



Designation: D6448 – 16

Standard Specification for Industrial Burner Fuels from Used Lubricating Oils¹

This standard is issued under the fixed designation D6448; 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 reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

1. Scope*

1.1 This specification covers four grades of fuel oil made in whole or in part with hydrocarbon-based used or reprocessed lubricating oil or functional fluids, such as preservative and hydraulic fluids. The four grades of fuel are intended for use in various types of fuel-oil-burning industrial equipment under various climatic and operating conditions. These fuels are not intended for use in residential heaters, small commercial boilers, combustion engines, or marine applications.

1.1.1 Grades RFO4, RFO5L, RFO5H, and RFO6 are used lubricating oil blends, with or without distillate or residual fuel oil, or both, of increasing viscosity and are intended for use in industrial burners equipped to handle these types of recycled fuels.

NOTE 1—For information on the significance of the terminology and test methods used in this specification, see [Appendix XI](#).

1.2 This specification is for use in contracts for the purchase of fuel oils derived from used lubricating oil and for the guidance of consumers of such fuels. This specification does not address the frequency with which any particular test must be run.

1.3 Nothing in this specification shall preclude observance of national or local regulations, which can be more restrictive. In some jurisdictions, used oil is considered a hazardous waste and fuels from used oil are required to meet certain criteria before use as a fuel.

NOTE 2—For United States federal requirements imposed on used oil generators, transporters and transfer facilities, reprocessors, marketers, and burners, see 40 CFR 279.

NOTE 3—The generation and dissipation of static electricity can create problems in the handling of distillate burner fuel oils. For more information on the subject, see [Guide D4865](#).

1.4 The values stated in SI units are to be regarded as standard; non-SI units, when given, are for information only.

¹ This specification is under the jurisdiction of ASTM Committee D02 on Petroleum Products, Liquid Fuels, and Lubricants and is the direct responsibility of Subcommittee D02.P0 on Recycled Products.

Current edition approved April 1, 2016. Published April 2016. Originally approved in 1999. Last previous edition approved in 2014 as D6448 – 14^ε. DOI: 10.1520/D6448-16.

2. Referenced Documents

2.1 ASTM Standards:²

- D56 Test Method for Flash Point by Tag Closed Cup Tester
- D93 Test Methods for Flash Point by Pensky-Martens Closed Cup Tester
- D95 Test Method for Water in Petroleum Products and Bituminous Materials by Distillation
- D96 Test Method for Water and Sediment in Crude Oil by Centrifuge Method (Field Procedure) (Withdrawn 2000)³
- D97 Test Method for Pour Point of Petroleum Products
- D129 Test Method for Sulfur in Petroleum Products (General High Pressure Decomposition Device Method)
- D240 Test Method for Heat of Combustion of Liquid Hydrocarbon Fuels by Bomb Calorimeter
- D396 Specification for Fuel Oils
- D445 Test Method for Kinematic Viscosity of Transparent and Opaque Liquids (and Calculation of Dynamic Viscosity)
- D473 Test Method for Sediment in Crude Oils and Fuel Oils by the Extraction Method
- D482 Test Method for Ash from Petroleum Products
- D1217 Test Method for Density and Relative Density (Specific Gravity) of Liquids by Bingham Pycnometer
- D1250 Guide for Use of the Petroleum Measurement Tables
- D1266 Test Method for Sulfur in Petroleum Products (Lamp Method)
- D1298 Test Method for Density, Relative Density, or API Gravity of Crude Petroleum and Liquid Petroleum Products by Hydrometer Method
- D1480 Test Method for Density and Relative Density (Specific Gravity) of Viscous Materials by Bingham Pycnometer
- D1481 Test Method for Density and Relative Density (Specific Gravity) of Viscous Materials by Lipkin Bicapillary Pycnometer
- D1552 Test Method for Sulfur in Petroleum Products by High Temperature Combustion and IR Detection

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ The last approved version of this historical standard is referenced on www.astm.org.

*A Summary of Changes section appears at the end of this standard

D1796 Test Method for Water and Sediment in Fuel Oils by the Centrifuge Method (Laboratory Procedure)

D2622 Test Method for Sulfur in Petroleum Products by Wavelength Dispersive X-ray Fluorescence Spectrometry

D2709 Test Method for Water and Sediment in Middle Distillate Fuels by Centrifuge

D2983 Test Method for Low-Temperature Viscosity of Lubricants Measured by Brookfield Viscometer

D3245 Test Method for Pumpability of Industrial Fuel Oils (Withdrawn 2010)³

D3828 Test Methods for Flash Point by Small Scale Closed Cup Tester

D4052 Test Method for Density, Relative Density, and API Gravity of Liquids by Digital Density Meter

