

		PROCES-VERBAL D'ESSAI TEST REPORT CRYOGENIC TURBO EXPANDER			N° : C4058-NT-15 (1) Folio : 1 / 11	
AFFAIRE : RHEA JOB :		N° : 301 0914 N° :		Fiche Suiveuse n° : Inspection traveller n° :		
Identification du matériel : C7 508 HF₁ N° : 324-XT001 <i>Material identification :</i>			Quantité / <i>Quantity</i> : 1 Lot / <i>Batch</i> :			
Fournisseur/Fabricant : <i>Supplier / Manufacturer :</i> AIR LIQUIDE		Organisme de Contrôle : <i>Inspected by :</i> DTEC		Lieu : <i>Location :</i> Sassenage		
Documents de référence : <i>Reference documents :</i> PROCEDURE : D4444-PO-2			Instruments de contrôles utilisés : <i>Inspection instruments used :</i>			
			Type / <i>Type</i>		N° de Gestion/ <i>Control n°</i>	
			Test bed		504 9999 100	
MESURES		RESULTATS		OBSERVATIONS		
PIVOTERIE / <i>BEARINGS</i>		Pass				
VITESSES CRITIQUES <i>Critical speeds</i>		Pass				
SURVITESSE / <i>Overspeeds</i>		Pass				
DESCENTE EN FROID <i>Cold down</i>		Pass				
RENDEMENT / <i>Efficiency</i>		Pass		Limited by our test bench		
DECISION : <i>DECISION :</i> CONFORME / PASS <input checked="" type="checkbox"/> NON CONFORME / FAIL <input type="checkbox"/>			OBSERVATIONS : <i>COMMENTS :</i>			
	ESSAI / TEST	Responsable / Manager		A.Q. / Q.A.		
NOM / NAME	B. Renzetti L. Pelosi	F. Delcayre				
DATE / DATE	17 07 2013	17 07 2013				
SIGNATURE / VISA						

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1. SCOPE

This report is a summary of the tests of a Cryogenic turbo-expander cartridge, performed on DTA test bed according to the procedure D4444-PO-2.

2. PROCESS CONDITION

The data sheet in appendix gives the turbine process conditions specified by the customer.

3. GAS USED FOR THE TEST

Helium

Nitrogen

4. BEARING CONDITIONS

The diagrams in appendix give the gas bearing conditions :

- to be applied on site,
- to be applied during the test.

5. ANNEXES

TESTS REPORTS

TEST REPORT
5.1 THRUST BEARING TEST, LOW SPEED

(Items 6.1 of procedure)

 Cartridge number: C7 508 HF₁

Bearing conditions required: NORMAL

CASE	EXTREME 1	EXTREME 2	
INPUTS			
Load	23	1310	N
On	Brake	Turbine	Bearing
Equivalent pressure difference on the shaft	0	20	10 ⁵ Pa
OUTPUTS			
Inlet bearing pressure	18.00	18.03	10 ⁵ Pa
Outlet bearing pressure	2.15	2.11	10 ⁵ Pa
Turbine outlet pressure (1)	3.57	2.08	10 ⁵ Pa
Brake pressure (2)	3.93	17.13	10 ⁵ Pa
Pressure difference = (2) – (1)	-0.36	15.05	10 ⁵ Pa
Speed	>0	>0	Hz
Passed/failed	passed	passed	

TEST REPORT

5.2 THRUST AND JOURNAL BEARINGS TEST, HIGH SPEED

(Items 6.2 of procedure)

