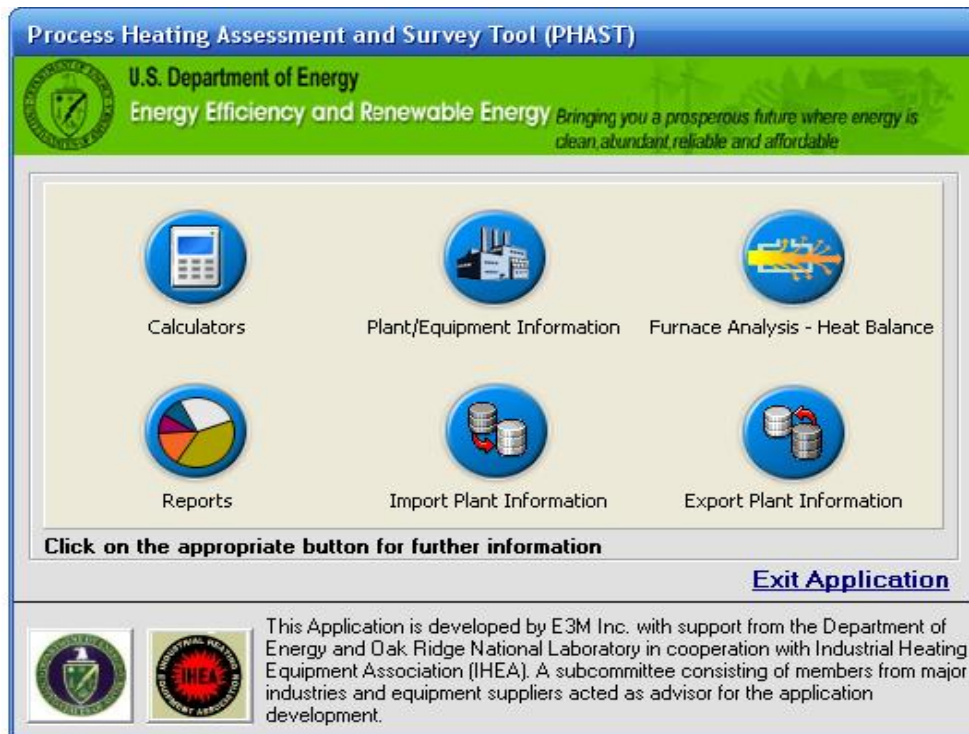


Process Heating Assessment and Survey Tool PHAST 3.0

Fuel Fired Technology (FF) – International (MKS) Units

**User Manual – Version 1.0
November 2010**



Developed by Oak Ridge National Laboratory in cooperation with the Industrial Heating Equipment Association (IHEA). A subcommittee consisting of members from major industries (steel, aluminum, heat treating, petro-chemical industry etc.) and equipment suppliers acted as advisor for the tool development.

Development supported by E3M, Inc.

Please contact ARVIND THEKDI, E3M, Inc. for all comments or suggestions

(Phone: 240.715.4333 or E-mail athekdi@e3minc.com)

What is PHAST 3.0?

PHAST 3.0 is a user-friendly tool that can be used to assess energy use and estimate reduction in energy use with application of selected methods of energy efficiency improvement for industrial process heating equipment such as furnaces, ovens, heaters, melters, boilers etc. The tool is designed for use with parameter input in U.S. – English units and International units of measurements with option of using local currency value for energy cost and savings calculations.

Note: The term “furnace” is used as a generic term to describe all commonly used process-heating equipment such as furnaces, ovens, heaters, melters, boilers, kilns, dryers etc.

The tool serves three major functions:

- 1. Provides an introduction to process heating methods and energy conversion tools. It also includes simple calculators for the performance comparison of furnaces at different operating conditions, flow calculations for orifice based gas flow meters and heat input calculations, with links to additional sources of information on topics related to process heating.*
- 2. Survey of the process equipments that use fuel, steam, or electricity as energy source for heating processes and a method to select the most energy consuming equipment. The user input is in the form of heat (energy) input and operating practices of the plant equipment being surveyed. The end result is a report that summarizes estimated annual energy use and energy cost in local currency as well as in U.S. dollars. The report identifies the high priority equipment that use the top 80% of the total process heating energy cost for the plant.*
- 3. Perform an energy (heat) balance for the selected process heating equipment (furnace) to identify major areas of energy use in the furnace and to provide guidance on how to reduce the non-productive use or loss of energy. The tool includes instructions on the required data, how to collect the data, methods to lower energy usage for each of the major areas of the furnace and a list of resources where the plant can get additional help.*

The tool allows the user to compare performance of the furnace at different operating conditions and test “what-if” scenarios for various energy saving options.

PHAST 3.0 is developed by Oak Ridge National Laboratory in cooperation with the Industrial Heating Equipment Association (IHEA). The development is supported by E3M, Inc. (Arvind Thekdi – project manager). A subcommittee consisting of members from major industries (steel, aluminum, heat treating, petro-chemical industry etc.) and equipment suppliers is acting as an advisor for the tool development.

Please contact ARVIND THEKDI, E3M, Inc. (Phone: 240.715.4333 or E-mail athekdi@e3minc.com) for all comments and suggestions.

Your cooperation and support is greatly appreciated.

Installing PHAST 3.0

The tool can be installed by 1) using a setup CD or 2) downloaded from the U. S. Department of Energy web site.

System Requirement:

- A PC running Windows 2000 /Windows XP/ Windows Vista with latest service pack
- At least 1200MB free space in hard disk
- A processor (preferably Pentium) 133 MHz or faster.
- A monitor supporting resolution of at least 1024 x 768.
- A mouse or compatible tracking device.
- An optical drive.
- Microsoft Office 2000 or higher with MS Access 2000 or higher
- Acrobat PDF Reader

1) PHAST 3.0 Setup CD

The CD includes:

- **PHAST 3.0 Setup**
- **User Manual** as PDF document
- **Survey Forms**

Installation Instructions:

- Insert the Setup Disc in the CD ROM Drive.
- Follow the on screen instructions.
- Unless otherwise changed/specified, the default path of the application is Start ->Programs ->PHAST3.0 -> PHAST3.0.
- Open the Application (Alternatively PHAST can be opened through the shortcut created on the Desktop)

Note: In case of problem during Installation

- *Update the operating system with latest service pack and run the PHAST Setup again.*
- *Disable any memory resident programs and run the PHAST setup again.*
- *Contact your IT support personnel for permission/security issues.*

Uninstall Instructions:

- *Start -> Control Panel -> Add or Remove Programs*
- *Select "PHAST3.0" from the list*
- *Click "Change/Remove"*
- *Choose either "Yes" or "Remove None" during course of uninstall*

2) PHAST 3.0 Setup - Web Download

For the web download, go to the U. S. Department of Energy web site- www.eere.energy.gov/industry.
On this web site

- Go to the link "Software Tools"

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

- Go to “Quick link to resources”
- Select “Software Tools”
- Select “Process Heating Assessment and Survey Tool (PHAST v3.0)” to download the tool

Installation Instructions:

- Click ‘Run’ to initiate the setup of PHAST 3.0
- Follow the on screen instruction
- Unless otherwise changed/specified, the default path of the application is
Start ->Programs ->PHAST3.0 -> PHAST3.0.
- Open the Application (Alternatively PHAST can be opened through the shortcut created on the Desktop)

Table of Contents

Summary: 6

Starting PHAST 3.0: 9

 Selection of Heating System 9

 Selection of Unit 10

Calculators: 12

 Energy Equivalency: 13

 Efficiency Improvement: 14

 O2 Enrichment: 15

 Flow Calculations/Energy Use: 16

Plant/Equipment Information: 17

 General Information: 19

 Add New Plant: 19

 Add New Currency: 21

 Energy Source: 23

 Add New Energy Source 25

 Furnace Information: 27

 Add New Furnace: 28

 Operating Hours 28

 Heat Zone 30

 Auxiliary Equipment 32

 Notes: 34

 Recreate New Furnace: 35

 Recreate New Zone: 36

Furnace Analysis and Heat Balance: 37

 Load Charge Material: 44

 Add New Material: 45

 Fixtures, Trays, Baskets etc. Losses 47

 Atmosphere Losses 48

 Add New Gas: 49

 Water-Cooling Losses 50

 Wall Losses 51

 Opening Losses 52

 Fixed Opening Losses 53

 Variable Opening Losses: 54

 Other Losses 56

 Flue Gas Losses/System Heating Efficiency 57

 Heat Storage 59

Reports: 62

 Plant Summary: 64

 Furnace Analysis: 68

 Furnace Summary: 72

 Input Data: 73

Import Plant Information: 75

Export Plant Information: 78

Appendix – A: Units for Conversion 80

Appendix – B: Currency and Default Conversion Rate 81

Appendix – C: Default Energy Sources (Fuel, Electricity, Steam) 82

Appendix – D: Properties of Default Material/Gas Used for Furnace Analysis 83

Summary:

A. Calculators.

This section includes several tools or calculators that can be used to assess (calculate) improvements in efficiency, reduction in fuel use and flow calculations for commonly used gases with a provision to calculate heat input for gaseous fuel-fired process heating equipment (furnaces etc.)