D4057 Practice for Manual Sampling of Petroleum and Petroleum Products

D4175 Terminology Relating to Petroleum Products, Liquid Fuels, and Lubricants

D4177 Practice for Automatic Sampling of Petroleum and Petroleum Products

D4294 Test Method for Sulfur in Petroleum and Petroleum Products by Energy Dispersive X-ray Fluorescence Spectrometry

D4377 Test Method for Water in Crude Oils by Potentiometric Karl Fischer Titration

D4865 Guide for Generation and Dissipation of Static Electricity in Petroleum Fuel Systems

D4868 Test Method for Estimation of Net and Gross Heat of Combustion of Burner and Diesel Fuels

D4980 Test Methods for Screening of pH in Waste (Withdrawn 2009)³

D5185 Test Method for Multielement Determination of Used and Unused Lubricating Oils and Base Oils by Inductively Coupled Plasma Atomic Emission Spectrometry (ICP-AES)

D5854 Practice for Mixing and Handling of Liquid Samples of Petroleum and Petroleum Products

D6304 Test Method for Determination of Water in Petroleum Products, Lubricating Oils, and Additives by Coulometric Karl Fischer Titration (Withdrawn 2016)³

D6450 Test Method for Flash Point by Continuously Closed Cup (CCCFP) Tester

D6822 Test Method for Density, Relative Density, and API Gravity of Crude Petroleum and Liquid Petroleum Products by Thermohydrometer Method

D7042 Test Method for Dynamic Viscosity and Density of Liquids by Stabinger Viscometer (and the Calculation of Kinematic Viscosity)

D7094 Test Method for Flash Point by Modified Continuously Closed Cup (MCCCFP) Tester

2.2 *U.S. Environmental Protection Agency Standards:*⁴

EPA 600/4-79-020 Determination of Inorganic Anions by Ion Chromatography

EPA SW-846 Method 9000 Determination of Water in Waste

Materials by Karl Fisher Titration

EPA SW-846 Method 9001 Determination of Water in Waste Lubricants by Quantitative Calcium Hydride Reaction

EPA SW-846 Method 9056 Determination of Inorganic Anions by Ion Chromatography

2.3 *Federal Code of Regulations Standards:*⁵

40 CFR 279 Standards for the Management of Used Oil

3. Terminology

3.1 Definitions:

3.1.1 *burner fuel oil, n*—any petroleum liquid suitable for the generation of heat by combustion in a furnace or firebox as a vapor or a spray, or a combination of both.

3.1.1.1 *Discussion*—Different grades are characterized primarily by viscosity ranges.

3.1.2 *reclaiming, n*—the use of cleaning methods during recycling primarily to remove insoluble contaminants, thus making the oil suitable for further use. The methods may include settling, heating, dehydration, filtration, and centrifuging.

3.1.3 *recycling, n*—in petroleum technology, the acquisition of oil that has become unsuitable for its intended use, and processing it to regain useful materials.

3.1.4 *re-refining, n*—the use of refining processes during recycling to produce high quality base stocks for lubricants or other petroleum products. Re-refining may include one or more of the following: distillation, hydrotreating, or treatments employing acid, caustic, solvent, clay, or other chemicals, or combination thereof.

3.1.5 *used oil, n*—in petroleum product recycling, oil whose characteristics have changed since being originally manufactured, and that is suitable for recycling.

3.1.6 *waste oil, n*—in petroleum technology, oil having characteristics making it unsuitable either for further use or for economic recycling.

3.2 For definitions of other terms used in this specification, refer to Terminology D4175.

3.3 Definitions of Terms Specific to This Standard:

3.3.1 *industrial burner, n*—a device that produces heat for industrial use through the combustion of liquid hydrocarbon fuels.

3.3.1.1 *Discussion*—Industrial burners are typically designed for one of two applications:

(a) *industrial furnaces*—integral components of manufacturing processes that provide direct heating, for example, in aggregate, cement, lime, or phosphate kilns; coke ovens; or blast, smelting, melting, refining, or drying ovens.

(b) *industrial boilers*—large indirect heating units that transfer thermal energy to water or other fluids or gases for use in heating in industrial settings and in manufacturing processes

3.3.2 *reprocessing, n*—in petroleum product recycling, the preparation of used oil to be suitable as a fuel.

⁴ Available from United States Environmental Protection Agency (US-EPA), Ariel Rios Bldg., Pennsylvania Ave., NW, Washington D.C. 20460. (www.epa.gov/epaoswer/hazwaste/test/main.htm).

⁵ National Archives and Records Administration, Code of Federal Regulations (CFR), Available from U.S. Government Printing Office Superintendent of Documents, 732 N. Capitol St., NW, Mail Stop: SDE, Washington, DC 20401. www.gpoaccess.gov/cfr/index.html.

