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Introduction

This draft standard is based on national and international discussions. Your comments on this draft are invited and will assist in the preparation of the consequent standard.

For international standards, comments will be reviewed by the relevant UK national committee before sending the consensus UK vote and comments to the international committee, which will then decide appropriate action. If the international standard is approved, it is usual for the text to be published as a British Standard.

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Date: xx/xx/20xx	Document: ISO/DIS xxxx
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1	2	(3)	4	5	(6)	7
MB	Clause No./ Subclause No./Annex (e.g. 3.1)	Paragraph/Figure/ Table/Note	Type of comment	Commend (justification for change) by the MB	Proposed change by the MB	Secretariat observations on each comment submitted
	3.1	Definition 1	ed	Definition is ambiguous and needs clarifying.	Amend to read '...so that the mains connector to which no connection...'	
	6.4	Paragraph 2	te	The use of the UV photometer as an alternative cannot be supported as serious problems have been encountered in its use in the UK.	Delete reference to UV photometer.	

DRAFT INTERNATIONAL STANDARD

ISO/DIS 9300

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Measurement of gas flow by means of critical flow nozzles

Mesure de débit de gaz au moyen de Venturi-tuyères en régime critique

ICS: 17.120.10

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see www.iso.org/iso/foreword.html.

ISO 9300 was prepared by Technical Committee ISO/TC 30, *Measurement of fluid flow in closed conduits*, Subcommittee SC 2, *Pressure differential devices*.

This third edition cancels and replaces the second edition (ISO 9300:2005), which has been technically revised.

The information presented in this standard was gathered from many published papers and from the experience of the technical committee members and other knowledgeable engineers. This Standard is a blend of the available technical information and best practices and it is intended to be a practical guide to the proper use of critical flow nozzles.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

Measurement of gas flow by means of critical flow nozzles

1 Scope

This International Standard specifies the geometry and method of use (installation in a system and operating conditions) of critical flow nozzles (CFNs) used to determine the mass flow-rate of a gas flowing through a system basically without calibrating the CFN. It also gives the information necessary for calculating the flow-rate and its associated uncertainty.

If the CFN is to be flow calibrated, all the installation, operating conditions, and calculations shall comply with the instructions by the calibration facility, therefore, this International Standard does not cover it. For some conditions, e.g., small CFNs, gas with significant vibrational relaxation effect, and so on, the flow calibration is recommended.

This International Standard is applicable to nozzles in which the gas flow accelerates to the critical velocity at the minimum flowing section, and only where there is steady flow of single-phase gas. When the critical velocity is attained in the nozzle, the mass flow-rate of the gas flowing through the nozzle is the maximum possible for the existing inlet condition, while the CFN can only be used within specified limits, e.g. the CFN throat to inlet diameter ratio and Reynolds number. This International Standard deals with the toroidal- and cylindrical-throat CFNs for which direct calibration experiments have been made in sufficient number to enable the resulting coefficients to be used with certain predictable limits of uncertainty.

Information is given for cases where the pipe upstream of the CFN is of circular cross-section, or when there is a large volume (chamber) upstream of the CFN or a set of CFNs mounted in a cluster. The chamber configuration offers the possibility of installing CFNs in parallel, thereby achieving high flow-rates and/or variable volume flow-rate.

For information, the diameter correction method (DCM) is described that uses the result of a flow calibration at a single Reynolds number to match the discharge coefficient curve on a reference one by modifying the throat diameter without affecting the calculation result of the flow-rate. The DCM replaces the role of throat diameter by the calibration result; therefore, it is not necessary to measure the throat diameter accurately when applying the DCM.

The CFNs are especially suited as transfer standards, reference flow meters for calibration and testing, and for precise flow-rate control applications. Provided the upstream condition is stable, a CFN immediately produces a stable gas flow of known flow-rate without any adjustment except for lowering the downstream pressure sufficiently. The CFNs should be associated with a precise statement of uncertainty for the measured flow-rate.

2 Normative references

There are no normative references in this document.

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply. Regarding to pressure and temperature, this International Standard uses only the absolute pressure and absolute temperature, respectively.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <http://www.electropedia.org/>

3.1 Pressure

3.1.1

static pressure

pressure of the flowing gas

Note to entry: The static pressure can be measured through a wall pressure tapping.

3.1.2

stagnation pressure

pressure which would exist in a flowing gas stream if the stream were brought to rest by an isentropic process

3.1.3

wall pressure tapping

hole drilled in the wall of a conduit to measure the static pressure of the flowing gas in the conduit

3.2 Temperature

3.2.1

static temperature

temperature of the flowing gas

Note to entry: The static temperature cannot be measured by a temperature sensor fixed in the conduit (see J.3.2.1)

3.2.2

stagnation temperature

temperature which would exist in a flowing gas stream if the stream were brought to rest by an isentropic process

3.2.3

recovery temperature (wall temperature, measured temperature)

temperature of the gas touching the wall

Note to entry: The temperature sensor fixed on a conduit measures the recovery temperature.

3.3 Nozzle

3.3.1

contraction

portion of the nozzle upstream of the throat intended to accelerate the flow and attain the supposed flow field at the critical point

3.3.2

throat

portion of the nozzle where the cross section is minimum

Note to entry: This International Standard deals with nozzles with toroidal- and cylindrical-throats.

3.3.3**diffuser**

divergent portion of the nozzle behind the throat intended to recover the pressure

3.3.4**traditional diffuser**

frustum diffuser machined as one piece

3.3.5**nozzle**

device inserted in a system intended to use for measurement of the flow-rate through system, which consists of contraction and throat, or contraction, throat, and diffuser

3.3.6**critical flow nozzle (CFN, choked nozzle)**

nozzle that attains the critical flow

3.3.7**normal precision nozzle (NPN)**

nozzle machined by a lathe, with the surface polished to achieve the desired roughness

3.3.8**high precision nozzle (HPN)**

nozzle machined by a lathe that can achieve mirror finish without polishing the surface, thus it has the form exactly as designed

3.4 Flow**3.4.1****isentropic flow**

theoretical flow along which the thermodynamic process is adiabatic and reversible (see J.3.4.1)

3.4.2**critical flow**

flow in a nozzle that has attained the maximum flow-rate of the nozzle for a given set of inlet conditions

3.4.3**choke**

attaining the critical flow in a nozzle

3.4.4**critical point**

location in the CFN where the flow attains the critical velocity

3.4.5**critical pressure**

p^*

static pressure at the critical point

3.4.6**critical pressure of perfect gas**

p_p^*

theoretical static pressure at the critical point assuming the isentropic flow of perfect gas

3.4.7

critical temperature

T^*

static temperature at the critical point

3.4.8

critical temperature of perfect gas

T_p^*

theoretical static temperature at the critical point assuming the isentropic flow of perfect gas

3.4.9

critical density

ρ^*

density at the critical point

3.4.10

critical density of perfect gas

ρ_p^*

theoretical density at the critical point assuming the isentropic flow of perfect gas

3.4.11

critical velocity

c^*

flow velocity at the critical point

3.4.12

critical velocity of perfect gas

c_p^*

theoretical flow velocity at the critical point assuming the isentropic flow of perfect gas

3.5 Flow-rate

3.5.1

mass flow-rate

q_m

mass of the gas passing through the CFN per unit time

Note to entry: In this International Standard, the term "mass flow-rate" without any adjective always refers to the true mass flow-rate through CFN.

