 12, 2018

Guideline for Internal Inspection of Air-Cooled Condensers

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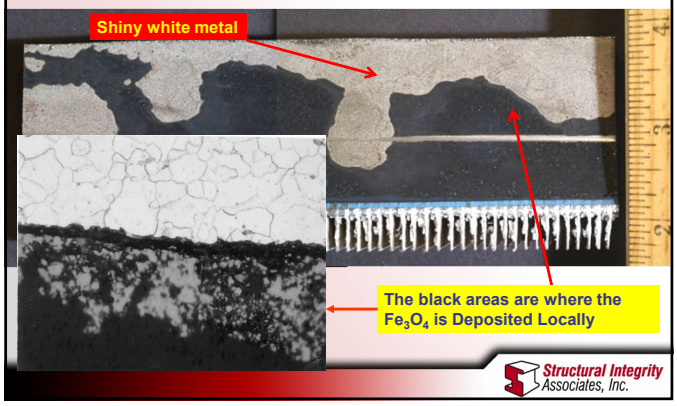
Inside diameter surface of an ACC Tube



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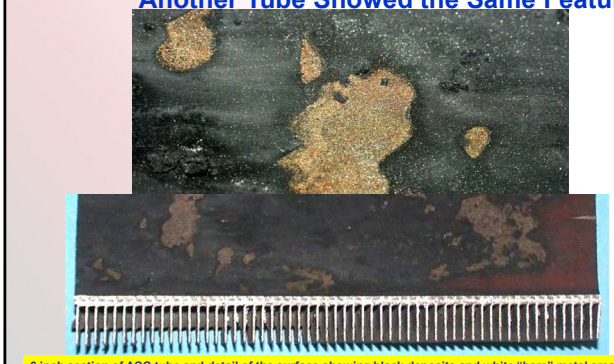
Another Tube Showed the Same Features



6 inch section of ACC tube and detail of the surface showing black deposits and white "bare" metal areas. Note some Fe_3O_4 has turned red

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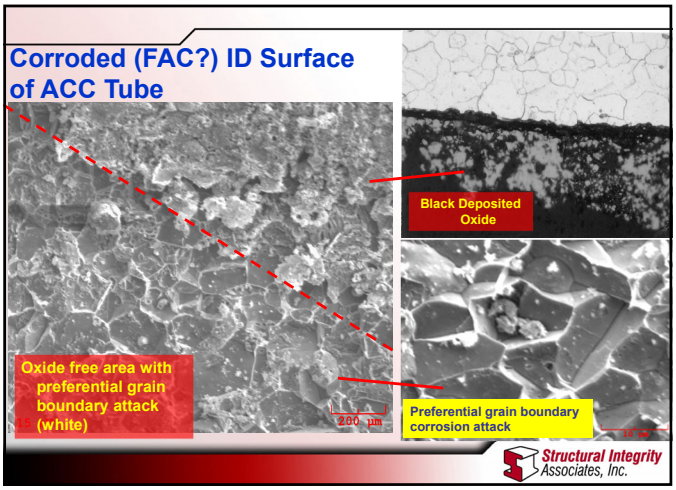
Corroded (FAC?) ID Surface of ACC Tube



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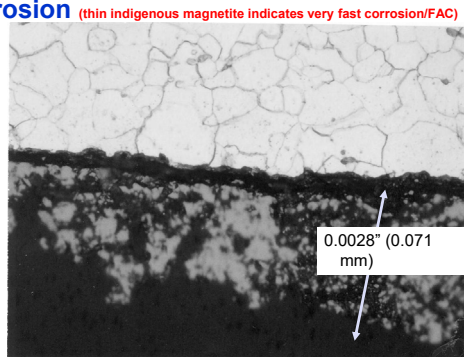
ID black deposit in area with little corrosion (thin indigenous magnetite indicates very fast corrosion/FAC)



