

Report

on Re-Check a Gasket Material for Reactivity with Oxygen

Reference Number	2-689/2012 E
Copy	1. Copy of 2 Copies
Customer	Frenzelit-Werke GmbH Frankenhammer 7 95460 Bad Berneck Germany
Order Date	February 13, 2012
Reference	EMP / BWI
Receipt of Order	March 8, 2012
Test Samples	Gasket material novaflon® 200 for use in flanged connections in piping, valves and fittings or other components for gaseous oxygen service and for liquid oxygen service. BAM-Order No. 2.1/51 019
Receipt of Samples	February 17, 2012
Test Date	May 23, 2012 to December 11, 2012
Test Location	BAM – Working Group "Safe Handling of Oxygen"; building no. 41, room no. 073
Test Procedure or Requirement According to	DIN EN 1797: 2002-02 „Cryogenic Vessels - Gas/Material Compatibility“ ISO 21010: 2004-07 „Cryogenic Vessels - Gas/Material Compatibility“ Annex of pamphlet M 034-1 (BGI 617-1) "List of nonmetallic materials compatible with oxygen by BAM Federal Institute for Material Research and Testing.", by Berufsgenossenschaft Rohstoffe und chemische Industrie, Edition: September 2011; Rule BGR 500 "Betreiben von Arbeitsmitteln" part 2, chapter 2.32 "Betreiben von Sauerstoffanlagen", paragraph 3.17 "Lubricants and sealing materials", Edition: April 2008.

All pressures of this report are excess pressures.
This test report consists of page 1 to 4 and annex 1 to 3.

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In case a German version of the test report is available, exclusively the German version is binding.

TEST REPORT



1 Documents and Test Samples

The following documents and samples were submitted to BAM:

- 1 Test Application
- 15 Disks of the gasket material novaflon® 200
Diameter 140 mm; Thickness 2 mm
Colour: White

2 Test Methods

The non-metallic material novaflon® 200 has already been tested and evaluated in 2001 as a gasket material for use in flanged connections in piping, valves and fittings or other components for gaseous oxygen service at 250 °C and 83 bar and for liquid oxygen service under reference number II-3205/2001.

The gasket material was already tested by BAM for the first time in 2001, reference number II-3205/2001. This time, a re-check was carried out to evaluate the compatibility of the gasket material for gaseous oxygen service at temperatures up to 250 °C and 83 bar. For this purpose, a determination of the autogenous ignition temperature (AIT) and a flange test in high pressure oxygen were performed at the same final oxygen pressure as in 2001.

The compatibility of the material with liquid oxygen was tested by its reactivity with liquid oxygen on mechanical impact.

3 Results

3.1 Autogenous Ignition Temperature (AIT)

The test method is described in annex 1.

Results:

Test No.	Initial Oxygen Pressure p_i [bar]	Final Oxygen Pressure p_F [bar]	AIT [°C]
1	34	86	467
2	34	87	468
3	34	87	467
4	34	87	467
5	34	88	466

In five tests with an initial oxygen pressure of $p_i = 87$ bar, an AIT of 467 °C was determined with a standard deviation of ± 1 °C. The oxygen pressure p_F at ignition is approximately 87 bar.

3.2 Flange Test

The test method is described in annex 2.

Results:

Number of Tests	Temperature [°C]	Oxygen Pressure [bar]	Notes
1	250	83	Only those parts of the gasket burn that project into the pipe.
2	250	83	Only those parts of the gasket burn that project into the pipe
3	250	83	Only those parts of the gasket burn that project into the pipe
4	250	83	Only those parts of the gasket burn that project into the pipe
5	250	83	Only those parts of the gasket burn that project into the pipe

In five tests at 83 bar oxygen pressure and 250 °C, only those parts of the gasket burn that project into the pipe; the fire is neither transmitted to the steel nor does the gasket burn between the flanges. The flange remains gas-tight.

3.3 Reactivity with Liquid Oxygen on Mechanical Impact

The test method is described in annex 3.

Results:

Test No.	Drop Heights [m]	Impact Energy [Nm]	Reaction
1	0.67	500	reaction
2	0.50	375	no reaction
3	0.50	375	no reaction
4	0.50	375	reaction
5	0.33	250	no reaction
6	0.33	250	no reaction
7	0.33	250	no reaction
8	0.33	250	reaction
9	0.17	125	no reaction
10	0.17	125	no reaction
11	0.17	125	reaction

At drop heights of 0.67 m to 0.17 m (impact energy 500 Nm to 125 Nm), severe reactions of the sample with liquid oxygen occurred.

4 Summary and Evaluation

The non-metallic material novaflon® 200 had already been tested and evaluated in 2001 as a gasket material for use in valves and fittings or other components for gaseous oxygen service under reference numbers Tgb.-Nr.: II-3205/2001.

The tests have shown that the autogenous ignition temperature of the gasket material novaflon® 200 is 467 °C at 87 bar oxygen pressure. The standard deviation of the AIT is ± 1 °C.

This shows, that the AIT of novaflon® 200 is identical compared to the AIT of the material in 2001 within the precision of measurement.

