

ÍNDICE

I.- AUTHOR'S EXPERIENCES – ENG. ALBERTO MTZ LLAURADO.....	32
II.- ACKNOWLEDGMENT.....	32
III.- PROLOGUE	33
SECTION 11.- BUYING & SELLING CENTRIFUGAL COMPRESSORS.....	38
XXVIII.- BUYING / SELLING – SERIAL # 1 (TURBOMACHINERY).....	38
1.- INTRODUCTION.....	38
2.- EVOLVING END USER REQUIREMENTS.....	39
3.- OEM PRODUCT DEVELOPMENT.....	40
4.- END USER - WHAT IS NEEDED TO VALIDATE THE DECISION FOR BUYING SERIAL #1.....	41
5.- SOME OF THE TYPICAL ISSUES THAT MAY BE FOUND IN SERIAL NUMBER ONE COMPRESSORS.....	44
6.- MECHANICAL FACTORS.....	45
7.- AERODYNAMIC CONSIDERATIONS.....	47
8.- MECHANICAL CONSIDERATIONS.....	51
9.- CONCLUSIONS.....	56
10.- FIGURES.....	57
SECTION 12.- ADVANCES IN TECHNOLOGY FOR CENTRIFUGAL COMPRESSORS.....	68
XXIX.- ADVANCES IN CENTRIFUGAL COMPRESSOR TECHNOLOGY.....	68
SECTION 13.- IMPROVEMENTS IN SPECIFICATIONS AND PURCHASING ABOUT RELIABILITY ISSUES FOR CENTRIFUGAL COMPRESSORS.....	70
XXX.- RELIABILITY ASSESSMENT OF ROTATING EQUIPMENT.....	70
1.- OPTIMIZING RELIABILITY.....	71
2.- INPUT DATA.....	71
3.- THE CONCEPT OF A SYSTEM.....	71
4.- EXPERIENCE COUNTS!.....	71
XXXI.- MOVING FROM A REPAIR-FOCUSED TO A RELIABILITY-FOCUSED CULTURE.....	73
XXXII.- CAN SPECIFICATIONS IMPROVE COMPRESSOR RELIABILITY?.....	75
XXXIII.- EQUIPMENT PURCHASING RELATED WITH CENTRIFUGAL COMPRESSORS.....	79
1 CONSIDER SINGLE-POINT RESPONSIBILITY FOR MAJOR FLUID MACHINES.....	79
2 FOCUSING ON THE BRIGHT SIDE.....	79
3 CONVERSIONS FACTORS FOR COMMONLY USED UNITS IN THE PROCESS INDUSTRY....	80
4 Aerothermodynamic fundamentals of different types of compressors.....	82
XXXIV.- 15 THINGS TO CONSIDER WHILE BUYING TURBOMACHINERY	87
1. BIDS and PROPOSALS.....	87
2. SPECIFICATIONS.....	87
3. MILESTONE MEETINGS.....	88
4. BROWN or GREEN FIELD.....	89
5. NEW or REFURBISHED EQUIPMENT.....	89
6. TESTS.....	90
7. REPORTS AND SCHEDULES.....	90
8. PRICE.....	90
9. DELIVERY PERIOD.....	91

10. PENALTIES / BONUSES.....	91
11. WARRANTIES/GUARANTEES.....	91
12. START UP AND COMMISSIONING.....	92
13. MAINTENANCE AND USER SUPPORT.....	92
14. TRAINING.....	93
15. 30-YEAR LIFE CYCLE SUPPORT.....	93

SECTION 14.- REAL CASES & RELEVANT PROJECT STUDIES APPLICABLE TO CENTRIFUGAL COMPRESSORS IN OIL, GAS & PETROCHEMICAL INDUSTRY.....94

XXXV.- PRACTICAL CASES ABOUT CENTRIFUGAL COMPRESSORS BEING APPLIED ON INDUSTRIAL PROJECTS (OIL & GAS, PETRO-CHEMICALS).....94

- SECONDARY PARTS INVOLVED IN THE RELIABILITY OF CENTRIFUGAL COMPRESSORS...	94
1.- PARTICULAR CASE ABOUT A CENTRIFUGAL GAS COMPRESSOR DRIVEN BY ELECTRIC MOTOR COUPLED TO A VARIABLE HYDRAULIC SPEED DRIVER, AS REQUIRED IN A "DELAYED COKER" PLANT IN OIL REFINERY.	95
2.- PARTICULAR CASE FOR 3 COMPRESSION TRAINS IN A NATURAL GAS COMPRESSION STATION, WITH 3 CENTRIFUGAL COMPRESSORS DRIVEN BY DIRECT COUPLING TO GAS TURBINES WITH ALL THE AUXILIARIES' SYSTEMS AND ACCESSORIES (BALANCE OF PLANT).....	146
3.- APPLICATION FOR CENTRIFUGAL COMPRESSORS IN THE PROCESSES RELATED TO CRYOGENIC PLANTS IN THE INDUSTRY.....	161
4.- CASE IN PROJECT FOR THE IMPROVEMENT IN CLEAN GASOLINE "GUBA" (ULTRA LOW SULFUR CONTENT, 10 PPMW), IN OIL REFINERIES.....	164
5.- CASE IN PROJECT FOR THE IMPROVEMENT IN CLEAN DIESEL "DUBA" (ULTRA LOW SULFUR CONTENT, 10 PPMW), IN OIL REFINERIES.....	166

XXXVI.- SPECIFYING LARGE HP MOTORS FOR CENTRIFUGAL COMPRESSORS.....170

XXXVII.- UNDERSTANDING MACH NUMBERS AS APPLIED TO CENTRIFUGAL COMPRESSORS.....172

1.- INLET RELATIVE MACH NUMBER.....	172
2.- IMPELLER TIP MACH NUMBER.....	173
3.- NOZZLE MACH NUMBER.....	173

XXXVIII.- CASE STUDIES IN RELIABILITY AND MAINTENANCE.....175

1.- Introduction and Overview.....	175
2.- RELIABILITY, MAINTENANCE, MAINTAINABILITY, AND QUALITY.....	175
2.1.- Reliability.....	175
2.2.- Maintenance.....	176
2.3.- Maintainability.....	178
2.4.- Quality.....	178
3.- The Role and Importance of Reliability, Maintenance, Maintainability, and Quality.....	178
4.- HISTORY OF RELIABILITY AND MAINTAINABILITY.....	179
5.- APPLICATIONS.....	180
6.- LIFE-CYCLE CONCEPTS.....	180
6.1.- Basic Concept.....	180
6.2.- Manufacturer.....	181
7.- TOOLS AND TECHNIQUES FOR THE STUDY OF RELIABILITY.....	183
7.1.- Systems Approach.....	183
7.2.- Modeling.....	184

7.3.- Tools and Techniques for Reliability Analysis.....	184
7.4.- Optimization.....	185
8.- RELIABILITY AND MAINTENANCE DATA AND ANALYSIS.....	185
8.1.- Types of Data.....	186
8.2.- Data Structure.....	186
8.3 Data Acquisition.....	187
8.4 Data Analysis.....	187
9.- ISSUES IN RELIABILITY AND MAINTENANCE.....	188
9.1.- Interdisciplinary Nature of R&M.....	188
9.2.- Issues in R&M Studies.....	188
9.3.- Technical Issues.....	188
9.4.- Operational Issues.....	188
9.5.- Commercial Issues.....	189
9.6.- Management Issues.....	189

SECTION 15.- REVAMP / RE-RATE DESIGN AND REPLACEMENT IN CENTRIFUGAL COMPRESSORS.....190

XXXIX.- REVAMP / RE-RATE DESIGN CONSIDERATIONS.....	190
1.- INTRODUCTION.....	190
2.- BACKGROUND.....	190
3.- TERMINOLOGY.....	190
4.- MOTIVATIONS.....	191
5.- LIMITATIONS OF A COMPRESSOR REVAMP / RE- RATE.....	192
6.- CASE CONSIDERATIONS.....	193
6.1.- Casing Pressure and Temperature Ratings.....	193
6.2.- Casing Internal Dimensions.....	193
6.3.- Aerodynamic Flow Path Integral with Casing.....	194
7.- THE RE-USE OF EXISTING INTERNAL COMPONENTS.....	195
8.- AERODYNAMIC CONSIDERATIONS.....	196
8.1.- Flow Coefficient.....	196
8.2.- Efficiency.....	196
8.3.- Flow Range.....	197
8.4.- Rise-To-Surge.....	197
8.5.- Machine Mach Number, U_2/A_0	197
8.6.- Inlet Relative Mach Number.....	198
8.7.- Impeller Relative Velocity Ratio or the like.....	198
9.- IMPELLERS.....	199
9.1.- Riveted to Welded or Brazed.....	199
9.2.- Three-Piece Welded to 5-Axis Machined.....	200
9.3. - Improved Blading.....	200
9.4.- Stage Spacing.....	200
9.5.- Modifying Impellers/Inlet Guides for Reduced Stage Space.....	200
10.- INLET GUIDE CHANGES.....	200
11.- DIFFUSERS.....	201
11.1.- Vaned Diffusers.....	202
12.- OTHER STATIONARY COMPONENTS.....	202
12.1.- Return Channels.....	202
12.2.- Inlets/Volutes/Collectors.....	202
13.- ROTORDYNAMIC CONSIDERATIONS FOR REVAMPS AND UPGRADES.....	202

