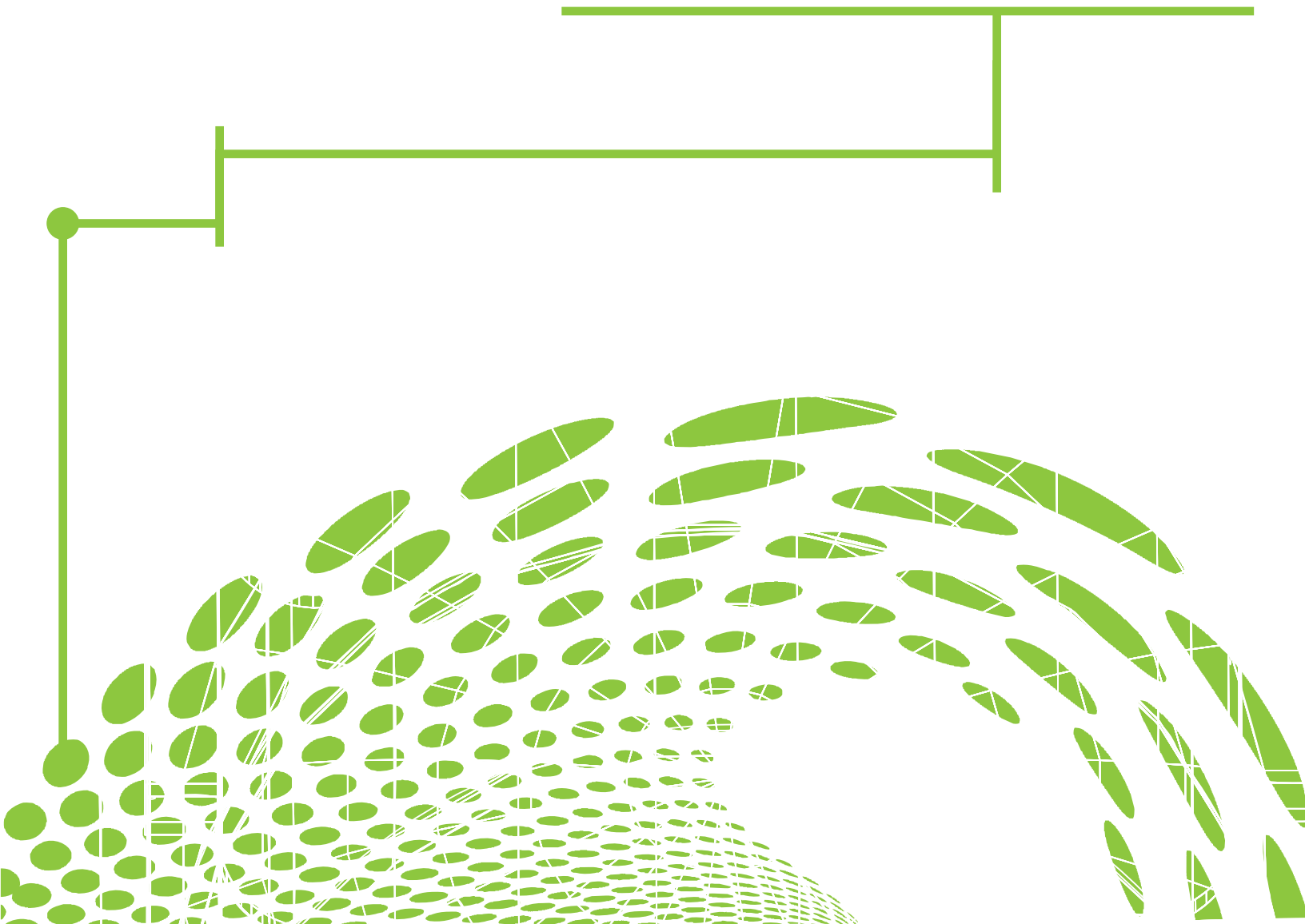


LOCAL HEATING OF PIPING: THERMAL ANALYSIS



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TABLE OF CONTENTS

Foreword.....	vii
Executive Summary.....	viii
Abbreviations and Acronyms	ix
1 INTRODUCTION.....	1
2 ANALYSIS METHODOLOGY	2
2.1 Geometry	2
2.2 Physics	3
2.3 Calibration Model Cases.....	6
2.4 Prediction Model Cases	8
3 RESULTS.....	9
3.1 Calibration Model Cases.....	9
3.2 Prediction Model Cases	9
4 RECOMMENDED FUTURE WORK	21
5 CONCLUSION	22
Appendix A: Experimental Design Drawings	23
Appendix B: Prediction Cases Images.....	37
References.....	98

