



Standard Specification for Design and Fabrication of Flue Gas Desulfurization System Components for Protective Lining Application¹

This standard is issued under the fixed designation D 4618; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This specification covers the design and fabrication of metal components for Flue Gas Desulfurization (FGD) equipment, including absorbers, tanks, chimney liners, ductwork and associated equipment that are to be lined for corrosion or abrasion resistance, or both.

1.2 Limitations

1.2.1 This specification is intended only to define the design considerations for successful application and performance of protective linings for FGD system components.

1.2.2 It does not cover structural performance of FGD components.

1.2.3 It does not cover use of metallic linings.

1.3 This specification represents the minimum requirements for lining work. In cases where the manufacturer's instructions and recommendations differ from this specification, these differences must be resolved before fabrication is started.

1.4 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.

1.5 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Design/Engineering Requirements

2.1 Rigidity:

2.1.1 The components shall be designed so that the interior metal surfaces are sufficiently rigid for the intended lining materials. Manufacturer's recommendations for maximum strains or deflection limits for the lining material shall be followed.

2.1.2 The weight of the lining system shall be considered in the structural design of the component.

2.1.3 The design shall consider the effects of pressure, wind, seismic and other design loads.

2.1.4 Vibration may cause flexing or high surface strains on the lining. This is of particular concern to rigid lining materials

and shall be minimized.

2.1.5 Special consideration shall be given to all conditions of potentially excessive strain such as unsupported bottom areas, oil-canning, out of roundness, sidewall-to-bottom joints, etc.

2.1.5.1 Where a component is on a concrete foundation, grouting shall be done if necessary to correct unsupported bottom areas.

2.1.5.2 Sand fill shall not be used for bottom support unless provisions are made to ensure that the sand cannot be lost due to erosion.

2.2 Accessibility:

2.2.1 All interior surfaces of the components shall be designed to be readily accessible for welding, grinding, surface preparation, and lining application.

2.2.2 The minimum manway size for a working entrance during lining application shall be 36 in. (900 mm) in diameter or 24 in. (600 mm) width by 36 in. (900 mm) height.

2.2.2.1 Closed components shall have a minimum of two manways, one near the top and one near the bottom, preferably located 180° apart to facilitate adequate ventilation for workers.

2.2.2.2 Additional or larger openings may be required to facilitate ventilation and material handling. The lining material applicator should be consulted for specific requirements.

2.3 Shell Penetrations:

2.3.1 Openings such as, inlets, manholes, and outlet nozzles shall be flush with the interior wall.

2.3.1.1 Inlet nozzles may extend into vessels if incoming fluids will be detrimental to lining materials.

2.3.2 Any exterior or interior connection shall be flanged in order to facilitate lining.

2.3.3 The maximum length of flanged nozzles, 4 in. (100 mm) and greater in diameter, shall not exceed the dimensions in Table 1.

2.3.3.1 Only 4 in. (100 mm) diameter and larger nozzles shall be used for maximum reliability of the lining system.

2.3.3.2 As an alternative to lined nozzles, compatible prefabricated, reinforced plastic, ceramic or alloy metal inserts (sleeves) may be used if they offer superior corrosion and abrasion protection. Lining shall overlap onto prefabricated liners.

2.3.3.3 If an insert is used as an alternate, the lining shall overlap onto the insert or some other means of ensuring an

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TABLE 1 Maximum Length of Nozzles

Nominal Nozzle Size, in. (mm)	Maximum Nozzle Length— Shell to Face of Flange, in. (mm)
4 (100)	8 (200)
6 (150)	12 (300)
8–24 (200–600)	16 (400)
26–36 (600–900)	24 (600)
Over 36 (900)	any length

adequate seal should be provided.

2.3.4 Lining thickness may dictate changes in nozzle dimensions to achieve design flow rates.

2.4 Appurtenances Inside Components:

2.4.1 The requirements in Sections 2 and 3 apply to any appurtenances that are being lined and installed inside a lined component, such as agitators, anti-swirl baffles, gaging devices, internal piping, ladders, and support brackets.