13.1.- Motivations for a Lateral Analysis.....	202
13.2.- Lateral Rotor Dynamic Programs – History.....	205
13.3.- Additional Material on Lateral Analysis Programs.....	206
13.4.- Lateral Analysis Procedures for Revamps and Upgrades (and New Compressors).....	207
14.- STABILITY HISTORY.....	207
15.- CASE HISTORIES.....	210
16.- STRETCHING THE RULES.....	213
17.- COMMUNICATIONS.....	213
18.- OEMs v. OTHERS	214
19.- CONCLUSIONS.....	215
XXXIX. A.- COMPRESSOR TRAIN REPLACEMENT: A SUMMARY OF EFFICIENCY AND RELIABILITY OPPORTUNITIES.....	230
1.- COMPRESSOR CONFIGURATION.....	231
2.- ANTI-SURGE SYSTEM.....	232
3.- STEAM TURBINE DRIVER.....	233
SECTION 16.- ROTODYNAMIC ANALYSIS IN CENTRIFUGAL COMPRESSORS.....	234
XL.- LATERAL DYNAMICS.....	234
1.- OVERVIEW OF PERFORMANCE REQUIREMENTS.....	234
2.- COMPONENT MODELING CONSIDERATIONS.....	236
XLI. A.- TYPICAL LATERAL ANALYSES.....	239
1.- LATERAL STABILITY OF ROTORS.....	242
2 OTHER LATERAL ANALYSIS CONSIDERATIONS.....	245
3 ROTORDYNAMICS DESIGN VERIFICATION TESTING.....	245
XLI. B.- TORSIONAL DYNAMICS.....	246
1. OVERVIEW OF PERFORMANCE REQUIREMENTS.....	246
2. TYPICAL TORSIONAL ANALYSES.....	247
3. OTHER TORSIONAL ANALYSIS CONSIDERATIONS.....	250
XLI. C.- CRITICAL SPEEDS AND ROTOR RESPONSE.....	250
1.- INTRODUCTION.....	250
2.- CRITICAL SPEEDS.....	251
3.- CRITICAL SPEED HORIZONTAL (X) VERTICAL (Y).....	251
4.- THE ROTOR SYSTEM (INPUT).....	252
5.- ROTOR RESPONSE (OUTPUT).....	254
6.- Measured rotor response.....	256
XLII. A.- NOVEL MITIGATION TECHNIQUES FOR SOLVING ROTOR STABILITY PROBLEMS.....	257
1.- COMBINING AN ARC SPRING WITH A SQUEEZE FILM DAMPER BEARING TO MITIGATE A ROTOR STABILITY PROBLEM.....	257
2. TORSIONAL VIBRATION PROBLEM SOLVED USING A NEW DESIGN VISCOUS ROTATIONAL DAMPER.....	263
3.- CONCLUSION.....	268
XLII. B.- ROTOR DYNAMICS AND DESIGN CRITERIA APPLIED TO CENTRIFUGAL COMPRESSORS IN INDUSTRIAL OIL PLANTS.....	268
1.- INTRODUCTION	268
2.- SYNCHRONOUS VIBRATION	268

3.- ASYNCHRONOUS VIBRATION	269
SECTION 17.- STABILITY PROBLEMS IN CENTRIFUGAL COMPRESSORS.....	273
XLI I . - SOLVING STABILITY PROBLEMS.....	273
1.- DECREASING OR ELIMINATING EXCITATION FORCES.....	275
2.- INCREASING EFFECTIVE DAMPING.....	276
3.- STANDARD PARAGRAPH SECTIONS FOR STABILITY ANALYSIS SP6.8.5 – SP6.8.6.....	277
3.1.- Philosophy.....	277
3.2.- Level I.....	277
3.3.- Level II.....	278
3.4.- Stability Standard Paragraph Discussion.....	278
3.5.- SP6.8.5 Level I Stability Analysis.....	279
3.6.- SP6.8.6 Level II Stability Analysis.....	283
3.8.- Level I - screening Criteria.....	285
3.9.- Level II Analysis.....	285
3.10.- Level II Acceptance Criteria.....	287
XLIV.- API DOCUMENT PARAGRAPHS ON TORSIONAL VIBRATION.....	289
1.- TORSIONAL ANALYSIS.....	289
2.- PARAGRAPHS FROM API 617 - 7TH EDITION SP2.6.7	289
SECTION 18.- DESIGN AUDIT CHECKLIST.....	291
XLV.- TYPICAL DESIGN AUDIT CHECKLIST.....	291
SECTION 19.- ACTIVE MAGNETIC BEARINGS IN CENTRIFUGAL COMPRESSORS	292
XLVI.- TECHNOLOGY APPLIED TO CENTRIFUGAL COMPRESSORS TO IMPROVE THEIR RELIABILITY AND MAINTAINABILITY.....	292
NEW ACTIVE MAGNETIC BEARING REQUIREMENTS FOR COMPRESSORS IN API 617 EIGHTH EDITION.....	292
1- INTRODUCTION.....	292
2.- AMB SYSTEM OVERVIEW AND TECHNOLOGY.....	293
3.- FORCE GENERATION IN A MAGNETIC BEARING.....	294
4.- AMB SYSTEM FORCE LIMITATIONS.....	297
4.1.- Saturation and Maximum Load Capacity.....	297
4.2.- Thermal Limits.....	298
4.3.- Slew Rate.....	298
4.4.- Eddy current losses.....	299
4.5.- Other Limitations.....	299
5.- SOME OTHER IMPORTANT AMB SPECIFIC SYSTEM ISSUES.....	299
5.1.- Non-collocation.....	299
5.2.- Synchronous cancellation.....	300
5.3.- Gain Scheduling.....	300
5.4.- Auxiliary Bearings.....	300
5.5.- Some Comments on AMB Rotor Balancing.....	301
6.- API 617 EIGHTH EDITION AMB REQUIREMENTS.....	301
7.- ROTORDYNAMIC ANALYSIS FOR AMB SUPPORTED ROTORS PER API 617 EIGHTH EDITION.....	302
7.1.- Introduction and Overview.....	302
7.2.- New System/Modeling Data Vendor Requirements.....	302
7.4.- Outline of the Analysis.....	303
7.5.- Undamped Critical Speed Map.....	303

7.6.- Free-Free Map.....	304
7.7.- Unbalance Response.....	305
7.8.- Unbalance Rotor Response Verification Test (If Specified Item).....	306
7.9.- Closed Loop Transfer Functions (If Specified Item).....	306
7.10.- Open Loop Transfer Functions (If Specified Item).....	307
7.11.- Level I Stability Analysis, Including Sensitivity Function Analysis.....	307
7.12.- Level II Stability Analysis, Including Sensitivity Function Analysis.....	308
8.- TORSIONAL ANALYSIS.....	308
9.- AXIAL ANALYSIS.....	309
10.- AS INSTALLED ANALYSIS.....	309
11.- AUXILIARY BEARING ANALYSIS.....	309
12.- ROTORDYNAMICS ANALYSIS CODE REQUIREMENTS.....	310
13.- ROTORDYNAMIC ANALYSIS SUMMARY.....	310
14.- ACTIVE MAGNETIC BEARING TESTING.....	311
14.1.- Overview.....	311
14.2.- AMB Component Testing.....	311
14.3.- AMB system testing.....	312
14.4.- Mechanical Running Test.....	312
14.5.- Vibration Response limits.....	312
14.6.- Sensitivity function measurement.....	313
14.7.- Model validation - Unbalance Response (If Specified Item).....	313
14.8.- Model validation - Closed Loop Transfer Functions (If Specified Item).....	313
14.9.- Rotor drop onto auxiliary bearings test (If Specified Item).....	314
15.- EXAMPLE CASES.....	315
15.1.- Small AMB Turbocompressor Example.....	315
15.2.- Rotor Model.....	315
15.3.- Complete Coupled Model.....	317
16.- INDUSTRIAL COMPRESSOR EXAMPLE.....	318
16.1.- Overview.....	318
16.2.- Rotodynamic model.....	318
16.3.- Free-Free Map and Mode Shapes.....	318
16.4.- Undamped Critical Speed Map.....	319
16.5.- Unbalance Response displacements and forces.....	320
16.5.1.- Closed Loop Transfer Functions.....	321
16.6.- Stability Analysis.....	322
16.7.- Sensitivity Transfer Function.....	323
16.8.- Axial stability and sensitivity function analysis.....	323
16.9.- As Installed Analysis.....	323
16.11.- Vibration.....	323
16.12.- Sensitivity Transfer Function.....	326
16.13.- Auxiliary Bearing Testing.....	327
16.14.- Summary.....	327
17.- CLOSING COMMENTS.....	327
18.- NOMENCLATURE.....	328
XLVII.- MAGNETIC BEARINGS – THEORY & DESIGN.....	331
1.- OPERATING PRINCIPLES.....	331
2.- OPERATING EXPERIENCE AND BENEFITS.....	333
3.- PROBLEMS AND SOLUTIONS.....	333