LIST OF FIGURES

Figure 2-1: PWHT model heating configuration. Top right, full domain. Main, half-symmetric heating configuration	3
Figure 2-2: PWHT configuration.....	3
Figure 2-3: Two body thermal contact.....	5
Figure 2-4: Piping Heating Configuration. Full-symmetry shown, half-symmetry modelled.....	6
Figure 2-5: Calibration case summary	7
Figure 2-6: Circumferential ID and OD temperature profiles at centerline.	7
Figure 2-7: Prediction model geometry parameters.....	8
Figure 3-1: Calibration centerline ID temperatures for thermal contact resistance of 0.0037 m ² K/W	9
Figure 3-2: CFD SB delta T results for 6 inch schedule 80, 120, 160 P91 pipes	10
Figure 3-3: CFD SB delta T results for 10 inch schedule 80, 120, 160 P91 pipes	11
Figure 3-4: CFD SB delta T results for 14 inch schedule 80, 120, 160 P91 pipes	11
Figure 3-5: CFD SB delta T results for 24 inch schedule 80, 120, 160 P91 pipes	12
Figure 3-6: CFD SB delta T results for 30 inch schedule 80, 120, 160 P91 pipes	12
Equation 1	13
Figure 3-7: Power curve-fit coefficients	13
Figure 3-8: Delta T in SB for AWS D10.10 HB.....	14
Figure 3-9: CFD HB results for SB temperature difference of 15°F plotted against OD and t/OD	15
Figure 3-10: CFD HB results for SB temperature difference of 15°F plotted against OD and t/OD. Viewed from in-plane direction.....	15
Figure 3-11: Required HB lengths for a SB delta T=15°F from CFD and HB length from AWS D10.10	16
Figure 3-12: Ratio of CFD HB length for SB delta T=15°F over HB length from AWS D10.10.....	17
Figure 3-13: Axial distance where OD temperature equals min ID SB temperature for 6 in pipe.	18
Figure 3-14: Axial distance where OD temperature equals min ID SB temperature for 10 in pipe.	18
Figure 3-15: Axial distance where OD temperature equals min ID SB temperature for 14 in pipe.	19

Figure 3-16: Axial distance where OD temperature equals min ID SB temperature for 24 in pipe. 19

Figure 3-17: Axial distance where OD temperature equals min ID SB temperature for 30 in pipe. 20

Figure 3-18: Curve-fit coefficients for OD/ID temperature correlation. 20

Figure A-1: Case 1 24

Figure A-2: Case 2 29

Figure A-3: Case 3 31

Figure A-4: Case 4 33

Figure A-5: Case 5 34

Figure A-6: Case 6 35

Figure A-7: Case 7 36

Figure B-1: Temperature contours, cross section of all regions (°F). 6 inch schedule 80 38

Figure B-2: Temperature contours, cross section of all regions, close-up (°F). 6 inch schedule 80..... 38

Figure B-3: Temperature contours in pipe wall (°F). 6 inch schedule 80..... 39

Figure B-4: Temperature contours in pipe wall, close-up (°F). 6 inch schedule 80 39

Figure B-5: Temperature contours in SB (°F). 6 inch schedule 80..... 40

Figure B-6: Temperature contours in SB, isometric view (°F). 6 inch schedule 80 40

Figure B-7: Velocity contours, cross section of all regions (ft/s). 6 inch schedule 80..... 41

Figure B-8: Velocity contours, cross section of all regions, isometric view (ft/s). 6 inch schedule 80 41

Figure B-9: Temperature contours, cross section of all regions (°F). 6 inch schedule 120 42

Figure B-10: Temperature contours, cross section of all regions, close-up (°F). 6 inch schedule 120..... 42

Figure B-11: Temperature contours in pipe wall (°F). 6 inch schedule 120..... 43

Figure B-12: Temperature contours in pipe wall, close-up (°F). 6 inch schedule 120 43

Figure B-13: Temperature contours in SB (°F). 6 inch schedule 120..... 44

Figure B-14: Temperature contours in SB, isometric view (°F). 6 inch schedule 120 44

Figure B-15: Velocity contours, cross section of all regions (ft/s). 6 inch schedule 120..... 45

Figure B-16: Velocity contours, cross section of all regions, isometric view (ft/s). 6 inch schedule 120.. 45

Figure B-17: Temperature contours, cross section of all regions (°F). 6 inch schedule 160 46

