

ÍNDICE

I.- AUTHOR'S EXPERIENCES – ENG. ALBERTO MTZ LLAURADO	26
II.- ACKNOWLEDGMENT.....	26
III.- PROLOGUE	27
IV.- OBJECTIVES AND GOALS IN RELIABILITY FOR CENTRIFUGAL COMPRESSORS.....	32
V.- INTRODUCTION.....	34
 PART 1.....	 35
 SECTION 1.- COMPRESSORS, CLASSIFICATION, TYPES IN OIL & GAS & PETROCHEMICAL INDUSTRY, INDUSTRIAL APPLICATIONS.....	 35
 VI.- COMPRESSORS — CLASSIFICATION.....	 35
A.- DESIGN CLASSES.....	35
B.- CLASSIFICATION BY EQUIPMENT TYPE.....	37
C.- CLASSIFICATION OF COMPRESSOR APPARATUSES BY OPERATION PRINCIPLES.....	37
D.- CLASSIFICATION OF COMPRESSOR MACHINES BY OPERATION PRINCIPLES.....	39
E.- DESIGN CLASSES OF COMPRESSOR MACHINES.....	40
F.- DESIGN CLASSES OF POSITIVE DISPLACEMENT COMPRESSORS.....	43
1.- General.....	43
2.- Design classes of single-rotor compressors.....	44
3.- Design classes of double-rotor compressors.....	46
4.- Design classes of reciprocating compressors.....	50
4.1 General.....	50
4.2 Design classes of crankshaft-driven piston compressors.....	54
g.- Basic functional classes of compressor machines.....	55
h.- Formation principles of derivative functional classes for compressor machines.....	58
i.- Functional classes of compressor apparatuses.....	61
j.- Design classes of the aggregated compressor equipment, terms, and definitions.....	62
k.- Design classes of geared mechanical compressors.....	64
l.- Design classes of driver-compressors.....	65
m.- Design classes of geared driver-compressors.....	71
n.- Design and service-duty classes of compressor plants.....	73
n.1 Cooling classes.....	73
n.2.- Lubrication classes.....	74
n.3.- Service-pressure classes.....	74
o.- Design classes of packaged compressor plant.....	76
o.1 Mobility classes.....	76
p.- Compressor-number classes.....	77
q.- Enclosure-type classes.....	78
 VII.- TYPES OF COMPRESSORS IN THE OIL, GAS, AND PETROCHEMICAL INDUSTRY	 79
 VIII.- INDUSTRIAL APPLICATION OF CENTRIFUGAL COMPRESSORS	 86
1.- REFORMER.....	86
2.- CRACKED.....	87
3.- PRODUCTION OF LUBRICANTS.....	87
4.- PRODUCTION OF BITUMEN AND ASPHALT.....	87
5.- AMMONIA SYNTHESIS PLANTS	87
6.- NATURAL GAS COMPRESSORS.....	88

7.- AIR COMPRESSORS	88
8.- SYNTHESIS COMPRESSORS	88
9.- REFRIGERATION COMPRESSORS	89
10.- METHANOL SYNTHESIS PLANTS	89
11.- UREA SYNTHESIS PLANTS	89
12.- NATURAL GAS SERVICE	90
13.- GAS REINJECTION	90
15.- LIQUEFACTION AND REGASIFICATION	91
16.- OXYGEN SERVICE IN METALLURGICAL PLANTS	91
IX.- APPLICATION CONSIDERATIONS RELATED TO CENTRIFUGAL COMPRESSORS.....	93
1.- APPLICATIONS AND INDUSTRY SECTORS.....	93
2.- AIR SEPARATION PLANTS AND COMPRESSORS FOR INSTRUMENT AND PLANT AIR SERVICES.....	94
3 . - NATURAL GAS PROCESSING INDUSTRY.....	96
4 . - OFFSHORE INDUSTRY.....	98
5 . - REFINING INDUSTRY.....	99
6 . - PETROCHEMICALS AND FERTILIZERS.....	100
7.- STEEL INDUSTRY.....	101
8.- SPECIAL APPLICATIONS.....	102
8.1.- COMPRESSOR REVAMPS.....	102
X.- CENTRIFUGAL COMPRESSORS TYPICALLY FOUND IN PETROLEUM REFINING AND OTHER PETROCHEMICAL PROCESSES.....	103
Examining 1 st case.....	103
Examining Tables X-2 and X-3.....	106
SECTION 2.- CENTRIFUGAL COMPRESSORS, EVOLUTION, DESIGN, SPECIFICATIONS...112	
XI.- CENTRIFUGAL COMPRESSOR EVOLUTION	112
By: James M. Sorokes & Mark J. Kuzdzal	112
1.- INTRODUCTION	112
2.- ROTORDYNAMICS	113
3.- LOOKING FORWARD	120
4.- CLOSING REMARKS	121
5.- NOMENCLATURE.....	122
XII.- DESIGN SPECIFICATIONS, ACCESSORIES.....	123
SECTION 3.- RELIABILITY ASSURANCE, FEASIBILITY, FEED VALIDATIONS ATTRIBUTES, IMPROVING RELIABILITY IN CENTRIFUGAL COMPRESSORS.....	125
XII.A.- ROTATING EQUIPMENT RELIABILITY ASSURANCE.....	125
1.- INTRODUCTION.....	125
2.- THE PRE-FEED PHASE.....	127
4.- REFRIGERATION COMPRESSOR CASE HISTORY.....	128
5.- THE SPECIFICATION AND ITB (INVITATION TO BID) PHASE.....	128
6.- ITB GUIDELINES.....	129
7.- PRE-BID ACTIVITY AND DEGREE OF AUDITS.....	130
8.- DESIGN AND/OR MANUFACTURING AUDIT REQUIREMENTS IN THE PRE-BID PHASE.....	130
9.- BID EVALUATIONS.....	131
10.- PRE-AWARD MEETING.....	132