4.- DEVELOPMENT EFFORTS.....	334
4.1.- Thrust-Reducing Seals.....	334
5.- INTEGRATED DESIGNS.....	336
XLVIII.- THE REALITIES OF MAGNETIC BEARING APPLICATIONS.....	339
1.- WEAKNESS #1: EXCESSIVE HEAT.....	339
2.- WEAKNESS #2. LIMITED FAULT PROTECTION.....	340
3.- WEAKNESS #3. INADEQUATE COMPENSATION FORCE.....	340
4.- ADDITIONAL PROBLEMS AND TRADEOFFS.....	341
4.1.- Energy Consumption.....	341
4.2.- Diagnostic Capabilities.....	342
4.3.- Experience.....	342
XLIX.- MAGNETIC BEARINGS (DESIGN AS PER WAUKESHA).....	342
1.- MAGNETIC BEARING APPLICATIONS.....	343
2.- ROTOR DELEVITATION SYSTEM (RDS) DESIGNS.....	346
3.- NO MACHINE TEARDOWN NECESSARY.....	348
4.- THE PRINCIPLE OF OPERATION OF THE MAGNETIC BEARING.....	350
5.- RADIAL BEARING CONFIGURATION.....	350
6.- AXIAL BEARING CONFIGURATION.....	350
7.- POSITION TRANSDUCERS.....	350
8.- THE ELECTRONIC CONTROL SYSTEM.....	351
9.- AUXILIARY BEARINGS.....	351
10.- THE BENEFITS OF MAGNETIC BEARINGS:.....	351
10.1.- no mechanical contact.....	351
10.2.- No Oil Contamination of Process Fluid.....	351
10.3.- No Liquids.....	351
10.4.- No Lubrication System.....	351
10.5.- Capability to Operate in a Process Fluid.....	351
10.6.- Wide Temperature Range Capability.....	351
10.8.- Low Energy Consumption.....	352
10.9.- Controllable Rotor Dynamics.....	352
10.10.- Vibration Attenuation.....	352
10.11.- Improved Machine Diagnostics.....	352
10.12.- Increased Reliability/Availability.....	352
10.13.- Benefits of Working with a Magnetic Bearing Manufacturer.....	352
11.- ADVANCED CONTROLLER FUNCTIONS.....	353
11.1.- Advanced Controller Functions.....	353
12.- AUXILIARY BEARING TECHNOLOGY.....	355
12.1.- Rotor Delevitation System® (RDS®).....	355
12.2.- Advanced Capabilities.....	355
SECTION 20.- FLUID INSTABILITY, EXTERNAL PRESSURIZED AND AIR / GAS BEARINGS APPLIED TO CENTRIFUGAL COMPRESSORS.....	356
L.- FLUID-INDUCED INSTABILITY AND EXTERNALLY PRESSURIZED BEARINGS.....	356
1.- INSTABILITY CONSIDERATIONS.....	356
2.- FLUID-INDUCED INSTABILITY.....	356
2.1.- Controlling Lambda.....	357
2.2.- Controlling Stiffness.....	357
2.3.- Eccentricity and Stiffness.....	358

2. 4 . - Externally Pressurized Bearings and Seals.....	358
2. 5 . - Practical Applications.....	360
2. 6 . - Rotor Model, Dynamic Stiffness, and Fluid Instability.....	361
2.7.- More About Externally Pressurized Bearings.....	363
3.- CONCLUSIONS.....	365

LI. A.- GAS BEARING LUBRICATION IN TURBOMACHINERY	366
1.- DRY GAS SEALS (DGS)	366
2.- FOIL BEARINGS	367
3.- AEROSTATIC LUBRICATION	369
4.- WHAT IS COMPENSATION?	369
5.- ORIFICE COMPENSATION	370
6.- POROUS COMPENSATION	370
7.- ROTOR DYNAMIC CONSIDERATIONS	370
8.- THE FUTURE	372
Chart LI. A-2.....	373

LII.- AIR BEARINGS – THEORY, DESIGN AND APPLICATIONS.....	373
1.- CAPABILITIES AND LIMITATIONS OF GAS LUBRICATION.....	373
2.- WHEN IS THE USE OF AIR BEARINGS PERTINENT.....	374
2.1.- What Hinders the Extensive Application of Air Bearings.....	374
3.- CLASSIFICATION OF AIR BEARINGS FOR ANALYSIS PURPOSES.....	375
4.- DYNAMIC WHIRLING BEHAVIOUR AND THE ROTORDYNAMIC STABILITY PROBLEM.....	376
4.1.- Introduction.....	376
5.- TILTING PAD AIR BEARINGS.....	377
5.1.- Introduction.....	377
6.- FOIL BEARINGS.....	378
6.1.- Introduction.....	378
7.- POROUS BEARINGS.....	380
7.1.- Introduction.....	380

SECTION 21.- FEATURES ABOUT TORQUEMETERS IN COMPRESSORS.....383

LIII.- NEW OPTIONAL FEATURES OF TORQUE METERS.....	383
1.- HOT ALIGNMENT.....	383
2.- TRANSIENT/DYNAMIC TORQUE MEASUREMENT.....	383
3.- POTENTIAL USES FOR DYNAMIC TORQUE MONITORING.....	383
4.- TORQUETRONICS DYNAMIC TORQUE-METERING SYSTEM.....	383
5.- INDIKON/RIVERHAWK DYNAMIC TORQUE-METER SYSTEM.....	384
6.- TMS 2200 TORQUE METERING SYSTEM.....	384
6.1.- TORQUE METERING SYSTEM OPERATION.....	384
6.2.- SYSTEM ARRANGEMENT.....	385
6.3.- THEORY OF OPERATION.....	385
a.- system organization.....	385
b.- principles of torque measurement.....	385

SECTION 22.- RELIABILITY IN STANDARD & HYDRODYNAMIC COUPLINGS FOR CENTRIFUGAL COMPRESSORS.....388

LIV.- SPECIAL-PURPOSE COUPLINGS.....	388
1.- INTRODUCTION.....	388
2.- DIAPHRAGM COUPLINGS.....	388
3. - DISK COUPLINGS.....	390

LV.- BACKUP OPTIONS IN CASE YOUR COUPLING FAILS..... 392

LVI.- NEW DEVICE IMPROVES AXIAL CAPABILITY OF DISC COUPLINGS..... 393

LVII.- REPLACING GEAR COUPLINGS WITH DRY COUPLINGS?.....	394
LVII. A.- THE USE OF HYDRODYNAMIC COUPLINGS.....	396
SECTION 23.- GAS CENTRIFUGAL COMPRESSOR DESIGN & SELECTION, LATEST AND FUTURE TRENDS, APPLICABLE TO SEVERE / CRITICAL GAS SERVICES...	398
LVII. B.- INTEGRALLY GEARED BARREL COMPRESSORS ADDRESS THE CHALLENGES OF HYDROGEN COMPRESSION.....	398
LVIII.- CENTRIFUGAL HYPER-COMPRESSORS FOR ETHYLENE SERVICE.....	401
1.- LAYOUT AND PRINCIPAL DIMENSIONS OF COMPRESSORS.....	403
2.- DISCUSSION OF THE COMPRESSOR DESIGN WITH RESPECT TO KNOW-HOW.....	407
3.- SUMMARY OF THE PRESENT DEVELOPMENT'S RESULTS.....	409
4.- CONCLUSIONS.	410
LVIII. A.- APPLICATION GUIDELINE FOR ELECTRIC MOTOR DRIVE EQUIPMENT FOR NATURAL GAS COMPRESSORS.....	411
1.- ROTORDYNAMIC CONSIDERATIONS.....	411
1.1.- Types of Torsional Analyses.....	411
1.2.- Required Input Data for Torsional Rotodynamic Analyses.....	412
1.3.- Torsional Mass Elastic Model.....	413
1.4.- Torsional Critical Speed and Forced Response Analyses.....	413
1.5.- Transient Torsional Analysis (Start-up and Short Circuit Events).....	413
1.6.- Torsional Damping Levels.....	414
1.7.- Torsional Analysis Allowable Stress and Torque Criteria.....	414
1.8.- Transient Torsional Cumulative Fatigue Analysis.....	414
1.9.- Synchronous Motor Slip Frequency Excitation.....	415
1.10.- Torsional Excitations Due to Variable Frequency Drives.....	415
1.11.- Motor, Centrifugal Compressor, and Gearbox Lateral Critical Speeds.....	415
2.- STARTING OF THE ELECTRIC MOTOR.....	416
2.1- Method 1: Across-the-Line Start.....	416
2.2- Method 2: Soft-Start with Full Size VFD.....	417
2.3- Method 3: Small VFD for Soft-Start.....	417
2.4- Method 4: Smaller Starter Motor at Reduced Load.....	417
2.5- Method 5: Smaller Starter Motor with Torque Converter.....	417
2.6- Method 6: Low Voltage Options for Reduced Load.....	417
2.7- Evaluation Process for Start-up Method.....	417
3.- CENTRIFUGAL COMPRESSOR APPLICATIONS.....	418
4.- OUTPUT POWER AS A FUNCTION OF DRIVER OUTPUT SPEED.....	419
5.- ELECTRIC MOTOR WITH VARIABLE FREQUENCY DRIVE FOR CENTRIFUGAL COMPRESSORS.....	420
5.1.- Typical Power/Speed Characteristics on VFD's.....	421
6.- ELECTRIC MOTOR WITH VSHD FOR CENTRIFUGAL COMPRESSORS.....	421
7.- CONSTANT SPEED ELECTRIC MOTOR DRIVES FOR CENTRIFUGAL COMPRESSORS.....	422
LVIII. B.- FUTURE TRENDS IN LNG COMPRESSORS (TURBOMACHINERY)	425
1.- INTRODUCTION.....	425
2.- COMPRESSORS FOR LNG SERVICE	425
3.- COMPRESSOR CONFIGURATIONS AND COMPRESSOR TECHNOLOGY MILESTONES	426
4.- AXIAL COMPRESSOR FOR MIXED REFRIGERANTS	427
5.- AERODYNAMIC & MECHANICAL TRENDS	428
6.- IMPELLER HEAD PER STAGE	429