3.5.2

theoretical mass flow-rate of perfect gas

q_{thP}

theoretical mass flow-rate through the CFN assuming one-dimensional isentropic flow of perfect gas

3.5.3

theoretical mass flow-rate of real gas

q_{thR}

theoretical mass flow-rate through the CFN assuming one-dimensional isentropic flow of real gas

3.5.4

volume flow-rate

q_v

volume of the gas passing through the conduit, in which the CFN is installed, per unit time at a designated location

Note to entry: The volume flow-rate at the designated location, where the density is ρ , is given by:

$$q_v = \frac{q_m}{\rho}$$

3.5.5

Reynolds number

$$R_e = \frac{4q_m}{\pi d \mu_0}$$

dimensionless parameter calculated from the throat diameter, mass flow-rate, and gas dynamic viscosity at CFN inlet stagnation condition

3.5.6

discharge coefficient

$$C_d = \frac{q_m}{q_{thR}}$$

ratio of the mass flow-rate to theoretical one of real gas at the same inlet stagnation condition

3.5.7

critical pressure ratio

ratio of the critical pressure of perfect gas to the inlet stagnation pressure

3.5.8

back-pressure ratio

ratio of the static pressure at the diffuser exit to the inlet stagnation pressure

3.5.9

Mach number in a conduit

$$M_a$$

ratio of the mean axial flow velocity over the cross-section of upstream conduit to the acoustic velocity at the same location

Note to entry: It is not necessary for M_a to be accurate and it may be approximated by:

$$M_a = \frac{q_m}{\frac{\pi D^2}{4} \rho_0} \frac{1}{\sqrt{\gamma \frac{R}{M} T_0}}$$

3.5.10

uncertainty

parameter, associated with the results of a measurement, that characterizes the dispersion of the values that could reasonably be attributed to the measurand

3.6 Gas

3.6.1

perfect gas

theoretical gas whose isentropic exponent equals to the specific heat that is constant at any gas condition and also compressibility factor is always unity

3.6.2

real gas

actual gas whose isentropic exponent and compressibility factor depend on its pressure and temperature

3.6.3

compressibility factor

Z

correction factor for the deviation of the real gas constant from the universal one

3.6.4

critical flow function

C^*

dimensionless function that relates the thermodynamic properties of the gas at the throat of CFN to its inlet stagnation condition assuming one-dimensional isentropic flow

3.6.5

critical flow function for the flow-rate equation using density

$$C^*_{\text{D}} = C^* \sqrt{Z_0}$$

alternative critical flow function to be used in the equation of mass flow-rate that uses density

3.6.6

isentropic exponent

κ

ratio of the relative variation in pressure to the corresponding relative variation in density under isentropic process

4 Symbols and abbreviations

Symbol	Description	Dimension	SI unit
a, b, c, d, e, f, n	Coefficients for Equation (17)	Dimensionless	-
A_2	Cross-sectional area of nozzle exit	L^2	m^2
A_{nt}	Cross-sectional area at the critical point at the operating CFN temperature	L^2	m^2
c	Local acoustic velocity	LT^{-1}	$m \cdot s^{-1}$
c^*	Local acoustic velocity at the critical point	LT^{-1}	$m \cdot s^{-1}$
c_p^*	Local acoustic velocity at the critical point of perfect gas	LT^{-1}	$m \cdot s^{-1}$
C_c^*	Parameter for the equation of C^*	Dimensionless	-
C_μ	Parameter for the equation of μ	Dimensionless	-
C_d	Discharge coefficient	Dimensionless	-
$C_{d,target}$	Target discharge coefficient obtained when applying the DCM	Dimensionless	-
C_d^{ISO}	Discharge coefficient calculated by using Equation (17)	Dimensionless	-
C^*	Critical flow function	Dimensionless	-
C_p^*	Critical flow function for the flow-rate equation using density	Dimensionless	-
C_p^*	Critical flow function of perfect gas	Dimensionless	-
C^{*DA}	Critical flow function of dry air	Dimensionless	-
C^{*HA}	Critical flow function of humid air	Dimensionless	-
$C_{i,j}$	Coefficient to calculate C^*	b	b
c_v	Covariance	Dimensionless	-
D	Diameter of the inlet conduit	L	m
d_{DCM}	Throat diameter corrected by the DCM	L	m
d_{nt}	Throat diameter at the operating CFN temperature	L	m
d_{nt0}	Measured throat diameter (at temperature T_{nt0})	L	m
d_{ORI}	Throat diameter used at the calibration for the DCM	L	m
d_p	Diameter of the wall pressure tapping breakthrough into the conduit	L	m
H_R	Relative humidity	%	-
k	Coverage factor	Dimensionless	-
l	Diffuser length	L	m
l_1	Distance between Etoile straightener outlet and nozzle inlet plane	L	m
l_2	Length of Etoile straightener	L	m
M	Molar mass	M	$kg \cdot mol^{-1}$
M_a	Local Mach number at the location of the inlet pressure tapping	Dimensionless	-
M_{a2}	Local Mach number at the CFN exit assuming the fully subsonic flow in the diffuser	Dimensionless	-

p	Pressure of the gas	$\text{ML}^{-1}\text{T}^{-2}$	Pa
p_0	Stagnation pressure of the gas at the CFN inlet	$\text{ML}^{-1}\text{T}^{-2}$	Pa
p_1	Static pressure of the gas measured through the upstream wall pressure tapping	$\text{ML}^{-1}\text{T}^{-2}$	Pa
p_2	Static pressure of the gas at the diffuser exit	$\text{ML}^{-1}\text{T}^{-2}$	Pa
p_{2i}	Theoretical static pressure of the gas at the diffuser exit when the nozzle is choked but the flow in the diffuser is fully subsonic	$\text{ML}^{-1}\text{T}^{-2}$	Pa
p_{den}	Static pressure in the gas at densitometer	$\text{ML}^{-1}\text{T}^{-2}$	Pa
P_r	The Prandtl number	Dimensionless	-
p^*	Static pressure at the critical point	$\text{ML}^{-1}\text{T}^{-2}$	Pa
p_p^*	Theoretical static pressure at the critical point of perfect gas	$\text{ML}^{-1}\text{T}^{-2}$	Pa
q_m	Mass flow-rate (True mass flow-rate)	MT^{-1}	$\text{kg}\cdot\text{s}^{-1}$
q_{thP}	Theoretical mass flow-rate of perfect gas	MT^{-1}	$\text{kg}\cdot\text{s}^{-1}$
q_{thR}	Theoretical mass flow-rate of real gas	MT^{-1}	$\text{kg}\cdot\text{s}^{-1}$
q_v	Volume flow-rate	MT^{-1}	$\text{kg}\cdot\text{s}^{-1}$
R	Universal gas constant (8,314 5 J/(mol·K))	$\text{M L}^2\text{T}^{-2}\Theta^{-1}$	$\text{J}\cdot\text{mol}^{-1}\text{K}^{-1}$
R_a	Arithmetic average roughness	L	m
Re	Reynolds number	Dimensionless	-
Re^{ORI}	The Reynolds number at the calibration for the DCM	Dimensionless	-
R_f	Recovery factor	Dimensionless	-
r_c	Radius of inlet contraction	L	m
r_{CBP}	Critical back-pressure ratio	Dimensionless	-
r_{nt}	Radius in the vicinity of throat inlet in cylindrical-throat CFN	L	m
T	Temperature of the gas	Θ	K
T_0	Stagnation temperature of the gas at the CFN inlet	Θ	K
T_1	Measured temperature of the gas at the CFN inlet	Θ	K
T_{den}	Static temperature at densitometer	Θ	K
T_m	Measured temperature	Θ	K
T_{nt0}	Temperature when throat diameter was measured	Θ	K
T^*	Static temperature at the critical point	Θ	K
T_p^*	Theoretical static temperature at the critical point of perfect gas	Θ	K
T_{c^*}	Parameter for the equation of C^*	Θ	K
T_μ	Parameter for the equation of μ	Θ	K
u	Standard uncertainty ($k = 1$)	b	-
u_c	Combined standard uncertainty ($k = 1$)	b	-
U	Expanded uncertainty (with specified coverage factor, k)	b	U
V_{ij}	Coefficient to calculate viscosity	b	U
U	Expanded uncertainty (with specified coverage factor, k)	b	U
x_i	Mole fraction of the i -th component	Dimensionless	-
Z	Compressibility factor	Dimensionless	-
Z_0	Compressibility factor at upstream stagnation condition	Dimensionless	-
Z_{den}	Compressibility factor at densitometer	Dimensionless	-
α	Linear expansion coefficient of the nozzle material	Θ^{-1}	K^{-1}
β	Diameter ratio of the throat and conduit (d_{nt}/D)	Dimensionless	-
δ	Absolute uncertainty	a	a
γ	Heat capacity ratio	Dimensionless	-
κ	Isentropic exponent	Dimensionless	-

μ_0	Dynamic viscosity of the gas at the inlet stagnation conditions	$ML^{-1}T^{-1}$	Pa·s
μ	Dynamic viscosity of the gas	$ML^{-1}T^{-1}$	Pa·s
θ	Angle of the frustum diffuser wall against the nozzle AOS	Dimensionless	rad
ρ	Density of the gas	ML^{-3}	kg
ρ_0	Gas density at the inlet stagnation conditions at nozzle inlet	ML^{-3}	$kg \cdot m^{-3}$
ρ_{den}	Gas density measured by a densitometer	ML^{-3}	$kg \cdot m^{-3}$
ρ^*	Theoretical density of the gas at the critical point	ML^{-3}	$kg \cdot m^{-3}$
ρ_p^*	Theoretical density of the gas at the critical point of perfect gas	ML^{-3}	$kg \cdot m^{-3}$

M = mass
L = length
T = time
 Θ = temperature
^a Same as the corresponding quantity.
^b Depending on each terms of the equation.