2.4.2 If appurtenances inside the component cannot be lined, they shall be made of corrosion-resistant materials. If alloys are used, the lining shall carry over the welded area onto the alloy a minimum of 3 in. (76 mm). Some linings may require special designs to protect the edge of the lining. If bolted connections are used, dielectric insulation shall be provided.

2.4.3 Heating elements shall be attached with a minimum clearance of 6 in. (150 mm) from the surface of the lined component. Greater clearance may be required to protect the lining from excessive temperature conditions depending on the temperature of the element.

2.4.4 Special precautions shall be taken in lined components where severe abrasion/impingement damage may occur. Precautionary design measures, such as wear plates, brick liners or added coating thickness, shall be considered when necessary.

2.5 Structural Reinforcement Members and Supports:

2.5.1 Structural reinforcement members (stiffeners) should be installed on the vessel exterior, wherever necessary. However, if such members are installed internally they shall be fabricated of simple closed shapes such as round bars, pipe, or box beams for ease of applying the lining material.

2.5.2 The use of box beams or pipe for internal supports is recommended. The use of angles, channels, I-beams and other complex shapes shall be avoided wherever possible. If they must be installed internally, these members shall be fully seal welded and the edges ground to a 1/8 in. (3 mm) minimum radius.

2.5.3 If closed chambers are formed with internal box beams or pipes, they shall be vented to the vessel exterior at the lowest point, so that pressures are not developed during operation and possible curing procedures and so that corrosion, due to localized lining failures, can be observed early.

3. Fabrication

3.1 Welds:

3.1.1 All internal welds to be lined shall be continuous without imperfections such as weld slag, weld spatter, rough surfaces, undercutting, high peaks, porosity, sharp corners, sharp edges and inadequate thickness shall be corrected (see Fig. 1).

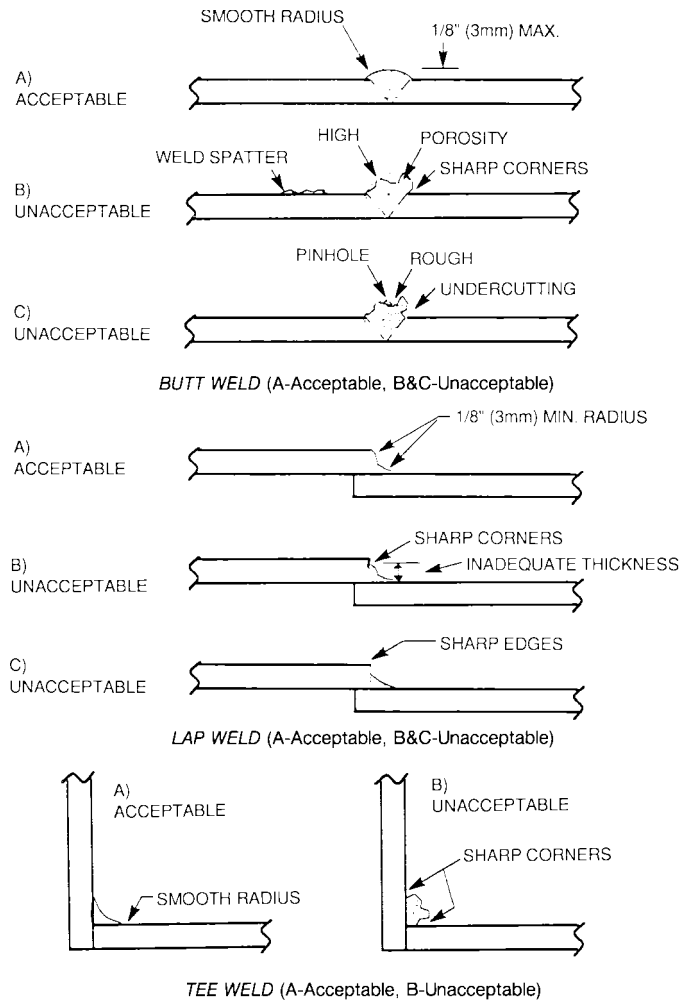


FIG. 1 Weld Fabrication for Lining Application

3.1.2 The degree of weld preparation prior to lining depends on the type of lining to be applied. The lining manufacturer must be consulted for specific requirements for weld preparation during the design of the component and prior to start of fabrication.

