IN REFRACTORY LININGS:
“IT’S WHAT’S INSIDE THAT COUNTS”

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IN REFRACTORY LINING SYSTEMS

- It’s what’s inside that counts
- If it’s not good inside, it’s not good!
- It doesn’t matter how well a lining is installed
- It doesn’t matter how good the design is
- It doesn’t matter how good the materials are
- The only thing that matters is what’s inside – if it isn’t good inside, it isn’t good, and the war has been lost
DOES THIS LOOK FAMILIAR?

WHAT ARE THE ISSUES THAT LEAD TO POOR REFRACTORY QUALITY?

• New refractory material can be bad refractory material
• The refractory installer may not be competent to install the refractory system as specified
• Good anchor installers can do inferior work
• Installation specifications may be lacking in detail
• Installation procedures may be incomplete, incorrect, or non-existent
• The refractory design may be impractical or impossible to install
### WHAT ARE THE IMPLICATIONS OF POOR REFRACTORY QUALITY?

- Reduced refractory life: Inferior refractory linings will be replaced sooner than will high quality systems
- Increased maintenance that can lead to increased downtime
- Greater possibility of refractory failure resulting in emergency outage
- The cost of inferior refractory systems can be huge
- Kind of like the old Fram oil filter commercial: You can pay now or pay later

### HOW ARE THESE QUALITY PROBLEMS AVOIDED?

- **Refractory Quality Control**
  - Refractory material pre-installation certification by laboratory testing
  - Refractory installer pre-installation certification
  - Laboratory testing of field production samples
  - Continuous inspection during refractory lining installation
  - Approved refractory installer installation procedure
REFRACTORY MATERIAL CERTIFICATION
WHY TEST?

• Being new does not necessarily make a refractory material good
• Certification performed prior to refractory shipment from the manufacturer
• Acceptable physical properties are agreed on prior to placing any order
• Making sure that the physical properties of the materials shipped are as specified and agreed upon
• It’s what’s on the wall that counts

REFRACTORY MATERIAL DATASHEETS

Typical Refractory Datasheet

<table>
<thead>
<tr>
<th></th>
<th>ASTM C-704</th>
<th>Less than 10 cc</th>
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</thead>
<tbody>
<tr>
<td>Erosion Loss:</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Maximum Service Temperature:</td>
<td>2750°F (1510°C)</td>
<td></td>
</tr>
<tr>
<td>Bulk Density:</td>
<td>150°F (815°C)</td>
<td>137 lb/ft³ (2192 kg/m³)</td>
</tr>
<tr>
<td></td>
<td>150°F (815°C)</td>
<td>130 lb/ft³ (2080 kg/m³)</td>
</tr>
<tr>
<td>Cold Crushing Strength:</td>
<td>1000°F (540°C)</td>
<td>9000-12000 psi (630-840 kig/cm²)</td>
</tr>
<tr>
<td></td>
<td>150°F (915°C)</td>
<td>8000-11000 psi (560-770 kig/cm²)</td>
</tr>
<tr>
<td></td>
<td>2500°F (1400°C)</td>
<td>9000-12000 psi (630-840 kig/cm²)</td>
</tr>
<tr>
<td>Modulus of Rupture:</td>
<td>1000°F (540°C)</td>
<td>1600-1900 psi (105-133 kig/cm²)</td>
</tr>
<tr>
<td></td>
<td>1500°F (915°C)</td>
<td>1400-1900 psi (98-126 kig/cm²)</td>
</tr>
<tr>
<td></td>
<td>2500°F (1400°C)</td>
<td>1500-1900 psi (105-133 kig/cm²)</td>
</tr>
<tr>
<td>Permanent Linear Change(%):</td>
<td>1500°F (915°C)</td>
<td>-0.1 to -0.3</td>
</tr>
<tr>
<td></td>
<td>2000°F (1090°C)</td>
<td>-0.1 to -0.3</td>
</tr>
<tr>
<td>Conductivity or “K” Factor:</td>
<td>BTU/min°F/in</td>
<td>W/mK</td>
</tr>
<tr>
<td>Mean Temp:</td>
<td></td>
<td></td>
</tr>
<tr>
<td>1000°F (540°C)</td>
<td>7.4</td>
<td>1.07</td>
</tr>
<tr>
<td>1500°F (915°C)</td>
<td>8.0</td>
<td>1.15</td>
</tr>
<tr>
<td>2000°F (1090°C)</td>
<td>8.4</td>
<td>1.21</td>
</tr>
<tr>
<td>Typical Chemical Analysis(%):</td>
<td>Al₂O₃</td>
<td>SiO₂</td>
</tr>
<tr>
<td></td>
<td>51.1</td>
<td>39.9</td>
</tr>
<tr>
<td>Standard Packaging:</td>
<td>72 - 55 lb. bags per pallet</td>
<td></td>
</tr>
</tbody>
</table>
### Refractory Material Datasheets