10.1.- The pre-award meeting agenda.....	132
11.- THE COORDINATION MEETING.....	132
11.1.- VCM agenda - key facts.....	133
11.2.- VCM agenda checklist.....	133
12.- DESIGN AND MANUFACTURING AUDITS.....	133
12.1.- Vendor audit requirements.....	133
12.2.- Manufacturing audit guidelines.....	133
12.3.- Design audit summary and follow-up action.....	134
13.- DOCUMENT REVIEW.....	134
13.1.- Effective document review considerations.....	134
14.- TESTING PHASE.....	134
14.1.- The shop test is an opportunity to.....	134
14.2.- Shop test agenda review - key facts.....	135
15.1.- Pre-test meeting - key facts.....	135
16.- MECHANICAL TEST - KEY FACTS.....	136
17.- AUXILIARY SYSTEM TEST - KEY FACTS.....	136
18.- COMPRESSOR PERFORMANCE TEST - KEY FACTS.....	136
19.- POST-TEST - KEY FACTS.....	136
20.- REJECTED TEST ACTION.....	136
21.- TEST REPORT - KEY FACTS.....	137
22.- APPENDIX.....	137
22.1- Suggested vendor pre-bid meeting details letter.....	137
22.2.- Pre-bid procedure fact summary.....	137
22.3.- Typical compressor train pre-bid meeting agenda.....	138
XIII.- FEASIBILITY, CONCEPT DESIGN, AND FEED VALIDATIONS ATTRIBUTES FOR CENTRIFUGAL COMPRESSORS.....	143
1 GENERAL.....	143
2 AERODYNAMIC/HYDRODYNAMIC PERFORMANCE ATTRIBUTES.....	143
3 CASING DESIGN ATTRIBUTES.....	143
4 MATERIAL DESIGN ATTRIBUTES.....	143
5 SEAL DESIGN ATTRIBUTES.....	144
6 ROTOR DYNAMICS ATTRIBUTES.....	144
7 IMPELLER/BLADE DESIGN ATTRIBUTES.....	144
XIV.- IMPROVING DESIGN RELIABILITY: EIGHT PRINCIPLES.....	145
1. REDUCE STATIC LOADINGS.....	145
2. REDUCE DYNAMIC LOADINGS.....	145
3. REDUCE CYCLIC EFFECTS.....	145
4. REDUCE OPERATING TEMPERATURES.....	145
5. REMOVE STRESS-RAISERS.....	145
6. REDUCE FRICTION.....	146
7. DESIGN FOR ACCURATE ASSEMBLY.....	146
8. ISOLATE CORROSIVE AND EROSION EFFECTS.....	146
DESIGN FOR RELIABILITY – A NEW APPROACH.....	146
THE TECHNIQUE.....	146
SECTION 4.- MEASURING RELIABILITY, MAINTAINABILITY, MEANING OF BENCHMARKING.....	148

XV.- MEASURING AND DESIGNING FOR RELIABILITY AND MAINTAINABILITY.....	148
1.- INTRODUCTION.....	148
2.- WHAT IS AND WHY RELIABILITY?.....	148
3.- WHY IS RELIABILITY IMPORTANT?.....	149
4.- AVAILABILITY.....	150
5.- THE BATHTUB CURVE AND RELIABILITY DISTRIBUTION.....	150
6.- RELIABILITY APPROACH IN DESIGN.....	151
7.- RELIABILITY ANALYSIS.....	151
8.- MAINTAINABILITY ANALYSIS.....	151
9.- SYSTEM SAFETY AND HAZARD ANALYSIS.....	151
10.- HUMAN FACTORS ENGINEERING ANALYSIS.....	151
11.- LOGISTICS ANALYSIS.....	151
12.- DESIGN REVIEWS CHECKLIST.....	152
13.- SUMMARY.....	152
XVI.- THE MEANING OF BENCHMARKING AND BENCHMARKS.....	154
1.- WHAT IS BENCHMARKING?.....	154
2.- SUMMARY.....	155
SECTION 5.- COLLECTION & EXCHANGE OF DATA ABOUT RELIABILITY MAINTAINABILITY FOR CENTRIFUGAL COMPRESSORS.....	157
XVII.- COLLECTION AND EXCHANGE OF RELIABILITY AND MAINTENANCE DATA FOR EQUIPMENT.....	157
1.- INTRODUCTION.....	157
1.1.- ABBREVIATED TERMS.....	158
2.- APPLICATION.....	158
2.1.- Equipment coverage.....	158
2.2.- Benefits of RM data collection and exchange.....	159
3.- EQUIPMENT BOUNDARY, TAXONOMY, AND TIME DEFINITIONS.....	160
3.1.- Boundary description.....	160
3.2.- Taxonomy.....	160
3.3.- Timeline issues.....	163
a.- Surveillance and operating period.....	163
b.- Data collection periods.....	163
c.- Maintenance times.....	164
4.- RECOMMENDED DATA FOR EQUIPMENT, FAILURES, AND MAINTENANCE.....	164
4.1.- Data categories.....	164
a) Equipment unit data (inventory data).....	164
b) Failure data.....	165
c) Maintenance data.....	165
4.2.- Failure data.....	165
4.3.- Maintenance data.....	166
a.- General.....	166
b.- Maintenance categories.....	166
c.- Reporting maintenance data.....	167
c.1.- Corrective maintenance.....	167
c.2.- Preventive maintenance.....	167
c.3.- Preventive maintenance program.....	167
ANNEX XVII-A.....	169

1.- EQUIPMENT-CLASS ATTRIBUTES.....	169
1.1.- General.....	169
1.2.- Boundary definitions.....	169
1.3.- Rotating equipment data.....	170
1.4.- Equipment boundary definition for compressors.....	170
ANNEX XVII-B.....	172
1.- INTERPRETATION AND NOTATION OF FAILURE AND MAINTENANCE PARAMETERS.....	172
B.1 Failure interpretation.....	172
B.2 Failure and maintenance data notations.....	173
B.2.1 General.....	173
B.2.2 Failure mechanism.....	173
B.2.3 Failure cause.....	175
B.2.4 Detection method.....	176
Table XVII-B.4 — Detection method.....	176
B.2.5 Maintenance activity.....	176
B.2.6 Failure modes.....	178
ANNEX XVII-C.....	181
1.- GUIDE TO INTERPRETATION AND CALCULATION OF DERIVED RELIABILITY AND MAINTENANCE PARAMETERS.....	181
C.1 Interpretation rules for commonly used failure and maintenance parameters.....	181
C.1.1 Introduction.....	181
C.1.2 Redundancy definitions.....	181
C.1.3 On-demand data.....	181
C.1.4 Independent failures.....	181
C.1.5 Dependent failures.....	182
C.1.6 Common-cause failure (CCF).....	182
C.1.7 Common-mode failure.....	182
C.1.8 Trip definitions.....	182
C.1.9 Failure consequence classification.....	183
C.1.10 Analysis of failures.....	183
C.1.11 Safety critical equipment.....	184
C.2 Availability.....	184
C.2.1 Normalized definition.....	184
C.2.2 Mathematics of availability.....	185
C.3 Failure rate estimation.....	186
C.3.1 General.....	186
C.3.1.1 Mathematics for failure rate and hazard rate estimation.....	186
C.3.1.2 Uses of failure rate and hazard rate estimation.....	187
C.3.2 Maximum likelihood estimator of a constant failure rate.....	187
C.4 Maintainability.....	188
C.4.1 Normalized definitions.....	188
C.4.2 Mathematical meaning.....	189
C.4.2.1 Maintainability concepts.....	189
C.4.2.2 Maintainability performance.....	189
C.4.2.3 Repair rate.....	189
C.4.2.4 Measures and estimates.....	190
C.4.3 Maintainability — Intrinsic and extrinsic factors.....	190
C.5 "Mean time" definitions.....	191
C.5.1 Principle.....	191