Abbreviation	Description
AOS	axis of symmetry
CFN	critical flow nozzle
DCM	diameter correction method
HPN	high precision nozzle
NPN	normal precision nozzle
IP	inlet plane
PUP	premature unchoking phenomenon
TLS	tangential line of surface

5 Basic equations

5.1 Gas behaviour

5.1.1 Isentropic process

The pressure, temperature, and density of gas in the isentropic process are related by;

$$\frac{p^{\gamma-1}}{T^{\gamma}} = \text{const.} \quad (1)$$

$$\frac{p}{\rho^{\gamma}} = \text{const.} \quad (2)$$

5.1.2 State equation

The behaviour of real gas is described by:

$$\frac{p}{\rho} = \left(\frac{RZ}{M} \right) T \quad (3)$$

5.2 Isentropic flow of perfect gas

5.2.1 Flowing area

The flowing area is related to the local Mach number by:

$$A = \frac{1}{M_a} \left[\frac{(\gamma - 1) M_a^2 + 2}{\gamma + 1} \right]^{\frac{1}{2} \frac{\gamma + 1}{\gamma - 1}} A_{nt} \quad (4)$$

5.2.2 Static pressure

The static pressure is related to the local Mach number by:

$$p = \left(1 + \frac{\gamma - 1}{2} M_a^2 \right)^{-\frac{\gamma}{\gamma - 1}} p_0 \quad (5)$$

5.2.3 Static temperature

The static temperature is related to the local Mach number by:

$$T = \frac{2}{2 + (\gamma - 1) M_a^2} T_0 \quad (6)$$

5.3 Theoretical variables at the critical point

5.3.1 General

The theoretical variables at the critical point are derived assuming the isentropic flow of perfect gas.

5.3.2 Critical pressure

The theoretical static pressure at the critical point is given by:

$$p^*_p = \left(\frac{2}{\gamma + 1} \right)^{\frac{\gamma}{\gamma - 1}} p_0 \quad (7)$$

5.3.3 Critical temperature

The theoretical static temperature at the critical point is given by:

$$T^*_p = \frac{2}{\gamma + 1} T_0 \quad (8)$$

5.3.4 Critical density

The theoretical density at the critical point is given by:

$$\rho^*_p = \left(\frac{2}{\gamma + 1} \right)^{\frac{1}{\gamma - 1}} \rho_0 \quad (9)$$

5.3.5 Critical velocity

The theoretical flow velocity at the critical point is given by:

$$c^*_{\text{p}} = \sqrt{\gamma \frac{R}{M} T^*_{\text{p}}} \quad (10)$$

5.4 Theoretical mass flow-rates

5.4.1 General

The theoretical mass flow-rates are derived assuming one-dimensional isentropic flow of perfect or real gas.

5.4.2 Theoretical mass flow-rate of perfect gas

The theoretical mass flow-rate of perfect gas is defined by the product of flowing area, local acoustic velocity, and density at the critical point assuming one-dimensional isentropic flow of perfect gas, i.e. $Z=1$ and $k=g$, which is given by:

$$q_{\text{thP}} \equiv A^* c^*_{\text{p}} \rho^*_{\text{p}} = A^* C^*_{\text{p}} \frac{P_0}{\sqrt{\left(\frac{R}{M}\right) T_0}} \quad (11)$$

5.4.3 Theoretical mass flow-rate of real gas

The theoretical mass flow-rate of real gas is defined by the product of flowing area, local acoustic velocity, and density at the critical point assuming one-dimensional isentropic flow of real gas, which is given by:

$$q_{\text{thR}} \equiv A^* c^* \rho^* = A^* C^* \frac{P_0}{\sqrt{\left(\frac{R}{M}\right) T_0}} \quad (12)$$

5.5 Mass flow-rate

The mass flow-rate of CFN is given by

$$q_{\text{m}} = C_{\text{d}} q_{\text{thR}} \quad (13)$$

or

$$q_{\text{m}} = C_{\text{d}} \left(A^* C^*_{\text{D}} \sqrt{p_0 \rho_0} \right) \quad (14)$$

6 General requirements

- 1) The flow shall be stationary and single-phase with no condensation to the critical point (throat).
- 2) A sufficiently low back-pressure ratio shall be applied on the CFN to maintain the critical flow.

NOTE The typical pressure ratio required to operate the CFN with a sufficiently long diffuser may be about 0,8 at high Reynolds numbers, e.g., greater than 2×10^5 (corresponding to ca. 50 m³/h CFN at the atmospheric pressure); however, it

is often necessary to keep the ratio lower than 0,5 at low Reynolds numbers or sometimes 0,25 at very low Reynolds numbers (see Clause 11 and Annex H).

- 3) The thermodynamic properties of the gas, C^* and M (or C^*_{D} and r when a densitometer is used), are required at low uncertainties (see 10.4).

NOTE For a gas mixture, accurate gas composition is required to calculate C^* at sufficiently low uncertainty..

If the following requirements cannot be achieved, the CFN will have to be flow calibrated at the same condition as in its application.

- 4) The gas should have no significant relaxation effect (see B.5).
- 5) The temperatures of gas and CFN should be stable (see J.3.4.1).
- 6) The form and surface in the contraction and throat should be accurately machined as specified in Clause 8 (see Annex G).
- 7) The form of the CFN will be verified periodically, especially in the contraction and throat (see Annex G).

NOTE The contraction and throat may be deformed over time by the impact of any solid contained in the gas.

The contraction and throat shall retain their cleanliness and hence surface finish. If this cannot be guaranteed, the measurement shall not be claimed to conform to this International Standard, and flow calibration is recommended.

7 Applications for which the method is suitable

Each application should be evaluated to determine whether a CFN or some other device is the most suitable.

The most common applications for CFNs are to act as working or reference standards to calibrate other meters, as check or transfer standards to verify or compare calibration facilities, as controllers of flow-rates, and so on.

Important considerations are:

- 1) The mass and volume flow-rates through the CFN are independent of the downstream condition.
- 2) The volume flow-rate through the conduit where the CFN is installed is almost constant at any upstream pressure if the temperature is stable.

NOTE Multiple CFNs installed in parallel (e.g., the chamber configuration) are required to vary the volume flow-rate through CFN system (see 9.3 and J.7(2)).

Some other considerations are:

- 3) Accurate measurements of the pressure and temperature (or density when using a densitometer) are required only at the upstream location of the CFN.
- 4) The downstream pressure should be monitored or estimated to confirm that the CFN is choked.

- 5) The mass flow-rate of CFN is proportional to the inlet stagnation pressure, accordingly, the maximum mass flow-rate that can be achieved by the CFN is practically limited by the maximum inlet pressures.

8 CFN

8.1 General requirements for both the standard types

8.1.1 General

This section specifies the common requirements to the toroidal- and cylindrical-throat CFNs.

To perform the measurement of flow-rate at the uncertainty specified in 10.3.2 by using the discharge coefficient specified in 10.3.1, the CFN shall be complying with the specifications in 8.1.2 to 8.1.4 and 8.2.

Verification of the form and dimensions by CMM will have to be mandatory, and if the manufacturing tolerances specified in this section including the roughness cannot be achieved or verified by inspections, flow calibration is recommended.

8.1.2 Materials

The CFN shall be made of material suitable for the intended application. Some considerations are that:

- a) it should be possible to finish or machine the surface to the conditions required in 8.1.3 and 8.2,
 NOTE Some materials are unsuitable due to pits, voids and lack of homogeneity.
- b) the material, together with any surface treatment used, shall not be subject to corrosion in the intended service, and
- c) the material should be dimensionally stable and should have known and repeatable thermal expansion characteristics, so that the throat diameter correction in Equation (16) can be made.

8.1.3 Contraction and throat

The contraction and throat of the CFN shall be;

- a) axisymmetric around the centreline (axis of symmetry, AOS) of the CFN,
- b) smoothly finished so that the surface roughness should be

for $d_{nt} > 13 \text{ mm}$: $R_a = 15 \times 10^{-6} d_{nt}$ as a maximum requirement.

for $d_{nt} \leq 13 \text{ mm}$: $R_a = 200 \text{ nm}$ as a maximum requirement

- c) free from dirt or any other contaminants.

It is difficult to machine the contraction and throat as specified, on which the discharge coefficient directly depends, and also to measure the throat diameter accurately, particularly in small nozzles, thus great care should be taken.

Great care is also necessary when polishing the contraction and throat because it may result in significant deformation of the surface.

8.1.4 Diffuser

The only requirement on the diffuser is that it shall not disturb the flow at the throat; therefore, the form of diffuser is not specified.