Figure B-18: Temperature contours, cross section of all regions, close-up (°F). 6 inch schedule 160..... 46

Figure B-19: Temperature contours in pipe wall (°F). 6 inch schedule 160..... 47

Figure B-20: Temperature contours in pipe wall, close-up (°F). 6 inch schedule 160 47

Figure B-21: Temperature contours in SB (°F). 6 inch schedule 160..... 48

Figure B-22: Temperature contours in SB, isometric view (°F). 6 inch schedule 160..... 48

Figure B-23: Velocity contours, cross section of all regions (ft/s). 6 inch schedule 160..... 49

Figure B-24: Velocity contours, cross section of all regions, isometric view (ft/s). 6 inch schedule 160.. 49

Figure B-25: Temperature contours, cross section of all regions (°F). 10 inch schedule 80 50

Figure B-26: Temperature contours, cross section of all regions, close-up (°F). 10 inch schedule 80..... 50

Figure B-27: Temperature contours in pipe wall (°F). 10 inch schedule 80..... 51

Figure B-28: Temperature contours in pipe wall, close-up (°F). 10 inch schedule 80 51

Figure B-29: Temperature contours in SB (°F). 10 inch schedule 80..... 52

Figure B-30: Temperature contours in SB, isometric view (°F). 10 inch schedule 80 52

Figure B-31: Velocity contours, cross section of all regions (ft/s). 10 inch schedule 80..... 53

Figure B-32: Velocity contours, cross section of all regions, isometric view (ft/s). 10 inch schedule 80.. 53

Figure B-33: Temperature contours, cross section of all regions (°F). 10 inch schedule 120 54

Figure B-34: Temperature contours, cross section of all regions, close-up (°F). 10 inch schedule 120..... 54

Figure B-35: Temperature contours in pipe wall (°F). 10 inch schedule 120..... 55

Figure B-36: Temperature contours in pipe wall, close-up (°F). 10 inch schedule 120 55

Figure B-37: Temperature contours in SB (°F). 10 inch schedule 120..... 56

Figure B-38: Temperature contours in SB, isometric view (°F). 10 inch schedule 120 56

Figure B-39: Velocity contours, cross section of all regions (ft/s). 10 inch schedule 120..... 57

Figure B-40: Velocity contours, cross section of all regions, isometric view (ft/s). 10 inch schedule 120 57

Figure B-41: Temperature contours, cross section of all regions (°F). 10 inch schedule 160 58