7.- SIDESTREAM LAYOUT	430
8.- COMPRESSOR DESIGN TRADEOFFS AND COMPROMISES	430
9.- ABRADABLE SEALS	430
10.- FLNG COMPRESSORS	431
11.- INTEGRALLY GEAR COMPRESSOR AND ISOTHERMAL COMPRESSION	431
12.- HIGH PRESSURE RATIO COMPRESSOR DEVELOPMENT	432
13.- LIQUID TOLERANT COMPRESSOR DEVELOPMENTS.....	433
14.- CO ₂ COMPRESSION	433
15.- COMPRESSOR DRIVERS FOR LNG LIQUEFACTION - TRENDS	433
16.- GAS TURBINE DRIVERS.....	434
LIX.- LATEST ADVANCES IN LNG COMPRESSORS	435
1.- INTRODUCTION.....	435
2.- PREVIOUS AND CURRENT TRAIN CONFIGURATIONS:	435
3.- FLNG COMPRESSORS.....	437
4.- HIGH-PRESSURE-RATIO COMPRESSOR DEVELOPMENT.....	437
5.- INTEGRALLY GEARED COMPRESSORS AND ISOTHERMAL COMPRESSION.....	437
6.- LIQUID-TOLERANT COMPRESSOR DEVELOPMENTS.....	438
7.- AERODYNAMICS IMPELLERS.....	438
8.- SEALS:	440
9.- VANED:	440
10.- SIDE STREAMS:	441
MECHANICAL DESIGN.....	441
11.- CASING:	441
12.- IMPELLER:	441
ROTORDYNAMIC.....	441
13.- LATERAL:	441
14.- TORSIONAL:	442
15.- OPERATING EXPERIENCE FOR RE-BUNDLE.....	442
16.- AUXILIARY SERVICES.....	442
17.- BOG COMPRESSOR:	442
18.- CO ₂ COMPRESSOR:	443
19.- OTHER COMPRESSORS:	443
LIX. A.- READYING PIPELINE COMPRESSOR STATIONS FOR 100% HYDROGEN.....	444
1.- HYDROGEN COMPRESSION	444
2.- MATERIAL CONSIDERATIONS.....	445
3.- TURBINE ADAPTATION	446
4.- THE ROAD AHEAD.....	447
LIX. B.- CENTRIFUGAL COMPRESSORS AS A VIABLE METHOD FOR FUEL GAS	
BOOSTING.....	447
1.- INTRODUCTION.....	447
2.- CENTRIFUGAL VERSUS RECIPROCATING COMPRESSORS.....	447
3.- STATE-OF-THE-ART CENTRIFUGAL COMPRESSORS.....	449
4.- NOMENCLATURE.....	451
SECTION 24.- PROBLEMS CAUSING LOW RELIABILITY IN CENTRIFUGAL	
COMPRESSORS	452

LX.- COMPRESSOR PROBLEMS CAUSING LOW RELIABILITY	452
1.- INCRUSTATION.....	452
2.- COKE DEPOSITION.....	452
3.- SALT DEPOSITION.....	454
4.- MACHINERY COMPONENT FAILURES.....	455
4.1.- Shafts.....	456
4.2.- Stresses Acting on a Shaft.....	456
4.3.- Fatigue Failures.....	458
4.4.- Shaft Wear.....	459
4.5.- Shaft Distortion.....	460
4.6.- Hydrodynamic Bearings.....	460
4.7.- Operation of a Hydrodynamic Bearing.....	461
1. Hydrodynamic lubrication or full film lubrication.	461
2. Elastohydrodynamic lubrication or thin film lubrication.	461
3. Boundary lubrication.....	461
4.8.- Hydrodynamic Bearing Construction.....	462
4.9.- Hydrodynamic Bearing Failure Analysis.....	462
4.10.- Fatigue Failures.....	463
4.11.- Bearing Metal Wear.....	463
4.13.- Effect of Hard Particles on Bearings.....	464
4.14.- Effect of Lubrication.....	465
4.15.- Effect of Temperature.....	466
4.16.- Effect of Overloads.....	467
4.17.- Assembly Deficiencies.....	467
4.18.- Electrical Discharge Damage.....	467
4.19.- Fabrication-related Failures.....	468
5.- DESIGN-RELATED FAILURES.....	470
6.- COMPRESSOR TYPES AND APPLICATIONS.....	470
LXI.- THE EFFECTS ABOUT THE FOULING IN CENTRIFUGAL COMPRESSORS	472
1.- INTRODUCTION.....	472
2.- THE MECHANISM OF FOULING.....	472
3.- THE EFFECT OF FOULING ON THE OPERATING POINT.....	473
4.- THE CAUSES OF FOULING.....	475
5.- DETECTING FOULING BY CONDITION MONITORING.....	476
6.- CONDITION MONITORING GUIDELINES TO DETERMINE FOULING:.....	477
7.- PREVENTING AND CORRECTING FOULING.....	477
7.1.- Preventing and correcting fouling.....	477
7.2.- Preventing fouling.....	477
LXI. A.- FOULING CONSIDERATIONS AND COATINGS	479
1.- POLYMERIZATION AND FOULING.....	479
2.- FOULING AND ITS EFFECT ON COMPRESSOR OPERATION.....	480
3.- COATING CASE STUDY.....	481
4.- SERMALON COATING.....	482
5.- RESULTS.....	483
LXI. B.- DEVELOPMENT OF NEW ON-LINE WASH OIL INJECTION SYSTEM FOR CENTRIFUGAL COMPRESSOR	483
1.- INTRODUCTION.....	483

2.1.- STEP-1. INVESTIGATION OF CONVENTIONAL MODEL.....	485
2.2.- STEP-2. DEVELOPMENT OF NEW CONCEPT OF ON-LINE WASH.....	485
2.3.- STEP-3&4 VERIFICATION TEST OF DEVELOPED NEW CONCEPT.....	487
3.- RISK ASSESMENT OF DEVELOPED WASH OIL INJECTION SYSTEM.....	488
4.- EFFECTIVENESS EVALUATION ON ACTUAL MACHINE.....	489
5.- CONCLUSIONS.....	489

SECTION 25.- MATERIAL SELECTION IN SEVERE SERVICES FOR OIL, GAS & PETROCHEMICAL INDUSTRIES, FOR CENTRIFUGAL COMPRESSORS.....490

LXI. C.- MATERIALS SELECTION AND DEVELOPMENT FOR CENTRIFUGAL COMPRESSORS OPERATING IN EXTREME SOUR & ACID GAS SERVICE490

1.- INTRODUCTION	490
2.- DESIGN SPACE	490
2.1, - Condensed Water or Moisture	491
2.2.- The partial pressures of acid gas and the related corrosion mechanism	492
2.3.- Contaminants in the water (i.e. Chlorides)	492
2.4.- Stress distribution	493
3.- MATERIAL SELECTION BY STANDARDS	493
4.- FIELD EXPERIENCE	494
Figure LXI. C.3 Centrifugal compressor impeller failure.....	494
Figure LXI. C.4 Intergranular fracture surface	495
Figure LXI. C.5 Heavy pitting on impeller flow path	495
Figure LXI. C.6 Crack origin from pit and propagation	496
5.-RISK MANAGEMENT BY FIT-FOR-PURPOSE MATERIAL SELECTION	496
5.1.- Testing Experience	496
6.- RECENT DEVELOPMENT IN MATERIAL FOR CC	498
6.1.- Wrought and Casted Nickel-Based Alloys	498
6.2.- Commercial Alloys	498
6.3.- Bridge Alloys	499
6.4.- Advanced Manufacturing Processes	500
6.5.- Powder Metallurgy HIP (Hot Isostatic Pressing)	500
6.6.- Additive Manufacturing	502
7.- CONCLUSIONS	503
8.- NOMENCLATURE	503

LXI. D.- HOW TO SELECT MATERIALS FOR CENTRIFUGAL COMPRESSORS.....504

1.- PROPERTIES WHICH REQUIRE CONSIDERATION.....	504
2.- ASPECTS TO BE CONSIDERED.....	504
3.- IMPELLER FABRICATION.....	505
4.- IMPELLER MATERIALS.....	508
5.- SULFIDE CRACKING.....	511
5.1.- Background.	511
5.2.- Essential features.	511
5.3.- Inhibition.....	511
5.4.- Metallurgical condition.	511
5.5.- Effect of pH.	512
5.6.- Effect of temperature.	512
5.7.- Service experience.	512
5.8.- Prevention.	514

