

## Contents

12	Rotodynamic centrifugal slurry pumps . . . . .	1
12.0	Introduction . . . . .	1
12.0.1	Purpose . . . . .	1
12.0.2	Scope . . . . .	1
12.0.3	Units, Symbols & Subscripts . . . . .	1
12.1	Pump types and nomenclature . . . . .	4
12.1.1	Definition of slurry . . . . .	5
12.1.2	Definition of a slurry pump . . . . .	5
12.1.3	Overhung impeller . . . . .	5
12.1.4	Frame mounted . . . . .	5
12.1.5	Cantilevered wet pit . . . . .	5
12.1.6	Submersible . . . . .	5
12.1.7	Lined type . . . . .	5
12.1.8	Unlined type . . . . .	5
12.1.9	Construction drawings . . . . .	6
12.1.10	Part names . . . . .	6
12.1.11	Letter dimensional designations . . . . .	31
12.2	Definition . . . . .	34
12.2.1	Rate of flow ( $Q$ ) . . . . .	34
12.2.2	Speed ( $n$ ) . . . . .	34
12.2.3	Head ( $h$ ) – general term . . . . .	34
12.2.3.1	Gauge head ( $h_g$ ) . . . . .	34
12.2.3.2	Velocity head ( $h_v$ ) . . . . .	34
12.2.3.3	Elevation head ( $Z$ ) . . . . .	34
12.2.3.4	Datum . . . . .	34
12.2.3.5	Total suction head ( $h_s$ ), open suction . . . . .	35
12.2.3.6	Total suction head ( $h_s$ ), closed suction . . . . .	35
12.2.3.7	Total discharge head ( $h_d$ ) . . . . .	35
12.2.3.8	Pump total head ( $H$ ) . . . . .	36
12.2.3.9	Atmospheric head ( $h_{atm}$ ) . . . . .	36
12.2.3.10	Friction head ( $h_f$ ) . . . . .	36
12.2.4	Condition points . . . . .	36
12.2.4.1	Rated condition point . . . . .	36

12.2.4.2	Specified condition point . . . . .	36
12.2.4.3	Normal condition point . . . . .	36
12.2.4.4	Best efficiency point (BEP) . . . . .	36
12.2.4.5	Shutoff . . . . .	36
12.2.4.6	Allowable operating range. . . . .	36
12.2.5	Suction conditions . . . . .	36
12.2.5.1	Submerged suction. . . . .	36
12.2.5.2	Net positive suction head available (NPSHA) . . . . .	37
12.2.5.3	Net positive suction head required (NPSHR, NPSH3) . . . . .	37
12.2.5.4	Maximum suction pressure. . . . .	37
12.2.6	Power. . . . .	37
12.2.6.1	Electric motor input power ( $P_{mot}$ ) . . . . .	37
12.2.6.2	Pump input (shaft) power ( $P_p$ ) . . . . .	37
12.2.6.3	Pump output (useful) power ( $P_u$ ) . . . . .	37
12.2.6.4	Pump efficiency $\eta_p$ . . . . .	38
12.2.6.5	Overall efficiency $\eta_{OA}$ ) . . . . .	38
12.2.7	Pump pressures . . . . .	38
12.2.7.1	Working pressure ( $p_o$ ) . . . . .	38
12.2.7.2	Maximum allowable working pressure . . . . .	38
12.2.7.3	Test pressure . . . . .	38
12.2.8	Mechanical seal terms. . . . .	38
12.2.8.1	Pusher seal. . . . .	38
12.2.8.2	Nonpusher seal. . . . .	38
12.2.8.3	Dual seal. . . . .	39
12.2.8.4	Dual pressurized seal . . . . .	39
12.2.8.5	Dual unpressurized seal . . . . .	39
12.2.8.6	Buffer fluid . . . . .	39
12.2.8.7	Barrier fluid . . . . .	39
12.2.8.8	External flush fluid . . . . .	39
12.2.8.9	Secondary seal. . . . .	39
12.2.8.10	Single seal . . . . .	39
12.2.9	Slurry terminology . . . . .	39
12.2.9.1	Slurry . . . . .	39
12.2.9.2	Apparent viscosity. . . . .	39
12.2.9.3	Minimum carrying velocity. . . . .	40
12.2.9.4	Mean effective particle diameter, or average particle size (d <sub>50</sub> ). . . . .	40