- **The Disclaimer**
  - Refractory material manufacturers attach a disclaimer to their advertised data
  - Interpretation: We don’t guarantee you will get what we got

- **Avoiding the Disclaimer**
  - Determine ahead of time what properties are required for the work
  - Look at competitive datasheets
  - If the selected refractory material manufacturer cannot stand behind the properties required, buy somewhere else

### Refractory Material Testing

#### Which Tests and Why

- **Density or Bulk Density**
  - Weight per unit volume of the refractory concrete
  - A reflection of insulating ability

- **Compressive (Cold Crushing) Strength**
  - The ultimate strength of the material in compression

- **Permanent Linear Change**
  - The percent change in length from the dried to the fired state

- **Abrasion Resistance**
  - A guide to the expected resistance to abrasion in service

- **How valid is the test data/how does it relate to reality?**
  - Room temperature tests/ why is it reliable?
  - Easy and inexpensive tests to perform
  - Red flag tests
REFRACTORY MATERIAL TESTING

Compression | Modulus of Rupture

Abrasions Resistance | Measurements

Typical Laboratory Specimens

INSTALLER CERTIFICATION

- Not every refractory installer is able to do the work as specified even if he has done the same work in the past

- Installer demonstrates ability to do the work in advance of the actual refractory installation

- The installer uses Owner specifications and agreed-upon written installation procedures

- The adequacy of installer personnel is confirmed

- The adequacy of installer equipment is confirmed
INSTALLER CERTIFICATION
HOW IS IT DONE?

Vibration Casting

Pneumatic Ramming

Pneumatic Gunning

FIELD PRODUCTION TESTING
WHY TEST?

- A certified installer can do bad work
- Field sampling and testing keeps the installer alert to quality
- A record is provided of what’s on the wall, and it’s what’s on the wall that counts
- In event of failure, the owner has the knowledge to make an informed engineering decision regarding the problem
- If testing is not faithfully performed, quality suffers and cost goes up
REFRACTORY INSPECTION
WHY INSPECT?

• To confirm that the agreed upon specifications and procedures have been followed
• To provide a documented record of what has been installed on the wall, where it counts
• To provide information from which the owner can make educated refractory engineering decisions
• To assist the owner in making quality assessments of new or existing refractory lining systems
• Most importantly, to make certain that all refractory installations are of the best reasonable quality, that good service should be expected.

TYPICAL AREAS OF REFRACTORY INSPECTION

• Review material test reports
• Monitor site storage of refractory material
• Initial inspection of existing systems with repair recommendations
• Assure steel surfaces are properly repaired for refractory installation
• Verify refractory anchoring systems are as specified and properly installed
### TYPICAL AREAS OF REFRACTORY INSPECTION

#### Refractory Anchor Inspection

#### Surface Preparation

#### Refractory Installation by Pneumatic Gunning

#### Refractory Installation by Pneumatic Ramming
### TYPICAL AREAS OF REFRACTORY INSPECTION

**Refractory Installation by Vibration Casting**

- [Image of refractory installation process]
- [Image of vibration casting setup]

**Thermal Drying**

- [Image of thermal drying equipment]
- [Image of drying process]

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### TYPICAL AREAS OF REFRACTORY INSPECTION

**Maintaining Lining Thickness**

- [Image of worker measuring lining thickness]
- [Image of hammer testing]

**Visual Inspection and Hammer Testing**

- [Image of visual inspection in action]
- [Image of hammer testing setup]
TYPICAL AREAS OF REFRACTORY INSPECTION

• Monitor all aspects of refractory preparation and installation:
  - Water content
  - Temperature control
  - Mixing time
  - Lining thickness
  - Joint construction
  - Form installation
  - Ambient curing procedures
  - Drying and firing
  - Visual inspection
  - Hammer testing
TYPICAL AREAS OF REFRACTORY INSPECTION

HOW TO CONTACT US

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