B. Plant/Equipment Information

This section can be used to:

- Survey energy use and the annual cost of energy in a local currency or US dollars for a heating system (fuel fired, electric heating, steam heating) and auxiliary equipment (i.e. pumps, motors, compressors, fans, vacuum pump etc.) associated with a heating system used in a plant;
- Assess and Summarize the expected annual cost of operation in a local currency or US dollars of each of the surveyed equipment;
- Identify specific heating equipment that account for a large (80%) percentage of the process heating energy cost for the plant;
- Add new heating equipment on over all annual energy use and energy cost for the plant
- Evaluate the effect of decommissioning or eliminating the use of any one or more existing pieces of heating equipment surveyed;
- Select equipment (furnaces) for detailed analysis to identify the distribution of energy used in various parts or sectors of the furnace.

C. Furnace Analysis - Heat Balance

This section can be used to analyze the energy used in various parts of the selected furnace under a given operating condition. The furnace has to be included in the Plant/Equipment Information section. The areas for energy use include charge or load, fixtures, trays etc., wall losses, water cooling losses, losses through openings and exposed hot parts, flue products (or exhaust gases) and heat storage. The load or material being processed can be in the form of solid, liquid or gas with phase change (melting, evaporation) and may include chemical reaction. This section allows the user to identify major areas of energy use and the magnitude of losses to study the effect of changes in operating conditions and their effect on the energy used in the furnace.

D. Reports

This section provides four reports in the form of tables and charts. The **Plant Summary** report includes a table of energy used, expected cost of operation for the furnaces surveyed and their comparison. The **Furnace Analysis** report includes a table of energy used in various parts of the furnace analyzed, their relative importance in terms of the percentage of the total energy used, and the effect of changes in key operating parameters on energy consumption for the furnace. The **Furnace Summary** report includes a schematic of heat loss/use distribution of the selected furnace components in the form of a “Static” Sankey Diagram format. The **Input Data** report includes all the data that has been given as input for a selected plant.

Note: All reports can be printed or saved as PDF for future reference

E. Import Other Plant Information

This section provides functionality of importing plant and furnace information of the plants previously assessed and for which the user has exported information through another installation of PHAST (Version 3.0). The complete information about plant, its furnaces, heat zones, energy sources used, cost of energy used, heat balance analysis of each furnace can be imported to the existing PHAST (Version 3.0) database. Later such information can be analyzed/ modified/ reviewed as discussed in the above section.

Note: The data entered/analyzed through earlier versions PHAST (such as v1.2, 1.3, 2.0) cannot be imported to latest versions of PHAST such as PHAST (Version 3.0)




F. Export Plant Information

This section provides functionality of exporting plant and furnace information of selected plant that is entered through PHAST (Version 2.0). The complete information about plant, its furnaces, heat zones, energy sources used, cost of energy used, heat balance analysis of each furnace can be exported as an MS Access database. Later such information can be imported in to the existing PHAST (Version 3.0) database through Import Feature and new information can be analyzed/ modified/ reviewed as discussed in the above section.

Note: The data entered/analyzed through PHAST (Version 3.0) cannot be exported to earlier versions of PHAST such as PHAST (such as v1.2, 1.3, 2.0)

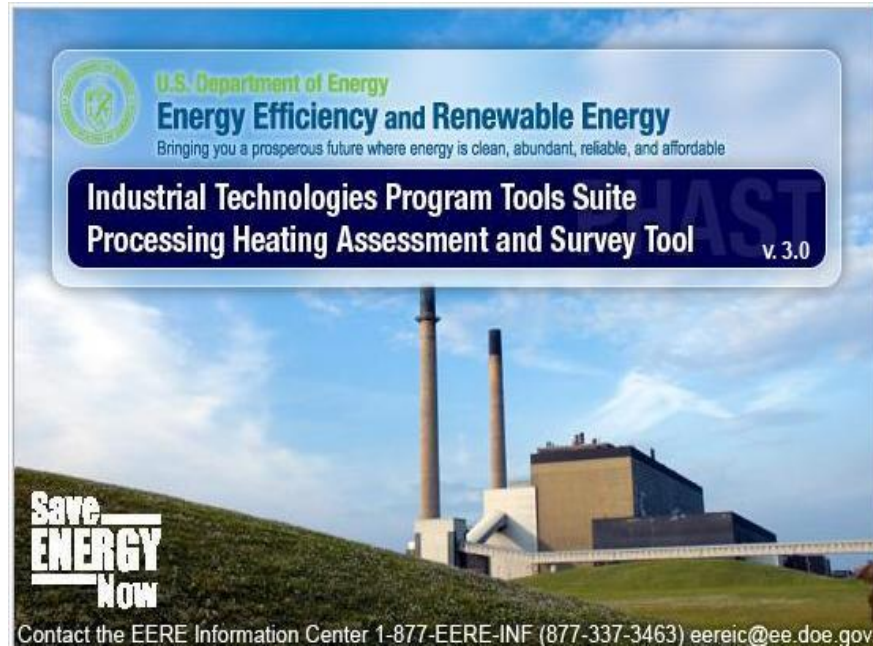
Description and Use of the Tool:

General Notes:

- *The screens of the PHAST are best viewed with the screen resolution of 1024 x 768 pixels.*
- *On all screens, enter the required information in the “white background” text boxes. The results will be shown in “colored background” text boxes or as labels.*
- *Do not use special characters (‘, ’, &, *, #, etc.) while entering the data in different text boxes. This may cause the problem when other user imports such data.*
- *Throughout the application, invoke specific unit converter by pressing “F2”. On pressing “F2”, the specific unit converter will be invoked if the cursor is in any input text box and the data being filled has unit attached to it. Also invoke general unit converter through top menu bar option (Information → Unit Converter) or by clicking  (a button given in bottom of the Furnace Analysis screen).*
- *Click on  (a button at bottom left corner of each screen) will open a new window with detailed information related to each field on the screen.*
- *Click on “ Look Up ” buttons (available on some screens) for additional references. This will open a PDF document in new window with related guidance*
- *On all screens, move the mouse over the label next to the input boxes to display a “tool-tip” and get a hint about the information that user is expected to fill in the respective text box.*
- *Refer to “Information” menu in the top bar for accessing user manual, additional references and knowledge material.*

Starting PHAST 3.0:

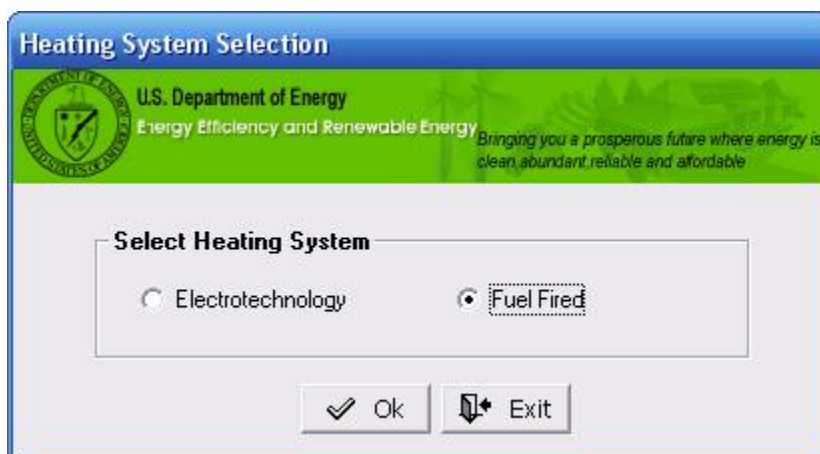
On starting PHAST 2.0, user is greeted with flash screen for a brief time.



Selection of Heating System

After brief display of splash screen, user is presented with an option to select Heating System – “Electrotechnology” or “Fuel Fired”. User can select one of the heating systems and click “OK” to proceed or “Exit” to shut down the application. After the system selection, screen with unit selection is displayed.

Note: The application remembers which heating system was used on its last run, and automatically keeps the unit selection for the next run of the application. However, user can always change the selection.



Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

Selection of Unit

After brief display of splash screen, user is presented with an option to select the units – US (SI) or International (MKS). User can select one of units and click “OK” to proceed or “Exit” to shut down the application. Based on the unit selection, screens with related unit labels are displayed for all modules.

Note: The application remembers which unit system was used on its last run, and automatically keeps the unit selection for the next run of the application. However, user can always change the unit selection.



The initial screen describes the six major sections of the application.



1. Calculators
2. Plant/Equipment Information
3. Furnace analysis – Heat Balance
4. Reports
5. Import Other Plant Information
6. Export Plant Information

Click on “**Exit Application**” to close all screens and leave PHAST 2.0

Click on “**logo**” of DOE and IHEA to go their respective website.

Calculators:

This section includes several tools or calculators (four) that can be used to assess (calculate) improvements in efficiency, reduction in fuel use, and flow calculations for commonly used gases with a provision to calculate heat input for gaseous fuel-fired process heating equipment (furnaces etc.).

Common Instructions for ALL four tabs:

- Insert the required information in the boxes or “white” areas. The results will be shown in “yellow colored” boxes.
- Use the **Tab** key or your mouse to go from one text box to another.
- Click on “**Save**” to save the information that can be displayed next time. User should save the changes in information on each tab before moving to the next tab.
- Click on “**Print**” Button to print the current screen that contains calculations.
- Click on either “**Previous**” or “**Next**” to toggle between different screens of Introduction.
- Click on the “**Close**” button to close the screen and return to the main screen.