C.5.2 Mean downtime (MDT).....	191
C.5.3 Mean time between failures (MTBF).....	191
C.5.3.1 Definition.....	191
C.5.3.2 Mathematics of MTBF.....	191
C.5.3.3 Uses for MTBF.....	191
C.5.4 Mean time to failure (MTTF).....	191
C.5.4.1 Definition.....	192
C.5.4.2 Mathematics of MTTF.....	192
C.5.4.3 Use of MTTF.....	192
C.5.5 Mean time to repair (MTTR).....	192
C.5.5.1 Definition.....	192
C.5.5.2 Mathematics of MTTR.....	192
C.5.5.3 Uses of MTTR.....	192
C.5.6 Mean up time (MUT).....	193
C.6 Testing for hidden failures in safety systems.....	193
C.6.1 General principles.....	193
C.6.3 Mathematics of cost-benefit availability.....	193
ANNEX XVII-D.....	195
1.- TYPICAL REQUIREMENTS FOR DATA.....	195
D.1 General.....	195

SECTION 6.- RISK-BASED MACHINERY ANALYSIS & TOOLS.....196

XVIII.- RISK-BASED MACHINERY MANAGEMENT.....	196
1. INTRODUCTION.....	196
2. SCOPE.....	197
2.1 General.....	197
3. MACHINERY RISK MANAGEMENT.....	198
3.1 General.....	198
3.2 Management System.....	198
3.3 Risk Assessments.....	198
3.4 Risk Mitigation.....	198
3.5 Integration with Other Risk Assessments.....	198
4. ACRONYMS AND ABBREVIATIONS.....	198
5. FRONT-END ENGINEERING DESIGN.....	200
5.1 INTRODUCTION.....	200
5.2 PRELIMINARY MACHINERY RISK ASSESSMENT.....	201
5.2.1 Purpose.....	201
5.2.4 Supplementary Protective Measures.....	202
5.3 RELIABILITY, AVAILABILITY, AND MAINTAINABILITY ANALYSIS.....	202
5.4 MACHINERY DESIGN AND SELECTION.....	203
5.5 PROCESS AND INSTRUMENT DIAGRAM (P&ID) REVIEWS.....	203
5.6 LONG LEAD MACHINERY.....	203
5.7 VENDOR QUALIFICATION.....	204
5.8 OPERATIONS, MAINTENANCE, AND FACILITIES STRATEGIES.....	204
5.9 OPTIONAL FIELD TESTING.....	204
5.9.1 General.....	204
5.9.2 Steam Turbine Solo Run Test.....	205
5.9.3 Motor Solo Run Test.....	205
5.9.4 Centrifugal, Axial, and Screw Compressor Inert Gas Test.....	205
5.9.5 Inert Gas Test.....	205

5.9.6 Field Performance Test on Process Gas.....	205
6. DETAILED DESIGN.....	206
6.1 INTRODUCTION.....	206
7. INSTALLATION AND COMMISSIONING.....	206
7.1 INTRODUCTION.....	206
7.2 INSTALLATION.....	207
7.3 COMMISSIONING, DECOMMISSIONING, AND DECONTAMINATION.....	207
7.3.1 General.....	207
7.3.2 Procedures.....	207
7.3.3 Field Functional Safety Testing.....	208
7.3.4 Process Safety Valves.....	208
7.3.5 Auxiliary Equipment.....	208
7.3.6 Operating and Maintenance Procedures.....	208
7.4 PRE-START-UP SAFETY REVIEW.....	209
7.5 OPTIONAL TESTS.....	209
7.5.1 General.....	209
7.5.2 Solo Run Testing.....	209
7.5.3 Motor Solo Run Testing.....	209
7.5.4 Compressor Air and Inert Gas Testing.....	209
8. OPERATIONS AND MAINTENANCE.....	209
8.1 INTRODUCTION.....	209
8.1.1 General.....	209
8.1.2 Identification of API 691 Machinery.....	209
8.2 FIELD RISK ASSESSMENTS.....	211
8.3 RISK MITIGATION.....	213
8.4 OPERATING COMPANY IMPLEMENTATION.....	214
ANNEX XVIII-A.....	216
A.2.4 ANALYZE MACHINERY RISKS.....	216
A.2.4.1 General.....	216
A.2.4.3 What-if Analysis.....	216
A.2.4.4 Hazard and Operability Analysis.....	216
A.2.4.6 Technical Risk Categorization.....	217
A.2.4.7 Failure Modes and Effects Analysis.....	218
A.2.4.8 Layers of Protection Analysis for Machinery.....	219
A.2.4.9 Reliability, Availability, and Maintainability Analysis.....	220
A.2.4.10 Fault Tree Analysis.....	220
A.2.5 MACHINERY RISK RANKING.....	221
A.2.6 MACHINERY RISK MITIGATION.....	221
ANNEX XVIII-B.....	222
B.- RISK-BASED MACHINERY VALIDATION CHECKLISTS.....	222
B.1 INTRODUCTION.....	222
B.2 FEASIBILITY AND CONCEPT DESIGN AND FEED VALIDATIONS.....	222
B.2.1 General.....	222
B.2.2 Aerodynamic/Hydrodynamic Performance Attributes.....	222
B.2.3 Casing Design Attributes.....	222
B.2.4 Material Design Attributes.....	223
B.2.5 Seal Design Attributes.....	223
B.2.6 Rotor Dynamics Attributes.....	223
B.2.7 Impeller/Blade Design Attributes.....	223