6.- HYDROGEN ENVIRONMENT EMBRITTLEMENT.....	514
6.1.- Types of hydrogen environment embrittlement.....	514
6.2.- Features of hydrogen environment embrittlement.....	515
6.3.- Categories of hydrogen environment embrittlement.....	515
6.4.- Effect of variables.....	515
6.5.- Prevention.....	516
7.- LOW TEMPERATURE OPERATION BRITTLE FAILURE.....	517
7.1.- Background.....	517
7.2.- Criteria for resistance to brittle fracture.....	517
7.3.- Materials and fabricating procedures.....	518
7.4.- Materials for rotating parts.....	518
8.- STABILITY.....	519
9.- ROTATING PARTS.....	520

SECTION 26.- THEORY, APPLICATIONS, MATERIALS, CONTAMINATION, OPERATION, MAINTENANCE, CASES STUDIES & TECHNICAL ADVANCE ISSUES FOR A HIGH RELIABILITY IN DRY GAS SEALS SYSTEMS & SUPPORTS IN CENTRIFUGAL COMPRESSORS.....521

TECHNICAL ASPECTS ABOUT DRY GAS SEALS IN CENTRIFUGAL COMPRESSORS.....521

LXII.- DRY GAS SEAL SYSTEMS FOR CENTRIFUGAL COMPRESSORS	521
1.- DRY GAS SEAL FACES.....	521
2.- SLOW SPEED OPERATION OF SEAL FACES (SLOW ROLL).....	522
3.- TYPES OF DRY GAS SEALS.....	523
3.1.- Single seal.....	524
3.2.- Double seal.....	524
3.3.- Tandem seal.....	524
3.4.- Separation (barrier) seal.....	525
3.5.- Separation gas.....	525
4.- SEAL GAS CONTROL METHODS.....	526
5.- SEAL GAS CONDITIONING.....	527
6.- DRY GAS SEAL VENT SYSTEM.....	528
7.- DRY GAS SEAL IN CRYOGENIC APPLICATIONS.....	528
8.- SULFUR CONTAMINATION.....	529
9.- STORAGE AND PROTECTION OF DRY GAS SEALS.....	530

LXII. A.- SEAL TYPES.....	530
1.- TANDEM SEAL WITH INTERMEDIATE LABYRINTH.....	530
2.- TANDEM SEAL.....	531
3.- DOUBLE SEAL.....	531
4.- SINGLE SEAL.....	532
5 SEPARATION SEALS.....	532
5.1.- General.....	532
5.2.- Non-contacting Bushing Seal.....	532
5.3.- Labyrinth Seal.....	533
5.4.- Contacting Bushing Seal.....	533
6.- PROCESS SIDE SEALS.....	534
6.1.- General.....	534
6.2.- Labyrinth Seal.....	534
6.3.- Abradable Seal.....	534

6.4.- Non-contacting Bushing Seal.....	535
7.- SEAL NOMENCLATURE.....	536
8.- DRY GAS SEAL SELECTION GUIDE.....	540
9.- DRY GAS SEAL MATERIALS.....	540
9.1.- General.....	540
9.2.- Rotating Seal Face—Silicon Carbide, Silicon Nitride, Tungsten Carbide, and Steel.....	541
9.3.- Stationary Seal Face—Carbon Graphite and Silicon Carbide.....	542
9.4.- Seal Face Operation.....	542
9.5.- Sleeves, Retainers, Housings, Disk, and Carrier—Metals.....	545
9.6.- Static and Dynamic Sealing Elements.....	546
9.7.- Spring Energized Polymer Seals.....	547
9.8.- Static and Dynamic Sealing Element Materials.....	547
9.9.- Springs, Fasteners, Drive, Anti-rotation, Centralizing Devices, and Labyrinths.....	548
9.10.- Fasteners.....	548
9.11.- Dowels, Drive, and Anti-rotation Devices.....	549
9.12.- Centering Devices.....	549
9.13.- Labyrinths.....	550
10.- DAMAGE IN DRY GAS SEALS (DGS).....	551
10.1.- Seal Faces.....	551
10.2.- Metallic Components.....	554
10.3.- Static and Dynamic Sealing Elements	555
11.- MISCELLANEOUS ITEMS.....	556
11.1.- Centering Elements.....	556
11.2.- Labyrinths and Carbon Rings.....	557
LXIII.- TANDEM SEAL FOR DRY GAS APPLICATIONS.....	561
1.- TANDEM SEALS FOR SATURATED GAS APPLICATIONS.....	562
2.- TANDEM SEALS WITH INTERSTAGE LABYRINTH.....	562
LXIV.- DRY GAS SEAL TYPES FOR LOW- AND HIGH-PRESSURE APPLICATIONS.....	563
1.- LOW/MEDIUM PRESSURE APPLICATIONS – DRY AIR OR INERT GAS.	563
2.- HIGH PRESSURE APPLICATIONS.....	563
LXV.- SEAL FACE MATERIALS AND THEIR APPLICATIONS.....	564
1.- FACE MATERIALS.....	564
LXVI.- DRY GAS SEALS, AUXILIARIES, AND SUPPORT SYSTEMS.....	565
1 . - DRY GAS SEALS (DGS).....	565
2 . - PRINCIPLE OF OPERATION.....	566
3.- MERITS OF USING DIFFERENT SEAL CONFIGURATIONS.....	567
3.1.- Tandem seal arrangement.....	567
3.2.- Double-seal arrangements.....	568
3 . 3 . - Dry gas seal support systems.....	569
4 . - SEAL GAS SUPPLY.....	570
5 . - MONITORING PRIMARY SEAL.....	570
6.- SECONDARY SEAL MONITORING.....	571
7.- SEPARATION SEAL SUPPLY SYSTEM AND MONITORING.....	571
8.- DRY GAS SEAL INNOVATIONS.....	572
9.- INCREASED SEALING PRESSURE CAPABILITIES.....	573
10.- EXPANDING TEMPERATURE CAPABILITIES.....	574
11.- REDUCING SEAL LEAKAGE.....	575

12.- SLOW ROLL TURNING AND RATCHETING.....	576
13.- SEPARATION SEALS.....	577
14.- INCREASING SEAL RELIABILITY.....	578
15.- DUAL-PHASE GAS.....	579
16.- MATERIAL SELECTION.....	580
17.- ROTATING FACE.....	582

LXVII.- THE PROS AND CONS OF DRY GAS SEALS INSTALLATION IN GAS COMPRESSOR.....	583
1.- SHAFT SEAL TYPES COMPARISON.....	583
2.- WHY CHANGE? (THE PROS).....	584
3.- WHY CHANGE? (THE CONS).....	584

LXVII. A.- DRY GAS SEAL ADVANCEMENTS ADDRESS SEALING PRESSURE, TEMPERATURE RANGE, FACE CONTACT, LEAKAGE AND OIL MIGRATION.....	585
1.- SEALING PRESSURE.....	585
2.- TEMPERATURE RANGE.....	586
3.- FACE CONTACT.....	586
4.- LEAKAGE.....	587
5.- SEPARATION SEAL.....	588
6.- SEALING MEDIA.....	588

LXVIII.- “MONITORING A TANDEM DRY GAS SEAL’S SECONDARY SEAL”	589
1.- INTRODUCTION.....	589
2.- DRY GAS SEAL OPERATION	589
3.- DRY GAS SEAL SUPPORT SYSTEM	590
4.- TRADITIONAL SEAL MONITORING	593
5.- CONCERNS WITH UNMONITORED SECONDARY SEALS	593
6.- CAUSES OF SECONDARY SEAL FAILURES	593
7.- OVERVIEW OF BASIC LEAKAGE MONITORING METHODS	594
8.- METHODS OF SECONDARY SEAL MONITORING	596
9.- MONITORING THE SECONDARY SEAL VIA MONITORING PRIMARY VENT PRESSURE	596
9.1.- Option 1: Pressure Control Valve	597
9.2.- Option 2: Spring-loaded Check Valves	597
9.3.- Option 3: Restriction Orifice.....	598
10.- MONITORING THE SECONDARY SEAL VIA MONITORING PRIMARY VENT FLOW	599
11.- MONITORING THE SECONDARY SEAL VIA SECONDARY VENT.....	599
11.1.- Option 1: Secondary Vent Pressure Monitoring	600
11.2.- Option 2: Secondary Vent Flow Monitoring	600
11.3.- Option 3: Process Gas Content Monitoring	601
12.- MONITORING SECONDARY SEAL VIA SEAL FACE TEMPERATURE	601
12.1.- Option 1: Seal Face Temperature	601
13.- SECONDARY SEAL MONITORING CHALLENGES FOR LOW PRESSURE APPLICATIONS... ..	602
14.- CONCLUSIONS	602
15.- NOMENCLATURE	602