Energy Equivalency:

Calculations for converting values of energy requirements when the heat source is changed from fuel firing (kJ/hr) to electricity (kW) or vice versa.

1

2

3

4

- Enter furnace efficiency (in terms of percentage) for fuel fired equipment (60% in the example)
- Enter furnace efficiency (in terms of percentage) for electric heating system (90% in the example)
- Enter Heat Input for Fuel fired equipment (10 GJ/hr in the example)
- Equivalent Electrical Heat Input (1851.85 kW in the example) is calculated and displayed in colored text box

Efficiency Improvement:

Calculation of available heat (an indication of thermal efficiency) for fuel fired furnaces and expected energy savings when the burner operating conditions (exhaust flue gas temperature, excess air and preheated air) are changed for the burners.

	Current	New
Flue Gas Oxygen (% Dry)	6	2
Flue Gas Temperature (Celsius)	871	871
Excess Air (%)	35.80	9.42
Combustion Air Temperature (Celsius)	27	399
Available Heat (% of HHV)	45.57	67.16
Fuel Savings (%)	Base	32.15
Energy Input (GJ/hr)	10	6.79

Buttons: Print, Save, Close, Previous, Next

O2 Enrichment:

Calculation of available heat (an indication of thermal efficiency) for fuel fired furnaces and expected energy savings when oxygen in combustion, “air”, is changed from standard (21%) to a higher value.

	Combustion with Air	Combustion with Oxygen Enriched Air
O2 in combustion Air (%)	21	100
Flue Gas Temperature (Celsius)	982	982
O2 in Flue Gases (% Dry)	5	1
Combustion Air Preheat Temperature (Celsius)	482	27
Available Heat (% of HHV)	61.97	75.31
Fuel Savings (%)	Base	17.70
Fuel Consumption (GJ/hr)	10	8.23

Note: Current limitation of the program would result in an error of about 2% to 5% for the value of available heat calculations for oxygen enriched air case.

Flow Calculations/Energy Use:

Calculation of flow rates for commonly used gases using data for an orifice type flow meter and heat input calculations when the gas is a fuel (i.e. natural gas, propane).

Calculators

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Energy Equivalency	Efficiency Improvement	O2 Enrichment	Flow Calculations Energy Use
Select Gas	Natural Gas	Temperature of Gas (Celsius)	29
Specific Gravity (Air = 1)	0.65	Pressure of Gas (kPa)	138
Orifice Diameter (cm)	9	Orifice Pressure Drop (cm WC)	25.32
Inside Pipe Diameter (cm)	20	Flow (Nm ³ /hr)	1,666
Type of Section	Sharp Edge	Operating Time (Hours)	10
Coefficient of Discharge	0.6	Energy Use (GJ)	0.07
Heating Value of Gas HHV (MJ/m ³)	4		

Print Save Close Previous Next

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

Plant/Equipment Information:

General Notes:

- Do not use special characters (',", &*, #, etc.) while entering the data in different text boxes. This may cause the problem when other user imports such data.

This section contains three tabs. An image of the section is shown below and a description of each tab follows:

The screenshot shows the 'Plant' window in the PHAST 3.0 software. The window title is 'Plant' and it has a menu bar with 'File' and 'Help'. The header features the U.S. Department of Energy logo and the text 'U.S. Department of Energy Energy Efficiency and Renewable Energy Bringing you a prosperous future where energy is clean, abundant, reliable and affordable'. The form contains the following fields and controls:

- Company Name: NEW STEEL CORPORATION
- Plant Name: Test Plant - India (dropdown menu)
- Plant Description: Mini-mill to produce structural components
- Buttons: New Plant
- General Information tab (selected):
 - Description: Mini-mill in Pune - Maharashtra state
 - Final Product or Services Provided: structural components
 - Industry Code: 33
 - Select Currency: India - INR - Rupee (dropdown)
 - Initiation Date: 06 Mar 2008 (calendar icon)
 - Conversion Rate: 0.022 (Equivalent to USD - \$)
 - Buttons: New Currency
- Address Information:
 - Address Line1: 1234 Main street
 - Address Line2: (empty)
 - City: Pune
 - State: Maharashtra
 - Country: India
 - Zip Code: 23456-7889
- Contact Information:
 - Name: Raj Joshi
 - Phone: (228) - (652 3456)
 - Fax: (228) - (652 3000)
 - E-mail: rjoshi@newsteel.in.com
- Navigation: Previous, Next, Delete Plant, Close

Callouts in the image:

- 1: Points to the 'Description' field.
- 2: Points to the 'Final Product or Services Provided' field.
- 3: Points to the 'Furnace Information' tab.

1. General Information:

Collect general information related to the plant, including its Description, Final Product, Industry Segment, Contact Information and Currency for Cost Estimation.


2. Energy Sources:

Select available energy sources for the plant and input values for the fuel heating value and cost data using appropriate units. A library of energy sources, which are used in the plant's process heating equipment, can be prepared and viewed. An option for the input of a new energy source with heating value and cost with appropriate units is provided.

3. Furnace Information:

View the list of all process heating equipment (furnaces) within the plant. An option for viewing the details of each furnace or adding a new one is provided here.

Common Instructions for ALL tabs:

- Click on **“New Plant”** to add the general information, energy sources used and furnaces for the plant. The user must provide the Plant Name before adding other details.
- Click on either **“Previous”** or **“Next”** to toggle between the different screens of Plant/Equipment Information.
- Click on **“Delete Plant”** to delete all the related information of the currently selected plant and the details *will not* be available for future analysis.
- Click on **“Close”** to close the screen and return to the main screen.
- Click on  (a button at bottom left corner of each screen) will open a new window with detailed information related to each field on the screen.



Name	Description
Zone Name	Give appropriate name of the furnace zone.
Fuel firing	
Type of Fuel	Select the types of fuel used in the zone from the menu. The menu gives a list of all fuels selected in the "Energy Source" tab.
No. of Burners/Zone	Give total number of burners used in the zone.
Zone Burner Rating for All Burners (GJ/hr)	Give a number that represents Total (for all burners stated above) firing rate or rated heat input for ALL burners. (Note: This is NOT for each burner)
% of Rated Capacity Used	Give a number that represents percentage of the rated heat input (firing rate) used in the zone. This is percentage of the rated value given in "Zone burner rating for ALL burners" above.
% Loading Factor	This is % of operating hours or time the burners are fired or used. The hours are % of operating hours given in "Operating hours information" tab.
Electric heating	
Type of electricity	Select source of electrical energy (if known) used for the furnace zone
kW Rating for All Sections	Give a number that represents Total (for all electric heating sections in the zone) power rating. (Note: This is NOT for individual heating section within a zone of the furnace)
% of Rated Capacity Used	Give a number that represents percentage of the zone electrical heat input. This is percentage of the rated value given in "kW rating for all sections"
% Loading Factor	This is % of operating hours or time the electrical heating system is used. The hours are % of operating hours given in "Operating hours information" tab.
Steam heating	
Type of steam	Select source of steam (if known) used for the heating system or furnace
Steam Pressure-Absolute (MPa)	Give value of steam pressure in absolute pressure units
Steam Flow (kg/hr)	Give a number that represents Total (for all heating sections in the zone) steam flow rate (Note: This is NOT for individual heating section within a zone of the furnace)
% of Rated Capacity Used	Give a number that represents percentage of the rated steam flow or heat input. This is percentage of the total steam flow given above.
	This is % of operating hours or time the steam heating system is used. The hours are % of operating hours given in "Operating hours information" tab.

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

General Information:

On this tab provide General Information about the plant such as Description, Final Product, Industry Segment, Currency and its conversion rate to USD, Initiation Date and Contact Information.

Note:

- Currency selection and its conversion rate are required to proceed further.
- Conversion Rate entered on this screen (tab) is used for cost calculations.
- Instead of entering an Initiation Date, a calendar image can be used to select the date

Add New Plant:

Click on “**New Plant**” to add a new plant. On the same screen, all the input boxes will clear out for new data entry.

Plant

File Help

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Company Name: NEW STEEL CORPORATION

Plant Name: Test Plant - India

Plant Description: Mini-mill to produce structural components

New Plant

General Information | Energy Source | Furnace Information

Description: Mini-mill in Pune - Maharashtra state

Final Product or Services Provided: structural components

Industry Code: 33

Select Currency: India - INR - Rupee

Conversion Rate (Equivalent to USD):

Initiation Date: 06 Mar 2008

Currency Selection

Address

Address Line1: 12

Address Line2:

City: Pune

State: Maharashtra

Country: India

Zip Code: 23456-7889

Contact Information

Name: Raj Joshi

Phone: (228) - (652 3456)

Fax: (228) - (652 3000)

E-mail: rjoshi@newsteel.in.com

Previous Next

Delete Plant Close

- Enter “**Company Name**” (mandatory to proceed further or save the data)
- Enter “**Plant Name**” (mandatory to proceed further or save the data)
- Select “**Currency**” from the drop down list (mandatory to proceed further or save the data)
- Enter/modify “**Conversion Rate**” for currency (mandatory to proceed further or save the data)
- Enter other data (optional) such as description, product, address, contact information etc.

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

Add New Currency:

For US units' version, application selects US Dollars as default currency. However, user can change the selection from the available drop-down list of currencies (Appendix – B). A new currency that is not in the list can be added to the database.