12.2.9.5	Solids d85 size . . . . .	41
12.2.9.6	Maximum particle size . . . . .	41
12.2.9.7	Friction characteristic . . . . .	41
12.2.9.8	Heterogeneous mixture. . . . .	41
12.2.9.9	Homogeneous mixture . . . . .	41
12.2.9.10	Homogeneous fl w (fully suspended solids) . . . . .	41
12.2.9.11	Nonhomogeneous fl w (partially suspended solids) . . . . .	41
12.2.9.12	Nonsettling slurry . . . . .	41
12.2.9.13	Concentration of solids by volume ( $C_v$ ) . . . . .	41
12.2.9.14	Concentration of solids by mass or weight ( $C_w$ ) . . . . .	42
12.2.9.15	Saltation . . . . .	42
12.2.9.16	Settling slurry . . . . .	42
12.2.9.17	Settling velocity . . . . .	42
12.2.9.18	Deposit velocity ( $V_{stp}$ ) . . . . .	42
12.2.9.19	Maximum value of deposit velocity ( $V_{smax}$ ) . . . . .	42
12.2.9.20	Specific ravity of solids ( $S_s$ ) . . . . .	42
12.2.9.21	Specific ravity of slurry ( $S_m$ ) . . . . .	42
12.2.9.22	Water head ( $H_w$ ) . . . . .	42
12.2.9.23	Slurry head ( $H_m$ ) . . . . .	42
12.2.9.24	Head ratio ( $H_r$ ) . . . . .	42
12.2.9.25	Efficiency atio ( $\eta_r$ ) . . . . .	43
12.2.9.26	Head reduction factor ( $R_h$ ) . . . . .	43
12.2.9.27	Efficiency reduction actor ( $R_\eta$ ) . . . . .	43
12.2.9.28	Water efficiency $\eta_w$ ) . . . . .	43
12.2.9.29	Water power ( $P_w$ ) . . . . .	43
12.2.9.30	Slurry efficiency $\eta_m$ ) . . . . .	43
12.2.9.31	Slurry power ( $P_m$ ) . . . . .	43
12.2.9.32	Specific ravity correction factor ( $C_{sg}$ ) . . . . .	43
12.2.9.33	Fine-particle correction factor ( $C_{fp}$ ) . . . . .	43
12.2.9.34	Concentration correction factor ( $C_{cv}$ ) . . . . .	43
12.2.9.35	Stationary bed. . . . .	44
12.2.9.36	Laminar region . . . . .	44
12.2.9.37	Turbulent region . . . . .	44
12.2.9.38	Transition region . . . . .	44
12.2.9.39	Slurry service classes . . . . .	44
12.2.9.40	Impeller seal face . . . . .	44

12.2.9.41	Slurry abrasivity . . . . .	44
12.2.9.42	Abrasive wear . . . . .	44
12.2.9.43	Abrasion–corrosion . . . . .	44
12.2.9.44	Corrosion . . . . .	44
12.2.9.45	Erosion . . . . .	44
12.2.9.46	Erosion–corrosion . . . . .	45
12.2.9.47	Miller number . . . . .	45
12.2.9.48	SAR number . . . . .	45
12.2.9.49	Specific energy ( $E_{sp}$ ) . . . . .	45
12.2.9.50	Wear coefficient ( $W_o$ ) . . . . .	45
12.2.9.51	Specific energy consumption (SEC) . . . . .	45
12.3	Design and application . . . . .	45
12.3.1	Scope . . . . .	45
12.3.2	Slurry services . . . . .	46
12.3.2.1	Slurry applications . . . . .	46
12.3.2.2	Characteristics of slurries . . . . .	46
12.3.2.3	Slurry types . . . . .	46
12.3.2.4	Settling slurries . . . . .	49
12.3.2.5	Effect of slurry on performance . . . . .	51
12.3.2.6	Performance derating based on viscosity . . . . .	52
12.3.2.7	Performance derating based on solids size and content . . . . .	53
12.3.3	Froth pumping . . . . .	55
12.3.3.1	General considerations . . . . .	55
12.3.3.2	Application of an empirical froth factor . . . . .	56
12.3.3.3	Experimental froth volume factor . . . . .	58
12.3.3.4	Additional means to enhance froth handling . . . . .	59
12.3.4	Wear in centrifugal slurry pumps . . . . .	60
12.3.4.1	Wear considerations . . . . .	60
12.3.4.2	Pump wear . . . . .	63
12.3.5	Hydraulic design and application considerations . . . . .	66
12.3.6	Slurry system design . . . . .	67
12.3.7	Wetted materials of construction . . . . .	68
12.3.7.1	General usage selections . . . . .	68
12.3.7.2	Irons . . . . .	70
12.3.7.3	Stainless steels . . . . .	70