B.3 P&ID REVIEWS DURING FEED.....	223
B.3.1 General.....	223
B.3.6 API 617—Axial and Centrifugal Compressors.....	224
B.4 VENDOR QUALIFICATION DURING FEED AND DETAILED DESIGN.....	224
B.4.1 General.....	224
B.4.6 API 617—Axial and Centrifugal Compressors and Expander Compressors.....	224
B.5 OPERATIONS AND MAINTENANCE MACHINERY CHECKLISTS.....	225
B.5.1 Pre-turnaround Checklists.....	225
B.5.1.1 General.....	225
B.5.1.6 API 617—Centrifugal Compressors and API 619—Screw Compressors.....	225
B.5.2 Machinery Overhauls.....	225
B.5.2.1 General.....	225
B.5.2.5 API 617—Axial and Centrifugal Compressors and Expander Compressors.....	226
B.5.3 Additional Pressure Boundary Inspections for Machinery in Corrosive, Erosive, and Harsh Service.....	226
ANNEX XVIII-C.....	227
C.- MACHINERY FAILURE MODES, MECHANISMS, AND CAUSES.....	227
C.1 INTRODUCTION.....	227
C.2 FAILURE OBSERVATIONS.....	227
C.3 FAILURE MODES.....	228
C.4 FAILURE MECHANISMS.....	229
ANNEX XVIII-E.....	236
E.- GUIDELINE ON CONDITION MONITORING AND DIAGNOSTIC SYSTEMS.....	236
E.1 INTRODUCTION.....	236
E.2 THE BASIC PRINCIPLES OF CONDITION MONITORING.....	236
E.2.3 Required Prerequisites for Condition Monitoring.....	236
E.2.5 Consideration of Operating Context and Environment.....	237
E.2.6 Determination of Subsystems to Assign Condition Monitoring.....	238
E.3.1 General.....	238
E.3.2 Machinery Faults Matched to Condition Monitoring Techniques.....	238
E.5 ADVANCEMENTS IN CONDITION MONITORING.....	240
ANNEX XVIII-F.....	241
F.- GUIDELINE ON MACHINERY PROGNOSTICS.....	241
F.1 INTRODUCTION.....	241
F.1.2 Remaining Useful Life.....	241
F.1.3 Advanced Predictive Systems.....	242
F.1.4 Definition of Prognostics.....	242
F.1.5 The Relationship of Prognostics to Condition-based Maintenance.....	243
F.2 PROGNOSTIC MODELS CLASSIFICATION.....	243
F.2.1 Introduction.....	243
F.2.2 Failure Mode Specific Models.....	244
F.2.3 Type I—Traditional Reliability Analysis.....	244
F.2.4 Type II—Stress Based.....	245
F.2.5 Type III—Condition Based.....	245
F.2.5.1 General.....	245
F.2.5.2 General Path Model.....	246
F.2.5.3 Incorporating Prior Information via Bayesian Methods.....	246
F.2.5.4 Data-driven Prognostic Models.....	246
ANNEX XVIII-I.....	247
I.- API 691 FMEA WORKSHEET.....	247

I.1 INTRODUCTION.....	247
I.2 API 691 FMEA WORKSHEET.....	247
SECTION 7.- OREDA DATA, ANALYSIS, EVALUATION, CONCLUSIONS, AND RECOMMENDATIONS IN CENTRIFUGAL COMPRESSORS	249
XIX.- OREDA (Offshore and Onshore Reliability Data Handbook) STUDIES RELATED TO CENTRIFUGAL COMPRESSORS.....	249
1.- INTRODUCTION.....	249
1.1 THE OREDA PROJECT.....	249
1.2 PROJECT PHASES.....	249
2.- PROJECT MANAGEMENT AND ORGANIZATION.....	250
3.- DESCRIPTION OF OREDA 2015 HANDBOOKS.....	251
4.- FAILURE MODES.....	252
5.-USE OF THE DATA TABLES.....	252
6.- RELIABILITY DATABASE AND DATA ANALYSIS SOFTWARE.....	252
7.- THE PDS HANDBOOK.....	253
b.-Description of the handbook.....	253
c.-Use of the handbook.....	253
8.- RELIABILITY ANALYSIS CENTER/RELIABILITY INFORMATION ANALYSIS CENTER PUBLICATIONS.....	253
a-History.....	253
b-Non-electronic Part Reliability Data handbook.....	253
c-FMD.....	254
d-NONOP.....	254
e-Use of the publications.....	254
9.- OTHER PUBLICATIONS.....	254
-EXIDA HANDBOOKS.....	254
-ELECTRICAL ITEMS.....	254
Reports.....	254
-PIPELINES.....	254
- Conservation of Clean Air and Water in Europe.....	254
- European Gas Pipeline Incident Group.....	255
- United Kingdom Onshore Pipeline Operators' Association.....	255
- PARLOC.....	255
- Pipeline and Hazardous Materials Safety Administration.....	255
-FLEXIBLES.....	255
-MISCELLANEOUS.....	255
-MISSING INFORMATION.....	255
10.- USE OF EXPERT JUDGMENT.....	256
10.1.- INTRODUCTION.....	256
10.2.- BASIS.....	256
10.3.- ROLE OF THE FACILITATOR.....	257
10.4.- CHARACTERISTICS OF THE EXPERTS.....	257
11.- MECHANICAL RELIABILITY.....	259
11.1. CHARACTERISTICS.....	259
11.2. STRESS-STRENGTH INTERFERENCE.....	259
11.3. EMPIRICAL RELIABILITY RELATIONSHIPS.....	260
11.4. COMPARISON WITH SYSTEM (CONSTANT FAILURE RATE) APPROACH.....	260
12.- HUMAN RELIABILITY.....	261

12.1-HUMAN FACTORS.....	261
12.2-HUMAN RELIABILITY IN THE NUCLEAR INDUSTRY.....	261
12.3-EVALUATION OF HRA TECHNIQUES.....	261
12.4-HUMAN RELIABILITY IN THE OIL AND GAS INDUSTRY.....	261
13 PARTICIPANTS.....	262
14 EQUIPMENT CATEGORIES COVERED IN THE DIFFERENT PHASES.....	262
15.- SCOPE OF THE OREDA HANDBOOK.....	264
16.- LIMITATIONS.....	264
17.- COMPRESSORS.....	264
17.1.- INVENTORY DESCRIPTION.....	264
18.- LIST OF FAILURE MODES.....	265
19.- OREDA 2002:.....	266
19.1.- CENTRIFUGAL COMPRESSORS.....	266
20.- OREDA 2015:.....	268
20.1.- CENTRIFUGAL COMPRESSORS.....	268
21.- EVALUATION, ANALYSIS, AND CONCLUSIONS (OREDA).....	269
21.1.- 1st PHASE (1983 – 2000).....	269
21.2.- 2ND PHASE (2000 - 2015).....	274
21.3.- COMBINED STUDY OF THE 2 PHASES FOR THE ANALYSIS AND STUDY REGARDING THE COMPRESSOR FAILURES (PERIOD FROM 1983 TO 2015).....	278
22.- CONCLUSIONS.....	282
23.- RECOMMENDATIONS.....	288
SECTION 8.- FAILURES DATA, PREVENTION, CAUSES OF FAILURES, AND PROBLEMS RELATED TO CENTRIFUGAL COMPRESSORS.....	296
XIX.A.-MORE DATA ABOUT FAILURE STATISTICS FOR CENTRIFUGAL COMPRESSORS.....	296
XXA.- HOW TO PREVENT MACHINERY FAILURES.....	297
1.- INTRODUCTION.....	297
2.- COMPONENT FUNCTION AWARENESS - 'WHAT SHOULD IT DO?'.....	297
3.- COMPONENT CONDITION MONITORING - 'WHAT IS IT DOING?'.....	298
4.- PREVENTIVE (PM) AND PREDICTIVE MAINTENANCE (PDM).....	298
4.1.- Preventive maintenance.....	298
4.2.- Predictive maintenance.....	299
5.- TROUBLESHOOTING.....	299
6.- RELIABILITY, EVERYONE'S RESPONSIBILITY.....	300
7.- OPTIMIZING CCM AND PDM.....	300
(Component condition monitoring and predictive maintenance).....	300
7.1.- Component condition monitoring.....	301
7.2.- Baseline.....	301
7.3.- Trending.....	301
7.4.- The rotor.....	302
7.5.- Radial bearings.....	302
7.6.- Thrust bearings.....	303
8.- PREDICTIVE MAINTENANCE (PDM) TECHNIQUES.....	304
9.- EFFECTIVE PREDICTIVE MAINTENANCE (INCLUDING ROOT CAUSE ANALYSIS TECHNIQUES).....	304
9.1.- INTRODUCTION.....	304
9.2.- WHAT IS TROUBLESHOOTING?.....	304