Figure B-42: Temperature contours, cross section of all regions, close-up (°F). 10 inch schedule 160..... 58
 Figure B-43: Temperature contours in pipe wall (°F). 10 inch schedule 160..... 59
 Figure B-44: Temperature contours in pipe wall, close-up (°F). 10 inch schedule 160 59
 Figure B-45: Temperature contours in SB (°F). 10 inch schedule 160..... 60
 Figure B-46: Temperature contours in SB, isometric view (°F). 10 inch schedule 160 60
 Figure B-47: Velocity contours, cross section of all regions (ft/s). 10 inch schedule 160..... 61
 Figure B-48: Velocity contours, cross section of all regions, isometric view (ft/s). 10 inch schedule 160 61
 Figure B-49: Temperature contours, cross section of all regions (°F). 14 inch schedule 80 62
 Figure B-50: Temperature contours, cross section of all regions, close-up (°F). 14 inch schedule 80..... 62
 Figure B-51: Temperature contours in pipe wall (°F). 14 inch schedule 80..... 63
 Figure B-52: Temperature contours in pipe wall, close-up (°F). 14 inch schedule 80 63
 Figure B-53: Temperature contours in SB (°F). 14 inch schedule 80..... 64
 Figure B-54: Temperature contours in SB, isometric view (°F). 14 inch schedule 80 64
 Figure B-55: Velocity contours, cross section of all regions (ft/s). 14 inch schedule 80..... 65
 Figure B-56: Velocity contours, cross section of all regions, isometric view (ft/s). 14 inch schedule 80.. 65
 Figure B-57: Temperature contours, cross section of all regions (°F). 14 inch schedule 120 66
 Figure B-58: Temperature contours, cross section of all regions, close-up (°F). 14 inch schedule 120..... 66
 Figure B-59: Temperature contours in pipe wall (°F). 14 inch schedule 120..... 67
 Figure B-60: Temperature contours in pipe wall, close-up (°F). 14 inch schedule 120 67
 Figure B-61: Temperature contours in SB (°F). 14 inch schedule 120..... 68
 Figure B-62: Temperature contours in SB, isometric view (°F). 14 inch schedule 120. 68
 Figure B-63: Velocity contours, cross section of all regions (ft/s). 14 inch schedule 120..... 69
 Figure B-64: Velocity contours, cross section of all regions, isometric view (ft/s). 14 inch schedule 120 69
 Figure B-65: Temperature contours, cross section of all regions (°F). 14 inch schedule 160 70
 Figure B-66: Temperature contours, cross section of all regions, close-up (°F). 14 inch schedule 160..... 70
 Figure B-67: Temperature contours in pipe wall (°F). 14 inch schedule 160..... 71
 Figure B-68: Temperature contours in pipe wall, close-up (°F). 14 inch schedule 160 71
 Figure B-69: Temperature contours in SB (°F). 14 inch schedule 160..... 72
 Figure B-70: Temperature contours in SB, isometric view (°F). 14 inch schedule 160 72
 Figure B-71: Velocity contours, cross section of all regions (ft/s). 14 inch schedule 160..... 73
 Figure B-72: Velocity contours, cross section of all regions, isometric view (ft/s). 14 inch schedule 160 73
 Figure B-73: Temperature contours, cross section of all regions (°F). 24 inch schedule 80 74
 Figure B-74: Temperature contours, cross section of all regions, close-up (°F). 24 inch schedule 80..... 74
 Figure B-75: Temperature contours in pipe wall (°F). 24 inch schedule 80..... 75
 Figure B-76: Temperature contours in pipe wall, close-up (°F). 24 inch schedule 80 75
 Figure B-77: Temperature contours in SB (°F). 24 inch schedule 80..... 76
 Figure B-78: Temperature contours in SB, isometric view (°F). 24 inch schedule 80 76
 Figure B-79: Velocity contours, cross section of all regions (ft/s). 24 inch schedule 80..... 77
 Figure B-80: Velocity contours, cross section of all regions, isometric view (ft/s). 24 inch schedule 80.. 77
 Figure B-81: Temperature contours, cross section of all regions (°F). 24 inch schedule 120 78
 Figure B-82: Temperature contours, cross section of all regions, close-up (°F). 24 inch schedule 120..... 78
 Figure B-83: Temperature contours in pipe wall (°F). 24 inch schedule 120..... 79
 Figure B-84: Temperature contours in pipe wall, close-up (°F). 24 inch schedule 120 79
 Figure B-85: Temperature contours in SB (°F). 24 inch schedule 120..... 80
 Figure B-86: Temperature contours in SB, isometric view (°F). 24 inch schedule 120 80
 Figure B-87: Velocity contours, cross section of all regions (ft/s). 24 inch schedule 120..... 81
 Figure B-88: Velocity contours, cross section of all regions, isometric view (ft/s). 24 inch schedule 120 81
 Figure B-89: Temperature contours, cross section of all regions (°F). 24 inch schedule 160 82
 Figure B-90: Temperature contours, cross section of all regions, close-up (°F). 24 inch schedule 160..... 82
 Figure B-91: Temperature contours in pipe wall (°F). 24 inch schedule 160..... 83
 Figure B-92: Temperature contours in pipe wall, close-up (°F). 24 inch schedule 160 83

Figure B-93: Temperature contours in SB (°F). 24 inch schedule 160..... 84

Figure B-94: Temperature contours in SB, isometric view (°F). 24 inch schedule 160 84

Figure B-95: Velocity contours, cross section of all regions (ft/s). 24 inch schedule 160..... 85

Figure B-96: Velocity contours, cross section of all regions, isometric view (ft/s). 24 inch schedule 160 85

Figure B-97: Temperature contours, cross section of all regions (°F). 30 inch schedule 80 86

Figure B-98: Temperature contours, cross section of all regions, close-up (°F). 30 inch schedule 80..... 86

Figure B-99: Temperature contours in pipe wall (°F). 30 inch schedule 80..... 87

Figure B-100: Temperature contours in pipe wall, close-up (°F). 30 inch schedule 80 87

Figure B-101: Temperature contours in SB (°F). 30 inch schedule 80..... 88

Figure B-102: Temperature contours in SB, isometric view (°F). 30 inch schedule 80 88

Figure B-103: Velocity contours, cross section of all regions (ft/s). 30 inch schedule 80..... 89

Figure B-104: Velocity contours, cross section of all regions, isometric view (ft/s). 30 inch schedule 80 89

Figure B-105: Temperature contours, cross section of all regions (°F). 30 inch schedule 120 90

Figure B-106: Temperature contours, cross section of all regions, close-up (°F). 30 inch schedule 120... 90