Click on “Add New Currency” to add a new currency. A new screen will be presented to enter the data of new currency as given below.

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Add New Currency

Country: Hong Kong
Currency Name: Dollar
Currency Code: HKD
Default Conversion Rate (Equivalent to USD - \$): 0.128

Delete New Cancel Save

Double click to select existing currency

No	Country	Currency Name	Currency Code	Default Conversion Rate (Equivalent to USD - \$)
1	Australia	Dollar	AUD	0.79600
2	Canada	Dollar	CAD	0.85000
3	China	Yuan	CNY	0.12900
4	European Union	Euro	EUR	1.33100
5	Hong Kong	Dollar	HKD	0.12800
6	India	Rupee	INR	0.02200
7	Indonesia	Rupiah	IDR	0.01700
8	Japan	Yen	JPY	0.00900
9	Malaysia	Ringgit	MYR	0.28500
10	Mexico	Peso	MXN	0.08900

Close

The grid table displays all currencies available in the database. Double click on any row of the currency will populate the data in the upper boxes.

User cannot edit the details of the default currencies shown in Appendix – B and encouraged to enter a new currency if it is not available in the list. The details of currency entered by user can be edited.

- Click on “New” to add a new currency.

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

Note: Country Name, Currency Name, three letters Currency Code and conversion rate with reference to US Dollar are required to have a new currency for future use.

- Click on **“Save”** to save the new currency data for future use.
- Click on **“Delete”** to delete the selected currency

Note: Currency cannot be deleted if it is used in any of the plant analysis or part of master list (Appendix –B). Application will display the message with a reason if user cannot delete the currency.

- Click on **“Cancel”** to cancel the action.
- Click on **“Close”** to close the screen and return to the Plant – General Information tab.

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

Energy Source:

On this tab, provide information of energy sources such as fuel heating value and cost that are used in the plant.

Company Name: NEW STEEL CORPORATION

Plant Name: Test Plant - India

Plant Description: Mini-mill to produce structural components

Select Type: Fuel Electricity Steam

Energy Source: Electricity

Heating Value: 3600 kJ/kWh

Cost per unit (INR): 8.000 /kWh

No	Energy Source	Type	Heating Value	Cost
1	Electricity	Electricity	3,600 kJ/kWh	INR 8,000/kWh
2	Fuel Oil	Fuel	137,000 kJ/l	INR 120.00/GJ
3	Natural Gas	Fuel	38,000 kJ/m ³	INR 300.00/GJ
4	Steam	Steam	2,790 kJ/kg	INR 250.00/GJ

Double click to select energy source. Item shown in red have not been modified after currency change

Result of Energy Source Selection

Select Available Source from Drop down List

For any new plant, application provides three energy sources - Electricity, Natural Gas and Steam along with their heating value and standard costs in selected currency as default values. However, user can change these default values to values of his/her choice. A new energy source that is not in the list (Appendix – C) can be added to the database. Application must have at least one energy source of each type for analysis otherwise a selection for Fuel/Electricity/Steam in the Heat Zone information will not be available. The heating value and cost data for Fuel, Electricity and Steam are used to calculate plant wide energy consumption and its cost distribution.

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

Note: Heating value and cost units are required to have this energy source available for plant.

- Select the energy source from the drop list.
- Edit/enter the Heating Value input box (*Note: this value will be used for calculation*)
Note: User can invoke specific unit converter by pressing “F2”, if cursor is in Heating Value input box. User will be presented with unit converter screen as given below.

The image shows two screenshots. The top screenshot is the 'Energy Source' tab in the PHAST 3.0 software. It features three tabs: 'General Information', 'Energy Source', and 'Furnace Information'. The 'Energy Source' tab is active, showing a 'Select Type' section with radio buttons for 'Fuel', 'Electricity' (selected), and 'Steam'. Below this, there is an 'Energy Source' dropdown menu set to 'Electricity', a 'Heating Value' input box containing '3600' with units 'kJ/kWh', and a 'Cost per unit (INR)' input box containing '8,000' with units '/kWh'. There are 'Delete' and 'Save' buttons at the bottom. An arrow points from the '3600' input box to the 'Unit Calculator' dialog box below.

The 'Unit Calculator' dialog box is titled 'Unit Calculator' and features the U.S. Department of Energy logo and the text 'Energy Efficiency and Renewable Energy'. It has an 'Input' section with three fields: 'What Quantity?' (3600), 'Convert From' (Btu/kWh), and 'Convert To' (kJ/kWh). The 'Output' section shows a 'Result' of 3795.66. At the bottom, there are 'Close' and 'Return Value' buttons.

- Enter/Edit the “**What Quantity**” value
- Select the unit from “**Convert From**” list
- Select the unit from “**Convert To**” list”
- Click on “**Return Value**” to bring the calculated result (output) to the input box from where F2 was invoked i.e. Heating Value on energy source tab
- Click on “**Close**” to close the unit converter form without bringing the calculated result (output) to the input box
- Edit/enter the cost of energy source in the selected currency (*Note: this value will be used for calculation*)
- Click on “**Save**” to save the energy source for selected plant.

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

Note: The grid table displays all energy sources that are saved and available for the plant. Double click on any row of the energy source will populate the data in the upper boxes.

- Click on **“Delete”** to delete the selected energy source.

Note: Energy source cannot be deleted if it is used in any of the plant analysis. Application will display the message with a reason if user cannot delete the energy source.

The application has a provision to add more than one type of Electricity and Steam with a different name, heating value and cost. The application calculates energy cost according to the selected energy source in the heat zone data in furnace information section of the application.

Add New Energy Source

Click the **“New”** button to add a new Energy Source. A separate screen (shown below) will pop up.

No	Name	Energy Type	Heating Unit	Cost Unit
1	Blast Furnace Gas	Fuel	kJ/m ³	INR/GJ
2	Coal	Fuel	kJ/kg	INR/tonne
3	Coke	Fuel	kJ/kg	INR/tonne
4	Coke Oven Gas	Fuel	kJ/m ³	INR/GJ
5	Fuel Oil	Fuel	kJ/l	INR/GJ
6	Natural Gas	Fuel	kJ/m ³	INR/GJ
7	Propane	Fuel	kJ/m ³	INR/GJ
8	solid fuel	Fuel	kJ/kg	INR/tonne

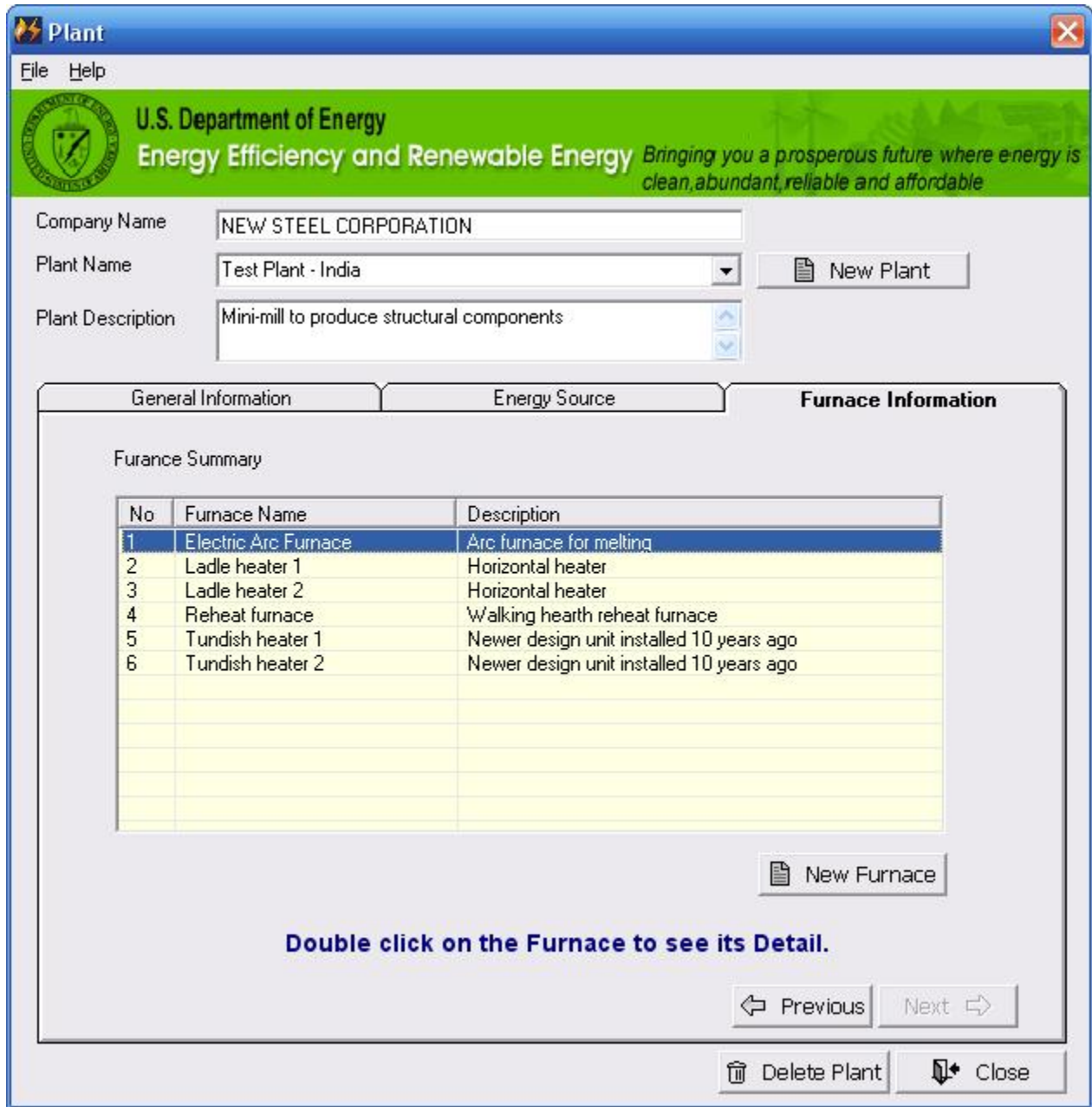
- Select **Type of new Energy Source** (Fuel, Electricity or Steam)
- Enter/Input the **“Name of Energy Source”**
- Select the **“Heating Value Unit”** form the drop down list (*Note: The list of available units is dependent on the selected fuel type*)
- Select the **“Cost Unit”** form the drop down list (*Note: The list of available units is dependent on the selected fuel type and currency*)
- Click on **“Save”** to save the information. (*Note: The saved information can be viewed in the Summary list and is later available when this energy source is selected for plant analysis.*)