3.1.3 Use of weld display samples before and after grinding may be of help to the component fabricator in supplying acceptable welds with a minimum required rework. All welds shall be inspected, corrected, and reinspected prior to blast cleaning. Whenever possible, shop welds shall be inspected and imperfections corrected in the fabricator's shop.

3.1.3.1 All weld areas shall be inspected before and after blast cleaning. Pinholes, pits, blind holes, porosity, undercutting or similar depressions are not permissible in the finished surface. These shall be repaired. The profile shall be reestablished as required by the lining manufacturer.

3.1.4 Weld spatter shall be removed. Chipping may be utilized only if followed by grinding for the required surface finish.

3.1.4.1 The use of non-silicone, anti-spatter coating applied adjacent to weld areas is suggested. This coating shall be of a type that can be removed by the final blast cleaning.

3.1.5 After inspection, all undercuts and pinholes shall be eliminated by welding or grinding. All rough welds shall be

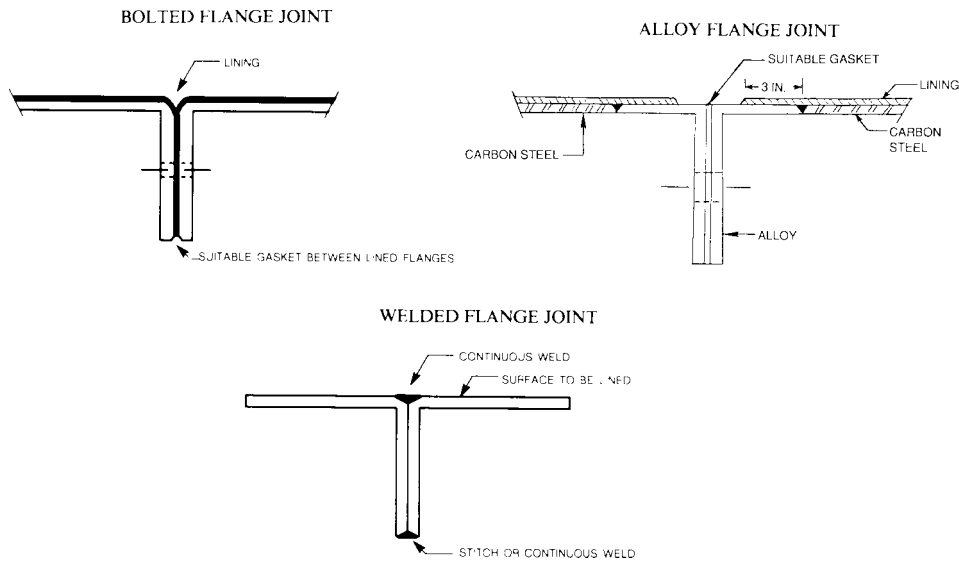


FIG. 2 Joint Fabrication for Lining Application

ground to remove sharp edges. Chipping may be used to remove sharp edges if followed by grinding.

3.1.6 All edges and similar abrupt contours shall be rounded off by grinding or machining to a 1/8-in. (3 mm) minimum radius.

3.1.7 Flame cut edges shall be avoided.

3.1.7.1 Where flame cut edges are necessary, they should be ground to removed hardened material prior to blasting.

3.1.8 Fillets and changes in contour shall be ground to a 1/8-in. (3-mm) minimum radius where required for the selected lining material. Any grinding done on welds, edges, and fillets shall be done carefully to eliminate potential problems caused by gouging of the parent metal.

3.1.9 All internal and external welding shall be completed prior to any lining application.

3.2 Joints:

3.2.1 All welds shall be continuous. Intermittent or spot welding is not permitted (see Fig. 2).

3.2.2 Riveted joints shall not be used. Internal bolted joints shall not be used except to avoid welding on an already lined surface. In this case, corrosion resistant alloy or nonmetallic bolts and suitable gasket or sealant shall be used.

