

Contents

Page

Foreword	ix
9.6.5 Rotodynamic Pumps for Condition Monitoring	1
9.6.5.1 Introduction	1
9.6.5.1.1 Scope	1
9.6.5.1.2 Purpose	1
9.6.5.1.3 Use of This Document	1
9.6.5.2 Condition-Based Maintenance Fundamentals	1
9.6.5.2.1 Overview of Potential-to-Failure Curves and Intervals	1
Figure 9.6.5.2.1 — Typical P-F Curves	2
9.6.5.2.2 Asset Management Overview	2
Table 9.6.5.2.2 — Asset reliability management strategies	3
9.6.5.2.3 Rotodynamic Pump Failure Modes	3
9.6.5.3 Monitoring Strategies	4
9.6.5.3.1 Monitoring Frequency	4
9.6.5.3.2 Control Limits	4
9.6.5.3.2.1 Alert Limit Settings	4
9.6.5.3.2.2 Alarm Limit Settings	5
9.6.5.3.2.3 Shutdown Limit Settings	5
9.6.5.3.2.4 Definition of Baseline Used in Alarm Set Point Limits	5
9.6.5.3.2.5 Definition of Field Acceptance Level or Industry Standard Level	5
9.6.5.4 Power Monitoring	5
9.6.5.4.1 Introduction	5
9.6.5.4.2 Means of Power Monitoring	5
9.6.5.4.2.1 Torque Meter	6
9.6.5.4.2.2 Power Meter	6
9.6.5.4.2.3 Electrical Current Meter	6
9.6.5.4.2.4 Strain Gauges	7
9.6.5.4.2.5 Variable Frequency Drive	7
9.6.5.4.2.6 Measurement Practice	7
9.6.5.4.3 Power Monitoring Frequency	7
9.6.5.4.4 Power Control Limits	7

9.6.5.5	Temperature Monitoring	7
9.6.5.5.1	Introduction	7
9.6.5.5.2	Means of Monitoring Temperature	7
9.6.5.5.3	Specific Applications of Temperature Monitoring	8
9.6.5.5.3.1	Motor Winding Temperature	8
9.6.5.5.3.2	Temperature-Sensitive Liquids	8
9.6.5.5.3.3	Rolling Element Bearing Temperatures	8
9.6.5.5.3.4	Fluid-Film Bearing and Seal-Face Temperatures	8
9.6.5.5.3.5	Pumped-Liquid Temperature Rise	8
9.6.5.5.3.4	Sealless Pump Liquid Temperature	9
9.6.5.5.4.1	Sealless Pump Temperature Damage	9
9.6.5.5.5	Temperature Monitoring Frequency	9
9.6.5.5.6	Temperature Control Limits	9
9.6.5.6	Corrosion Monitoring	10
9.6.5.6.1	Introduction	10
9.6.5.6.2	Means of Corrosion Monitoring	10
9.6.5.6.2.1	Corrosion Monitoring by Visual or Dimensional Inspection	10
9.6.5.6.2.2	Corrosion by Electrical Resistance	10
9.6.5.6.2.3	Corrosion by Linear Polarization Resistance	10
9.6.5.6.2.4	Corrosion by Ultrasonic Thickness Measurement	10
9.6.5.6.3	Corrosion Monitoring Frequency	11
9.6.5.6.4	Corrosion Parameter Control Limits	11
9.6.5.7	Leakage Monitoring	11
9.6.5.7.1	Introduction	11
9.6.5.7.2	Means of Monitoring Leakage	11
9.6.5.7.2.1	Leakage by Visual Inspection	11
9.6.5.7.2.2	Leakage by Organic Vapor Analyzer Inspection	11
9.6.5.7.2.3	Seal Leakage in Submersible Pumps	12
9.6.5.7.2.4	Leakage in an Inner Seal of Dual Unpressurized Seal Arrangements	12
9.6.5.7.2.5	Leakage in an Inner Seal of Dual Pressurized Seal Arrangements	12
9.6.5.7.2.6	Double-Walled System	13
Table 9.6.5.7.2.6	– Application guidelines for leakage monitoring systems’ mechanical seals	13
9.6.5.7.3	Leakage Monitoring Frequency	13
9.6.5.7.4	Leakage Control Limits	13