Besides the traditional diffuser, the requirement allows no diffuser, detachable diffusers [3], and steps exactly at the throat and/or in the diffuser [14] (see J.8.1.4).

The traditional diffuser should be integrated in the nozzle by being machined as one piece. It should be controlled such that any steps, discontinuities, irregularities, and lack of concentricity do not exceed 1% of the local diameter. The length should be not less than d_{nt} . If there is a diameter discontinuity in the diffuser, then the diameter should increase (not decrease) toward the downstream. The arithmetic average roughness of the conical divergent section should not exceed $10^{-4}d_{nt}$. In the specified Reynolds number range, the critical back-pressure ratio of a traditional diffuser may be estimated in accordance with Clause 11.

Some phenomenon (premature unchoking phenomenon, PUP, see Annex H) impacts diffuser performance in an unpredictable manner at low Reynolds numbers [6]-[12]. If the critical back-pressure ratio is essential for the system operation at low Reynolds numbers, e.g., lower than 2×10^5 , the actual critical back-pressure ratio should be measured experimentally using the very CFN with its own conduit for the application because the phenomenon may depend significantly on a slight difference of the CFN form and/or quality as well as its installing condition [11][13].

It is recommended to make the diffuser as long as possible [10], at least $4d_{nt}$, to reduce the risk of the occurrence of PUP. If the diffuser is detachable, it can be exchanged by a longer one when the need arises. Additional detachable diffusers may be attached behind the integrated diffuser without affecting the discharge coefficient (see Figure J.1).

The inlet of the diffuser, regardless of whether it is integrated or detachable, shall be machined very carefully not to damage or block the throat, so as when attaching the detachable diffuser.

8.2 Requirements for each standard types

8.2.1 Standard CFNs

There are two forms of the standard CFNs:

- 1) toroidal-throat CFN
- 2) cylindrical-throat CFN

Besides the requirements in 8.1, the toroidal- and cylindrical-throat CFNs shall comply with 8.2.2 and 8.2.3, respectively.

8.2.2 Toroidal-throat CFN

8.2.2.1 Besides the requirements in 8.1, the toroidal-throat CFN shall comply with the specifications in 8.2.2.2 to 8.2.2.7. The requirements are summarized in Figure 1.

8.2.2.2 The inlet plane (IP) is defined as the physical or virtual plane perpendicular to the nozzle AOS intersecting the contraction at a diameter equal to $(2,5 \pm 0,1)d_{nt}$, regardless of the form upstream of the IP.

8.2.2.3 The contraction behind the IP shall be a portion of a torus. At the throat, the tangential line of surface (TLS) shall be parallel to the nozzle AOS. A short torus, in which the throat TLS is not parallel to the nozzle AOS, shall be avoided because it may result serious error even if the deficit is very small. To reduce the risk of throat being damaged in the application, the torus preferably extends over the throat

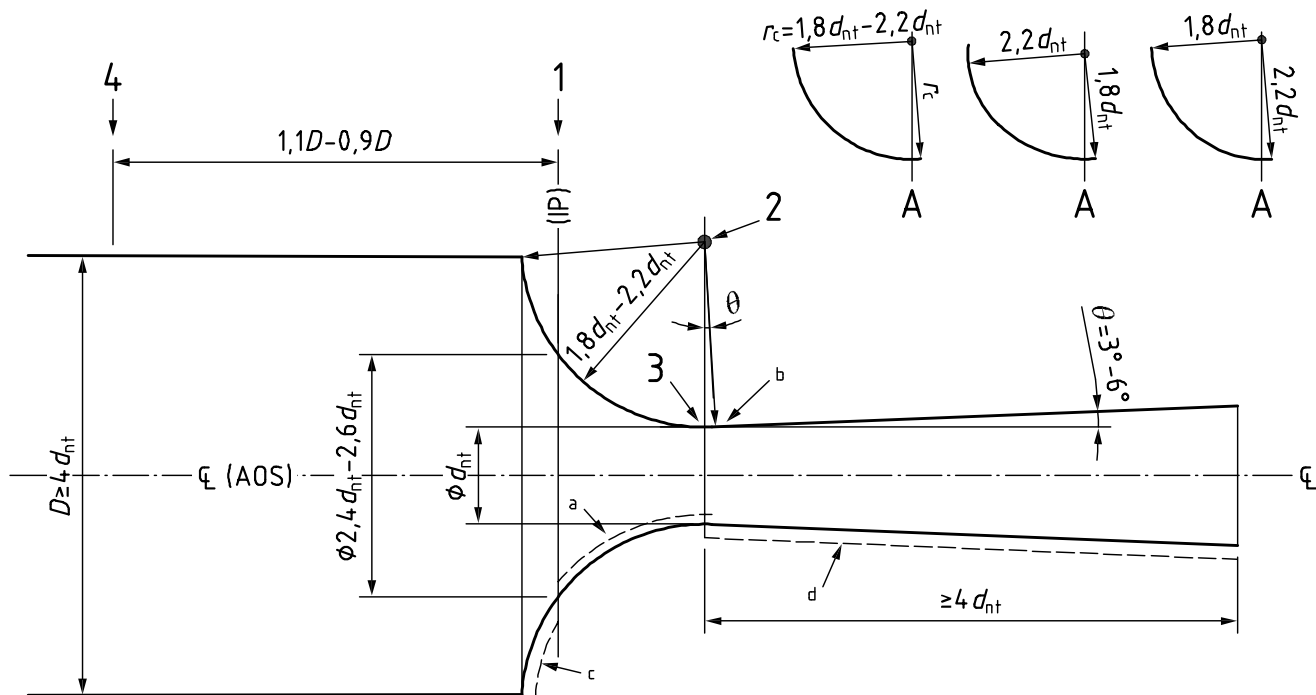
into the diffuser portion for some extent, e.g., to ca. $0.1d_{nt}$ behind the throat, in which the TLS of the torus end is approximately 3° against the nozzle AOS.

8.2.2.4 If the diffuser is integrated in the nozzle as one piece, great care shall be taken when machining the diffuser beyond throat because even a slight backlash of the lathe may produce unexpected forms exactly at the throat that may effect on the discharge coefficient significantly. Careful inspection of the throat form should be performed after machining, and then if any irregularity is found at the throat, the CFN should be flow calibrated.

8.2.2.5 The form upstream the IP is not specified provided it does not disturb the flow in contraction; however, it should be axisymmetric and its surface at each axial location should have a diameter greater than or equal to the extension of torus behind the IP.

8.2.2.6 The radius of the torus between the IP and throat may be constant or vary smoothly between $1.8d_{nt}$ and $2.2d_{nt}$ provided the varying radius does not disturb the flow at the throat. Examples of the torus with constant and variable radii are shown in Figure 1.

8.2.2.7 The half-angle of traditional diffuser should be between $2,5^\circ$ and $6,0^\circ$, which contacts with the torus end smoothly at the same TLS as in Figure 1.



Key

- 1 inlet plane (IP) (definition, not necessary to be a physical plane, see 8.2.2.2.)
- 2 centre of the inlet torus
- 3 throat
- 4 location of pressure tapping

A examples of the inlet torus (constant and variable radii)

- a see 8.2.2.3 and 8.2.2.6
- b contact plane of the inlet torus and traditional diffuser (typical form)
- c see 8.2.2.5 (typical form)
- d see 8.2.2.7 and 8.1.4 (typical form)

Figure 1 — Toroidal-throat CFN

8.2.3 Cylindrical-throat CFN

8.2.3.1 Besides the requirements in 8.1, the cylindrical-throat CFN shall comply with the specifications in 8.2.3.2 to 8.2.3.10. The requirements are summarized in Figure 2.

8.2.3.2 The inlet plane (IP) is defined at the physical plane of the nozzle front surface.

8.2.3.3 The contraction shall be a quarter of a torus tangential on one hand to the IP and on the other hand to the throat.

8.2.3.4 The contraction shall have the curvature of d_{nt} and shall not deviate from the torus by more than $\pm 0,001 d_{nt}$.