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

- Click on “**New**” to add another Energy Source and its information. (*Note: Double click any row in the Summary list to make it the current selection for edit/update.*)
- Click on “**Delete**” to delete the current Energy Source selection (*Note: Energy source cannot be deleted if it is used in any of the plant analysis or part of master list (Appendix –C). Application will display the message with a reason if user cannot delete the energy source.*)
- Click on “**Close**” to return to the Energy Source tab of the **Plant/Equipment Information** section.

Furnace Information:

The user can view a list of all the Process Heating Equipment (Furnaces) previously entered for analysis.



Double click on any row of “**Furnace**” in the list. A separate screen will pop up showing previously entered and saved information of the selected furnace.

Note: For a new plant, the summary list will not show any furnace and user must add furnaces and their operational information through “New Furnace”

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

Add New Furnace:

Click on “**New Furnace**” to add operational information for a new furnace. A separate interface screen as shown below will pop up where the appropriate information for the new furnace can be added.

Double click the any of the “**Furnace Name**” in the furnace list to edit the furnace information.

*Note: The current furnace is highlighted with **blue colored text** in the list on left side.*

No	Furnace Name
1	Electric Arc Furnace
2	Ladle heater 1
3	Ladle heater 2
4	Reheat furnace
5	Tundish heater 1
6	Tundish heater 2

Operating Hours

- Select the option of “**Calculate**” or “**Assign**”
 - For “Calculate” option (*Note: user must enter all individual numbers and application calculates the total hours based on the input*)
 - Enter the number of “**Weeks/year**” for which furnace is operating
 - Enter the number of “**Days/week**” for which furnace is operating
 - Enter the number of “**Shifts/day**” for which furnace is operating
 - Enter the number of “**Hours/shift**” for which furnace is operating
 - Application will calculate and display the “**Total Hours/year**”

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

- For “Assign” option (*Note: user won't be given an option to enter individual numbers and must enter the total hours*)
 - Enter the number of “**Total Hours/year**”
- Click on “**Next**” or “**Heat Zone tab**” to enter information about furnace's zones (*Note: The information entered is saved and available for later edit/update*)

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

Heat Zone

A separate screen as shown below will be displayed where user can enter each zone's information or, add/delete new zone

The zone information has three options. Depending on the source of heat, the user can select Fuel firing of burners, Electric Heating (through resistance heating, induction heating, electric arc/plasma or other types), or Steam Heating, commonly used for heating of liquids such as water or air for drying.

- In case of Fuel Firing, the drop down list of fuel type will display only those fuels that are available in the "Energy Sources" of the plant information.
- In case of Electric Heating, the drop down list of electricity type will display only that electricity that is available in the "Energy Sources" of the plant information.
- In case of Steam Heating, the drop down list of steam type will display only those steams that are available in the "Energy Sources" of the plant information.
- In case of steam heating, a set of nominal values for saturated steam is used as standard values for their respective text boxes when actual values are not available. It is advised that whenever possible, the actual operating conditions be used.

The screenshot shows the 'Furnace Information' window with the following details:

- Company Name:** NEW STEEL CORPORATION
- Plant Name:** Test Plant - India
- Furnace Name:** Reheat furnace
- Description:** Walking hearth reheat furnace
- Heat Zone List:**

No	Heat Zones
1	Heating zone - bott...
2	Heating zone - top
3	Preheat zone
4	Soak zone - bottom
5	Soak zone - top
- Zone Information:**
 - Fuel Firing:** Type of Fuel: Natural Gas, No. of Burners/Zone: 6, Zone Burner Rating for All Burners (GJ/hr): 60, % of Rated Capacity Used: 80, % Loading Factor: 75
 - Electric Heating:** Type of Electricity: [blank], % of Rated Capacity Used: 0, kW Rating for All Sections: 0, % Loading Factor: 100
 - Steam Heating:** Type of Steam: [blank], % Loading Factor: 100, Steam Pressure-Absolute (MPa): 85, Steam Temperature (Celsius): 350, Steam Flow (kg/hr): 0, Total Heat for Steam (kJ/kg): 1200, % of Rated Capacity Used: 0

- Enter the operating information of zone in the input boxes

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

- Click on “**Next**” to enter Auxiliary Equipment information. *(Note: The zone information entered is saved and available for later edit/update)*
- Click on “**Previous**” to go to operational information tab *(Note: The zone information entered is saved and available for later edit/update)*
- Click “**New Zone**” to add a new zone to a furnace. All input boxes turn to blank or default values for data entry. *(Note: The zone information entered is saved and available for later edit/update. The saved zone is displayed in the zone list)*
- Click “**Delete Zone**” to delete the selected heat zone of current furnace. *(Note: Make sure that the appropriate zone is selected before attempting to delete its information)*
- Click on “**Close**” to close the screen and return to the **Plant/Equipment Information** screen. *(Note: The zone information entered is saved and available for later edit/update)*

On this screen also, a specific unit converter can be invoked by pressing “F2” key. Following text boxes allow invocation of specific unit converter.

- Zone Burner Rating for All Burners
- kW Rating for All Sections
- Steam Pressure Absolute
- Steam Temperature
- Steam Flow
- Total Heat for Steam

Note: A furnace can be selected by double clicking the furnace name in the furnace list. The respective information about Operation, Heat Zone and Auxiliary Equipment will be available for review/modification. Similarly, the heat zone for a particular furnace can be selected by double clicking the heat zone name in the heat zone list (Heat Zone tab) and the respective data will be available for review/modification.

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

Auxiliary Equipment

Click on “**Auxiliary Equipment tab**” to enter information about plant’s auxiliary equipments. Major equipments included are: compressors, fans/blowers (outside or inside the furnace), vacuum pumps and other electric motors used for material handling/processing or other motor driven production equipment. This information is used to calculate energy used by auxiliary equipment associated with the furnace. A separate screen as shown below will be displayed where user can enter such information.

Note: It is assumed that all auxiliary equipments are powered by electricity. The drop down list of electricity type will display only that electricity which is available in the “Energy Sources” of the plant information.

The screenshot shows the 'Furnace Information' window with the following details:

- Company Name: NEW STEEL CORPORATION
- Plant Name: Test Plant - India
- Furnace Name: Reheat furnace
- Description: Walking hearth reheat furnace
- Selected Tab: Auxiliary Equipment
- Warning: Check Operating Hours before entering Auxiliary Equipment Information. * Connected power for all equipments
- Equipment Categories and Values:

Electricity Type	Compressors	Vac. Pumps	Pumps	Fans / Blowers	Other Motors
Electricity	0	0	2	3	2
Total Connected Power (kW)*	0	0	300	250	60
Duty Cycle (% of Operating Hours)	0	0	90	90	25
% Rated Capacity	0	0	60	75	60
Total Energy use (Thousand kWh)	0	0	1296	1350	72

- Enter the operating information of auxiliary equipments in the input boxes
- Click on “**Next**” to go to Notes/Comments tab (Note: The information entered is saved and available for later edit/update)
- Click on “**Previous**” to go to zone information tab (Note: The zone information entered is saved and available for later edit/update)

Note: On this screen also, a specific unit converter can be invoked by pressing “F2” key. Following text boxes allow invocation of specific unit converter - Total connected Power

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

- Click on “**New Furnace**” to add information of a new furnace.
- Click on “**Delete Furnace**” to delete the currently selected furnace. (*Note: Make sure that the appropriate furnace is selected before attempting to delete its information*)

Note: These two buttons are enabled only for the Operation Hour Information tab of furnace information screen.

- Click the “**Close**” button to close the screen and return to the main screen.

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

Notes:

Click on “Notes tab” to enter information about plant’s general notes/comments.