3.2.3 If bolts are used to facilitate installation or welding, or both, of a component, they shall be removed and holes plug welded before lining application.

3.2.4 Lap welded joints shall be avoided whenever possible. Where they are necessary, the interior lap shall be a full fillet weld and finished as in accordance with 3.1.6.

3.2.5 Expansion joints and bolted flanged duct or shell joints require special lining consideration. Bolted flange joint surfaces shall be lined before assembly. Special consideration shall be given during erection and fit-up so as not to damage the lining.

3.2.5.1 If alloy flanges are used at expansion joints, the design must allow for the lining system to be applied over the alloy by 3 in. (75 mm). Some linings may require special designs to protect the leading edge.

3.3 During and after the lining of the equipment, no welding shall be allowed on the interior or exterior surfaces.

3.4 Signs shall be hung or stenciled on the exterior surface of the equipment designating the following: LINED EQUIPMENT, DO NOT BURN OR WELD. They shall be visible from all elevations and sides of the equipment.

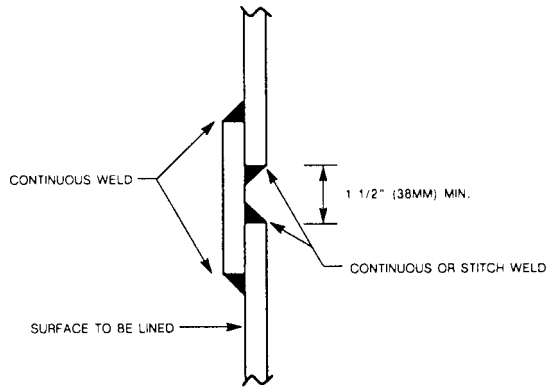
4. Miscellaneous

4.1 All lined surfaces should be clearly identified on all detail and arrangement drawings.

4.2 The following note shall appear on appropriate detail and arrangement drawings: All surfaces to be lined shall meet the requirements of ASTM Specification D 4618.

4.3 If hydrostatic testing is to be done prior to lining, it shall be performed with clean potable water.

DOUBLE LAP JOINT



CRIMP JOINT

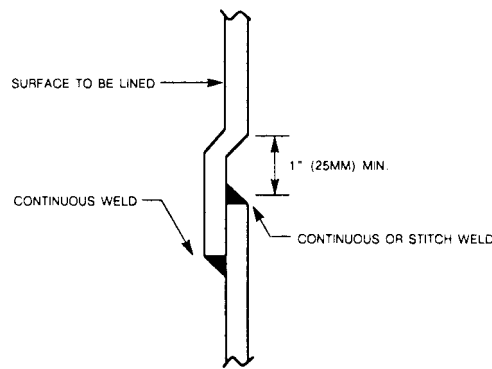


FIG. 2 Joint Fabrication for Lining Application (continued)

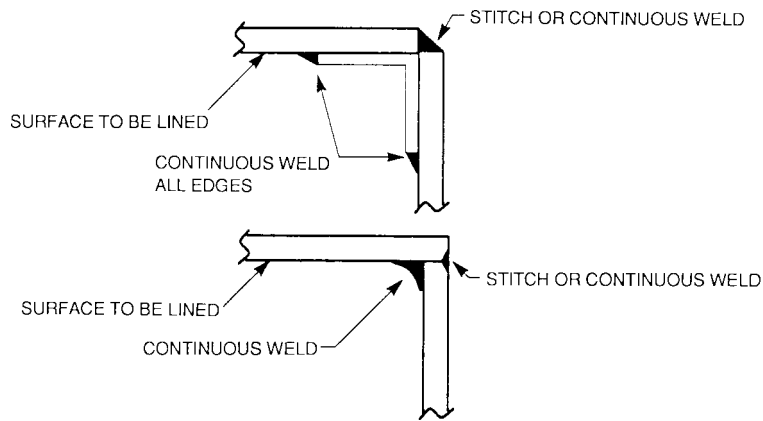


FIG. 2 Joint Fabrication for Lining Application (continued)

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