Cartridge number: C7 508 HF₁

Bearing conditions required: NORMAL

MODE	MINIMAL	NOMINAL	MAXIMAL	
INPUTS				
Turbine outlet design pressure (1)	14.1	12.4	9.6	10 ⁵ Pa
Brake design pressure (2)	11.2	14	16.8	10 ⁵ Pa
$\Delta = 2-1$	-2.9	1.6	7.2	10 ⁵ Pa
OUTPUTS				
Inlet bearing pressure	18.2	18.34	18.17	10 ⁵ Pa
Outlet bearing pressure	2.01	2.20	2.78	10 ⁵ Pa
Turbine outlet test pressure (1)	2.17	2.52	3.31	10 ⁵ Pa
Brake test pressure (2)	2.11	4.05	10.41	10 ⁵ Pa
$\Delta = (2) - (1)$	-0.06	1.53	+7.1	10 ⁵ Pa
Speed	936	909	698	Hz
Passed/failed	Passed	Passed	passed	

TEST REPORT

5.3 THRUST AND JOURNAL BEARING TEST, HIGH SPEED

(Items 6.2 of procedure)

Cartridge number: C7 508 HF₁

Bearing conditions required: ALARM AND STOP

BEARING CONDITIONS	ALARM	STOP	
Mode	Nominal	Nominal	
INPUTS			
Turbine design outlet pressure (1)	12.4	12.4	10 ⁵ Pa
Brake design pressure (2)	14	14	10 ⁵ Pa
$\Delta = 2-1$	1.6	1.6	10 ⁵ Pa
OUTPUTS			
Inlet bearing pressure		18.12	10 ⁵ Pa
Outlet bearing pressure		2.09	10 ⁵ Pa
Turbine outlet test pressure		2.43	10 ⁵ Pa
Brake outlet pressure		3.98	10 ⁵ Pa
$\Delta = 2-1$		1.56	10 ⁵ Pa
Speed		897	Hz
Passed/failed		passed	

TEST REPORT

5.4 CRITICAL SPEEDS AND SHAFT VIBRATIONS

(Items 6.3 of procedure)

Cartridge number: C7 508 HF₁

Bearing conditions required: STOP

INPUTS					
	1 st RIGID MODE		2 nd RIGID MODE		
Calculated peak freq.	650		750		H _z
OUTPUTS					
Measured critical speeds	BEGIN.	END	BEGIN.	END	
	500			650	H _z
Sound level estimation	B		B		
Time within the mode (> 3 ‘)					Min
Inlet bearing pressure	18.34		18.34		10 ⁵ Pa
Outlet bearing pressure	2.20		2.20		10 ⁵ Pa
Passed/failed	passed		passed		

Sound level estimation:

A: Inaudible

B: Perceptible

C: Noisy

D: Excessive

TEST REPORT

5.5 OVERSPEED TEST

(Items 6.4 of procedure)

Cartridge number: C7 508 HF₁

Bearing conditions required: NORMAL

INPUTS				
Nominal speed (Hz)		Maximum speed (Hz)		Over speed (Hz)
1060		1130		1140
OUPUTS				
BEARING TEST CONDITIONS				
BEARING GAS PRESSURE (10 ⁵ Pa)		BEARING GAS TEMPERATURE (°C)		BEARING GAS FLOW RATE (g/s)
SUPPLY	RETURN	SUPPLY	RETURN	
18.97	1.29	20.2	30.2	

TURBINE TEST CONDITIONS

TURBINE PRESSURE (10 ⁵ Pa)		TURBINE TEMPERATURE (K)		TURBINE FLOW RATE (g/s)
SUPPLY	RETURN	SUPPLY	RETURN	
8.81	2.70	297.9	245.2	

BRAKE TEST CONDITIONS

INLET BRAKE PRESSURE 10 ⁵ Pa	OUTLET BRAKE TEMPERATURE °C
3.12	38.7

TEST RESULTS

ROTATION SPEED H _z	STEADY STATE	OVERSPEED STATE DURATION (mn)	COMMENTS	
			FAIL	PASS
1146	A	3		X

Steady state evaluation:

A: Stable

B: Noisy

C: Unstable

TEST REPORT

5.6 COOL DOWN, START-UP AND SHUT-DOWN

(Items 6.5 and 6.6 of procedure)

Cartridge number: C7 508 HF₁

Bearing conditions required: normal

Nominal speed:

	AMBIENT	MEDIUM	+10% K	NOMINAL	- 10%	
Target outlet temperature	250	240	225	206	185	K
TURBINE :						
Inlet pressure	7.01		7.16	7.11	7.50	10 ⁵ Pa
Outlet pressure	2.43		2.36	2.42	2.47	10 ⁵ Pa
Inlet temperature	287.83		266.22	245.65	222.44	K
Outlet temperature	247.89		224.63	206.34	183.8	K
Flow	130.5		138.5	142.2	158.3	g/s
U1/C0	0.26		0.28	0.29	0.31	
μ	40.4		43.8	45.9	48.6	%
BRAKE :						
Inlet pressure	3.98		3.81	3.96	4.01	10 ⁵ Pa
Outlet temperature	31.3		53.3	57.7	57.3	°C
BEARING :						
Inlet pressure	18.1		18.22	17.99	18.3	10 ⁵ Pa
Outlet pressure	2.1		2.02	2.11	2.17	10 ⁵ Pa
Inlet temperature	19.5		18.4	17.9	17.5	°C
Outlet temperature	25.7		26.1	25.8	22.3	°C
Inlet flow	26.5			26.4	27	g/s
SPEED :	897		956	932	947	Hz
Number of start up/shut down	3	 	 	 	3	
Fail/pass	passed	passed	passed	passed	passed	