9.3.- PREDICTIVE MAINTENANCE AND TROUBLESHOOTING.....	305
10.- OBTAINING AND MAINTAINING MANAGEMENT SUPPORT.....	305
11.- OBTAINING ALL THE PERTINENT FACTS.....	305
12.- THOROUGHLY UNDERSTANDING THE EQUIPMENT AND COMPONENT FUNCTIONS.....	306
13.- DEFINING EFFECT CAUSES AND ROOT CAUSES.....	306
14.- THE CONCEPT OF SYSTEM.....	307
15.- TROUBLESHOOTING PROCEDURE OVERVIEW.....	307
16.- ELIMINATING CAUSES BASED ON FACTS.....	308
17.- INITIAL FACT-FINDING.....	308
18.- DEFINING THE AFFECTED COMPONENTS.....	308
19.- OBTAINING ALL IMPORTANT FACTS.....	308
20.- BASELINE CONDITIONS AND TRENDS.....	309
21.- INSPECTION.....	309
22.- THOROUGH KNOWLEDGE OF EQUIPMENT COMPONENTS AND SYSTEM FUNCTIONS....	310
23.- DEFINING ABNORMAL CONDITIONS.....	310
24.- LISTING ALL POSSIBLE CAUSES.....	310
25.- ELIMINATING CAUSES NOT RELATED TO THE PROBLEM.....	311
26.- DEVELOP AN ACTION PLAN TO ELIMINATE THE ROOT CAUSE.....	311
27.- PREPARING A SITE RELIABILITY OPTIMIZATION PLAN.....	311
27.1.- INTRODUCTION.....	311
27.2.- IDENTIFYING OPPORTUNITIES FOR OPTIMIZATION.....	312
27.3.- DETERMINE THE ROOT CAUSE OF EACH IDENTIFIED OPPORTUNITY.....	314
27.4.- ESTABLISH STEPS TO PREVENT THE RE-OCCURRENCE OF PROBLEMS.....	316
27.5.- OPTIMIZING PM BASED ON PDM RESULTS.....	317
27.6.- SETTING UP AN EFFECTIVE MULTI-DISCIPLINED SITE RELIABILITY INITIATIVE.....	318
27.7.- OBTAIN AND MAINTAIN MANAGEMENT SUPPORT.....	319
27.8.- HOW TO MAINTAIN CONTINUOUS IMPROVEMENT OF THE ESTABLISHED PROGRAM.....	319
27.9.- THE PERCENTAGE OF PROPOSED ACTION PLAN IMPLEMENTATION APPROACHES 100%.....	320
27.10.- APPROVAL FOR PROCUREMENT OF ADDITIONAL 'RELIABILITY TOOLS'.....	320
27.11.- APPROVAL FOR SITE-SPECIFIC AWARENESS TRAINING OF ALL GROUPS.....	320
27.12.- APPROVAL FOR YEARLY VENDOR CONTINUOUS IMPROVEMENT MEETINGS.....	320
27.13.- APPROVAL FOR ATTENDANCE AT INDUSTRY SEMINARS.....	321
27.14.- APPROVAL FOR PARTICIPATION IN USER GROUPS.....	321
27.15.- APPROVAL FOR INDEPENDENT AUDITS PERFORMED FOR DIFFICULT RELIABILITY ISSUES..	321
27.16.- TURNAROUND ACTIVITIES.....	325
27.17.- CRITICAL EQUIPMENT FORCED OUTAGES.....	326
27.18.- PLEASE LIST THE FIELD MONITORING PERFORMED BY OPERATIONS AND NOTE IF IT IS MRC (CONTROL ROOM) AND/OR LOCAL.....	326
27.19.- ROTATING EQUIPMENT CONTINUOUS IMPROVEMENT STUDY OPERATIONS ENGINEERING AND OPERATIONS INPUT DATA QUESTIONNAIRE.....	326
28.- EXAMPLE OF MANAGEMENT AWARENESS OF WORKSHOP AGENDA.....	330
XX.B.- THE MAJOR CAUSES OF MACHINERY FAILURE.....	331
1. ROTATING EQUIPMENT DOES NOT FAIL RANDOMLY.....	331
2. THE MAJOR CAUSES OF MACHINERY FAILURE - FAILURE CLASSIFICATIONS.....	331
3. IMPROPER ASSEMBLY MAINTENANCE/INSTALLATION.....	332
4. IMPROPER OPERATING PROCEDURES.....	332
5. DESIGN PROBLEMS.....	333
5.1.- Design problem determination and action plan.....	333

6. COMPONENT WEAR-OUT.....	334
XX.C.- CENTRIFUGAL COMPRESSOR PROBLEMS.....	334
1.- COMPRESSOR FOULING	334
1.1.- TECHNIQUES TO PREVENT FOULING.....	335
- PROCESS GAS COMPRESSORS.....	335
1.2.- ONLINE SOLVENT INJECTION	336
1.3.- AIR COMPRESSORS.....	336
1.3.1.- inlet filter	336
1.3.2.- online compressor water wash.....	336
1.4.- COMPRESSOR BLADE COATING.....	337
2.- COMPRESSOR FAILURES.....	338
2.1.- BARREL-TYPE COMPRESSORS	338
3.- BEARING BRACKET ALIGNMENT.....	339
4.- MATERIAL PROBLEMS.....	340
5.- COMPRESSORS IN GENERAL.....	340
5.1.- ROTOR THRUST CALCULATIONS.....	340
5.2.- THRUST COLLAR DESIGNS	341
5.3.- BEARING MAINTENANCE	342
5.4.- CLEARANCE CHECKS	342
5.5.- THRUST BEARING MAINTENANCE.....	343
5.6.- THRUST-BEARING FAILURE.....	344
5.7.- FAILURE INITIATION.....	344
5.8.- FLUID SLUGGING	344
5.9.- BUILDUP OF SOLIDS IN ROTOR AND/OR STATOR PASSAGES ("PLUGGING" OF TURBINE BLADES)	344
5.10.- OFF-DESIGN OPERATION	344
5.11.- COMPRESSOR SURGING	344
5.12.- GEAR COUPLING THRUST	344
5.13.- DIRT IN OIL	345
5.14.- MOMENTARY LOSS OF OIL PRESSURE	345
5.15.- FAILURE PROTECTION.....	345
5.16.- IMPELLER PROBLEMS.....	346
5.17.- COMPRESSOR SEALS.....	347
5.18.- RADIAL CLEARANCES	348
5.19.- QUALITY CONTROL	348
5.20.- AXIAL CLEARANCES	348
5.21.- SEAL DESIGN	348
5.22.- TRAINING FOR SEAL MAINTENANCE	348
5.23.- RULES OF THUMB.....	348
There are a few rules of thumb that help in understanding seal operation and maintenance:.....	348
5.24.- ROTOR REPAIRS.....	348
5.24.1.- REPAIRS IN FACTORIES.....	348
5.24.2.- REPAIRS IN LOCAL SHOPS	349
5.24.3.- REPAIRS IN USER'S SHOPS.....	349
5.25.- REBLADING	349
5.26.- COMPRESSOR RERATING.....	349
5.27.- CHANGES IN INLET PRESSURE OR TEMPERATURE.....	349
5.28.- INCREASE OR DECREASE IN THE HEAD DELIVERED.....	350
5.29.- INCREASE OR DECREASE IN FLOW DELIVERED.....	351