9.6.5.8	Pressure Monitoring	14
9.6.5.8.1	Introduction	14
9.6.5.8.2	Means of Pressure Monitoring	14
9.6.5.8.3	Pressure Monitoring Frequency	15
9.6.5.8.4	Pressure Control Limits	15
9.6.5.9	Vibration Monitoring	15
9.6.5.9.1	Introduction	15
9.6.5.9.2	Means of Vibration Monitoring	16
9.6.5.9.2.1	Bearing Housing Vibrations	16
9.6.5.9.2.2	Shaft Vibration	16
9.6.5.9.2.3	Vertical Pumps	17
9.6.5.9.2.4	Measurement Practice	17
9.6.5.9.3	Vibration Monitoring Frequency	17
9.6.5.9.4	Vibration Control Limits	17
	Table 9.6.5.9.4 – Recommended vibration control limits	17
9.6.5.10	Lubricant Analysis	18
9.6.5.10.1	Introduction	18
9.6.5.10.2	Measuring Metal Particles from Wear	18
9.6.5.10.2.1	Evaluating Wear Rates	18
9.6.5.10.3	Measuring Contamination of Lubricant	19
9.6.5.10.3.1	Organic Contamination of Lubricant	19
9.6.5.10.3.2	Inorganic Contamination of Lubricant	19
9.6.5.10.4	Measuring Lubricant Degradation	19
9.6.5.10.5	Lubricant Sampling Techniques	20
9.6.5.10.6	Lubricant Monitoring Frequency	20
9.6.5.10.7	Lubricant Control Limits	20
9.6.5.11	Total Indicated Runout (Periodic)	20
9.6.5.11.1	Introduction	20
9.6.5.11.2	How to Monitor Shaft Position	20
9.6.5.11.3	Shaft Monitoring Frequency	20
9.6.5.11.4	Shaft Control Limits	20
9.6.5.12	Rate-of-Flow Monitoring	21

9.6.5.12.1	Introduction	21
9.6.5.12.2	Measuring Rate of Flow.	21
9.6.5.12.3	Rate-of-Flow Monitoring Frequency	21
9.6.5.12.4	Rate of Flow Control Limits	21
9.6.5.13	Speed Monitoring (Rotational)	21
9.6.5.13.1	Introduction	21
9.6.5.13.2	Speed Measurement Methods	22
9.6.5.13.3	Speed Monitoring Frequency	22
9.6.5.13.4	Speed Control Limits	22
9.6.5.14	Bearing Wear Monitoring of Plain Bearings in Sealless Pumps	22
9.6.5.14.1	Introduction	22
9.6.5.14.2	Means of Detecting Bearing Wear.	22
9.6.5.14.2.1	Bearing Material Considerations.	22
9.6.5.14.2.2	Bearing Wear Detection Methods	22
9.6.5.14.2.2.1	Progressive Monitoring.	23
9.6.5.14.2.2.2	Contact Detection.	23
9.6.5.14.2.2.2.1	Acoustic (Sound) Detection	23
9.6.5.14.2.2.2.2	Power Monitor	23
9.6.5.14.2.2.2.3	Vibration Sensor.	23
9.6.5.14.2.2.2.4	Temperature Probe.	23
9.6.5.14.2.2.2.5	Contact or Continuity Switch	23
9.6.5.14.2.3	Bearing Wear Monitoring Frequency	24
9.6.5.14.2.4	Bearing Wear Control Limits	24
9.6.5.15	Pump Erosion Wear Monitoring	24
9.6.5.15.1	Introduction	24
9.6.5.15.2	Erosion Wear Monitoring Methods	24
9.6.5.15.3	Erosion Wear Monitoring Frequency.	25
9.6.5.15.4	Erosion Wear Control Limits	25
9.6.5.16	System and Pump Design Review	25
9.6.5.16.1	Introduction	25
9.6.5.16.2	Design Review Practice	25
9.6.5.16.2.1	Mechanical Application Review	25
9.6.5.16.2.2	Hydraulic Application Review	26