Furnace Information

File Help

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Company Name **NEW STEEL CORPORATION** Plant Name **Test Plant - India**

Furnace List
Double Click to Select

No	Furnace Name
1	Electric Arc Furnace
2	Ladle heater 1
3	Ladle heater 2
4	Reheat furnace
5	Tundish heater 1
6	Tundish heater 2

Furnace Name: Reheat furnace

Description: Walking hearth reheat furnace

Operation Hours Information | Heat Zone | Auxiliary Equipment | **Notes**

Notes Information

Walking hearth furnace data from the design manual and the furnace operators

Previous Next

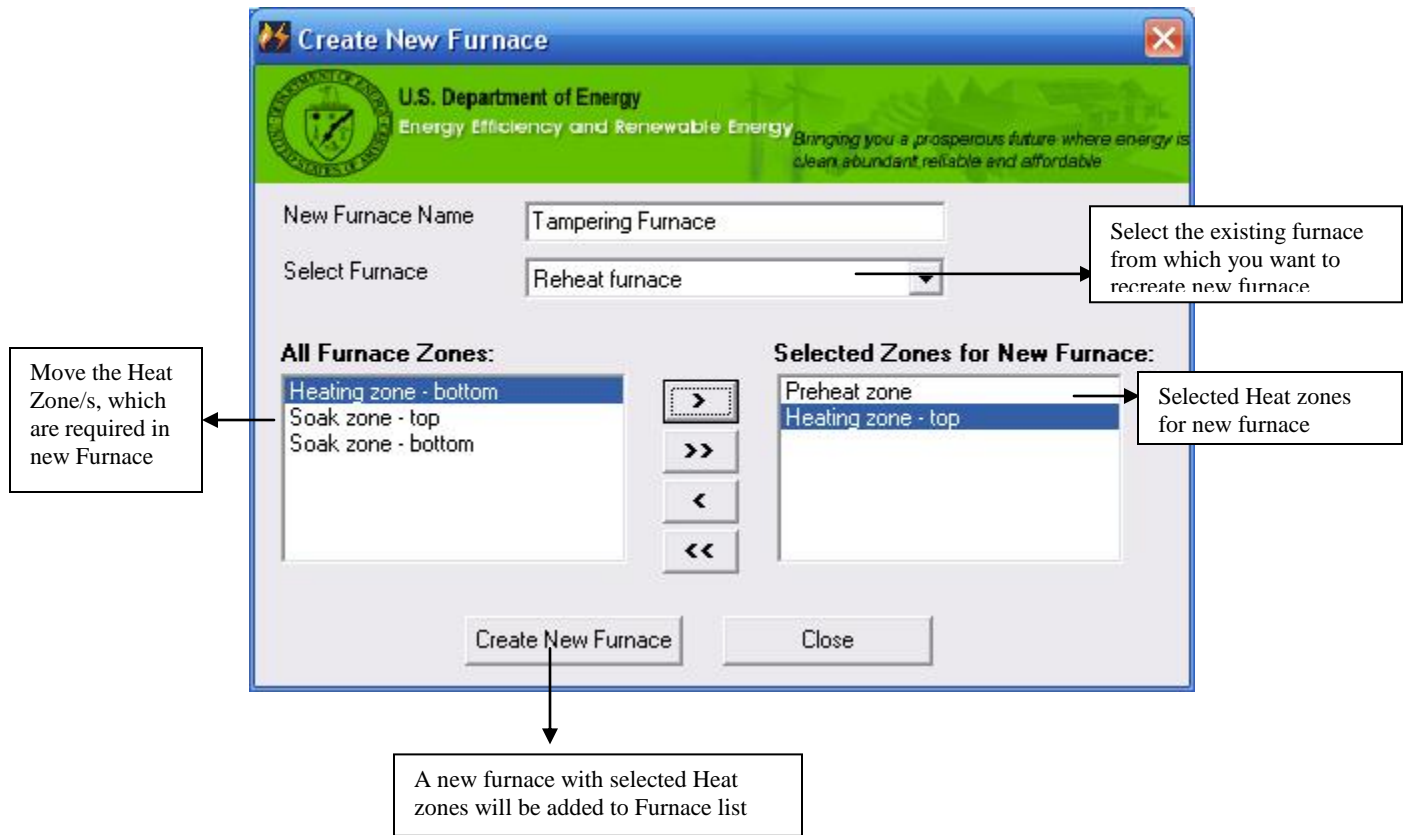
New Furnace Delete Furnace Close

Recreate New Furnace:

Application has an option to recreate the furnace using the existing furnace's information of the current plant including heat zone information. The newly created furnace will have similar information to the existing one. Further information for the Heat Zone, Auxiliary Equipment or other Operation can be added or modified later.

- Click on “**Create with Other Furnace Data**” next to the **Furnace Name** on the screen. A separate screen interface will pop up as shown below.

*Note: This button is enabled only when new furnace is being added and at least one character is entered in “**Furnace Name**” Text box.*



- Select the **furnace from the drop-down list** of existing furnaces i.e. the one which is recreated
- Select the **zones from left side window** (All Furnace Zones) and move **to the right side window** (Selected Zones for New Furnace)

Note: Use Arrow Keys (>, >>, <, <<) to move the zones between two windows.

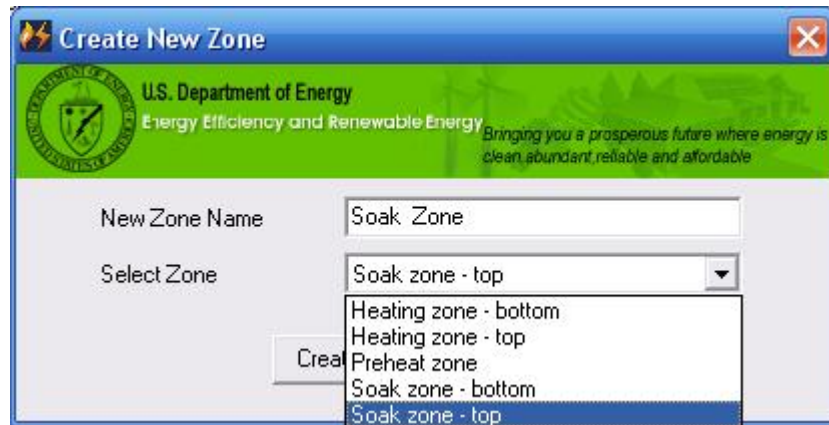
- Click on “**Create New Furnace**” to create a new furnace with selected zones and their data.
Note: The newly created furnace will appear in the furnace list.
- Click on “**Close**” to close the screen without saving the data and return to the **Furnace Information** screen.

Recreate New Zone:

Application has an option to recreate the zone of a furnace using the existing zone information of the current furnace. The newly created zone will have similar information to the existing one can that can be modified later.

- Click on **“Create with Other Zone Data”** next to the **Zone Name** on the screen. A separate screen interface will pop up as shown below.

Note: This button is enabled only when new furnace is being added and at least one character is entered in “Zone Name” Text box



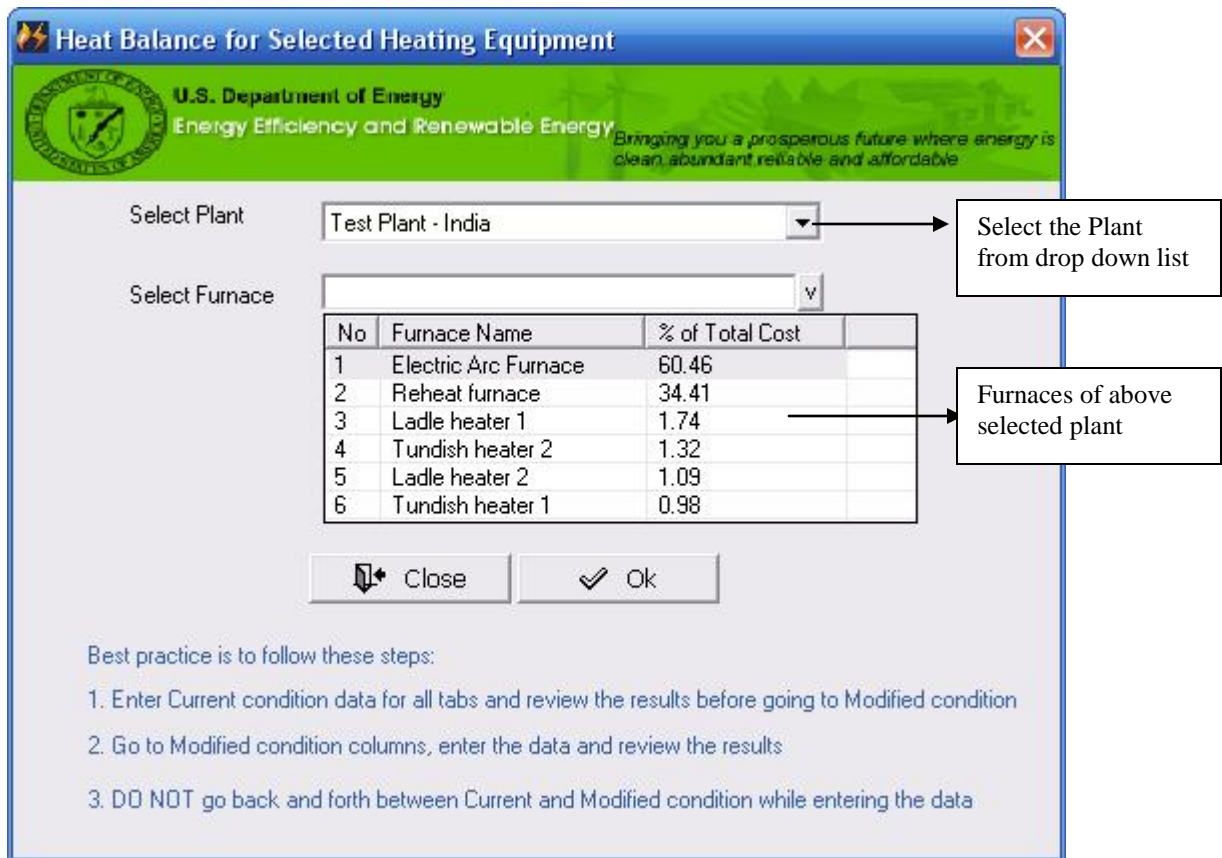
- Select the **zone from the drop-down list** of existing zones i.e. the one which is recreated
Note: Only zones of the current furnace are available for selection to recreate. Note that the zones of other furnaces can not be recreated
- Click on **“Create New Zone”** to create a new zone with data. (*Note: The newly created zone will appear in the zone list of tab.*)
- Click on **“Close”** to close the screen without saving the data and return to the Heat Zone tab screen.

