



Standard Practice for Design of Steam Turbine Generator Oil Systems¹

This standard is issued under the fixed designation D 4248; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

INTRODUCTION

The ever-increasing size and complexity of steam turbine generators makes the oil system more important than ever. The system is required to provide not only lubrication but surface protection, cooling, sealing, and control as well. Failure in any one of these functions could result in damage to expensive equipment with loss of system capability and increased generation costs due to the use of less efficient equipment or the purchase of power through interconnections.

This practice has resulted from a culmination of the experiences of the turbine builders, the erectors, the oil suppliers and the operators. Out of necessity, it is a generalized and minimal standard. Previous issues of this standard have been used in specifications to aid in obtaining satisfactory performance of the lubricating oil system.

1. Scope

1.1 This practice is applicable to steam turbine-generator units and provides recommended practices for the design of the oil system.

1.1.1 The oil system is defined as that assembly which uses and circulates the turbine-generator lubricating oil. The oil system generally includes high pressure, bearing, control, generator seal, and drain systems. The system may also include the supply and return lines for a boiler feed pump and hydraulic coupling.

1.2 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ISO Standard:²

ISO 4572 Hydraulic fluid power filters-multi-pass method for evaluating filtration performance

¹ This practice is under the jurisdiction of ASTM Committee D02 on Petroleum Products and Lubricants and is the direct responsibility of Subcommittee D02.C0 on Turbine Oils.

All previous recommended practices have been published by ASME as joint ASTM-ASME-NEMA standards. With the issuance of this document, all standards under the auspices of Subcommittee C of ASTM Committee D02 will be published by ASTM as ASTM standards. This standard replaces ASME Standard Practice No. 116.

Current edition approved Nov. 1, 2003. Published November 2003. Originally approved in 1983. Last previous edition approved in 1998 as D 4248-98.

² Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036.

3. Significance and Use

3.1 The purpose of this guide for turbine generator oil systems is to ensure that:

3.1.1 Lubrication, control, and sealing will be performed satisfactorily by the oil in a manner mutually acceptable to the parties concerned.

3.1.2 Installation, cleaning, and flushing will be facilitated.

3.1.3 Satisfactory system cleanliness can be maintained.

3.1.4 Safe practices are observed.

4. System Components

4.1 Materials:

4.1.1 Steel piping, tubing, valves, fittings, and fabrication plates are acceptable and recommended. The use of catalytic and corrodible materials, such as copper, zinc, and lead, should be minimized, and if used, they should be properly alloyed. Bearing linings should be made of tin base babbitt.

4.1.2 All materials used in system construction, including gaskets, seals, diaphragms, interior permanent type surface coatings, and hoses, should be resistant to turbine oils and maintain adequate physical and chemical properties at the maximum expected operating temperatures and service life.

4.2 Pumps:

4.2.1 Pumps must circulate lubricating oil from the reservoir to the bearings, controls, and other points of use. The pressure level must be high enough to ensure proper distribution and satisfy control functions.

4.2.1.1 Satisfactory circulation and pressure levels must be provided for start-up, operation, and shut down.

4.2.2 Several commonly used pumps are defined as follows:

4.2.2.1 The main pump normally supplies the oil circulation and pressure for the steam turbine generator operation.

4.2.2.2 The auxiliary pump is sized to permit continued operation if the main pump fails.

4.2.2.3 The emergency pump is of reduced capacity. Its function is to provide last resort lubrication for coastdown, should the other pumping fail.

4.2.2.4 Many combinations of pumps can be satisfactory. As a minimum these should be two pumps driven from two independent and different power sources. Thus, no single incident or equipment failure can cause loss of pumping.

(1) An exception can be made to the two pump recommendation if the turbine generator can survive shut-downs without oil circulation.

4.2.3 Examples of these pump drive combinations are listed as follows:

Main	Auxiliary	Emergency
shaft	ac motor	dc motor
shaft	none	ac/dc motor
shaft	ac motor	turbine
ac motor	none	dc motor

4.2.4 The auxiliary and emergency pump drivers shall be sized for adequate capacity when operating with the oil viscosity corresponding to the minimum temperature for start-up.

