TABLE OF CONTENTS

1 INTRODUCTION 1-1

2 HRSG TUBE DESIGN 2-1

2.1 OVERVIEW 2-1
2.2 TYPICAL HRSG LAYOUT 2-2
2.3 GENERAL TUBE DESIGN CONSIDERATIONS 2-4
2.3.1 Tube Materials 2-4
2.4 WATER CHEMISTRY IN HRSGS 2-9
2.4.1 Tube Failures Related to Water Chemistry 2-11
2.4.2 Tube Failures Related to Layup 2-11
2.5 TUBE FABRICATION 2-13
2.5.1 Tube Bends 2-13
2.5.2 Tube-to-Header Welds 2-14
2.5.3 Seam Welds 2-15
2.5.4 Butt Welds 2-16
2.5.5 Groove Welds 2-16
2.5.6 Tube Fins 2-18

3 HRSG TUBE FAILURE DIAGNOSTICS 3-1

3.1 DIAGNOSING THE PROBLEM 3-1
3.2 TUBE FAILURE DIAGNOSTIC ELEMENTS 3-2
3.3 TUBE FAILURE DIAGNOSTIC CHARTS 3-3
3.3.1 Failure Diagnosis Charts 3-3
3.3.2 Failure Cause Specification Sheets 3-3
3.4 FAILURE CAUSE SPECIFICATION SHEETS 3-25
3.4.1 Corrosion Fatigue 3-26
3.4.2 Creep/Creep Fatigue 3-31
3.4.3 Deposition and Under-Deposit Corrosion 3-35
3.4.4 Erosive Wear and Flow Accelerated Corrosion 3-39
3.4.5 External Corrosion 3-44
3.4.6 Fatigue 3-47
3.4.7 Pitting 3-50
3.4.8 Stress Corrosion Cracking 3-54
3.4.9 Sulfuric Acid Dew Point Corrosion 3-59
3.4.10 Wear 3-62
3.4.11 Weld Defects 3-65
3.5 FAILURE CAUSES BY HRSG MODULE 3-70
3.5.1 Superheater Tube Failures 3-71
3.5.2 Reheater Tube Failures 3-75
3.5.3 Evaporator Tube Failures 3-77
3.5.4 Economizer Tube Failures 3-79
3.5.5 Feedwater Pre-Heater Tube Failures 3-81

4 ROOT CAUSE EVALUATIONS 4-1

4.1 OVERVIEW 4-1
4.2 ROOT CAUSE ANALYSIS PROCESS 4-1
4.2.1 Make Area Safe and Avoid Contamination 4-1
4.2.2 Visual Examination 4-2
4.2.3 Photography 4-2
4.2.4 Document Conditions 4-2
4.2.5 Identify Origin of Failure 4-2
4.2.6 Identify Mode of Failure 4-2
4.2.7 Identify Similar Locations 4-3
4.2.8 Select and Remove Tube Section 4-3