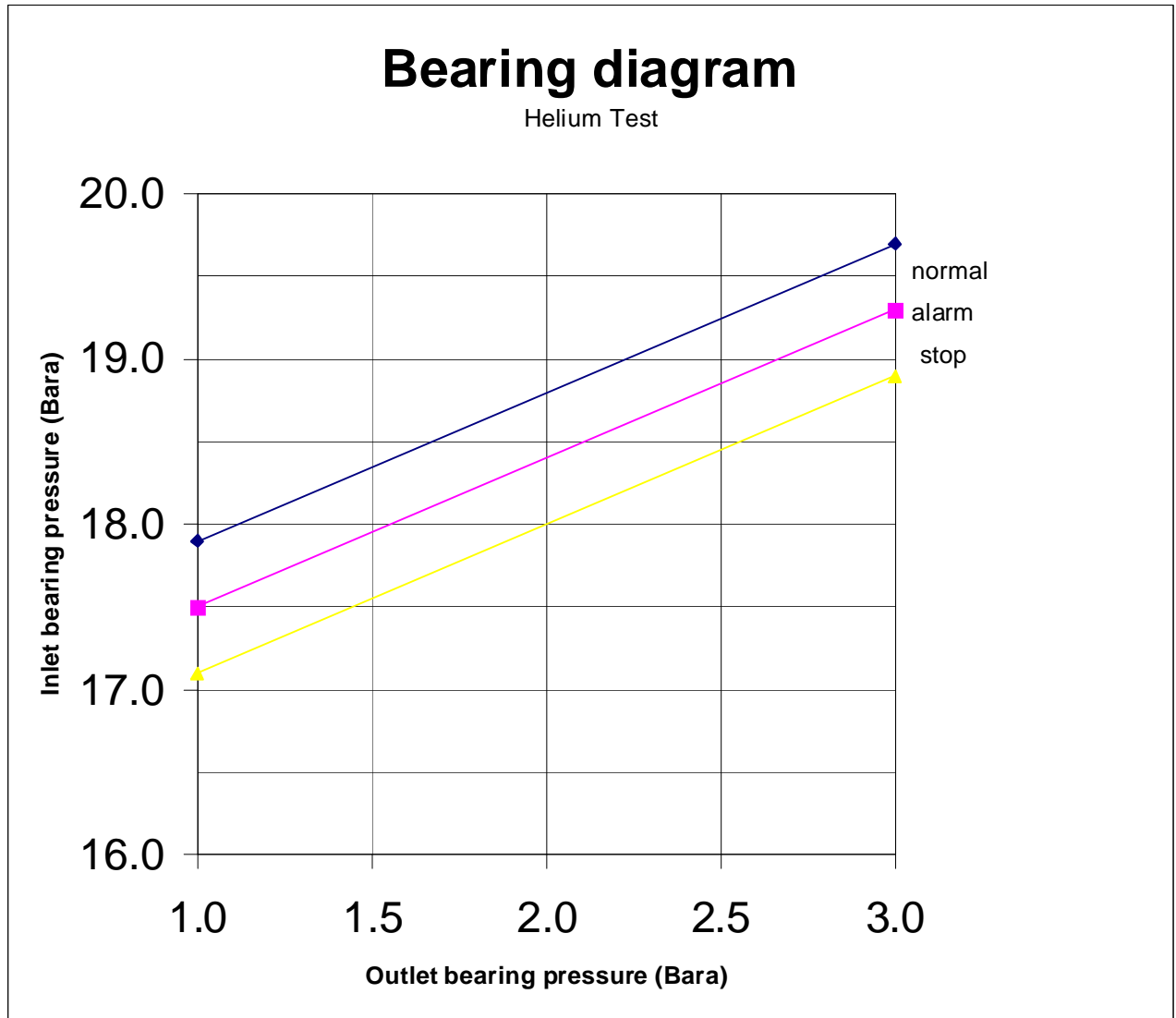
AFFAIRE / JOB : RHEA

N° : T1

Identification du matériel / Material identification : C7 508 HF₁

APPLICATION : Site Client/Customer

ALAT Test



TEST REPORT

5.7 EFFICIENCY VERSUS U1/CO

(Items 6.7 of procedure)

Cartridge number: C7 508 HF₁

INPUTS

TURBINE PROCESS CONDITIONS (12.5Bar 735W/37Lh w LN2)

GAS	PRESSURES 10 ⁵ Pa		TEMPERATURES K		FLOW kg/s 10 ⁻³	ENTHALP. DROP kJ/kg		η $\Delta H_r / \Delta H_s$	ROTATION SPEED Hz	REFRIG. POWER Watt	INLET WHEEL PRESS. 10 ⁵ Pa
	INLET	OUTLET	INLET	OUTLET		ΔH_s	ΔH_r				
He	19.6	12.41	234.4	205.6	1166	205.5	152.09	0.74	1060	177333	15.17

OUTPUTS

TURBINE TEST CONDITIONS

GAS	PRESSURES 10 ⁵ Pa		TEMPERATURES K		FLOW kg/s 10 ⁻³	ENTHALP. DROP KJ/kg		η $\Delta H_r / \Delta H_s$	ROTATION SPEED Hz	REFRIG. POWER Watt	INLET WHEEL PRESS. 10 ⁵ Pa
	INLET	OUTLET	INLET	OUTLET		ΔH_s	ΔH_r				
He	6.73	2.28	210.38	171.74	145.2	384.9	202.1	0.53	1003	29346	2.93

BEARING TEST CONDITIONS

GAS	PRESSURES 10 ⁵ Pa		TEMPERATURES °C	
	INLET	OUTLET	INLET	OUTLET
He	18.21	2.05	18.0	22.0

BRAKE TEST CONDITIONS

GAS	PRESSURES 10 ⁵ Pa		TEMPERATURES °C	
	INLET	OUTLET	INLET	OUTLET
He	3.10	3.42	36.0	58.3

TEST RESULTS

WHEEL DIAM. mm	TIP VELOCITY U ₁ m/s	SPOUTING VELOCITY C ₀ m/s	U ₁ / C ₀	η %	COMMENTS	
					FAIL	PASS
94.0	296.0	878	0.34	52.5		X

UTILITY FLOW RATE

GAS BEARING SUPPLY g/s	BRAKE SUPPLY g/s	SEAL GAS g/s	RETURN g/s
27.31	0.44	0.13	30.46