9.6.5.16.2.3	Installation Review	26
9.6.5.16.2.4	Operating Procedures Review	27
9.6.5.16.3	Design Review Frequency	27
9.6.5.17	Maintenance Inspection	27
9.6.5.17.1	Introduction	27
9.6.5.17.2	Maintenance Inspection Practice	28
9.6.5.17.2.1	Maintenance Inspection of Keys and Keyways	28
9.6.5.17.2.2	Maintenance Inspection of Flexible Coupling Elements	28
9.6.5.17.2.3	Maintenance Inspection for Shaft Bending Fatigue	29
9.6.5.17.2.4	Maintenance Inspection for Shaft Torsional Fatigue	29
9.6.5.17.2.5	Maintenance Inspection for Torsional Overload	29
9.6.5.17.2.6	Maintenance Inspection for Impeller Fatigue or Breakage	29
9.6.5.17.2.7	Maintenance Inspection for Erosion Wear from the Action of Flow, Abrasion, and Corrosion	29
9.6.5.17.2.8	Maintenance Inspection for Cavitation Erosion	30
9.6.5.17.2.9	Maintenance Inspection for Hydraulic Performance	30
9.6.5.17.3	Maintenance Inspection Frequency	30
9.6.5.18	Condition-Based Maintenance	30
9.6.5.18.1	Introduction to Condition-Based Maintenance	30
9.6.5.18.2	Overview of CBM	30
9.6.5.18.2.1	General Philosophy—Goals of CBM	30
9.6.5.18.2.2	Differences Compared to Periodic Maintenance	31
9.6.5.18.2.3	Potential Benefits	31
9.6.5.18.2.4	Potential Downsides	31
9.6.5.18.3	Things to Consider	31
9.6.5.18.3.1	Data to Collect	32
9.6.5.18.3.2	Sensors	32
9.6.5.18.3.3	Tools, Software, and Hardware	32
9.6.5.18.3.4	Cost	32
9.6.5.18.3.5	Staff Capabilities and Training	32
9.6.5.18.4	Condition Monitoring Techniques	32
9.6.5.18.4.1	Vibration Analysis	32
9.6.5.18.4.1.1	Monitoring Techniques	32
9.6.5.18.4.1.2	How Monitoring Vibration Can Benefit Your Maintenance Program	33

9.6.5.18.4.2	Lube Oil Analysis	33
9.6.5.18.4.2.1	Monitoring Techniques	33
9.6.5.18.4.2.2	How Monitoring Lube Oil Can Benefit Your Maintenance Program	33
9.6.5.18.4.3	IR Thermography	33
9.6.5.18.4.3.1	Monitoring Techniques	33
9.6.5.18.4.3.2	How Monitoring Temperature Can Benefit Your Maintenance Program	34
9.6.5.18.4.4	Ultrasonic Testing	34
9.6.5.18.4.4.1	Monitoring Techniques	34
9.6.5.18.4.4.2	How Monitoring Ultrasound Can Benefit Your Maintenance Program	34
9.6.5.18.4.5	Process Parameter Trending.	34
9.6.5.18.4.5.1	Monitoring Techniques	34
9.6.5.18.4.5.2	How Monitoring Can Benefit Your Maintenance Program.	34
9.6.5.18.5	Asset Reliability and Risk Management	35
9.6.5.18.6	CBM as a Tool for Risk Management	35
Appendix A	Condition monitoring and failure modes	36
Table A.1	— Condition monitoring failure modes	36
Table A.2	— Additional failure modes for sealless pumps and pumps with journal bearings	42
Appendix B	Condition monitoring indicators	43
Table B.1	— Condition monitoring indicators.	43
Appendix C	References	47
Appendix D	Definitions.	48