5.31.- REPAIR AND REHABILITATION OF TURBOMACHINERY FOUNDATIONS.....	354
5.32.- INSTALLATION DEFECTS.....	354
5.33.- INCREASING MASS AND RIGIDITY.....	356
5.34.- GEARS AND GEARBOXES.....	356
6.- SYNCHRONOUS AND HARMONIC SPECTRA.....	359
6.1.- ALIGNMENT PROBLEMS	359
6.2.- GEAR NOISE	359

SECTION 9.- CONTINUED RELIABILITY, ROLE & IMPORTANCE IN RELIABILITY AND AUDITING ABOUT CENTRIFUGAL COMPRESSORS.....

XXI.-MAINTENANCE FOR CONTINUED RELIABILITY

1.- MODERN MAINTENANCE APPROACHES AND WHEN TO APPLY THEM.....	360
2.- WHAT IS TPM?.....	360
3.- WHAT EXACTLY IS RCM?.....	362
4.- RCM: THE REST OF THE STORY.....	362
5.- ESSENTIAL QUESTION TO BE ASKED.....	363
6.- PREREQUISITES TO ACM.....	364
7.- EMPHASIZING RELIABILITY INSTEAD OF MAINTENANCE: THE WAY TO INCREASE PROFITS!.....	364
8.- BENCHMARKING: COMPARING YOURSELF TO YOUR COMPETITION.....	365
9.- CHOOSING WISELY IN A STRESSFUL ENVIRONMENT.....	365
10.- MAINTENANCE MANAGEMENT OPTIONS.....	366
10.1.- Captive, or In-House, Maintenance.....	366
10.2.- Full Contract Maintenance.....	367
10.3.- Peak Shaving Maintenance.....	367
11.- INDEPENDENT OR OEM?.....	368
11.1.- The Independent Service Contractor.....	368
11.2.- Original Equipment Manufacturer Service Organization.....	368
12.- MODIFIED PEAK SHAVING MAINTENANCE MUST BE CONSIDERED.	369
13.- MACHINERY TURNAROUND PLANNING.....	370
14.- THE ROLE OF THE MAINTENANCE ENGINEER IN THE KNOWLEDGE AGE*.....	373

XXII.- THE ROLE AND IMPORTANCE OF RELIABILITY, MAINTENANCE, MAINTAINABILITY, AND QUALITY.....

1.- HISTORY OF RELIABILITY AND MAINTAINABILITY.....	374
2.- LIFE-CYCLE CONCEPTS.....	375
Basic Concept.....	375
b. Manufacturer.....	376
3.- TOOLS AND TECHNIQUES FOR THE STUDY OF RELIABILITY.....	377
4.- RELIABILITY AND MAINTENANCE DATA AND ANALYSIS.....	377
4.1.- Types of Data.....	378
5.- WHY STUDY RELIABILITY?.....	378
6.- FAILURE MODELS.....	379
6.1.- Stress –Strength Model.....	379
6.2.- Damage–Endurance Model.....	380
6.3.- Performance–Requirement Model.....	380
7.- FAILURE MECHANISMS.....	380
8.- PERFORMANCE MEASURES.....	382
9.- DEFINITION OF AVAILABILITY.....	384

10.- DEFINITION OF RISK.....	384
11.- SPECIFICATIONS.....	388
XXIII.- AUDITING AND REVIEWING CENTRIFUGAL COMPRESSORS.....	393
XXIV.- SPARE PARTS AND THEIR EFFECT, ASSOCIATED WITH CENTRIFUGAL COMPRESSORS.....	402
1.- SPARE PARTS PHILOSOPHIES.....	402
2.- SPARE PARTS STORAGE AND RETRIEVAL.....	402
3.- SPARE PARTS DOCUMENTATION.....	404
XXV.- USEFUL AND INTERESTING STATISTICS ABOUT MAINTENANCE.....	405
1.- MAINTENANCE COST BREAKDOWN BY WORK ORDER.....	405
2.- MAINTENANCE COST IS THE LARGEST COST LEVER AVAILABLE TO IMPROVE PROFITABILITY.....	406
3.- CURRENT MAINTENANCE METHODS DIFFER SIGNIFICANTLY FROM BEST PRACTICES... 407	407
4.- PLANT-WIDE ASSET MANAGEMENT PROVIDES A PLATFORM FOR INTEGRATING ASSETS.....	408
XXVI.- MANAGEMENT DECISIONS FOR AUDITS AND ASSET PROCUREMENT	410
1.- INDUSTRY STANDARDS AND THEIR PURPOSE.....	410
1.1.- Typical Scope of Standards.....	410
1.2.- Disclaimers in Standards.....	410
1.3.- Going Beyond the Standards.....	411
1.4.- DISADVANTAGES OF CHEAP PROCESS COMPRESSORS.....	411
1.5.- AUDITS VS. REVIEWS.....	412
1.5.1.- Staffing and Timing of Audits and Reviews.....	413
1.5.2.- Use of Equipment Downtime Statistics.....	413
1.6.- AUDITING AND REVIEWING COMPRESSORS.....	414
SECTION 10.- HISTORY & IMPROVEMENTS IN RELIABILITY, MAINTAINABILITY, AVAILABILITY, AND QUALITY IN DESIGN FOR CENTRIFUGAL COMPRESSORS IN THE OIL, GAS & PETROCHEMICAL INDUSTRY (API-617).	418
XXVIA.- HISTORY OF IMPROVEMENT IN RELIABILITY, MAINTAINABILITY, AVAILABILITY, AND SAFETY, AS APPLIED BY THE AMERICAN PETROLEUM INSTITUTE IN CASE OF CENTRIFUGAL COMPRESSORS (API-617).....	418
XXVII.- IMPROVEMENTS IN RELIABILITY, MAINTAINABILITY, AVAILABILITY, AND SAFETY (RAMS) IN THE DESIGN AND SELECTION PHASES OF CENTRIFUGAL COMPRESSORS IN THE OIL, GAS, AND PETROCHEMICAL INDUSTRY (API-617).....	419
PART 1 – GENERAL REQUIREMENTS.....	420
1.- SCOPE.....	420
2.- NORMATIVE REFERENCES & 3 TERMS, DEFINITIONS, AND ABBREVIATIONS.....	420
4.- GENERAL.....	421
4.1 Dimensions and Units.....	421
4.2 Statutory Requirements.....	421
4.3 Unit Responsibility.....	421
4.4 Basic Design.....	424
4.4.1 General.....	424
4.4.1.1 Performance.....	424
4.5.2 Castings.....	458
4.5.3 forgings.....	458