Furnace Analysis and Heat Balance:

This section is used to analyze the energy used in various parts of the furnace under given operating conditions. The areas for energy use include charge or load, fixtures, trays etc., wall losses, water cooling losses, losses through openings and exposed hot parts and flue products (or exhaust gases). It allows the user to identify major areas where energy is consumed and to study the effect of changes in operating conditions, which affect energy consumption in a furnace.

Select Furnace for Analysis

Click on “Furnace Analysis” from the main screen. Separate screens will pop-up as shown below



The screen includes a list of furnaces surveyed in the Plant Information section with the amount of energy cost (in terms of percentage of the total cost calculated during the survey) for each furnace. The furnace analysis can be carried out for selected furnaces or for all furnaces, one at a time. It is recommended that to begin with, you select the furnaces that use a relatively large amount (80% of the plant total) of energy. In the case shown above, the four furnaces use approximately 80% of the total plant energy and it will be advisable to perform a detailed analysis for only these four furnaces in the beginning.

Note: Furnace Names shown in blue colored text indicates that those furnaces have never been analyzed while black colored text indicates that those furnaces have been analyzed previously and have the saved data.

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

- Select the **Plant** from the drop down list.
- Select the **Furnace** from the drop down list.
- Click “OK” to analyze the selected furnace. A new screen as showed below will open up where information on different types of energy use (for the product) and losses for the furnace can be viewed or added.
- Click “Close” to exit without analyzing any furnace and return to main screen.

The screenshot shows the 'Furnace Data' window with the following details:

- Plant Name:** Test Plant - India
- Furnace Name:** Reheat furnace
- Loss Categories (highlighted in red):**
 - Other Losses
 - Flue Gas Losses/Heating System Efficiency
 - Heat Storage
 - Water - Cooling Losses
 - Wall Losses
 - Opening Losses
 - Load/Charge Material
 - Fixtures, Trays, Baskets etc. Losses
 - Atmosphere Losses
- Material Selection:** Solid (selected), Liquid, Gas
- Material Type:** Carbon Steel (selected in both Current and Modified)
- Current Values:**
 - Charge (wet)-Feed Rate (kg/hr): 70000
 - Water Content as Charged (%): 0
 - Water Content as Discharged (%): 0
 - Initial Temp. (Celsius): 150
 - Water Discharge Temp. (Celsius): 0
 - Discharge Temp. (Celsius): 1175
 - Charge Melted (% of Charge): 0
 - Charge Reacted (% of Dry): 0
 - Heat of Reaction (kJ/kg): 0, Endothermic
 - Additional Heat Required (kJ/hr): 0
 - Heat Required (kJ/hr): 45,059,000
- Modified Values:**
 - Charge (wet)-Feed Rate (kg/hr): 70000
 - Water Content as Charged (%): 0
 - Water Content as Discharged (%): 0
 - Initial Temp. (Celsius): 400
 - Water Discharge Temp. (Celsius): 0
 - Discharge Temp. (Celsius): 1175
 - Charge Melted (% of Charge): 0
 - Charge Reacted (% of Dry): 0
 - Heat of Reaction (kJ/kg): 0, Endothermic
 - Additional Heat Required (kJ/hr): 0
 - Heat Required (kJ/hr): 34,069,000
- Summary:**
 - Current Net Heat Required (kJ/hr): 54,939,823
 - Modified Net Heat Required (kJ/hr): 41,199,435
- Buttons:** Previous, Next, Comments, Furnace Summary, Enter/Edit Modified Data, Report, Close

Annotations:


- A box labeled "Type of Losses" points to the red-bordered loss categories.
- A box labeled "Click to display Heat Loss Schematic, summary of Gross, Net Heat Loss and Efficiency for the Furnace" points to the "Furnace Summary" button.
- A box labeled "Click to Enter Modified Data" points to the "Enter/Edit Modified Data" button.

There are nine tabs that represent commonly encountered losses (mentioned below) in a furnace. The screens are designed for use with fuel fired furnaces but can also be used for electrically heated (i.e. induction, resistance, arc/plasma or other) furnaces.

1. Load Charge Material
2. Fixtures, Trays, Baskets etc. Losses
3. Atmosphere Losses
4. Water-cooling losses
5. Wall Losses
6. Opening Losses
7. Other Losses
8. Flue Gas Losses/System Heating Efficiency
9. Heat Storage

Common Instructions for ALL tabs

Each screen has two columns. One is used to enter “current” operating information and the other for “modified” operating conditions. At any particular instance either of these is enabled. The user should start with the current information column for each tab and complete the analysis to study the results. The results can be used to decide on possible changes in operating conditions that can be inserted in the “modified” column to study the effect of the changes.

- Click on “**Previous**” or **Next** to toggle between different screens of Furnace Analysis section. Alternatively user can click on the name of the tab to access a specific screen.
- Click on “**Enter/Edit Modified Data**” to enable the portion of the screen where the user can enter/edit the information for the current/modified condition of the Furnace. This button toggles between the current and modified conditions. Later, this information is used in comparing the performance of the Furnace in Summary and Reporting Furnace Analysis.
Note: Initially data entered for “Current” condition will automatically be transferred to “Modified” condition upon clicking on “Enter/Edit Current Data”. The user can always review/modify this data. The purpose is to reduce unnecessary data input.
- Click on “**Report**” to view the Furnace Analysis Report (described in detail at end of this manual) for the current furnace. This button is enabled only for the tab *Flue gas losses/Heating System Losses* as it is one of the largest heat usage areas. The purpose of it is to ensure that the user fills in the data for all tabs before viewing the report
- Click on “**Close**” to close the screen and return to the main screen.
- Click on  to access the general unit converter. A separate screen will pop up where user can select different unit groups and their conversions. The table of units is shown in Appendix – A

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

The screenshot shows a window titled "General Unit Calculator" with a green header bar. The header bar contains the U.S. Department of Energy logo and the text "U.S. Department of Energy Energy Efficiency and Renewable Energy Bringing you a prosperous future where energy is clean, abundant, reliable and affordable".

The main interface is divided into two sections: "Input" and "Output".


Input Section:

- Select Group:** A dropdown menu set to "Heat Rate".
- What Quantity?:** A text input field containing the number "3000".
- Convert From:** A dropdown menu set to "Btu/hr".
- Convert To:** A dropdown menu with a list of options: "kJ/hr", "Btu/hr", and "kJ/hr". The "kJ/hr" option is currently selected.

Output Section:

- Result:** A text input field displaying the value "3165.17".

At the bottom center of the window is a "Close" button with a small icon to its left.

- Click on  to view the each field's description and their detailed explanation for each tab. A separate screen will pop up and display the help content specific to the tab from where it is clicked.