4.2.9 Perform Laboratory Tests and Examinations 4-4
4.3 ROOT CAUSE ANALYSIS CONCLUSIONS 4-5

5 TECHNICAL DESCRIPTIONS 5-1

5.1 SUMMARY 5-1
5.2 CORROSION FATIGUE 5-2
5.3 CREEP 5-3
5.3.1 Overview 5-3
5.3.2 Description of Damage Mechanism 5-3
5.3.3 Characteristics of Damage for HRSG Service 5-4
5.3.4 Component Life Prediction 5-5
5.3.5 Environmental Factors 5-5
5.3.6 Material Factors & Ranking 5-6
5.4 DEPOSITION AND UNDER-DEPOSIT CORROSION 5-8
5.4.1 Overview 5-8
5.4.2 Description of Damage Mechanism 5-8
5.4.3 Characteristics of Damage for HRSG Service 5-10
5.5 EROSION AND FLOW ACCELERATED CORROSION 5-11
5.5.1 Overview 5-11
5.5.2 Description of Damage Mechanism 5-11
5.5.3 Characteristics of Damage for HRSG Service 5-15
5.5.4 Component Life Prediction 5-19
5.5.5 Environmental Factors 5-22
5.5.6 Material Factors & Ranking 5-22
5.6 EXTERNAL CORROSION 5-24
5.6.1 Overview 5-24
5.6.2 Description of External Corrosion Mechanisms 5-24
5.6.3 Characteristics of External Corrosion Damage for HRSG Service 5-24
5.6.4 Characteristics of Damage for HRSG Service 5-25
5.6.5 Component Life Prediction 5-25
5.7 FATIGUE 5-26
5.7.1 Overview 5-26
5.7.2 Description of Damage Mechanism 5-26
5.7.3 Characteristics of Damage for HRSG Service 5-29
5.7.4 Stresses in Tubes 5-30
5.7.5 Fretting Fatigue 5-32
5.7.6 Creep Fatigue 5-33
5.7.7 Corrosion Fatigue 5-33
5.7.8 Low Cycle Fatigue / Thermal Shock 5-34
5.7.9 High Cycle Fatigue 5-36
5.7.10 Component Life Prediction 5-37
5.8 PITTING CORROSION 5-39
5.8.1 Overview 5-39
5.8.2 Description of Damage Mechanism 5-39
5.8.3 Characteristics of Damage for HRSG Service 5-39
5.8.4 Component Life Prediction 5-41
5.8.5 Environmental Factors 5-41
5.8.6 Material Factors & Ranking 5-41
5.9 STRESS CORROSION 5-42
5.9.1 Overview 5-42
5.9.2 Description of Damage Mechanism 5-42
5.9.3 Characteristics of Damage for HRSG Service 5-43
5.10 SULFURIC ACID CORROSION 5-46
5.10.1 Overview 5-46
5.10.2 Description of Sulfuric Acid Dew Point Corrosion Mechanism 5-46
5.10.3 Characteristics of Sulfuric Acid Damage for HRSG Service 5-47

5.10.4 Component Life Prediction 5-47
5.10.5 Environmental Factors 5-48
5.10.6 Material Factors & Ranking 5-50
5.11 WEAR 5-52
5.11.1 Overview 5-52
5.11.2 Description of Wear Damage Mechanisms 5-52
5.11.3 Characteristics of Wear Damage for HRSG Service 5-53
5.11.4 Component Life Prediction 5-55
5.11.5 Environmental Factors 5-55
5.12 WELD DEFECTS 5-56
5.12.1 Overview 5-56
5.12.2 Description of Damage Mechanism 5-56
5.12.3 Characteristics of Damage for HRSG Service 5-58
5.12.4 Component Life Prediction 5-59
5.12.5 Environmental Factors 5-59
5.12.6 Material Factors & Ranking 5-59

6 CASE STUDIES OF HRSG TUBE FAILURES 6-1

6.1 LP FEEDWATER TUBE #1 CASE STUDY 6-4
6.1.1 Background 6-4
6.1.2 As Received Specimen 6-4
6.1.3 Laboratory Test Plan 6-6
6.1.4 Optical Metallography 6-7
6.1.5 Optical Fractography 6-9
6.1.6 Base Material Test 6-11
6.1.7 Energy Dispersive Spectroscopy 6-11
6.1.8 Conclusion 6-11
6.1.9 Recommendations 6-12
6.2 REHEATER TUBE CASE STUDY 6-13
6.2.1 Background 6-13
6.2.2 As Received Condition 6-13
6.2.3 Laboratory Test Plan 6-14
6.2.4 Optical Metallography 6-15
6.2.5 Optical Fractography 6-16
6.2.6 Chemical Analysis 6-17
6.2.7 Tensile Test 6-17
6.2.8 Hardness Tests 6-18
6.2.9 Conclusion 6-18
6.2.10 Recommendations 6-18
6.3 LP FEEDWATER TUBE #2 CASE STUDY 6-19
6.3.1 Background 6-19
6.3.2 As-Received Condition 6-19
6.3.3 Section Plan 6-21
6.3.4 Optical Fractography 6-23
6.3.5 Optical Metallography 6-24
6.3.6 Scanning Electron Microscopy / Energy Dispersive Spectroscopy 6-26
6.3.7 Chemical Analysis 6-27
6.3.8 Conclusion 6-28
6.3.9 Recommendations 6-29

7 REFERENCES 7-1

8 APPENDIX 8-1

9 INDEX 9-1