4.5.4 Welding.....	458
4.6 Casings.....	460
4.6.1 Pressure-containing Casings.....	460
4.6.2 Casing Repairs and Inspections.....	460
4.6.3 Material Inspection of Pressure-containing Parts.....	460
4.6.4 Pressure Casing Connections.....	478
4.6.4.1 General.....	478
4.6.4.2 Main Process Connections.....	478
4.6.4.3 Auxiliary Connections.....	478
4.6.4.3.8 Requirements for Threaded Connections.....	478
4.6.5 Casing Support Structures.....	478
4.6.6 External Forces and Moments.....	478
4.6.7 Guide Vanes, Stators, and Stationary Internals.....	478
4.7 Rotating Elements.....	487
4.7.10 Impellers.....	487
4.8 Dynamics.....	497
4.8.1 General.....	497
4.8.2 Lateral Analysis.....	497
4.8.3 Unbalanced Rotor Response Verification Test.....	509
4.8.4 Additional Testing.....	509
4.8.5 Level 1 Stability Analysis.....	509
4.8.6 Level II Stability Analysis.....	509
4.8.7 Torsional Analysis.....	516
4.9 Bearings and Bearing Housings.....	533
4.9.1 General.....	533
4.9.2 Hydrodynamic Radial Bearings.....	533
4.9.3 Hydrodynamic Thrust Bearings.....	533
4.9.4 Bearing Housings.....	533
4.10 Shaft End Seals.....	535
4.10.1 General.....	535
4.10.2 Clearance Seals.....	535
4.10.3 Oil Seals.....	535
4.10.4 Self-acting Dry Gas Seal.....	540
4.11 Integral Gearing.....	558
4.12 Nameplates and Rotation Arrows.....	558
5 Accessories.....	558
5.1 Drivers and Gearing.....	558
5.2 Couplings and Guards.....	562
5.3 Lubrication and Sealing Systems.....	566
5.4 Mounting Plates.....	569
5.4.1 General.....	569
5.4.2 Baseplates.....	569
5.4.3 Soleplates and Subsoleplates.....	569
5.5 Controls and Instrumentation.....	580
5.5.1 General.....	580
5.5.2 Control Systems.....	580
5.5.3 Instrument and Control Panels.....	587
5.5.4 Instrumentation.....	587
5.5.5 Alarms, Shutdowns, and Control Systems.....	587
5.5.6 Electrical Systems.....	587

5.5.7 Vibration, Position, and Bearing Temperature Detectors.....	587
5.6 Piping and Appurtenances.....	590
5.6.1 General.....	590
5.6.2 Instrument Piping.....	590
5.6.3 Process Piping.....	590
6 Inspection, Testing, and Preparation for Shipment.....	594
6.1 General.....	594
6.2 Inspection.....	594
6.3 Testing.....	599
6.3.1 General.....	599
6.3.2 Hydrostatic Test.....	599
6.3.3 Overspeed Test.....	599
6.3.3.1 Impeller Overspeed Test.....	599
6.3.4 Dry Gas Seals.....	599
6.3.5 Mechanical Running Test.....	602
6.3.6 Assembled Machine Gas Leakage Test.....	602
6.3.7 Optional Tests.....	605
6.3.7.1 Performance Test.....	605
6.3.7.2 Field Performance Testing.....	605
6.3.7.3 Gas Test After Hydro.....	605
6.3.7.4 Sound-level Test.....	605
6.3.7.5 Auxiliary-equipment Test.....	605
6.3.7.6 Post-test Inspection of Compressor Internals.....	605
6.3.7.7 Full-pressure/Full-load/Full-speed Test.....	605
6.3.7.8 Post-test Inspection of the Hydraulic Coupling Fit.....	605
6.3.7.9 Spare-parts Test.....	605
6.4 Preparation for Shipment.....	612
7 Supplier's Data.....	619
7.1 General.....	619
7.2 Proposals.....	619
7.3 Contract Data.....	619
7.3.4 Parts Lists and Recommended Spares.....	623
7.3.5 Installation, Operation, Maintenance, and Technical Data Manuals.....	623
7.3.5.2 Installation Manual.....	623
7.3.5.3 Operating and Maintenance Manual.....	623
7.3.5.4 Technical Data Manual.....	623
8 Weight Control for Offshore Facilities.....	625
8.1 General.....	625
8.2 Engineering Information.....	625
PART 2—NON-INTEGRALLY GEARED CENTRIFUGAL AND AXIAL COMPRESSORS.....	626
1 SCOPE.....	626
2 NORMATIVE REFERENCES.....	626
3 TERMS, DEFINITIONS, AND ABBREVIATIONS.....	626
4 GENERAL.....	626
4.1 Dimensions and Units.....	626
4.2 Statutory Requirements.....	626
4.3 Unit Responsibility.....	626
4.4 Basic Design.....	626
4.4.1 Performance.....	626

4.6 Casings.....	633
4.6.1 Pressure-containing Casings.....	633
4.6.2 Casing Repair.....	633
4.6.3 Material Inspection of Pressure-containing Parts.....	633
4.6.4 Pressure Casing Connections.....	633
4.6.5 Casing Support Structures.....	640
4.6.6 External Forces and Moments.....	640
4.6.7 Guide Vanes, Stators, and Stationary Internals.....	641
4.6.8 Internal Joints.....	641
4.6.9 Seal Components.....	645
4.6.10 Diaphragms.....	645
4.7 Rotating Elements.....	647
4.7.1 General.....	647
4.7.2 Shafts.....	647
4.7.3 Thrust Balancing.....	647
4.7.4 Impellers.....	647
4.7.5 Axial Compressor Rotor Blading.....	647
4.9 Bearings and Bearing Housings.....	655
4.9.1 General.....	655
4.9.2 Hydrodynamic Radial Bearings.....	655
4.9.3 Hydrodynamic Thrust Bearings.....	655
5 Accessories.....	666
5.1 Drivers and Gearing.....	666
5.2 Couplings and Guards.....	666
5.3 Lubrication and Sealing Systems.....	666
5.4 Mounting Plates.....	666
5.5 Controls and Instrumentation.....	666
5.5.3 Instrument and Control Panels.....	666
5.5.4 Instrumentation.....	666
5.5.5 Alarms, Shutdowns, and Control Systems.....	666
5.5.6 Electrical Systems.....	666
5.5.7 Vibration, Position, and Bearing Temperature Detectors.....	666
5.6 Piping and Appurtenances.....	674
5.6.1 General.....	674
5.6.2 Process Piping.....	674
5.7 Special Tools.....	674
6 Inspection, Testing, and Preparation for Shipment.....	675
6.1 General.....	675
6.2 Inspection.....	675
6.3 Testing.....	676
6.3.1 Mechanical Running Test.....	676
6.3.2 Assembled Compressor Gas Leakage Test.....	676
6.3.3 Optional Tests.....	682
6.3.3.1 Factory Performance Test.....	682
6.3.3.2 Complete Unit Test.....	682
6.3.3.3 Tandem Test.....	682
6.3.3.4 Gear Test.....	682
6.4 Preparation for Shipment.....	695
7 Supplier's Data.....	696

