

RUBBER-LINED PROCESS EQUIPMENT

DEP 30.48.60.10-Gen.

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(DEP Circular 109/08 has been incorporated)

DESIGN AND ENGINEERING PRACTICE



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TABLE OF CONTENTS

1.	INTRODUCTION	4
1.1	SCOPE	4
1.2	DISTRIBUTION, INTENDED USE AND REGULATORY CONSIDERATIONS	4
1.3	DEFINITIONS	4
1.4	CROSS-REFERENCES	4
1.5	SUMMARY OF CHANGES SINCE PREVIOUS EDITION	5
1.6	COMMENTS ON THIS DEP	5
2.	APPLICATION	6
2.1	GENERAL	6
2.2	MATERIAL SELECTION	6
2.3	PROPERTIES OF RUBBER	7
2.4	VACUUM APPLICATIONS	8
2.5	EROSION RESISTANCE	8
3.	MATERIALS REQUIREMENTS	9
3.1	GENERAL	9
3.2	LINING MATERIALS	9
3.3	CARBON STEEL SUBSTRATE	9
4.	DESIGN, MANUFACTURING AND FABRICATION REQUIREMENTS	10
4.1	DESIGN	10
4.2	MANUFACTURE	10
4.3	FABRICATION OF RUBBER LINED PROCESS EQUIPMENT	10
4.4	CONNECTIONS	11
5.	QUALIFICATION TESTING	12
5.1	GENERAL	12
5.2	FINISHED PRODUCTS	12
6.	PRODUCTION INSPECTION AND TESTING	14
6.1	GENERAL	14
6.2	SHOP INSPECTIONS AND TESTS	14
6.3	REPAIR	14
7.	INSTALLATION	16
7.1	GENERAL	16
7.2	FLANGED CONNECTIONS	16
7.3	BOLTING	16
7.4	WELDING	16
7.5	VENTING SYSTEM	16
7.6	MARKING	16
8.	MAINTENANCE	17
8.1	MAINTENANCE AND REPAIR	17
9.	HANDLING AND STORAGE	18
9.1	MARKING	18
9.2	PACKAGING	18
9.3	HANDLING	18
9.4	STORAGE	18
10.	DOCUMENTATION	19
11.	REFERENCES	20

APPENDICES

APPENDIX 1	AIR VENT HOLES/WELDING DETAILS	22
APPENDIX 2	JOINTS IN RUBBER LININGS	23

1. INTRODUCTION

1.1 SCOPE

This DEP specifies requirements and gives recommendations for the application, design, qualification testing, fabrication, production testing, inspection, transportation and installation of rubber-lined process equipment.

This DEP is applicable to vulcanised and non-vulcanised rubber lined process equipment , both shop fabricated and field fabricated.

This DEP is a revision of the DEP of the same number dated December 1997; a summary of the main changes is given in (1.5).

1.2 DISTRIBUTION, INTENDED USE AND REGULATORY CONSIDERATIONS

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This DEP is intended for use in oil refineries, chemical plants, gas plants, exploration and production facilities and distribution storage depots and installations.

When DEPs are applied, a Management of Change (MOC) process should be implemented; this is of particular importance when existing facilities are to be modified.

If national and/or local regulations exist in which some of the requirements may be more stringent than in this DEP, the Contractor shall determine by careful scrutiny which of the requirements are the more stringent and which combination of requirements will be acceptable as regards safety, environmental, economic and legal aspects. In all cases the Contractor shall inform the Principal of any deviation from the requirements of this DEP which is considered to be necessary in order to comply with national and/or local regulations. The Principal may then negotiate with the Authorities concerned with the object of obtaining agreement to follow this DEP as closely as possible.

1.3 DEFINITIONS

The **Principal** is the party which initiates the project and ultimately pays for its design and construction. The Principal will generally specify the technical requirements. The Principal may also include an agent or consultant, authorised to act for, and on behalf of, the Principal.

The **Contractor** is the party which carries out all or part of the design, engineering, procurement, construction, commissioning or management of a project or operation of a facility. The Principal may sometimes undertake all or part of the duties of the Contractor.

The **Manufacturer/Supplier** is the party which manufactures or supplies equipment and services to perform the duties specified by the Contractor.

The word **shall** indicates a requirement.

The word **should** indicates a recommendation.

1.4 CROSS-REFERENCES

Where cross-references to other parts of this DEP are made, the referenced section number is shown in brackets. References used in this DEP are listed in (11).

1.5 SUMMARY OF CHANGES SINCE PREVIOUS EDITION

The previous edition of this DEP was dated July 1996; a summary of the main changes since the last edition is given below.

Section	Change
General	Increased alignment with ISO Standards and DEPs. Title and scope changed to restrict application to equipment excluding piping. Standard drawings for piping deleted.
2.2	Classification and nomenclature in compliance with ISO 1629
2.3	Properties of rubbers better aligned with DEP 30.10.02.13-Gen. and Manufacturers' recent data
4.3.2	Updated requirements for surface conditions during application
5.2.3	Added requirement for minimum adhesion strength

1.6 COMMENTS ON THIS DEP

Comments on this DEP may be sent to the DEP Administrator at standards@shell.com. Shell staff may also post comments on this DEP on the Surface Global Network (SGN) under the Standards/DEP 30.48.60.10-Gen. folder. The DEP Administrator and DEP Author monitor these folders on a regular basis.

