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## Vattenturbiner – Vägledning beträffande hydro-abrasiv erosion i Kaplan-, Francis- och Peltonturbiner

*Hydraulic machines –*

*Guide for dealing with hydro-abrasive erosion in Kaplan, Francis and Pelton turbines*

Som svensk standard gäller europastandarden EN 62364:2013. Den svenska standarden innehåller den officiella engelska språkversionen av EN 62364:2013.

### Nationellt förord

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**Hydraulic machines -  
Guide for dealing with hydro-abrasive erosion in Kaplan,  
Francis, and Pelton turbines  
(IEC 62364:2013)**

Machines hydrauliques -  
Guide relatif au traitement de l'érosion  
hydro-abrasive des turbines Kaplan,  
Francis et Pelton  
(CEI 62364:2013)

Wasserturbinen -  
Leitfaden für den Umgang mit  
hydroabrasiver Erosion in Kaplan-,  
Francis- und Pelton-Turbinen  
(IEC 62364:2013)

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Comité Européen de Normalisation Electrotechnique  
Europäisches Komitee für Elektrotechnische Normung

**CEN-CENELEC Management Centre: Avenue Marnix 17, B - 1000 Brussels**

## Foreword

The text of document 4/279/FDIS, future edition 1 of IEC 62364, prepared by IEC TC 4 "Hydraulic turbines" was submitted to the IEC-CENELEC parallel vote and approved by CENELEC as EN 62364:2013.

The following dates are fixed:

- latest date by which the document has to be implemented at national level by publication of an identical national standard or by endorsement (dop) 2014-05-01
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In the official version, for Bibliography, the following note has to be added for the standard indicated :

IEC 60193:1999      NOTE      Harmonised as EN 60193:1999 (not modified).

## CONTENTS

FOREWORD.....	5
INTRODUCTION.....	7
1 Scope.....	8
2 Terms, definitions and symbols .....	8
2.1 Units .....	8
2.2 Terms, definitions and symbols .....	9
3 Abrasion rate.....	11
3.1 Theoretical model.....	11
3.2 Introduction to the <i>PL</i> variable .....	13
3.3 Survey results .....	15
3.4 Reference model.....	16
4 Design.....	17
4.1 General.....	17
4.2 Water conveyance system.....	17
4.3 Valve.....	18
4.3.1 General .....	18
4.3.2 Selection of abrasion resistant materials and coating .....	18
4.3.3 Stainless steel overlays .....	19
4.3.4 Protection (closing) of the gap between housing and trunnion .....	19
4.3.5 Stops located outside the valve .....	19
4.3.6 Proper capacity of inlet valve operator.....	19
4.3.7 Increase bypass size to allow higher guide vane leakage .....	19
4.3.8 Bypass system design .....	20
4.4 Turbine.....	20
4.4.1 General .....	20
4.4.2 Hydraulic design.....	20
4.4.3 Mechanical design.....	22
4.4.4 Operation .....	28
4.4.5 Spares and regular inspections .....	29
4.4.6 Particle sampling and monitoring.....	29
5 Abrasion resistant materials .....	30
5.1 Guidelines concerning relative abrasion resistance of materials including abrasion resistant coatings.....	30
5.1.1 General .....	30
5.1.2 Discussion and conclusions.....	31
5.2 Guidelines concerning maintainability of abrasion resistant coating materials.....	32
5.2.1 Definition of terms used in this subclause .....	32
5.2.2 Time between overhaul for protective coatings .....	32
5.2.3 Maintenance of protective coatings.....	33
6 Guidelines on insertions into specifications .....	34
6.1 General.....	34
6.2 Properties of particles going through the turbine.....	35
6.3 Size distribution of particles .....	35
6.4 Mineral composition of particles for each of the above mentioned periods .....	36
Annex A (informative) <i>PL</i> calculation example.....	37
Annex B (informative) Measuring and recording abrasion damages .....	39

Annex C (informative) Water sampling procedure .....	52
Annex D (informative) Procedures for analysis of particle concentration, size, hardness and shape .....	53
Annex E (informative) Tests of abrasion resistant materials .....	56
Annex F (informative) Typical criteria to determine overhaul time due to abrasion erosion .....	67
Annex G (informative) Example to calculate the amount of erosion in the full model .....	68
Annex H (informative) Examples to calculate the TBO in the reference model.....	70
Bibliography.....	73
Figure 1 – Estimation of the characteristic velocities in guide vanes, $W_{GV}$ , and runner, $W_{run}$ , as a function of turbine specific speed .....	13
Figure 2 – Example of flow pattern in a Pelton injector at different load .....	14
Figure 3 – Example of protection of transition area .....	19
Figure 4 – Runner blade overhang in refurbishment project .....	21
Figure 5 – Example of “mouse-ear” cavitation on runner band .....	22
Figure 6 – Detailed design of guide vane trunnion seals .....	23
Figure 7 – Example of fixing of facing plates from the dry side .....	25
Figure 8 – Head cover balancing pipes with bends.....	26
Figure 9 – Step labyrinth with optimized shape for hard coating .....	28
Figure 10 – Development of spiral pressure over time.....	33
Figure D.1 – Typical examples of particle geometry .....	55
Figure E.1 – Schematic of test rig used for test 1 .....	56
Figure E.2 – ASTM test apparatus .....	58
Figure E.3 – Test coupon.....	59
Figure E.4 – Slurry pot test facility .....	60
Figure E.5 – High velocity test rig .....	61
Figure E.6 – Samples are located on the rotating disk .....	62
Figure E.7 – Comparison of two samples after testing.....	62
Figure E.8 – Whole test system of rotating disk .....	62
Figure E.9 – Schematic of test rig used for test 8.....	64
Figure E.10 – Testing of samples on hydro abrasive stand .....	65
Figure E.11 – Cover of disc .....	65
Figure E.12 – Curve of unit abrasion rate with circumference velocity for 3 kinds of materials.....	66
Table 1 – Data analysis of the supplied questionnaire.....	16
Table 2 – Overview over the feasibility for repair C .....	33
Table 3 – Form for properties of particles going through the turbine.....	35
Table 4 – Form for size distribution of particles.....	36
Table 5 – Form for mineral composition of particles for each of the above mentioned periods .....	36
Table A.1 – Example of documenting sample tests .....	37
Table A.2 – Example of documenting sample results .....	38
Table B.1 – Inspection record, runner blade inlet form .....	44