8.2.3.5 The throat shall be a cylinder with the length d_{nt} and diameter d_{nt} .

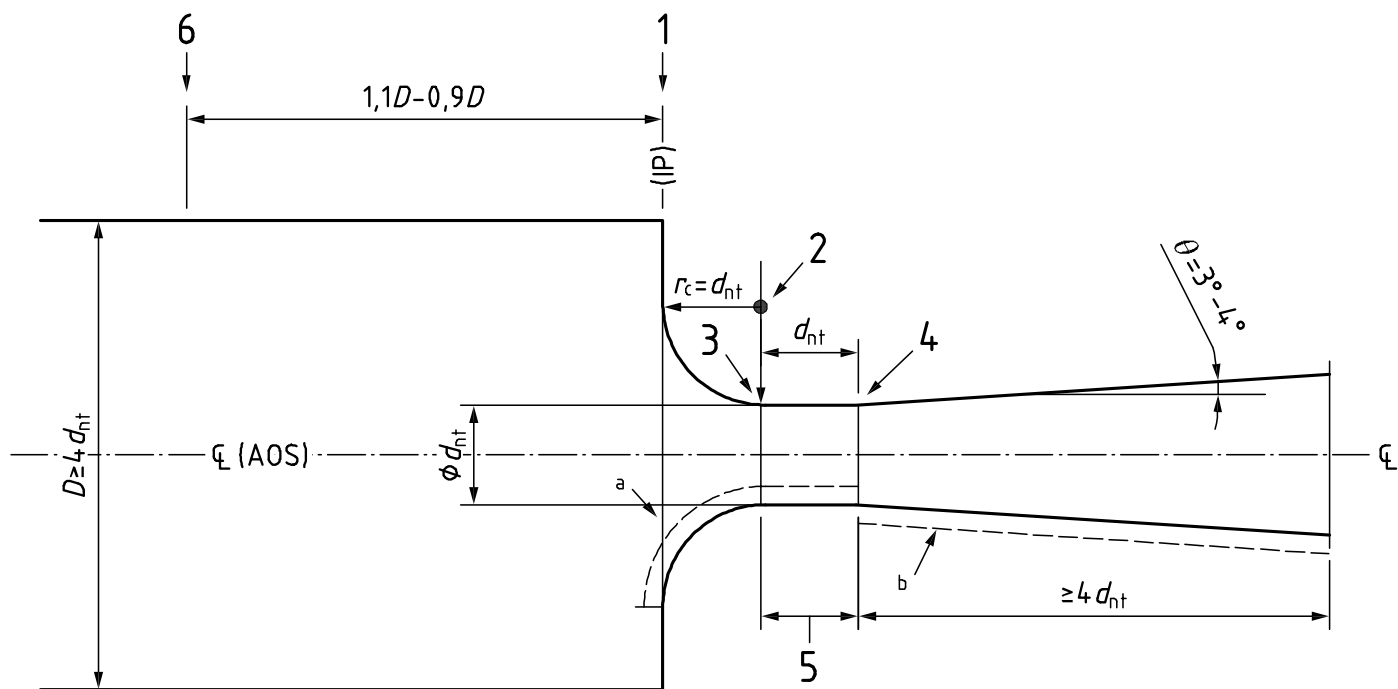
8.2.3.6 The throat diameter d_{nt} shall be defined by the mean diameter at the throat outlet section. The mean diameter shall be determined by measuring at least four angularly equally distributed diameters on the cylindrical throat outlet. No diameter along the throat length shall deviate by more than $\pm 0,001 d_{nt}$ from the mean diameter.

8.2.3.7 The transition between contraction and throat should be inspected to verify that the local radius of surface r_c in the plane in which the nozzle AOS lies is never less than $0,5d_{nt}$ throughout the circumference formed by the contact plane of the contraction and throat. Figure 3 illustrates this requirement.

8.2.3.8 The length of the throat shall not deviate from d_{nt} by more than $0,05d_{nt}$. The connection between the throat and diffuser shall also be inspected to have no defect.

8.2.3.9 The surface of contraction and throat shall be properly polished so that the arithmetic average roughness height does not exceed $15 \times 10^{-6} d_{nt}$, where it can be measured.

8.2.3.10 The half-angle of traditional diffuser should be between 3° and 4° .



Key

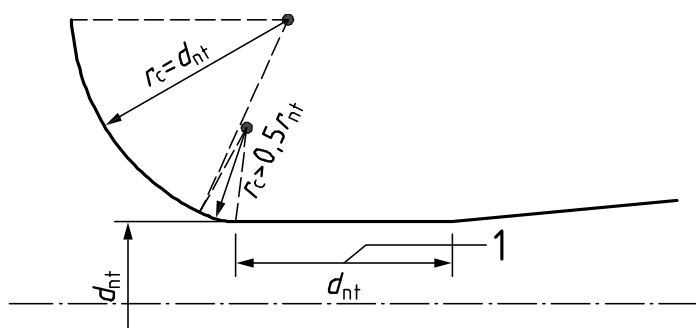
- 1 inlet plane (physical plane)
- 2 centre of the inlet torus
- 3 throat inlet
- 4 throat exit
- 5 throat
- 6 location of pressure tapping

a cylindrical throat

b in this portion, the arithmetic average roughness R_a shall not exceed $15 \times 10^{-6} d_{nt}$ and the contour shall not deviate from toroidal and cylindrical forms by more than $\pm 0,001 d_{nt}$.

c the length should be greater than d_{nt} but preferably than $4 d_{nt}$.

Figure 2 — Cylindrical throat CFN



Key

- 1 throat

Figure 3 — Detail of connection between quarter of torus and cylindrical throat (transition region)

9 Installation requirements

9.1 General requirements for both the standard configurations

9.1.1 Standard configurations

The CFN shall be installed in either of:

- a) the pipe configuration: a pipe of circular cross-section with $\beta \leq 0.25$, or
- b) the chamber configuration: a large volume (chamber or plenum) upstream the CFN such that b is effectively zero.

The pipe configuration shall contain only a single CFN and shall meet the requirements of 9.2 and 9.1.2 to 9.1.7.

The chamber configuration may contain multiple CFNs in a cluster and shall meet the requirements of 9.3 and 9.1.2 to 9.1.7.

9.1.2 Upstream pressure tapping

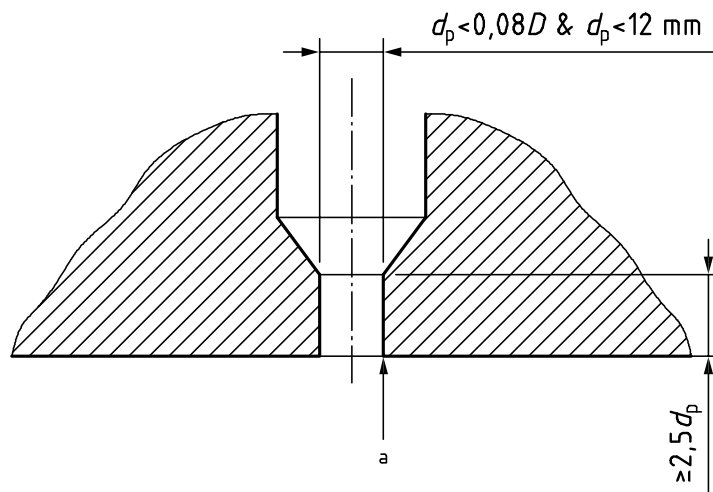
The upstream static pressure of CFN shall be measured through one or more wall pressure tapings drilled through the pipe or chamber wall upstream of the CFN.

The wall pressure tapings may be located at upstream or downstream locations specified in 9.2.3 and 9.3.3 provided that they have been demonstrated that the measured pressure can be used reliably to give the upstream stagnation pressure (see J.3.4.1).

If the flow over the pressure tapings cannot be approximated to be at rest, e.g., $\beta < 0.15$, the tapping hole shall meet the following requirements as summarized in Figure 4:

- a) the centreline shall be perpendicular to the nozzle AOS,
- b) the cross-section of breakthrough into the conduit shall be circular,
- c) the form in the wall shall be cylindrical with a minimum length of $2,5d_p$ from the breakthrough where d_p is the diameter of breakthrough,
- d) the edge of breakthrough shall be square or rounded to a radius not exceeding $0,1d_p$, and
- e) the edge of breakthrough shall be free from burrs.

Visual inspections shall confirm that these requirements are met.

**Key**

a Edge of hole flush with internal surface of conduit, burr-free and square to a radius not exceeding $0,1d_p$

Figure 4 — Detail of the wall pressure tapping

9.1.3 Downstream pressure tapping

The downstream pressure shall be measured through one or more wall pressure tappings, or estimated, in order to ensure that the nozzle is or all the nozzles are choked. The flow exhausted from the CFN exit should not directly hit any of the pressure tappings.

In some applications, the outlet pressure can be determined without the use of a wall pressure tapping, for example, when the CFN discharges directly into a large space of known pressure, e.g. into atmosphere or large tank, the downstream pressure of the CFN may be represented by the pressure in the large space.

9.1.4 Temperature measurement

The upstream temperature shall be measured using one or more sensors located upstream of the CFN. There is no need to measure the downstream temperature.