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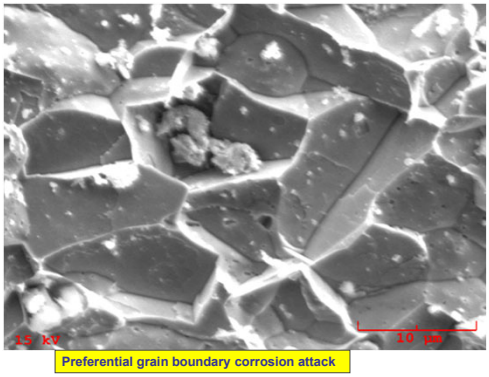
SEM Image of Corroded ID Surface



Preferential grain boundary corrosion attack

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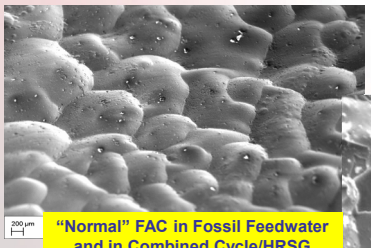
Typical Microscopic Appearance of FAC and ACC Corrosion



"Normal" FAC in Fossil Feedwater and in Combined Cycle/HRSG Circuits

"FAC" Damage in ACCs (white areas)

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Achievable Total Fe & Cu Levels – Different Plant Types/Optimized Chemistry

Feedwater		
OT:	Total Fe =	< 1 µg/kg
AVT:	Total Fe =	< 2 µg/kg
AVT (Mixed):	Total Fe & Cu =	< 2 µg/kg
HP/LP Heater Drains:	Total Fe & Cu =	< 1 µg/kg
HRSG Evaporators/Fossil Drums		
AVT/PT/CT:	Total Fe =	< 5 µg/kg
Air-Cooled Condenser (ACC)		
ACC Outlet:	Total Fe =	< 10 µg/kg
Post Condensate Filter:	Total Fe =	< 5 µg/kg
Cogeneration Plants		
Condensate Return:	Total Fe =	< 10 µg/kg

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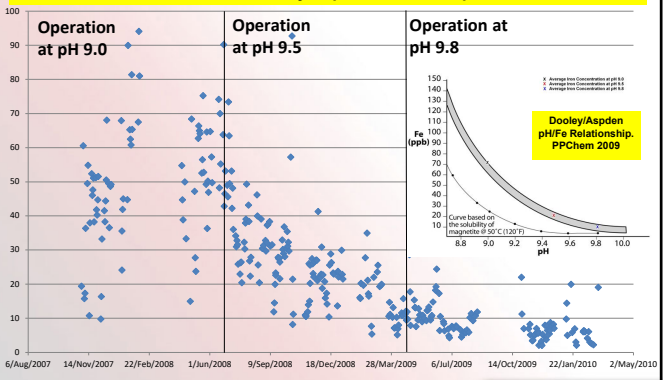
Plant Improvements in ACCs (reduction of total iron) are Directly in Agreement with the Dooley/Aspden relationship



Dooley/Aspden pH/Fe Relationship. PPChem 2009

Source: Richardson and Joy, ACCUG 2011

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Some Final Thoughts on "corrosion" in ACC

(Based on work conducted in Australia, Canada, Chile, China, Cote d'Ivoire, Dubai, India, Ireland, Mexico, Qatar, Abu Dhabi, South Africa, Trinidad, UK and US)

Increasing condensate pH to 9.8 will gradually eliminate the FAC damage at the tube entries and iron levels will reduce to international suggested levels (5 - 10 ppb). Documented by a reducing DHACI. FFS will also work but not sufficient detailed documentation before and after application and currently no understanding of/for improvement using the wide range of FFS.

Damage on cross members is not "arrested" as quickly by increasing pH. Is this LDI caused by the larger droplets leaving the PTZ of the LP Steam Turbine? Depth of damage into ACC tube?

FFS appears to arrest FAC/Corrosion in the two-phase environments of an ACC.

Much care is required when using FFS for possible problems in remainder of plant (boiler/HRSG tube failures, deposits, drums, valves, etc). Problems observed in the wide range of FFS supplied (FFA and FFP).