3.3.2.1 *Discussion*—Reprocessing includes procedures such as settling, filtration, blending, distillation, and chemical treatment.

4. Classification

4.1 There are four grades of industrial burner fuel containing recycled lubricating oils covered by this specification. These grades may or may not correlate directly with similar grades in other ASTM standards. The RFO designation identifies them as Reprocessed Fuel Oils. The usage descriptions of each grade may not describe all the uses, but are included as general information. The four grades are described as follows:

4.1.1 *Grade RFO4*—Primarily a blend of used lubricating oils and distillate or a reprocessed distillate product derived from used oil. It is intended for use in pressure atomizing industrial burners with no preheating. This grade of recycled oil fuel is used in many medium capacity industrial burners where ease of handling justifies the higher cost over the heavier used oil fuels.

4.1.2 *Grade RFO5L*—A straight (100 %) used lubricating oil blend or a used lubricating oil and distillate blend fuel of intermediate viscosity, heavier than Grade RFO4. It is intended for use both in pressure-atomizing industrial burners not requiring higher cost distillates and in burners equipped to atomize oils of higher viscosity with or without pre-heating. Its permissible viscosity range allows it to be pumped and atomized at relatively low-storage temperatures.

4.1.3 *Grade RFO5H*—A straight (100 %) used lubricating oil blend or a used lubricating oil and residual blend fuel, heavier than Grade RFO5L. It is intended for use in industrial burners equipped with devices that atomize oil of higher viscosity than domestic burners can handle. Preheating may be necessary in some types of equipment for burning and in colder climates for handling.

4.1.4 *Grade RFO6*—A high-viscosity used lubricating oil and residual blend fuel, heavier than Grade RFO5H. It is

intended for use in large industrial heaters and may require preheating in the storage tank to permit pumping. Additional preheating at the burner may be necessary to permit satisfactory atomization. The extra equipment and maintenance required to handle this fuel usually preclude its use in small installations.

5. General Requirements

5.1 The fuel oils specified herein shall contain a minimum volume of 25 % of used lubricating oil-derived products, the balance being a Specification D396 fuel oil or suitable refinery stocks.

5.2 The fuel oils shall be homogeneous fluids consisting primarily of hydrocarbons. Fuel oils containing residual components shall remain uniform in storage and shall not separate by gravity or aging into layers in normal operating conditions.

NOTE 4—Prolonged storage or equipment down time may necessitate circulation of the fuel oil in-tank to prevent such separation.

5.3 The fuel oil shall not contain excessive amounts of organic or inorganic acids, or both, and shall be free of solid or fibrous matter that could cause system handling or maintenance problems. The buyer and seller should agree on any requirements for particle size.

NOTE 5—The fuels defined by this specification are appropriate only for burners capable of handling and combusting fuels with potentially higher metals and ash content.

6. Detailed Requirements

6.1 *Grade RFO4*—The requirements for this type of fuel are presented in Table 1 and include fuels in the viscosity range below 5 mm²/s (cSt) at 100 °C in accordance with Test Method D445.

TABLE 1 Detailed Requirements for Industrial Burner Fuels from Used Lubricating Oils

Properties	Method ^A	Proposed Limits ^B			
		RFO4	RFO5L	RFO5H	RFO6
Physical:					
Viscosity @ 100 °C mm ² /s ^C	D445				
minimum	5.0	9.0	15.0
maximum	...	<5.0	8.9	14.9	50.0
Flash point, °C (°F), min	D93	38 (100)	55 (130)	55 (130)	60 (140)
Water & sediment, ^D percent by volume max	D95 and D473	2.0	3.0	3.0	3.0
Pour point, °C (°F), max	D97	-6 (21)	NA	NA	NA
Density, kg/m ³ @ 15 °C ^E	D1298	Report	NA	NA	NA
Chemical:					
Ash, percent by mass, max	D482	0.7	0.8	0.8	Report
Sulphur, percent by mass ^F	D129	Report	Report	Report	Report
Extracted pH, min	D4980	4.0	4.0	4.0	4.0
Performance:					
Gross heating value, MJ/kg (BTU/US gal), ^G min	D240	40.0 (130 000)	41.5 (135 000)	41.5 (135 000)	43.0 (140 000)

^A See Section 7 for details and additional methods.

^B Units given in parentheses are for informational purposes only.

^C 1 cSt = 1 mm²/s.

^D Solids content should not exceed 1.0 % for RFO4 and 5; 2.0 % for RFO 6; Filtration may be required to obtain appropriate particle size for use.

^E Density in kg/L at 15 °C multiplied by 1000 = kg/m³.

^F Local jurisdictions may limit the sulphur content in burner fuels.

^G Assumes 7.5 lb/U.S. gal.