4.2.5 Control of the auxiliary and emergency pump drivers can significantly affect reliability.

4.2.5.1 The auxiliary and emergency pump drive controls shall provide for automatic starting and in-service testing.

4.2.5.2 The pump motor overloads shall not trip the motor breaker. The overload shall only provide a warning.

4.2.6 Several application requirements shall be considered for proper pump functioning.

4.2.6.1 The main shaft driven pump shall have adequate suction conditions to provide uninterrupted supply of oil. Pumps shall be provided with a positive suction.

4.2.6.2 Pump suctions shall be below the minimum reservoir operating level. The exact submergence will be determined by the pump suction requirements including the consideration of air entrainment in the pump suction. In many cases the pump suction is at least 150 mm (6 in.) below the minimum operating level.

4.2.6.3 The auxiliary and emergency pumps shall be submerged with their suction below the minimum reservoir operating level.

4.2.6.4 The emergency pump suction shall be lower than other pumps so that with the loss of oil in the reservoir, shut down oil would still be available.

4.2.6.5 Coarse strainers should be provided in the suction system of all pumps.

4.2.7 Pump suctions should be at least 150 mm (6 in.) from the bottom of the reservoir.

4.2.8 The pump suction is defined as starting at the solid fluid conveyance to the pump inlet. Normally this begins at attachment of the suction strainer to the pump inlet or to the pump suction pipe.

4.3 *Reservoirs:*

4.3.1 The capacity of the reservoir should be sufficient to hold the sum of the operating oil volume contained within the normal operating range plus the volume that will drain from the remainder of the system when the turbine generator unit is shutdown.

4.3.2 To allow for the separation of entrained air and the settling by gravity of water and solid contaminants the normal operating oil volume should not be less than five times the flow per minute to the bearings.

4.3.3 A drain connection should be provided at the lowest point on the reservoir. A shut off valve should be located in the drain near the reservoir. To avoid accidental draining of the oil, the valve should be locked closed or have a blank in the drain line immediately downstream.

4.3.4 The bottom of the reservoir should slope towards the drain connection. On rectangular reservoirs the slope should be 40 mm/m (½ in./ft) or greater.

4.3.5 Connections for the oil purification system should be provided. The supply should be so located that oil is taken from as close as possible to the reservoir bottom. Both the supply and return connections should be arranged and located so that siphoning of the reservoir below a safe level is not possible.

4.3.6 Oil reservoir connections for major drain lines from bearings should be as far from the pump suction as practical or baffled to prevent return oil from flowing directly to pump suction, thereby providing a maximum oil rest period. Drains should be arranged to provide for maximum deaeration and minimum oil agitation.

4.3.7 A method for oil level determination should be provided.

4.3.8 The discharge of relief valves should be at least 150 mm (6 in.) below the operating oil level.

4.3.9 A vapor extractor connected to the highest point of the reservoir should be provided for the removal of gases and vapors. Internal baffles should have openings above the oil level to equalize the vacuum within the reservoir. The vacuum produced in the bearing housings should not average more than approximately 0.5 KPa (2 in. water) to minimize the entrance of atmospheric contaminants into the oil system.

4.3.10 The interior surfaces wherever possible should be protected by a permanent type, oil resistant surface coating unless a corrosion resistant metal is used.

4.3.11 The entire inside of the reservoir should be accessible.

4.3.12 For hydrogen cooled generator application, the reservoir should contain an explosion door capable of maintaining the reservoir internal pressure at a safe level at all times. This explosion door may serve as an access door.

4.3.13 All connections and openings should be sealed to minimize air leakage and the entrance of atmospheric contaminants into the reservoir.

4.3.14 The reservoir should be located such that the entire oil system external to the reservoir can drain, by gravity, into the reservoir.

4.3.15 Pumps and ejectors located inside the reservoir should be so located that the inlet is completely submerged at all times but no less than 150 mm (6 in.) from the reservoir bottom.