The temperature sensor shall not disturb the upstream pressure measurement; to ensure this is the case, the sensor shall not be aligned with the upstream pressure tapping in the flow direction.

Particular care has to be exercised in the selection of the temperature sensor and the insulation of conduit if the stagnation temperature of the flowing gas differs significantly from that of the environment, e.g. by more than 5 K. In such cases, the sensor shall be insensitive to the effect of thermal radiation and the conduit shall be well lagged to minimize heat transfer between the flowing gas and environment (see J.3.4.1). If the temperatures of flowing gas and conduit wall differ significantly, it is extremely difficult to measure the gas temperature accurately. The heat conduction from the conduit to the sensor shield shall be minimized.

9.1.5 Density measurement

For some applications, it may be desirable to measure directly the gas density upstream of the nozzle; for example, when the molar mass of the gas is not known with sufficient accuracy. The densitometer shall be installed upstream of the inlet pressure and temperature tapings.

To achieve accurate measurement of the flow-rate, particular attention shall be paid to:

- a) The densitometer shall not disturb the upstream static pressure and temperature measurements.
- b) If the densitometer is located in a bypass line from the upstream pipeline or chamber of CFNs, checks shall be carried out to ensure that the gas in the densitometer is the same as that flowing in the pipeline or chamber.
- c) The pressure and temperature at the densitometer should be as close as possible to those upstream the CFN in order to minimize the corrections. The stagnation density of the CFN shall be calculated by:

$$\rho_0 = \rho_{\text{den}} \frac{p_0}{p_{\text{den}}} \frac{T_{\text{den}}}{T_0} \frac{Z_{\text{den}}}{Z_0} \quad (15)$$

9.1.6 Drain hole

The pipe or chamber may be provided with drain holes to remove the condensate or other foreign substances that may collect in some applications. There shall be no flow through these drain holes while the measurement is in progress.

The drain holes shall be located upstream of the upstream wall pressure tapings in an axial plane different from that of the wall pressure tapping in order not to disturb the upstream static pressure measurement.

The drain holes should preferably follow the specifications of the pressure tapping shown in Figure 4. The axial distance from the drain hole to the plane of the inlet wall pressure tapping shall be greater than $1D$.

9.1.7 Downstream condition

There is no specification required on the downstream pipe and chamber provided it does not disturb the critical flow in the CFN or CFNs.

9.2 Pipe configuration

9.2.1 General

Besides 9.1, the pipe configuration shall conform to 9.2.2 to 9.2.4. The requirements are summarized in Figure 5.

9.2.2 Upstream pipe

The upstream pipe shall:

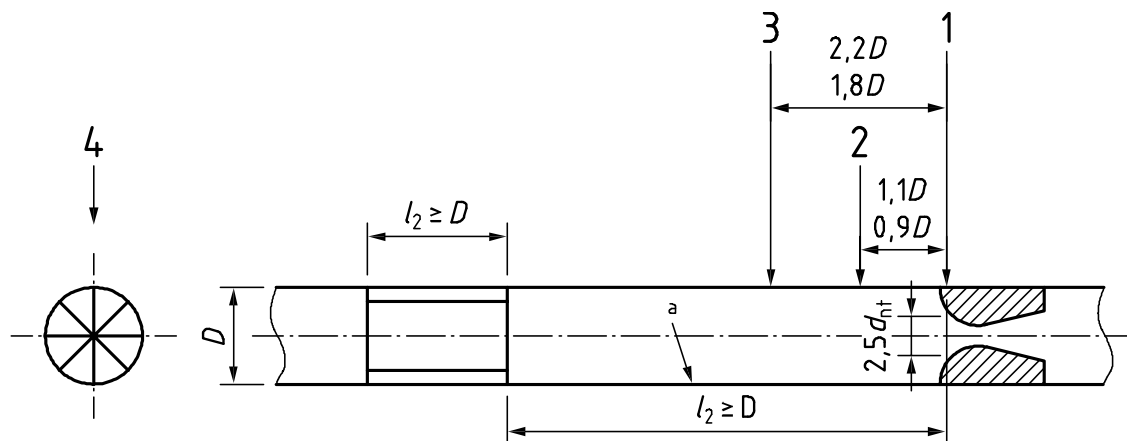
- a) be straight,
- b) have a circular cross-section,

- c) be concentric around the nozzle AOS within $\pm 0,02D$,
- d) have a diameter of greater than $4d_{nt}$ ($\beta \leq 0,25$),
- e) not deviate from circularity by more than $0,01D$ for up to $3D$ upstream the IP, and
- f) have an arithmetic average roughness of smaller than $10^{-4}D$ for up to $3D$ upstream the IP.

If these requirements cannot be met, specific tests are recommended to investigate the influence of the installation conditions or to determine C_d by flow calibration using the same pipe.

In the case when $\beta > 0,25$, the mass flow-rate calculated in accordance with Clause 10 may be corrected in accordance with Annex D; however, particular care shall be taken because the static pressure measurement of a high-speed flow may easily result a serious error depending on the location, form, and/or quality of the pressure tapping. Furthermore, the ambiguity of the recovery factor may affect significantly on the measurement and also the pressure drop between the upstream pressure tapping and IP may not be negligible (see J.3.1.4).

Swirl shall not exist in the upstream pipe. If there is certain flow velocity existed in the upstream pipe, swirl-free conditions may be ensured by installing a flow straightener of the design shown in Figure 5 (Étoile straightener) at a distance $l_1 > 5D$ upstream of the IP. Other flow conditioners may be used according to ISO 5167-1 for the upstream installation [1] [2].



Key

- 1 IP (Inlet plane)
- 2 location of pressure tapping
- 3 location of temperature sensor
- 4 Étoile straightener with vane thickness adequate to prevent buckling (if the flow velocity in conduit is not negligible)

a in this portion, the surface roughness shall not exceed $10^{-4}D$.

Figure 5 — Installation requirements in a pipe

9.2.3 Pressure measurement

The location of the upstream pressure tapping should be at a distance between $0,9D$ and $1,1D$ upstream of the IP.

If there are multiple tapings, all of them shall be in a plane perpendicular to the nozzle AOS.

The downstream pressure may be measured through a pressure tapping located within $0,5 D$ downstream of the diffuser exit. Locations further downstream can also be used provided there is no substantial pressure change. Other downstream tapping locations may be acceptable if an unchoking test (see H.4) is performed using that tapping location.

9.2.4 Temperature measurement

The upstream temperature may be measured at $1,8D$ to $2,2D$ upstream of the IP. The diameter of the sensor shall be not greater than $0,04D$.

If it is impracticable to use a sensor of diameter less than $0,04D$, the sensing element shall be so located that it can be demonstrated that it does not affect the upstream pressure measurement. The sensor may be located further upstream, provided that it has been demonstrated that the measured temperature can be used reliably to give the nozzle inlet stagnation temperature. See J.3.4.1.

9.3 Chamber configuration

9.3.1 General

Besides 9.1, the chamber configuration shall conform to 9.3.2 to 9.3.5.

9.3.2 Upstream chamber

The CFN can be assumed to be installed in a large volume (chamber) if its nozzle AOS is at least $5d_{nt}$ away from all the chamber walls.

If multiple CFNs are installed in a chamber in parallel, the minimum distance between the nozzle AOSs of any CFNs shall be greater than 6 times the largest throat diameter in order to avoid interference between CFNs [15]-[21]. Testing is recommended to ensure that the performance is not degraded by the interferences between each CFNs and also between each CFNs and chamber walls.

9.3.3 Pressure measurement

The wall pressure tapping in the upstream chamber should preferably be located in a wall perpendicular to the IP and within a distance of $(10 \pm 1) d_{nt}$ from the IP.

9.3.4 Temperature measurement

The temperature sensor in the upstream chamber shall not be located where the flow is stagnated in order to ensure that the measured temperature represents the gas temperatures flowing into each CFNs. Multiple sensors are recommended in a large chamber because of the high possibility of the stagnation of flow and/or temperature stratification.

9.3.5 Back-pressure ratio

If multiple CFNs are installed in a chamber, the back-pressure ratio across the chamber shall be smaller than the smallest value among the critical back-pressure ratios of all CFNs. See Annex H.

10 Calculations

10.1 General

If the CFN satisfies the requirements in Clauses 8 and 9, its mass flow-rate should be calculated in accordance with 10.2 to 10.6.

It is noted again that the temperature of CFN in operation is assumed to be in equilibrium with that of gas because of the isentropic assumption (see J.3.4.1); accordingly, the temperature of CFN itself is represented by that of gas in this International Standard. If there is any significant temperature difference observed between the gas, CFN, conduit, and environment, the user should be consulted by an expert [56].