LXIX.- A CASE STUDY IN DRY GAS SEAL TROUBLESHOOTING.....	602
1.- PRIMARY VENT LEAKAGE TREND.....	602

LXX.- DRY GAS SEALS IN OIL & GAS INDUSTRY.....	604
1.- WET SEAL SYSTEMS.....	604

2.- GAS SEALS.....	605
3.- SAFETY AND RELIABILITY.....	606
4.- INFORMED CHOICES.....	607
LXXI.- DESIGNING A DRY GAS SEAL SYSTEM: CONSIDERING ITS DISADVANTAGES.....	607
LXXII.- DRY GAS SEAL - OPERATION AND MAINTENANCE.....	608
1.- INSTALLATION.....	608
2.- EXERCISE THE GAS SEALS.....	608
3.- PREPARE THE COMPRESSOR.....	609
4.- INSTALL THE GAS SEALS.....	609
5.- COMMISSIONING.....	609
6.- STATIC TESTING.....	610
7.- DYNAMIC TESTING.....	610
LXXIII.- DRY GAS SEAL CONTAMINATION— LESSONS FROM THE FIELD.....	610
1.- INTRODUCCION.....	610
2.- CASE STUDY 1.....	611
2.1.- Gas Gathering Compressors.....	611
2.2.- Corrective actions.....	613
2.3.- Lessons learned.....	613
3.- CASE STUDY 2.....	615
3.1.- Gas Injection Compressor.....	615
3.2.- Corrective actions.....	618
3.3.- Lessons learned.....	618
4.- CASE STUDY 3.....	618
4.1.- Gas Injection Compressors.....	618
4.2.- Corrective actions.....	619
4.3.- Lessons learned.....	619
5.- CASE STUDY 4.....	620
5.1.- Gas Injection Compressors.....	620
5.2.- Corrective actions.....	620
5.3.- Lessons learned.....	620
6.- CASE STUDY 5.....	621
6.1.- Gas Processing Compressors.....	621
6.2.- Corrective actions.....	621
6.3.- Lessons learned.....	621
7.- CASE STUDY 6.....	622
7.1.- Gas Transmission Compressor.....	622
7.2.- Corrective actions.....	622
7.3.- Lessons learned.....	623
8.- CASE STUDY 7.....	623
8.1.- Gas Lift Compressors.....	623
8.2.- Corrective actions.....	623
8.3.- Lessons learned.....	623
LXXV.- ENGINEERED RESIDUAL STRESSES CAN BE USED TO LESSEN TURBOMACHINERY FAILURES.....	629
1.- STRESS CORROSION CRACKING.....	630
2.- FATIGUE.....	631
3.- CREEP.....	632

LXXVI.- DEALING WITH MIS-ALIGNMENT ISSUES ON NON-EQUALIZING THRUST BEARINGS.....	633
LXXVII.- CONTROLLING COMPRESSOR PERFORMANCE BY VARYING PROCESS VARIABLES.....	634
1.- CONTROL ELEMENT SELECTION FOR PERFORMANCE CONTROL DISCHARGE THROTTLE VALVE.....	635
2.- BLOW-OFF OR RECYCLE VALVE.....	635
3.- SUCTION THROTTLE VALVE.....	635
4.- ADJUSTABLE INLET GUIDE VANES (IGVS).....	636
5.- SPEED VARIATION.....	636
SECTION 28.- ROOT CAUSE ANALYSIS, COMPARATION WITH RECIP COMPRESSORS, FOUNDATION ISSUES AND FAILURE MECHANISMS IN CENTRIFUGAL COMPRESSORS.....	637
LXXVIII.- STEPS IN METALLURGICAL ROOT CAUSE ANALYSIS.....	637
1.- INTRODUCCION.....	637
2.- FAILURE INVESTIGATION.....	637
a. Material positive identification and chemical analysis of the base metal and foreign deposits	637
b. Non-Destructive Examination (NDE) of the failed component.....	637
3.- HARDNESS AND MECHANICAL TESTING.....	638
LXXIX.- WHEN CENTRIFUGAL AND RECIPROCATING COMPRESSORS ARE OPERATED TOGETHER.....	638
LXXX.- RECIP, SCREW OR CENTRIFUGAL COMPRESSOR? AN END-USER'S PERSPECTIVE.....	639
LXXXI.- MATERIALS THAT LINK THE ROTATING EQUIPMENT WITH THE FOUNDATION.....	641
LXXXII.- FAILURE MECHANISM ABOUT CASES IN STEAM TURBINES & GAS COMPRESSORS.....	642
1.- FATIGUE.....	643
2.- CORROSION FATIGUE AND STRESS CORROSION CRACKING.....	643
3.- EROSION – LIQUID OR SOLID PARTICLE.....	644
4.- CREEP.....	644
SECTION 29.- NEW ADVANCES IN SUBSEA FOR CENTRIFUGAL COMPRESSORS.....	645
LXXXIII.- WHAT THE SUBSEA COMPRESSION PROJECTS IN NORWAY TELL US.....	645
SECTION 30.- CHOKE OPERATION, RETROFITS IN COMPRESSORS.....	647
LXXXIV.- HOW DANGEROUS IS COMPRESSOR OPERATION AT CHOKE CONDITIONS.....	647
LXXXV.- RETROFITS TO SAVE ENERGY IN CENTRIFUGAL COMPRESSORS.....	648
LESSON LEARNT:	648
1.- CHANGE FROM WET SEALS TO DRY GAS SEALS.....	648
2.- ONLINE WASHING SYSTEMS.....	649
SECTION 31.- DESIGN ABOUT INDUCTION & SYNCHRONOUS ELECTRIC MOTORS FOR CENTRIFUGAL COMPRESSORS.....	650
LXXXVI.- ELECTRIC MOTORS DESIGNED TO DRIVE CENTRIFUGAL COMPRESSORS.....	650
1.- CORRECT MOTOR SIZE SELECTION.....	650
2.- CORRECT MOTOR TORQUE SELECTION.....	650
3.- MOTOR VOLTAGE AND STARTING METHOD.....	651

4.- WK2 OF THE COMPRESSOR.....	651
8.- CONTROL AND PROTECTIVE EQUIPMENT.....	652
8.1.- Temperature detectors (stator winding).....	652
8.2.- Bearing temperature detectors.....	652
8.3.- Lightning and surge protection.....	653
8.4.- Space heaters.....	653
8.5.- Differential protection.....	653
9.- MECHANICAL CONSIDERATIONS OF MOTOR-GEAR-COMPRESSOR ARRANGEMENT.....	653
10.- TORSIONAL ANALYSIS.....	653
14.- COUPLINGS--CHOICE IS IMPORTANT.....	653
LXXXVII.- SYNCHRONOUS VS INDUCTION MOTORS.....	655
SECTION 32.- CONTROLS, SURGE, ANTI-SURGE SYSTEMS, CONTROLLER	
TECHNICAL SPECIFICATIONS FOR CENTRIFUGAL COMPRESSORS.....	656
LXXXVIII.- MODIFYING CONTROL SETTINGS FOR HIGH VIBRATIONS AT STARTING.....	656
LXXXIX.- OPTIMIZING COMPRESSOR CONTROL SYSTEMS.....	657
1.- COMPRESSION STATION CONTROL SYSTEMS ELEMENTS.....	657
2.- INSTRUMENTATION.....	657
3.- CONTROL TASKS.....	658
4.- DANGEROUS OPERATIVE CONDITIONS.....	658
5.- RECYCLES AND SHUTDOWNS.....	659
6.-THE CASE STORY.....	659
7.- FINANCIAL AND ENVIRONMENTAL IMPACT OF THE OPTIMIZATIONS.....	661
8.- CONCLUSIONS.....	661
XC.- WHAT IS COMPRESSOR SURGE?.....	662
XC. A.- SURGE DETECTION SYSTEMS.....	663
XC. B.- VALIDATING ANTI-SURGE CONTROL SYSTEMS.....	665
1.- INTRODUCTION.....	665
2.- SIMULATION MODEL.....	665
3.- MODEL ASSUMPTIONS.....	666
4.- VALIDATION.....	667
5.- SIMULATION RESULTS.....	667
6.- CASES & SCENARIOS.....	667
- SCENARIO 1.....	667
6.1.- Case 1: open cold recycle valve.....	667
6.2.- Case 2: open hot recycle valve.....	668
6.3.- Case 3: opening hot and cold recycle Valves.....	668
7 SCENARIO 2.....	669
7.1.- Case 1: discharge valve closure (DVC) with OEM controller.....	669
7.2.- Case 2: DVC with purpose-built anti-surge.....	670
8- SCENARIO 3.....	671
8.1.- Case 1: Suction valve closure (SVC) (SDV80002) with OEM controller.....	671
9.- CONCLUSION.....	672
XC. C.- SURGE IDENTIFICATION.....	673
XCI.- CASE ABOUT A TECHNICAL SPECIFICATION FOR COMPRESSOR	
ANTI-SURGE CONTROLLERS.....	674
1.- GENERAL.....	674