Figure B-107: Temperature contours in pipe wall (°F). 30 inch schedule 120..... 91

Figure B-108: Temperature contours in pipe wall, close-up (°F). 30 inch schedule 120 91

Figure B-109: Temperature contours in SB (°F). 30 inch schedule 120..... 92

Figure B-110: Temperature contours in SB, isometric view (°F). 30 inch schedule 120 92

Figure B-111: Velocity contours, cross section of all regions (ft/s). 30 inch schedule 120..... 93

Figure B-112: Velocity contours, cross section of all regions, isometric view (ft/s). 30 inch schedule 120 93

Figure B-113: Temperature contours, cross section of all regions (°F). 30 inch schedule 160 94

Figure B-114: Temperature contours, cross section of all regions, close-up (°F). 30 inch schedule 160... 94

Figure B-115: Temperature contours in pipe wall (°F). 30 inch schedule 160..... 95

Figure B-116: Temperature contours in pipe wall, close-up (°F). 30 inch schedule 160 95

Figure B-117: Temperature contours in SB (°F). 30 inch schedule 160..... 96

Figure B-118: Temperature contours in SB, isometric view (°F). 30 inch schedule 160 96

Figure B-119: Velocity contours, cross section of all regions (ft/s). 30 inch schedule 160..... 97

Figure B-120: Velocity contours, cross section of all regions, isometric view (ft/s). 30 inch schedule 160 97

FOREWORD

The objective of this project is to perform thermal analysis of pipeline heating configurations, with the intention of creating guidelines for the sizing of heating bands.

The author acknowledges, with deep appreciation, the activities of ASME staff and volunteers who have provided valuable technical input, advice and assistance with review of, commenting on, and editing of, this document.

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EXECUTIVE SUMMARY

The initial phase of the project served to calibrate and verify the modeling assumptions used for the thermal analysis via comparison with experimental measurements taken for two post weld heat-treated pipes using multiple heating band configurations. The second phase analyzed five pipe diameters. The intent of the second phase was to determine appropriate sizing requirements for heating bands in order to minimize temperature variation around the weld location, for pipe diameters ranging from 6 to 30 inches.

The calibration cases were run to steady state while the thermal contact resistance was adjusted to match the centerline inside diameter (ID) temperature measurements from the experimental cases. The outside diameter (OD) temperature probes were set to adjust the power input such that their value matched the experimental measurements at the same locations.

The prediction model cases were run to steady state. Five different pipe diameters were investigated with three different pipe thicknesses per diameter. The heat band (HB) and gradient control band (GCB) were iteratively increased in length until the maximum temperature difference in the soak band (SB) was less than 15°F. This occurred with four to six iterations per geometry. The trend of these iterations followed roughly a power relation between temperature differences desired to HB lengths required.

The HB lengths required for a temperature difference in the SB of 15°F when plotted against OD and t/OD are nearly planar. These HB lengths were found to be much larger than is recommended in AWS D10.10 (American Welding Society, 1999), and this difference increases with pipe diameter due to increasing natural convection effects. The results of these analyses can be used to develop new HB sizing guidelines for AWS D10.10.

ABBREVIATIONS AND ACRONYMS

ASME	American Society of Mechanical Engineers
AWS	American Welding Society
BPVC	Boiler and Pressure Vessel Code
CHT	Conjugate Heat Transfer
CFD	Computational Fluid Dynamics
FEA	Finite Element Analysis
GCB	Gradient Control Band
HB	Heat Band
ID	Inside Diameter
OD	Outside Diameter
PWHT	Post Weld Heat Treatment
SB	Soak Band

1 INTRODUCTION

The objective of this project was to perform thermal analysis of pipeline heating configurations, with the intention of creating guidelines for the sizing of heating bands. The analysis consisted of two phases. The initial phase served to calibrate and verify the modeling assumptions used for the thermal analysis via comparison with experimental measurements taken for two post weld heat treated pipes using multiple heating band configurations. The second phase analyzed five pipe diameters. The intent of the second phase was to determine appropriate sizing requirements for heating bands in order to minimize temperature variation around the weld location, for pipe diameters ranging from 6 to 30 inches. The results of these analyses can provide refinement of the requirements found in AWS D10.10 [1] regarding the width of the soak band, heated band and gradient control band as a function of pipe diameter, thickness and heating rate/holding time to help ensure that the through-wall temperature difference does not exceed 15°F within the soak band region. Once these requirements are determined, they can be used to update the technical rules in the appropriate ASME BPVC construction and B31 piping codes.