2. APPLICATION

2.1 GENERAL

Rubber linings are mainly used for protection against corrosion and/or erosion damage. In brick-lined equipment rubber is used as a membrane between the brick lining and the load-bearing structure (see DEP 30.48.60.12-Gen. and DEP 30.48.60.13-Gen.).

A wide range of rubbers and elastomers are available for lining process vessels and tanks. Rubbers can also be made with anti-static properties to give a low surface electrical resistance.

Hard rubbers, i.e. hardness greater than Shore D 60, can only be applied by autoclave vulcanisation, and therefore hard rubber lining is restricted to small equipment or components. Only soft rubbers can be applied on site.

Hard rubber linings can only be applied to rigid structures and they are also sensitive to large temperature fluctuations. Soft rubber linings remain elastic over a large temperature range, and consequently they can accommodate major deformation, vibrations and significant temperature changes.

With respect to safety aspects, pressure rating, etc. the regulations which apply to equipment and structures are also valid for rubber-lined systems.

2.2 MATERIAL SELECTION

Material selection is determined by:

- service conditions (pressure, temperature, medium, etc.)
- design
- manufacturing method

The following rubber types are used for lining purposes (classification according to ISO 1629):

Type	Symbol
Natural rubber	NR
Isoprene rubber, synthetic	IR
Styrene-butadiene rubber	SBR
Chloroprene rubber (Neoprene)	CR
Butyl rubber	IIR
Bromobutyl rubber	BIIR
Chlorobutyl rubber	CIIR
Nitrile rubber	NBR
Ethylene propylene rubber	EPM, EPDM
Urethane rubber	AU, EU
Chlorosulphonyl polyethylene	CSM ¹⁾
Fluoro rubber	FKM ²⁾
¹⁾ Commercially available under trade name "Hypalon" (DuPont product).	
²⁾ Commercially available under trade name "Viton" (DuPont product).	

Depending on the degree of vulcanisation, rubbers can be classified as 'soft' or as 'hard'. The hardness of soft rubbers is expressed in Shore A, and the hardness of hard rubbers is expressed in Shore D (ASTM D 2240).

Hard rubbers (or Ebonites), i.e. with a hardness higher than Shore D 60, can be produced from NR or blends, e.g. NR/IR, NR/SBR and NR/IR/SBR.

2.3 PROPERTIES OF RUBBER

Each rubber material has a specific limit in terms of allowable service temperature and chemical resistance. Chemical resistance and temperature limits of several rubber types are given in DEP 30.10.02.13-Gen.

2.3.1 Natural rubber (NR)

Soft and hard natural rubber linings are suitable for handling most inorganic chemicals, with the exception of strong oxidising agents such as chromic and nitric acids. Natural rubber linings are also suitable for handling hydrochloric acid. Natural rubber is also resistant to most organic fluids, including alcohols and most esters. They should not be used in the presence of aliphatic or aromatic hydrocarbons, halogenated hydrocarbons, mineral oils and certain vegetable oils. The typical service temperature range is -30°C to $+80^{\circ}\text{C}$. The bond strength of NR linings on steel is excellent. The hardness is typically Shore A 70 for soft rubber and Shore D 75 for hard natural rubber.

2.3.2 Isoprene rubber (IR)

Isoprene rubber is a synthetic alternative form of NR, and has similar properties.

2.3.3 Styrene-butadiene rubber (SBR)

Styrene-butadiene rubber can be used for the containment of automotive brake fluids, alcohols and mixtures of alcohol and water. The typical service temperature range is -50°C to $+100^{\circ}\text{C}$. The hardness is in the same range as that of soft natural rubber (NR).

2.3.4 Chloroprene rubber (CR)

Chloroprene rubber (Neoprene), is resistant to ozone and sunlight, and reasonably resistant to oils and chlorine. The typical service temperature range is -40°C to $+100^{\circ}\text{C}$. The hardness is typically Shore A 70.

2.3.5 Butyl rubbers (IIR, BIIR, CIIR)

Butyl rubbers have excellent tolerance to hydrochloric acid. Butyl rubber is resistant to ozone and sunlight, non-flammable hydraulic fluids, animal and vegetable oils, water, alcohols, ketones and acids. Butyl rubber should not be used in the presence of free halogens, petroleum oils or halogenated or aromatic hydrocarbons. The typical service temperature range is -40°C to $+130^{\circ}\text{C}$. The hardness is typically Shore A 60.

2.3.6 Nitrile rubber (NBR)

Nitrile rubber (also known as BuNa-N) is resistant to petroleum-based hydraulic and lubricating oils, animal and vegetable oils, acetylene, alcohols, water, alkalis and fuel oils. Nitrile rubber should not be used for phenols, ketones, acetic acids, most aromatic hydrocarbons and nitrogen derivatives. The typical service temperature is -35°C to $+100^{\circ}\text{C}$. The hardness is typically Shore A 70.

2.3.7 Ethylene propylene rubbers (EPDM / EPM)

Ethylene propylene rubbers are resistant to ozone and sunlight, oxidising chemicals, non-flammable hydraulic fluids, pure aniline, fire extinguisher liquids, acids, hot water and steam. However, these rubbers are not resistant to mineral oils, petrol solvents and