Table B.2 – Inspection record, runner blade outlet form .....	45
Table B.3 – Inspection record, runner band form.....	46
Table B.4 – Inspection record, guide vanes form.....	47
Table B.5 – Inspection record, facing plates and covers form.....	48
Table B.6 – Inspection record, upper stationary seal form.....	49
Table B.7 – Inspection record, upper rotating seal form .....	49
Table B.8 – Inspection record, lower stationary seal form .....	50
Table B.9 – Inspection record, lower rotating seal form.....	51
Table E.1 – Relative wear resistance in laboratory test 1 .....	57
Table E.2 – Relative wear resistance in laboratory test 2 .....	57
Table E.3 – Relative wear resistance in laboratory test 3 .....	58
Table E.4 – Relative wear resistance in test 4.....	59
Table E.5 – Results of test.....	60
Table E.6 – Results of test.....	61
Table E.7 – Results from test.....	63
Table E.8 – Relative wear resistance in laboratory test 8 .....	64
Table E.9 – Results of relative wear resistance for some materials ( $U = 40\text{m/s}$ ).....	66
Table G.1 – Calculations.....	69
Table H.1 – Pelton turbine calculation example.....	70
Table H.2 – Francis turbine calculation example .....	71

## INTERNATIONAL ELECTROTECHNICAL COMMISSION

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**HYDRAULIC MACHINES –  
GUIDE FOR DEALING WITH HYDRO-ABRASIVE EROSION  
IN KAPLAN, FRANCIS, AND PELTON TURBINES**

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The text of this standard is based on the following documents:

FDIS	Report on voting
4/279/FDIS	4/283/RVD

Full information on the voting for the approval of this standard can be found in the report on voting indicated in the above table.

This publication has been drafted in accordance with the ISO/IEC Directives, Part 2.



The committee has decided that the contents of this publication will remain unchanged until the stability date indicated on the IEC web site under "<http://webstore.iec.ch>" in the data related to the specific publication. At this date, the publication will be

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- withdrawn,
- replaced by a revised edition, or
- amended.

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## INTRODUCTION

Many owners of hydroelectric plants contend with the sometimes very aggressive deterioration of their machines due to particle abrasion. Such owners must find the means to communicate to potential suppliers of machines for their sites, their desire to have the particular attention of the designers at the turbine design phase, directed to the minimization of the severity and effects of particle abrasion.

Limited consensus and very little quantitative data exists on the steps which the designer could and should take to extend the useful life before major overhaul of the turbine components when they are operated under severe particle abrasion service. This has led some owners to write into their specifications, conditions which cannot be met with known methods and materials.

## **HYDRAULIC MACHINES – GUIDE FOR DEALING WITH HYDRO-ABRASIVE EROSION IN KAPLAN, FRANCIS, AND PELTON TURBINES**

### **1 Scope**

This Guide serves to:

- a) present data on particle abrasion rates on several combinations of water quality, operating conditions, component materials, and component properties collected from a variety of hydro sites;
- b) develop guidelines for the methods of minimizing particle abrasion by modifications to hydraulic design for clean water. These guidelines do not include details such as hydraulic profile shapes which should be determined by the hydraulic design experts for a given site;
- c) develop guidelines based on “experience data” concerning the relative resistance of materials faced with particle abrasion problems;
- d) develop guidelines concerning the maintainability of abrasion resistant materials and hard facing coatings;
- e) develop guidelines on a recommended approach, which owners could and should take to ensure that specifications communicate the need for particular attention to this aspect of hydraulic design at their sites without establishing criteria which cannot be satisfied because the means are beyond the control of the manufacturers;
- f) develop guidelines concerning operation mode of the hydro turbines in water with particle materials to increase the operation life;

It is assumed in this Guide that the water is not chemically aggressive. Since chemical aggressiveness is dependent upon so many possible chemical compositions, and the materials of the machine, it is beyond the scope of this Guide to address these issues.

It is assumed in this Guide that cavitation is not present in the turbine. Cavitation and abrasion may reinforce each other so that the resulting erosion is larger than the sum of cavitation erosion plus abrasion erosion. The quantitative relationship of the resulting abrasion is not known and it is beyond the scope of this guide to assess it, except to recommend that special efforts be made in the turbine design phase to minimize cavitation.

Large solids (e.g. stones, wood, ice, metal objects, etc.) traveling with the water may impact turbine components and produce damage. This damage may in turn increase the flow turbulence thereby accelerating wear by both cavitation and abrasion. Abrasion resistant coatings can also be damaged locally by impact of large solids. It is beyond the scope of this Guide to address these issues.

This guide focuses mainly on hydroelectric powerplant equipment. Certain portions may also be applicable to other hydraulic machines.