On basis of the test results, there are no objections with regard to technical safety to use the gasket material novaflon® 200 in flange connections made of copper, copper alloys or steel at following conditions:

Maximum Temperature	Maximum Oxygen Pressure
up to 250 °C	up to 83 bar

This applies to flat faced flanges, male/female flanges, and flanges with tongue and groove.

According to the test results and the BAM-Standard "Testing for Reactivity with Liquid Oxygen on Mechanical Impact", described in annex 3, the gasket material novaflon® 200 is not suitable for liquid oxygen service. The test result of testing the reactivity with liquid oxygen on mechanical impacts has not been confirmed compared to the result in 2001.

5 Comments

The test results refer exclusively to the batch of the tested material.

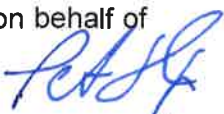
Products on the market that contain a reference to BAM testing shall be marked accordingly. It shall be evident that only a sample of a batch has been tested and evaluated for oxygen compatibility. The reference shall not produce a presumption of conformity that monitoring of the production on a regular basis is being performed by BAM.

It shall be clear that the product may only be used for gaseous oxygen service. The maximum safe oxygen pressure of the product and its maximum use temperature as well as other restrictions in use shall be given.

**BAM Federal Institute for Materials Research and Testing
12200 Berlin, April 8, 2013**

**Division 2.1
"Gases, Gas Plants"**

on behalf of



Dipl.-Ing. P. Hartwig
Study Director "Safe Handling of Oxygen"

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Annex 1

Determination of the Autogenous Ignition Temperature in High Pressure Oxygen

A mass of approximately 0.1 g to 0.5 g of the pasty or of the divided solid sample is placed into an autoclave (34 cm³ in volume) with a chrome/nickel lining. Liquid samples are applied onto ceramic fiber.

The autoclave is pressurized to the desired pressure p_a at the beginning of the test. A low-frequency heater inductively heats the autoclave in an almost linear way at a rate of 110 K/min. The temperature is monitored by means of a thermocouple at the position of the sample.

The pressure in the autoclave is measured by means of a pressure transducer. Pressure and temperature are recorded. During the test, as the temperature increases, the oxygen pressure increases within the autoclave. The ignition of the sample can be recognized by a sudden rise in temperature and pressure. The oxygen pressure on ignition p_e is calculated.

It is important to know the oxygen pressure p_e , as the autogenous ignition temperature of a material is a function of pressure. It may decrease as the oxygen pressure increases.

Annex 2

Testing of Gaskets for Flanges in Oxygen Steel Pipings

The test apparatus mainly consists of two DN 65 PN 160 steel pipes, each approximately 2 m in length, with corresponding standard flanges welded to each pipe.

Both pipes are sealed using the gasket to be tested. In case of a gasket disk its inner diameter is chosen in such a way that it projects into the pipe. If a gasket tape is under test, both ends of the tape are allowed to project into the pipe. The test apparatus is then pressurized with oxygen up to the desired test pressure. The flange is heated by heating sleeves to the test temperature, at least 50 K lower than the ignition temperature of the gasket. An electrical filament ignites that part of the gasket projecting into the pipe. If the gasket is electrically conductive, such as spiral seals or graphite foils, a nonconductive primer capsule of organic material (PTFE, rubber) is used which acts on the seal.

The gasket's behavior after ignition is important for its evaluation. If the seal burns with such a hot flame that the fire is transmitted to the steel of the flange (in most case the test apparatus is destroyed), the seal is considered unsuitable from the beginning. If only those parts of the seal burn that project into the pipe and the fire is not transmitted to the flanges and if the seal does not burn between the flanges there are no objections with regard to technical safety to use the seal under the conditions tested. Such a positive result is to confirm in four additional tests. If, however, the flanged connection becomes un-tight during a test, e. g., because of softening or burning of the seal, the test has to be continued at a lower temperature and oxygen pressure until a positive test result is reached in five tests, as mentioned above.

Annex 3

Testing for Reactivity with Liquid Oxygen on Mechanical Impact

Approximately 0.5 g of the liquid or divided sample is placed into a sample cup (height = 10 mm; diameter = 30 mm), made of 0.01 mm copper foil. Liquid oxygen is poured into the cup over the sample which is then exposed to the mechanical impact of a plummet (mass = 76.5 kg). The drop height of the plummet can be varied. A steel anvil with a chrome/nickel steel plate supports the sample cup. The anvil, having a mass eight times of the plummet, is supported by four damping elements mounted on the steel frame of the test apparatus that rests on a concrete base.

A reaction of the sample with liquid oxygen is usually indicated by a flame and a more or less strong noise of an explosion. The impact energy, at which no reaction occurs, is determined in varying the drop height of the plummet. This result shall be confirmed in a series of ten consecutive tests under the same conditions. The tests are finished, if reactions can be observed at impact energies of 125 Nm or less (equivalent to a drop height of the plummet of 0.17 m or less). In this case, with regard to technical safety, the material is not suitable for liquid oxygen service.