1.1- Scope of Specification	674
1.2.- Supplied by Others	675
1.3.- Terminology	675
1.4.- References	675
2.- SYSTEM DESCRIPTION	676
A.- Control Systems Objectives	676
B.- Design Requirements	676
2.1. General	676
2.2. Microprocessor-Based Controller General Requirements	676
2.3. Anti-surge Controller Requirements	677
C.- System Availability.....	678
D.- Power Supply Effect.....	678
E.- Radio Frequency Interference (RFI) Effect.....	678
F.- Electrical Requirements.....	678
3.- SUBMITTALS.....	679
3.1.- Documentation.....	679
3.2.- System Specification.....	679
3.3.- Installation, Operation and Maintenance Manuals.....	679
3.4.- System Drawings.....	679
3.5.- Spare Parts.....	680
3.6.- Test Equipment.....	680
3.7.- Quality Assurance.....	680
3.8.- Site Conditions.....	680
3.9.- Data Sheet Units.....	680
4.- PRODUCTS.....	681
4.1.- General.....	681
4.2.- Design Criteria.....	681
a. Controllers.....	681
5.- CONSTRUCTION.....	681
6.- INSPECTION AND TESTING.....	681
6.1.- General.....	681
6.2.- Factory Testing.....	682
6.3.- Field Inspection and Testing.....	682
7.- IDENTIFICATION AND TAGGING.....	682
7.1.- Controller System Nameplates.....	682
7.2.- Interconnection Cables and Signal Wires.....	683
7.3.- Terminals.....	683
8.- PREPARATION FOR SHIPPING.....	683
8.1.- Packaging.....	683
8.2.- Shipping.....	683
XCI.A.- HOW TO INSTRUMENT CENTRIFUGAL COMPRESSORS.....	683
1.- SYSTEM CHARACTERISTICS.....	683
2.- VARIABLE SPEED CONTROL.....	684
3.1.- Discharge Throttling.....	685
3.2.- Suction throttling.....	685
4.- SURGE.....	687
5.- TYPICAL APPLICATIONS.....	687
SECTION 33.- VIBRATION PROBLEMS RELATED WITH CENTRIFUGAL COMPRESSORS.....	692

XCII.- UNDERSTANDING ABOUT RESONANCE ESSENTIAL TO SOLVE VIBRATION PROBLEMS IN COMPRESSORS	692
1.- STRUCTURAL RESONANCE:	692
2.- ROTOR CRITICAL SPEED:	692
3.- THE CHARACTERISTICS OF RESONANCE.....	693
4.- THE DAMPING FACTOR.....	693
5.- BENDING MODES.....	695
SECTION 34.- REFERENCES ABOUT BEARING DESIGN IN CENTRIFUGAL COMPRESSORS	696
XCIII.- THREE MAIN JOURNAL BEARING TYPES, THEIR SELECTION	696
1.- PRESSURE DAM BEARING.....	696
SECTION 35.- REVERSE ROTATION, NOISE ISSUES, MENACE OF HYDRATES AND ULTRASONIC CLEANING FOR CENTRIFUGAL COMPRESSORS	698
XCV.- DANGER OF REVERSE ROTATION OF COMPRESSORS	698
1.- ROOT CAUSE FAILURE ANALYSIS FINDINGS:	698
2.- MITIGATING ACTIONS.	698
3.- LESSONS LEARNED.....	699
XCVII.- BEST PRACTICES FOR REDUCING COMPRESSOR NOISE	699
XCVIII.- THE MENACE OF HYDRATES IN COMPRESSORS	700
1.- HOW TO PREVENT HYDRATE FORMATION.....	701
XCIX.- USING ULTRASONIC CLEANING IN ROTATING MACHINES	701
1.- LESS EFFECTIVE AND SLOW VS. MORE EFFECTIVE AND FASTER.....	701
2.- HOW ULTRASONIC CLEANING TECHNOLOGY WORKS.....	702
3.- THE SOLUTION: OMEGASONICS OMG4430.....	702
4.- THE RESULT: CLEAN TIME WAS REDUCED BY 75%.....	702
SECTION 36.- USE OF DIFFUSERS AND THERMOPLASTICS SEALS ISSUES IN CENTRIFUGAL COMPRESSORS	703
C.- HOW DIFFUSERS IN CENTRIFUGAL COMPRESSORS HAVE EVOLVED OVER THE YEARS	703
CII.- THE USE OF THERMOPLASTICS AS LABYRINTH SEAL MATERIAL IN CENTRIFUGAL COMPRESSORS	704
SECTION 37.- STRUCTURAL ISSUES, AUXILIARY SYSTEMS DESIGN, TYPES, FUCTIONS, TECHNICAL SPECIFICATIONS, REASONS OF LOW RELIABILITY, RELATED WITH CENTRIFUGAL COMPRESSORS	706
CIII.- STRUCTURAL AND MANUFACTURING CHARACTERISTICS OF CENTRIFUGAL COMPRESSORS AT THE HOUSING LEVEL	706
1.- HOUSINGS	706
2.- VERTICALLY DIVIDED HOUSINGS.	706
CIV.- THE AUXILIARY SYSTEMS FOR TURBO-COMPRESSORS	707
1.- INTRODUCTION.....	707
2.- OBJECTIVES.....	709
3.- THE AUXILIARY SYSTEM.....	709
4.- THE TYPES OF AUXILIARY SYSTEMS.....	710
CV.- AUXILIARY SYSTEM TYPES AND FUNCTIONS	710

1.- INTRODUCTION.....	710
2.- TYPES OF AUXILIARY SYSTEMS.....	710
3.- LUBRICATION SYSTEMS.....	711
4.- FLUID SEALING SYSTEMS.....	712
5.- BUFFER FLUID SYSTEMS.....	714
6.- PLANT UTILITY SYSTEMS.....	717
7.- SUMMARY OF SYSTEM FUNCTIONS, SIMILARITIES AND DIFFERENCES.....	717
CVI.- THE REASONS FOR INHERENTLY LOW AUXILIARY SYSTEM RELIABILITY.....	717
1.- INTRODUCTION.....	717
2.- A TYPICAL APPLICATION.....	717
3.- THE PRE-ORDER PHASE.....	718
4.- MAJOR LUBE DATA SHEET REQUIREMENTS PRIOR TO PURCHASE ORDER.....	719
5.- THE SYSTEM DESIGN.....	719
6.- LUBE OIL SYSTEM TECHNICAL DATA REVIEW AGENDA.....	719
7.- SYSTEM TESTING.....	720
8.- SHIPMENT PRESERVATION AND INSTALLATION.....	720
9.- A SITE PREVENTATIVE MAINTENANCE PROGRAM.....	720
CVII.- AUXILIARY OIL SYSTEM SPECIFICATIONS APPLICABLE TO COMPRESSORS.....	721
1.- SPECIFICATION FORMAT.....	721
2.- SPECIFIC DETAILS.....	722
2.1.- System type selection.....	722
2.2.- System arrangement.....	722
2.3.- Installation data.....	722
2.4.- Critical equipment requirements.....	722
2.5.- Basic system details.....	723
2.6.- Specific component requirements.....	723
2.7.- Reservoir, piping, and component material preferences.....	723
2.8.- Oil Pumps.....	724
2.9.- Couplings.....	724
2.10 Drivers.....	724
2.11.- Relief valves and check valves.....	724
2.12.- Control valves.....	724
2.13.- Transfer valves.....	724
2.14.- Oil Coolers.....	724
2.15.- Oil Filters.....	724
2.16.- Oil Accumulators.....	725
2.17.- Instrumentation and electrical systems.....	725
2.19.- Vendor data requirements.....	725
CVIII.- ASSURING AND MAINTAINING AUXILIARY SYSTEM RELIABILITY.....	725
1.- INTRODUCTION.....	725
2.- SPARE PART REQUIREMENT.....	725
3.- SHIPPING PROCEDURE.....	726
4.- EQUIPMENT PRESERVATION.....	726
5.- LIFTING.....	726
6.- PROTECTION.....	726
7.- ON-SITE INSPECTION AND PRESERVATION.....	726
8.- INSTALLATION PROCEDURES.....	726

9.- LEVELING.....	726
10.- PIPE STRESS CHECK.....	727
11.- GROUTING.....	727
12.- AUXILIARY SYSTEM FLUSHING.....	727
13.- SPECIFIC SYSTEM DESIGN.....	727
14.- FLUSHING.....	727
15.- FLUSHING LOOPS.....	728
16.- HELPFUL HINTS.....	728
17.- FILTER CARTRIDGE ASSEMBLY.....	729
18.- DETERMINATION OF ACCEPTABILITY.....	729
19.- EFFECTIVE FLUSHING - FINAL COMMENTS.....	730
20.- COMMISSIONING.....	730
20.1.- functional testing.....	730
21.- TYPICAL OIL CONSOLE SHIPPING PROCEDURE - COURTESY OF ELLIOTT CO.....	731
22.- AUXILIARY SYSTEM FLUSHING PROCEDURE –	732
23.- FUNCTIONAL LUBE/SEAL SYSTEM TEST PROCEDURE OUTLINE.....	735

SECTION 38.- SIZING LUBE OIL SYSTEMS IN COMPRESSORS.....738

CIX.- APPROACHES FOR SIZING IN LUBE OIL SYSTEMS.....	738
1.- GENERAL APPROACH TO EQUIPMENT SIZING.....	738
2.- MAIN AND AUXILIARY STANDBY PUMP.....	739
3.- DETERMINING PUMP CAPACITY.....	739
4.- PUMP'S MAXIMUM PRESSURE.....	739
5.- OIL COOLERS.....	742
6.- RESERVOIR.....	743
7.- OIL FILTERS.....	744
8.- OIL ACCUMULATOR.....	745
9.- OPTIMIZING COAST-DOWN TIME FOR RDTS.....	749
10.- KEY DESIGN PARAMETERS TO BE EXAMINED.....	750
11.- METHODOLOGY USED TO VALIDATE KEY PARAMETERS.....	750
12.- CASE STUDY 1:	751
13.- CASE STUDY 2:	752