10.2 Calculation of mass flow-rate, q_m

The mass flow-rate through a CFN should be calculated by Equation (13) or (14) where A_{nt} should be the cross-section of throat when the CFN is measuring the flow-rate, thus calculated by:

$$A_{nt} = \frac{\pi d_{nt}^2}{4} = \frac{\pi d_{nt0}^2}{4} \left[1 + 2\alpha(T_1 - T_{nt0}) \right]^2 \quad (16)$$

It is noted that this equation is not for correcting the effect of non-isentropic flow caused by large temperature differences. See 10.1, J.10.1, and J.3.4.1.

10.3 Calculation of discharge coefficient, C_d

10.3.1 The discharge coefficient of the CFN should be calculated by:

$$C_d = \left(a - bR_e^{-n} \right) - \frac{\left(c - dR_e^{-n} \right)}{1 + \exp\left(e - \frac{R_e}{f} \right)} \quad (17)$$

The coefficients a , b , c , d , e , f , and n are given in Table 1 for each type of CFN (see Annexes F and G). They are valid in each specified Reynolds number range.

Table 1 — Coefficients a, b, c, d, e, f and n

Toroidal-throat CFN	
$2,1 \times 10^4 < Re_{nt} < 3,2 \times 10^7$	$a = 0,9990$
	$b = 3,415$
	$c = 0,0031$
	$d = 0,690$
	$e = 10$
	$f = 120\,000$
	$n = +0,5$
Cylindrical-throat CFN	
$1,5 \times 10^5 < Re_{nt} < 1,2 \times 10^7$	$a = 1,0000$
	$b = 6,341$
	$c = 0,009$ for air
	$c = 0,008$ for natural gas
	$d = 3,000$
	$e = 6$
	$f = 170\,000$
	$n = +0,5$

If the gas has the significant vibrational relaxation effect, e.g. CO₂ and SF₆, the discharge coefficient may cause more than 1 % if the steady state critical flow function (see 10.4) is used in small CFNs. See B.5.

For the purpose of calculation verification, the values of discharge coefficient are given in Annex A.

10.3.2 The relative uncertainty of the discharge coefficients calculated by using Equation (17) and Table 1 is 0,3 % at the 95 % confidence level.

10.4 Calculation of critical flow function, C^* or C^*_D

The value of critical flow function may be computed by any method of demonstrable accuracy. It is noted that most of the methods normally suppose that the state change of gas along the flow is in equilibrium, thus they cause serious errors if the gas cannot reach equilibrium because of the too quick state change in the flow. See B.5.

Some examples of the applicable method to calculate C^* and C^*_D for natural gases are AGA Report No. 8 [22][23], ISO 12213 [24]-[26], and ISO 20765 [27][28] as the state equation. This approach ensures a relative uncertainty on C^* of 0,1 % at 95 % confidence level. Alternatively, any other state equation with comparable uncertainty can be used.

The REFPROP, thermodynamic database [42], may be one of the most convenient and accurate ways to calculate C^* . It realizes the calculations based on all the state equations in the standards mentioned above. See B.3.

For some gases, the values of C^* may be calculated in accordance with Annex C without using any specific software. The equations were obtained by curve fittings on the calculation results produced by REFPROP 10.0.

10.5 Conversion of measured pressure into stagnation one

The inlet stagnation pressure, p_0 , should be calculated by:

$$p_0 = \left(1 + \frac{\kappa - 1}{2} M_a^2 \right)^{\frac{\kappa}{\kappa - 1}} p_1 \quad (18)$$

If $b \leq 0.15$, the conversion is ignorable, thus p_0 is given by:

$$p_0 = p_1 \quad (19)$$

10.6 Conversion of measured temperature into stagnation one

The inlet stagnation temperature, T_0 , should be calculated by:

$$T_0 = \frac{2 + (\kappa - 1) M_a^2}{2 + R_f (\kappa - 1) M_a^2} T_1 \quad (20)$$

If $\beta \leq 0.25$, the effect is negligible, thus T_0 is given by

$$T_0 = T_1 \quad (21)$$

The recovery factor R_f may be calculated by any reliable method. If $\beta \leq 0.25$, it may be approximated by

$$R_f = \sqrt{P_r} \quad (22)$$

where P_r is the Prandtl number of the gas. See J.3.2.3.

10.7 Calculation of viscosity

The value of viscosity may be computed by any method of demonstrable accuracy. The REFPROP may be one of the most convenient and accurate ways to calculate the viscosity.

For some gases, the value of viscosity may be calculated in accordance with Annex I without using any specific software. The equations were obtained by curve fits to the calculation results produced by REFPROP 10.0

11 Estimation of critical back-pressure ratio

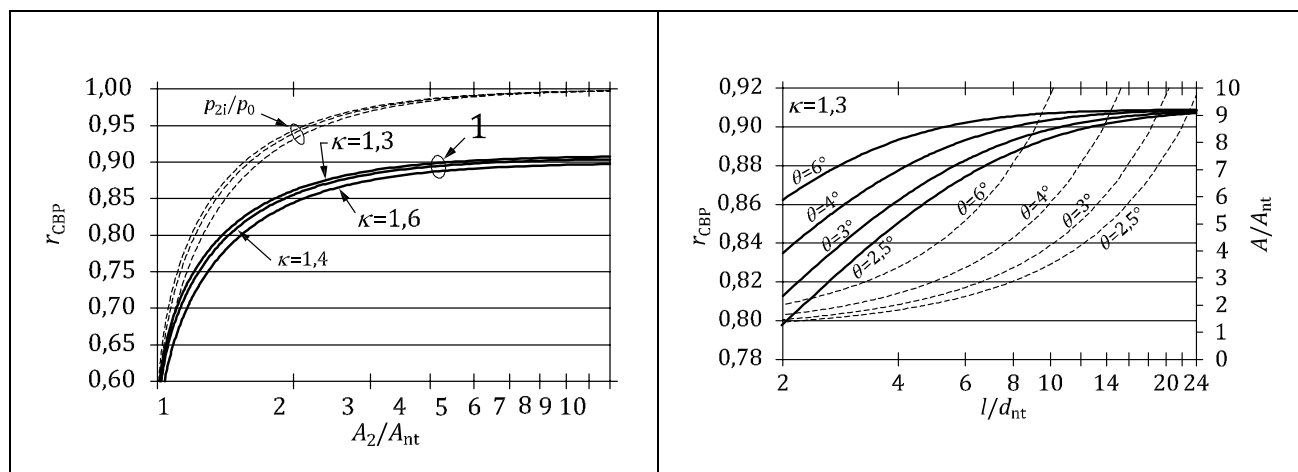
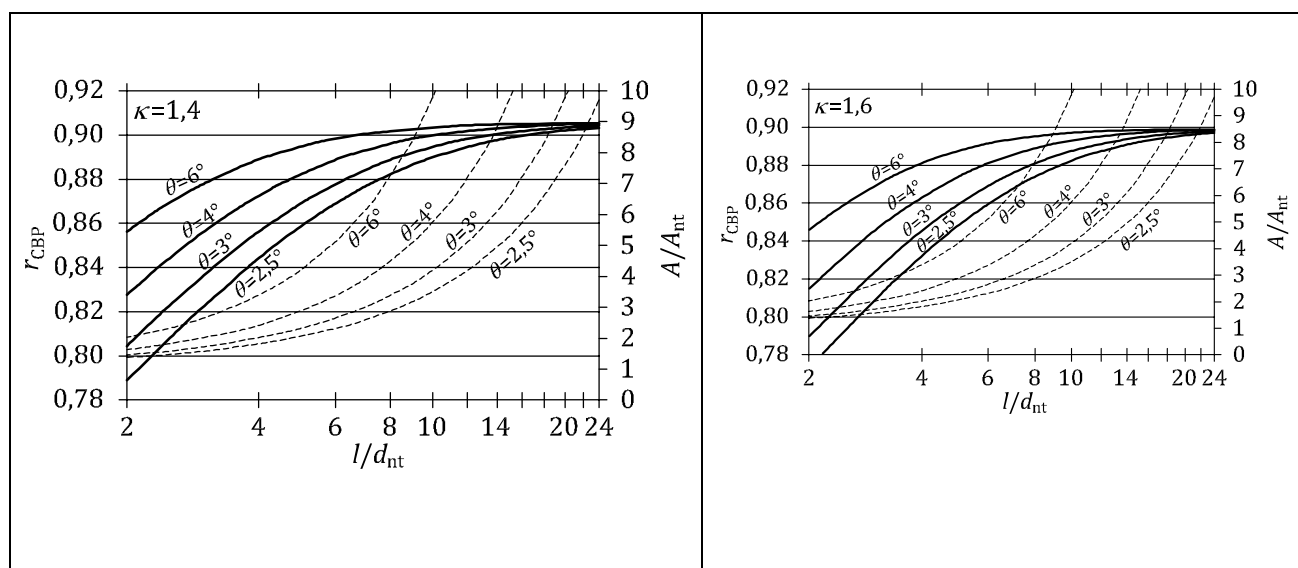
11.1 For traditional diffuser at Reynolds numbers higher than 2×10^5