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Summary

- **Some aspects relate to (LT Two-phase) FAC**
  - Adjacent black and white areas in severe turbulent areas
  - Increasing local pH reduces damage
- **But some aspects don't (normal FAC scalloped appearance and white areas on cross members is probably LDI)**
- **Environment is known and has been measured**
  - Two-phase mixture formed in PTZ of the steam turbine
  - Concentrating liquids **(Higher in chloride/sulphate, organics)**
  - Lower in pH (0.5) and very low in dissolved oxygen (close to zero)
- **"Arrested" two-phase FAC areas turn red slowly**
  - ACC Mechanism is thus not totally understood & what are amines/FFS doing?
- **Results from a number of plants indicate increased Al levels in turbine and drum deposits**
  - This may result from initial operation

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International Association for the Properties of Water and Steam

IAPWS
Technical Guidance Documents for Fossil and Combined Cycle Plants

(with particular relevance for plants with ACC)

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IAPWS Technical Guidance Documents for Plants with ACC

- **Procedures for the Measurement of Carryover of Boiler Water and Steam (September 2008).** This document includes the procedures to measure carryover from drum boilers to assist in preventing steam turbine failure/damage. TGD1-08
- **Instrumentation for monitoring and control of cycle chemistry for the steam-water circuits of fossil-fired and combined-cycle power plants (September 2015).** This document includes a table that can be used to determine the minimum key level of instrumentation required for any fossil or combined cycle/HRSG plant. Also addresses fast and/or frequently started units. TGD2-09(2015)
- **Volatile treatments for the steam-water circuits of fossil and combined cycle / HRSG power plants (July 2015).** This document includes the basis for AVT and OT for all plants with customization for plants with ACC and using ammonia and amines. Recently added guidance for fast and/or frequently start TGD3-10(2015)

Freely available and downloadable on IAPWS website www.IAPWS.org

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IAPWS Technical Guidance Documents for Plants with ACC

- **Phosphate and NaOH treatments for the steam-water circuits of fossil and combined cycle / HRSG power plants (Oct 2015).** This document includes the basis for selecting the optimum boiler/HRSG evaporator water treatment for (phosphate and NaOH treatments) for all plants with TGD4-11(2015)
- **Steam Purity for Turbine Operation (Sept 2013).** This document covers guidance for a wide range of turbines (fossil, nuclear, industrial, geothermal, etc) and failure mechanisms. It includes customizations for plants using amines and with carbon dioxide. TGD5-13
- **Corrosion Product Sampling and Analysis (May 2014).** This document covers the optimum procedures and techniques for monitoring iron and copper. Includes a table of achievable iron levels for plants including those with ACC. TGD6-13(2014)

Freely available and downloadable on IAPWS website www.IAPWS.org

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IAPWS Technical Guidance Documents for Plants with ACC

- **HRSG HP Evaporator Sampling for Internal Deposit Identification (Sept 2016).** This document includes the locations where to take samples from HGP and VGP HRSGs, how to analyze the samples, and an IAPWS map to assist in determining whether the HRSG HP evaporator needs to be chemically cleaned. TGD7-16
- **Application of FFS in Fossil, Combined Cycle and Biomass Plants (Revision October 2019).** This document covers optimum application guidance for FFA / FFAP / FFP in all-ferrous plants. It also includes customizations for shutdown / layup, multiple pressures, mixed-metallurgy feedwater systems, condensate polishing, and units with ACC. TGD8-16(2019)
- **Air In-leakage (Sept 2018).** This document covers guidance for the monitoring and control of AIL for a wide range of fossil, biomass, nuclear, and industrial plants including those with ACC. The major performance and cycle chemistry aspects are included. TGD9-18

Freely available and downloadable on IAPWS website www.IAPWS.org

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IAPWS Technical Guidance Documents for Plants with ACC

- **Application of FFS in Industrial Steam Generators (October 2019).** This document covers optimum application guidance for FFA / FFAP / FFP in industrial plants. It also includes customizations for shutdown / layup, multiple pressures, mixed-metallurgy and aluminum feedwater systems, condensate polishing, units with ACC, special boiler types and with poor makeup. TGD11-19
- **Chemistry Management in Generator Water Cooling (October 2019).** This document covers guidance for all generators with water-cooled windings. The high - and low - oxygen chemistries for operation and shutdown are included. TGD10-19

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Resources for all areas of water and steam

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