SECTION 39.- FATORY AND PERFORMANCE TESTING SPECIFICATIONS AND ISSUES FOR CENTRIFUGAL COMPRESSORS.....755

CX.- HIGH-PRESSURE COMPRESSORS, HOW TO SELECT THE RIGHT TESTS.....	755
1.- TEST SELECTION.....	756

CXI.- SYSTEM DESIGN AUDIT AND FACTORY TESTING.....	756
1.- INTRODUCTION.....	756
2.- DESIGN AUDIT AGENDA.....	757
3.- CONFIRMATION OF SCOPE.....	757
4.- SCHEMATIC (P&ID) REVIEW.....	757
5.- DATA SHEET REVIEW.....	757
6.- EXCEPTIONS TO SPECIFICATIONS.....	757
7.- COMPONENT SIZING AUDIT.....	757
8.- SYSTEM REQUIREMENTS.....	758

9.- RESERVOIR SIZING, CONSTRUCTION, AND SUB-COMPONENT DETAILS.....	758
10.- PUMP AND DRIVER SIZING.....	759
10.1.- Pump performance.....	759
10.2.- Pump mechanical requirements.....	759
10.3.- Pump unit couplings.....	760
10.4.- Driver sizing.....	760
11.- RELIEF VALVE SELECTION.....	761
12.- CONTROL VALVE SELECTION.....	761
13.- BYPASS VALVE.....	761
14.- PRESSURE REDUCING VALVE.....	762
15.- TEMPERATURE CONTROL VALVES.....	762
16.- CONTROL VALVE SENSING LINE SNUBBER DEVICES (DAMPERS).....	763
17.- SUPPLY PIPE VELOCITY CHECKS.....	763
18.- TRANSFER VALVE SIZING.....	763
19.- COOLER SIZING.....	764
20.- FILTER SIZING.....	764
21.- INSTRUMENTATION.....	764
22.- CONSOLE LAYOUT AND COMPONENT ARRANGEMENT.....	764
23.- CONSOLE CONSTRUCTION.....	764
24.- MAINTENANCE ACCESSIBILITY.....	764
25.- ON-LINE TESTING AND CALIBRATION ACCESSIBILITY.....	765
26.- UTILITY SUPPLY ARRANGEMENT.....	765
27.- CONSIDERATIONS FOR COMPONENT DISASSEMBLY.....	765
28.- FACTORY TESTING AND INSPECTION.....	765
29.- TEST AGENDA.....	765
30.- FLUSHING.....	765
31.- CONFIRM ARRANGEMENT DETAILS.....	765
32.- CONFIRM PROPER TEST FLUID AND CAPACITY ARE PRESENT TO PRIOR TO INITIATION OF TEST.....	766
32.1.- Temporary test setup.....	766

CXII.- FACTORY TESTING OF CENTRIFUGAL COMPRESSORS.....	771
1.- INTRODUCTION.....	771
2.- CLASS OF PERFORMANCE TEST.....	771
3.- GUIDELINES AND TEST SETUP FOR NO-LOAD AND FULL-LOAD MECHANICAL TESTS.....	772
3.1 test sequence.....	774
3.2.- The 4 h running test.....	774
3.3.- Acceptance criteria.....	775
3.4.- Unbalanced rotor response.....	776
3.5.- Additional.....	776
3.6.- Posttest inspection.....	776
3.6.1.- Bearings and seals.....	776
3.6.2.- Compressor internals.....	776
3.6.3.- Hydraulic coupling fit.....	776
4.- ROTOR STABILITY TEST.....	776
4.1.- Casing excitation.....	777
4.2.- Rotor excitation.....	777
5.- MEASURING OF TRAIN PERFORMANCE USING TORQUE METERS.....	777

5.1.- Measurement using strain gages.....	778
CXIII.- TURBO-COMPRESSOR PERFORMANCE TESTING.....	780
1.- INTRODUCTION.....	780
1.1.- Reasons to shop performance test.....	780
1.2.- Shop performance test overview.....	780
2.- PTC-10 OBJECTIVE.....	780
3.- THE PRINCIPLES OF DYNAMIC SIMILARITY.....	781
4.- EQUIVALENT SPEED DETERMINATION.....	781
5.- EQUIVALENT SPEED VALIDATION PROCEDURE.....	781
6.- TEST PROCEDURE.....	782
7.- PRE-TEST MEETING.....	782
8.- SHOP TEST ACTIVITY.....	782
9.- FIELD TESTING.....	784
10.- ACCEPTANCE TESTING AND PERFORMANCE TRENDING.....	784
11.- ACCEPTANCE TESTING.....	784
12.- PERFORMANCE TRENDING.....	785
13.- 'REAL TIME' OPERATING POINT.....	786
14.- WHEN TO TAKE ACTION.....	786
 SECTION 40.- MACHINERY INSTALLATION AND COMMISSIONING ISSUES AND GUIDELINES TO INCREASE THE RELIABILITY IN CENTRIFUGAL COMPRESSORS.....	 787
CXIV.- BEST PRACTICES FOR MACHINERY INSTALLATION.....	787
1.- FOUNDATION PREPARATION:	787
2.- INSTALLATION OF LEVELLING PAD:	787
3.- EQUIPMENT ERECTION.....	787
 CXV.- MACHINERY INSTALLATION GUIDELINES.....	 788
1.- INTRODUCTION.....	788
2.- SITE PROCEDURES.....	788
3.- CONSTRUCTION SPECIAL TOOLS.....	789
4.- INSTALLATION MANUALS.....	789
5.- SPARE PARTS.....	790
6.- ON SITE STORAGE.....	790
7.- FOUNDATIONS.....	790
7.1.- General considerations.....	790
Figure CXV.3 Foundations.....	790
7.2.- Foundation bolts.....	790
8.- LEVELING.....	791
9.- GROUT (GENERAL).....	791
9.1.- Epoxy grout.....	792
9.2.- Non shrink or cementous grout.....	793
10.- PIPING.....	793
11.- GENERAL PRACTICES.....	793
12.- SHAFT ALIGNMENT.....	794
12.1.- General considerations.....	794
12.2.- Alignment parameters.....	794
13.- DOWELLING.....	795
14.- COUPLINGS.....	795

15.- CLEANING OF EQUIPMENT AND ASSOCIATED PIPE.....	796
16.- CHEMICAL CLEANING.....	796
17.- STEAM PIPING.....	796
18.- CLEANING OF EQUIPMENT.....	797
19.- FLUSHING OF LUBE OIL AND SEAL OIL SYSTEMS.....	797
20.- FINAL INSPECTION AND START-UP CHECKS.....	799
21.- FIRST START RUN IN AND INITIAL OPERATION.....	799
22.- APPENDIX.....	800
22.1.- Auxiliary system flushing procedure - Courtesy of M. E. Crane Consultant.....	800
CXVI.- GOOD MACHINERY INSTALLATION PROCEDURES.....	802
1.- FOUNDATION PREPARATION:	802
2.- INSTALLATION OF LEVELLING PAD:	802
3.- EQUIPMENT ERECTION:	802
4.- PIPING INSTALLATION AND ALIGNMENT:	803
5.- GUIDELINES FOR PIPELINE CLEANING/FLUSHING.....	804
5.1.- CLEANING BY WATER:	804
5.2.- AIR BLOWING:	804
5.3.- STEAM FLUSHING:	804
5.4.- CHEMICAL CLEANING:.....	805
5.5.- OIL FLUSHING:.....	805
5.6.- OIL FLUSHING PROCEDURES.....	805
6.- PRE-COMMISSIONING ACTIVITIES:	806
7.- MINIMUM REQUIREMENT OF WORKSHOP FOR SUCCESSFUL CENTRIFUGAL MACHINERY COMMISSIONING.....	806
7.1.- COMMISSIONING ACTIVITIES.....	807
CXVII.- PRACTICAL GUIDELINES FOR THE COMMISSIONING OF TURBOMACHINERY.....	813
SECTION 41.- INSPECTION, SHIPPING & ERECTION IN CENTRIFUGAL COMPRESSORS.....	815
CXVIII.- INSPECTION, SHIPPING AND ERECTION.....	815
1.- BALANCE AND RUNNING TESTS.	815
2.- FINAL INSPECTION AND ASSEMBLY.	816
3.- PREPARATION FOR SHIPMENT.	817
4.- INSTALLATION INSTRUCTIONS.	819
5.- FIELD DISASSEMBLY AND RUN-IN.	819
6.- ERECTION AND RUN-IN DATA.	822
SECTION 42.- TURBOCOMPRESSOR SPECIFICATIONS (MODELS) BY MANUFACTURERS & PACKAGERS.....	823
CXIX.- TURBOCOMPRESSOR SPECIFICATIONS (MODELS) BY MANUFACTURERS & PACKAGERS (BASED IN INFORMATION TECHNICALLY & COMMERCIALY AVAILABLE).....	823
PACKAGER GUIDE 2021	838