The critical back-pressure ratio r_{CBP} for the traditional diffuser at Reynolds numbers higher than 2×10^5 may be estimated by [4]:

$$r_{CBP} = 0.8 \frac{p_{2i}}{p_0} + 0.2 \left(\frac{2}{\kappa + 1} \right)^{\frac{\kappa}{\kappa - 1}} \quad (23)$$

where p_{2i} is the theoretical static pressure at the diffuser exit when the nozzle attains the critical flow velocity but the flow in the diffuser is fully subsonic and fully attached, assuming one-dimensional isentropic flow. Equation (23) is graphed in Figure 6, by which the values of r_{CBP} may be estimated using A_2/A_{nt} or length of the frustum diffuser l at each wall half-angle θ . As seen in the figure, the pressure ratio

r_{CBP} will not significantly become higher by lengthening the diffuser such that $A_2/A_{nt} > 4$, e.g., $l/d_{nt} > 7$ at $\theta = 4^\circ$.

a) against A_2/A_{nt} b) against l/d_{nt} ($\kappa = 1.3$)c) against l/d_{nt} ($\kappa = 1.4$)d) against l/d_{nt} ($\kappa = 1.6$)**Key**

1 Equation (23)

— r_{CBP} - - - A/A_{nt} **Figure 6 — Maximum permissible back-pressure ratio r_{CBP} calculated by Equation (23)**

κ is not necessary to be accurate because the sensitivity on κ is not so high as seen in Figure 6 as well as Equation (23) gives only an estimation.

Higher back-pressure ratios may be used provided that it can be verified that the CFN chokes at those ratios. Pressure ratios of 0,9 may be achieved at high Reynolds numbers if the diffuser is sufficiently long and has an adequate form and quality.

11.2 For any diffuser at low Reynolds numbers

For any CFNs with diffuser, it is practically impossible to predict r_{CBP} at low Reynolds number, e.g. lower than 2×10^5 , because the premature unchoking phenomenon (PUP) may occur that results in serious decrease of discharge coefficient by some factors that are hard to identify. See 8.1.4 and Annex H. When the Reynolds number is lowered, the decrease of discharge coefficient caused by the PUP starts from an ignorable amount at a Reynolds number specific to each CFN and installing condition, and then, depending on the Reynolds number, it can reach several 10 % at the back-pressure ratios where the CFN should choke by the diffuser effect in theory (where the back-pressure ratio is greater than the critical pressure ratio). The amount of decrease at a specific back-pressure ratio at a specific Reynolds number is practically unpredictable.

If the Reynolds number is in the range where the PUP is suspected but it is not so low, most CFNs should choke at the back-pressure ratio slightly smaller than the critical pressure ratio (e.g. 0,5, see Figure H.1); however, if the Reynolds number approaches the lowest extreme of this International Standard, it is recommended to keep the back-pressure ratio less than 0,25 [9][10][12].

If the exact critical back-pressure ratio is essential for the system operation, it is recommended to measure r_{CBP} using the very CFN with its own upstream and downstream conduits (see J.8.1.4). The PUP may be very sensitive to the CFN form and also to its installing condition.

11.3 For CFNs without diffuser or with very short diffuser

For the CFNs without diffuser or with very short diffuser such as $l = 0.1d_{nt}$, it is recommended to keep the back-pressure ratio always smaller than 0,35 regardless of the Reynolds number. If the difference of flow-rate by 0,1 % is ignorable for the application, the critical back-pressure ratio of 0,5 (or slightly smaller ratio than the critical pressure ratio, see Figure H.5) may be applicable.

12 Uncertainties in the measurement of flow-rate

12.1 General

The uncertainty associated with each measurement of mass flow-rate is an essential consideration and shall be calculated and reported whenever a measurement is claimed to conform to this Standard. The uncertainty for a mass flow-rate measurement may be expressed in relative terms as a percentage, in relative (dimensionless) terms, or in absolute terms with the same units as the given mass flow-rate. Uncertainty may be expressed as a standard uncertainty, u (at a confidence level of 68 %), or as a combined standard uncertainty, u_c , or as an expanded uncertainty U , which is usually the final result with a 95 % confidence level. The uncertainty for mass flow-rate as determined using Equation (8) is most simply evaluated using relative uncertainties expressed as a percentage. The quantities and notation herein refer to relative uncertainties expressed as percentages of the average value. Uncertainty calculations should be performed in accordance with the GUM [44].

In general the expanded uncertainty for a measurand can be calculated from the combined standard uncertainty, comprised of the relative Type A uncertainty, which is obtained using statistics, and the relative Type B uncertainty, which is obtained using methods other than statistics. These are combined by root-sum-of-squares (RSS) as follows:

$$U(y) = ku_c(y) = k\sqrt{u_A^2(y) + u_B^2(y)} \quad (24)$$

where k is the coverage factor and $k = 1$ indicates a 68 % confidence level and $k = 2$ is generally appropriate to calculate a 95 % confidence level uncertainty. The Type A uncertainty is the standard deviation, at 68 % confidence level, of the replicated measurements of mass flow-rate from the repeatability and reproducibility test results. The relative Type B uncertainty is obtained from

evaluations of the uncertainty of the components in the equation used to calculate the mass flow-rate. It is common and usually more convenient to perform uncertainty calculations in relative uncertainty terms as shown in the practical computation methods that follow. Using relative uncertainty terms allows the use of normalized sensitivity coefficients, which are the exponents of the respective factors in the governing equation for the quantity being assessed.

Using a coverage factor $k = 2$ to obtain a 95 % confidence level uncertainty is appropriate when the system has a large number of degrees of freedom as is normally assumed for Type B uncertainty components. The degrees of freedom for the Type A component, calculated from the standard deviation of n repeated measurements, is $n-1$ and this can lead to larger values of k when the number of replicates is approximately 20 or less. The Welch-Satterthwaite formula [50] allows calculation of effective degrees of freedom and when the repeatability (Type A component) is small relative to the Type B components, leads to a coverage factor of approximately 2 for 95 % confidence level. In most applications, $k = 2$ is an acceptable value to obtain 95 % confidence level uncertainties.

12.2 Practical computation of uncertainty

Substituting Equation (12) into Equation (13), the governing equation for mass flow-rate, q_m through a CFN is:

$$q_m = A^* C_d C^* \frac{p_0}{\sqrt{\left(\frac{R}{M}\right) T_0}} \quad (25)$$

The uncertainty of a flow-rate measurement should be calculated from the standard deviation of the available flow measurement data plus evaluations of uncertainty of the individual quantities in the governing equation. In most cases, uncertainty components can be assumed to be independent and uncorrelated, but there are certain cases where correlated uncertainties are an issue (see 12.3).

Because Equation (24) is comprised of products, it is simplest to use normalized sensitivity coefficients and relative uncertainties expressed as percentages (the dimensional uncertainty divided by the average value of the respective component). In this way, the sensitivity coefficients for a function like Equation (24) are the exponents of the respective components. In the case where the uncertainty components are assumed to be independent and uncorrelated or when the respective correlated effects are negligible, a practical working formula for calculating the relative combined standard uncertainty by RSS is:

$$u_c(q_m) = \sqrt{u_A^2(q_m) + u_B^2(C_d) + u_B^2(A^*) + u_B^2(C^*) + u_B^2(p_0) + \frac{1}{4}[u_B^2(M) + u_B^2(T_0)]} \quad (26)$$

where the squares are variances.

The Type A relative uncertainty term, $u_A(q_m)$, can be calculated from the standard deviation of the available replicated measurement data. The Type B relative uncertainty terms in Equation (20) can be calculated from the uncertainty of each of the factors with the absolute uncertainties of each component being divided by the magnitude of that component to determine the relative uncertainties. Then the relative uncertainty terms are squared and combined by the RSS relationship.

Each of the Type B uncertainty components has its own subset of uncertainty sources. Uncertainty components that should be considered are:

- a) long term reproducibility (drift) of the discharge coefficient