12.3.7.4	Elastomers .....	70
12.3.7.5	Ceramics.....	71
12.3.8	General arrangement details.....	71
12.3.8.1	Impellers .....	71
12.3.8.1.1	Impeller balancing .....	72
12.3.8.2	Bearings .....	72
12.3.8.3	Flanges .....	75
12.3.8.4	Drive train arrangements .....	75
12.3.9	Shaft Sealing.....	75
12.3.9.1	Compression-type packing .....	75
12.3.9.2	Packing installation and leakage.....	77
12.3.9.3	Packing materials .....	78
12.3.9.4	Lantern ring materials.....	78
12.3.9.5	Shaft sleeves .....	78
12.3.9.6	Centrifugal (dynamic) seals .....	79
12.3.9.7	Multiple lip seals .....	79
12.3.9.8	Mechanical seal and seal chamber design.....	81
12.3.9.9	Mechanical seal types.....	84
12.3.9.10	Mechanical seal and packing flush ar angements .....	87
12.3.9.11	Mechanical seal materials .....	88
12.4	Installation, operation, and maintenance .....	89
12.4.1	Installation .....	89
12.4.1.1	Special requirements .....	89
12.4.2	Nozzle loads .....	89
12.4.2.1	Driver and pump .....	90
12.4.2.2	Limiting factors .....	90
12.4.2.3	Pump hold-down bolts .....	90
12.4.2.4	Assumed effect of nozzle loading .....	91
12.4.3	Connecting piping .....	92
12.4.4	Commissioning .....	92
12.4.5	Start-up .....	92
12.4.6	Storage of elastomer linings .....	93
12.4.7	Impeller removal .....	93
12.4.8	Adjustment of axial running clearances .....	93

12.4.9	Piping system design . . . . .	93
12.4.10	Possible operating problems . . . . .	94
12.4.10.1	Operating precautions for threaded impellers . . . . .	95
12.4.11	Spare parts stock . . . . .	96
12.4.12	Maintenance procedures for maximum part life . . . . .	96
12.4.12.1	Sideliners . . . . .	96
12.4.12.2	Impeller . . . . .	96
12.4.12.3	Hard irons . . . . .	96
12.4.13	Operational considerations . . . . .	96
12.5	Intentionally left blank . . . . .	97
12.6	Testing . . . . .	97
12.6.1	Scope . . . . .	97
12.6.1.1	Hydrostatic tests . . . . .	97
12.6.1.2	Performance tests . . . . .	97
12.6.1.3	Optional slurry test . . . . .	97
12.6.2	Test conditions . . . . .	97
12.6.3	Manufacturer's testing . . . . .	98
12.6.4	Field tests . . . . .	98
12.6.5	Wear tests . . . . .	98
12.6.6	Instrumentation . . . . .	99
12.6.6.1	Flowmeters . . . . .	99
12.6.6.2	Power measurement . . . . .	99
12.6.6.3	Head measurement . . . . .	99
12.6.6.4	Specific gravity measurement . . . . .	99
Appendix A	Equipment data sheets (informative) . . . . .	100
Appendix B	Nozzle loads tables . . . . .	104
Appendix C	Materials data (informative) . . . . .	106
C.1	Metal specification equivalents . . . . .	106
C.2	Specific gravity (relative density) of various materials . . . . .	107
Appendix D	Source material and references (informative) . . . . .	109
D.1	Source material . . . . .	109
D.2	References . . . . .	110
D.3	Standards organizations . . . . .	112