7.1 General.....	696
7.2 Proposals.....	696
7.3 Contract Data.....	696
1 SCOPE.....	697
2 NORMATIVE REFERENCES.....	697
3 TERMS, DEFINITIONS, AND ABBREVIATIONS.....	697
4 GENERAL.....	697
4.1 Dimensions and Units.....	697
4.2 Statutory Requirements.....	697
4.3 Unit Responsibility.....	697
4.4 Basic Design.....	697
4.4.1 Performance.....	697
4.5 Materials.....	700
4.6 Casings.....	700
4.6.1 Pressure-containing Casings.....	700
4.6.2 Casing Repair.....	700
4.6.3 Material Inspection of Pressure-containing Parts.....	700
4.6.4 Pressure Casing Connections.....	700
4.6.5 Casing Support Structure.....	700
4.6.6 External Forces and Moments.....	700
4.6.7 Variable Inlet and/or Diffuser Guide Vanes.....	700
4.7 Rotating Elements.....	703
4.7.3 Thrust Balancing.....	703
4.7.4 Impellers.....	703
4.8 Dynamics.....	704
4.9 Bearings and Bearing Housings.....	705
4.9.1 General.....	705
4.9.2 Hydrodynamic Radial Bearings.....	705
4.9.3 Hydrodynamic Thrust Bearings.....	705
4.9.4 Bearing Housings.....	705
4.10 Shaft End Seals.....	710
4.11 Integral Gearing.....	710
4.12 Nameplates and Rotation Arrows.....	710
5 Accessories.....	712
5.3 Lubrication and Sealing Systems.....	712
5.4 Mounting Plates.....	712
5.5 Controls and Instrumentation.....	713
5.5.1 Controls and instrumentation shall be in conformance with 5.5 of Part 1.....	713
5.5.2 Control Systems.....	713
5.5.3 Instrument and Control Panels.....	713
5.5.4 Instrumentation.....	713
5.5.5 Alarms and Shutdowns.....	713
5.5.6 Electrical Systems.....	713
5.5.7 Vibration, Position, and Bearing Temperature.....	713
5.6 Piping and Appurtenances.....	716
5.6.1 General.....	716
5.6.2 Process Piping and Accessories.....	716
5.7 Special Tools.....	716
6 Inspection, Testing, and Preparation for Shipment.....	718

6.1 General.....	718
6.2 Inspection.....	718
6.3 Testing.....	718
6.3.1 Mechanical Running Test.....	718
6.3.2 Assembled Compressor Gas Leakage Test.....	718
6.3.3 Optional Tests.....	722
6.3.3.1 Performance Test.....	722
6.3.3.2 Complete Unit Test.....	722
6.4 Preparation for Shipment.....	727
7 Supplier's Data.....	728
7.1 General.....	728
7.2 Proposals.....	728
7.3 Contract Data.....	728
PART 4—EXPANDER-COMPRESSORS.....	729
1 SCOPE.....	729
4.4 Basic Design.....	729
4.6 Casings.....	732
4.6.1 Pressure-containing Casings.....	732
4.6.2 Casing Repairs.....	732
4.6.3 Material Inspection of Pressure-containing Parts.....	732
4.6.4 Pressure Casing Connections.....	732
4.6.4.1 Main Process Connections.....	732
4.6.4.2 Auxiliary Connections.....	732
4.6.5 Casing Support Structures.....	732
4.6.6 External Forces and Moments.....	732
4.7 Rotating Elements.....	736
4.7.1 General.....	736
4.7.2 Shaft Sleeve.....	736
4.7.3 Shafts.....	736
4.7.4 Impellers.....	736
4.7.4.1 Thrust Balancing.....	736
4.8 Dynamics.....	737
4.8.1 Vibration Balancing.....	737
4.8.1.7 Residual Unbalance Procedure.....	737
4.9 Bearings and Bearing Housings.....	740
4.9.2 Hydrodynamic Radial Bearings.....	740
4.9.3 Hydrodynamic Thrust Bearings.....	740
4.9.4 Bearing Housings.....	740
4.10 Expander-compressor Shaft Seals.....	744
4.11 Integral Gearing.....	744
4.12 Nameplates and Rotation Arrows.....	744
5 Accessories.....	745
5.1 Drivers.....	745
5.2 Couplings and Guards.....	745
5.3 Lubrication and Sealing Systems.....	745
5.4 Mounting Plates.....	745
5.5 Controls and Instrumentation.....	746
5.5.1 Vibration and Position Monitoring.....	746
5.5.2 Hydrodynamic Bearings.....	746

5.5.3 Magnetic Bearings.....	746
5.5.4 Overspeed Shutdown System.....	746
5.5.5 Permanent Strainer.....	750
5.6 Piping and Appurtenances.....	751
5.7 Special Tools.....	751
Oil Company - SHELL:.....	751
6 Inspection, Testing, and Preparation for Shipment.....	751
6.1 General.....	751
6.2 Inspection.....	751
6.3 Testing.....	751
6.3.1 General.....	751
6.3.2 Wheel Shaker Test.....	751
6.3.3 Mechanical Running Test.....	751
6.3.4 Assembled Machine Gas Leakage Test.....	751
6.3.5 Optional Tests.....	756
6.3.5.1 Performance Test.....	756
6.4 Preparation for Shipment.....	760
7 Supplier's Data.....	761
7.1 General.....	761
7.2 Proposals.....	761
7.3 Contract Data.....	761
ANNEX - MAGNETIC BEARINGS.....	763
DRY GAS SEAL TESTING (AT SHOP).....	765
ANNEX F (normative).....	766
Dry Gas Seal Testing at MANUFACTURER's Shop.....	766
SPARE PARTS.....	768
LUBRICATION SYSTEM DESIGN REQUIREMENTS FOR CENTRIFUGAL COMPRESSORS (API 617) SPECIFICATION	771
SITE ACCEPTANCE TESTS.....	773
REFERENCE STANDARDS IN PROJECTS WITH CENTRIFUGAL COMPRESSORS.....	777