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units


Help
✕

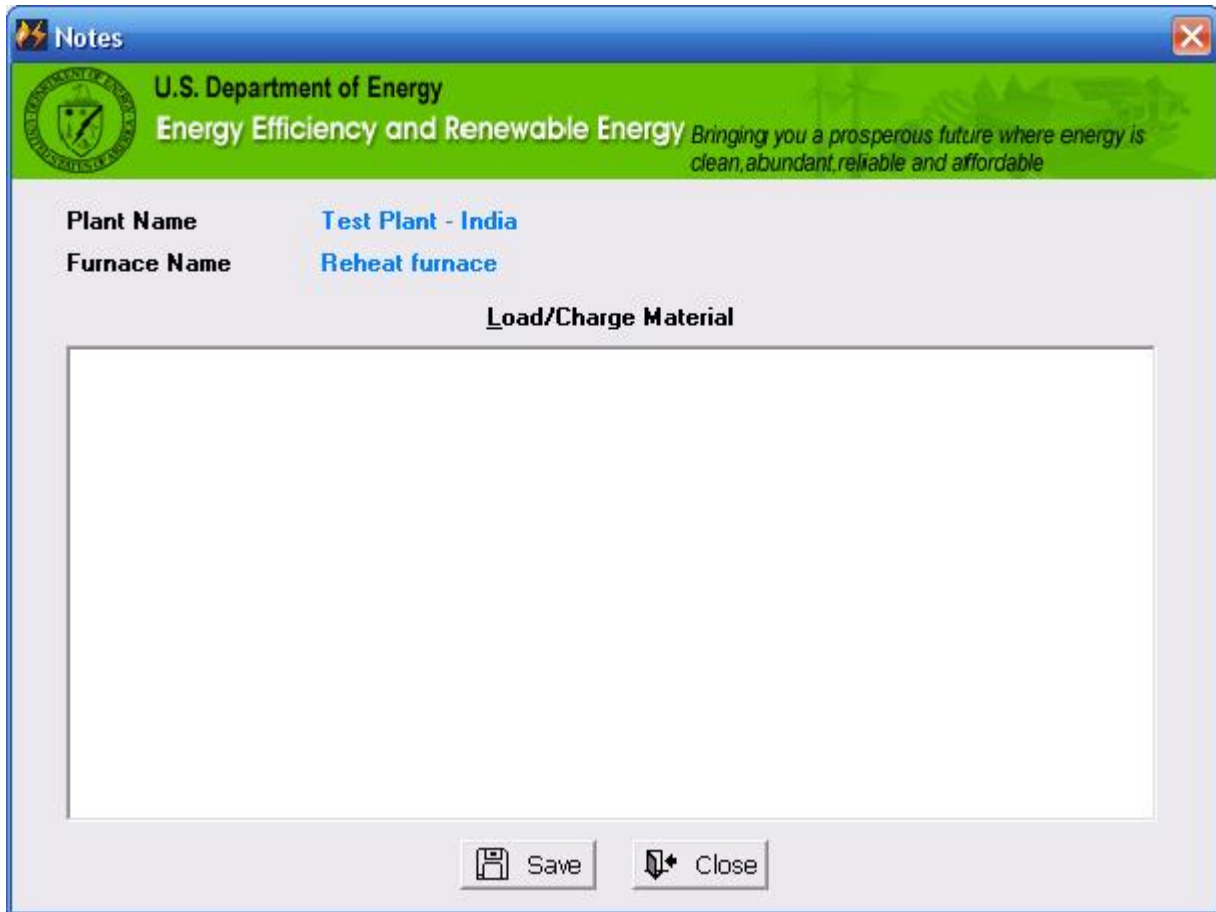
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Load/Charge Material - Solid

Name	Description
Type of Material	Select material from the drop down list.
Charge (wet)-Feed Rate (kg/hr)	Weight of material charged per hour. Use total weight including moisture in the charge material. Note that for batch furnaces the total weight should be corrected for cycle time to obtain weight per hour value.
Water Content as Charged (%)	Water content of the charge material as percentage of total charge weight - wet basis. This value can be obtained from moisture tests or specifications for the material charged.
Water Content as Discharged (%)	Water content of the discharged material as percentage of total discharged weight - wet basis. This value can be obtained from moisture tests or specifications for the material discharged.
Initial Temp. (Celsius)	Inlet temperature for the charge material. Use production data or actual measurement.
Water Discharge Temp. (Celsius)	Temperature of water vapor (usually mixed with exhaust air or flue gases) as it is discharged from the furnace/oven.
Discharge Temp. (Celsius)	Discharge temperature for the material as it is discharged from the furnace or oven. Use production data or actual measurement.
Charge Melted (% of Charge)	Charge material melted (as % of solid material charged). Use value or data from process/production engineering or measurement of the final product.
Charge Reacted (% of Dry)	Charge material (as % of dry material) reacted. Use value or data from process/production engineering or measurement of the final product.
Heat of Reaction (kJ/kg)	Insert value of heat of reaction when chemical or metallurgical reactions are involved during heating. Use positive (+) value for endothermic reactions, use negative (-) sign for exothermic reactions.
Additional Heat Required (kJ/hr)	Insert value of additional heat required and not accounted for in the above calculations.
Heat Required (kJ/hr)	Heat Required - calculated by using the information given in previous cells.

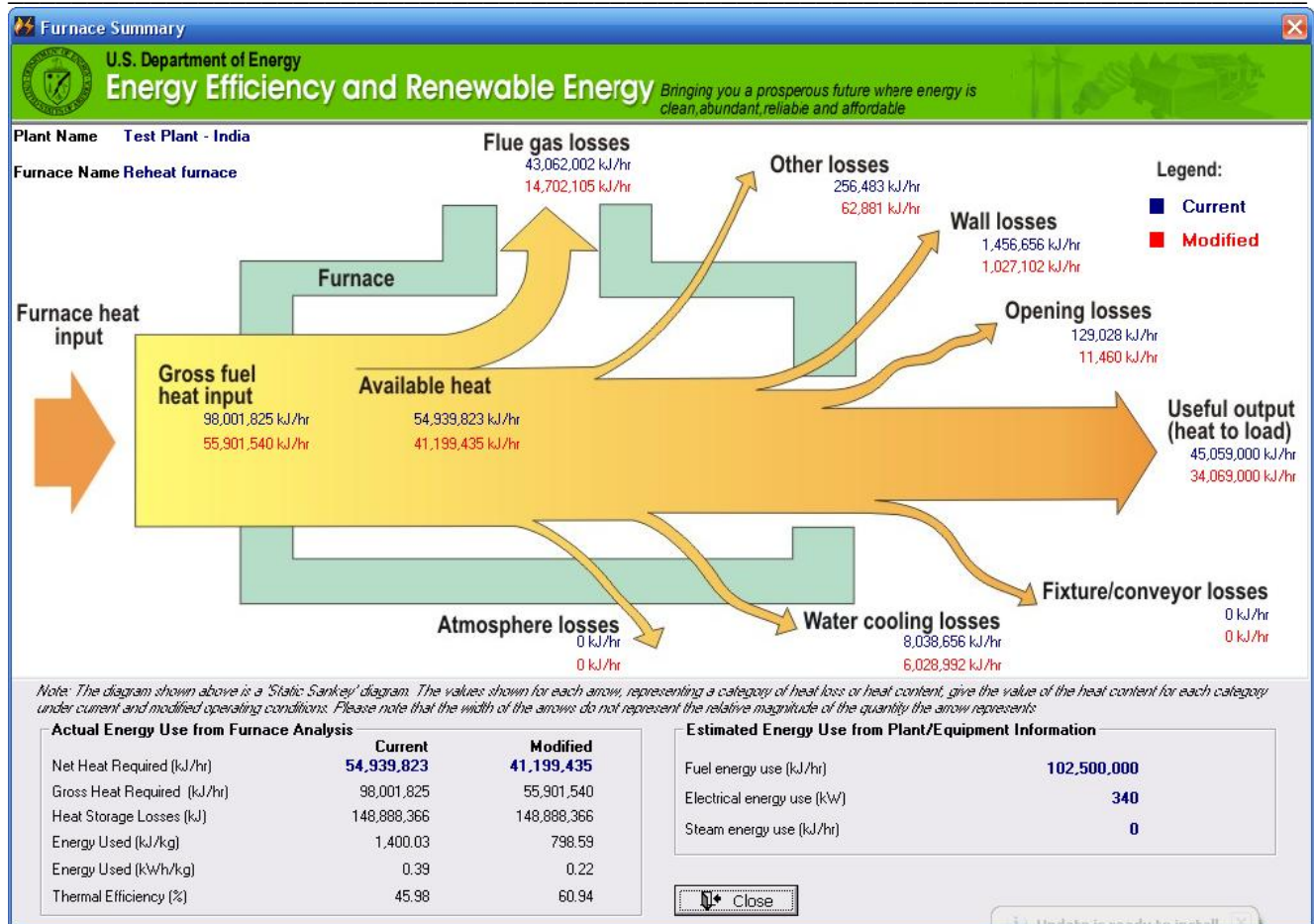
Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

- Click on “  Comments ” to enter the additional notes or comments while analyzing the each type of loss /consumption. A separate screen will pop up where user can enter the notes specific to the furnace losses.



- Click on “  Furnace Summary ” to open up a new screen where summarized data of Heat Loss, Energy Used and Efficiency with schematic of furnace losses can be viewed. A schematic showing furnace summary is shown below.

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units



Additional Notes:

- Refer to “Help”, “Calculator”, “Look up” or “Tool-tip” for additional references or knowledge material.
- Move the mouse over the label on each screen to display a “tool-tip” and get hint about the information that user is expected to fill in the respective text box.
- On all screens, a specific unit converter can be invoked by pressing “F2” key when cursor is in specific text box. Text boxes that allow invocation of specific unit converter are mentioned in each tab’s details.
- A change of value in the text boxes will affect the Gross and Net Heat Required for the Current/Modified Condition. Application calculates and displays these “real-time” values at the bottom of each screen. The overall status and comparison of it can be analyzed with the Furnace Analysis Report, which is described later in this document.

Load Charge Material:

A list of commonly used materials for charge material, fixtures and process atmosphere in process heating applications is given in the Type of Material drop-down menus. As described below, it is possible to add more materials (or modify properties of the existing materials) if the one for your specific application is not available in this list. The user added material (and data) would be automatically added to the database.

Click to add new type of Material

Select Material form Drop down List

	Current	Modified
Type of Material	Carbon Steel	Carbon Steel
Charge (wet)-Feed Rate (kg/hr)	70000	70000
Water Content as Charged (%)	0	0
Water Content as Discharged (%)	0	0
Initial Temp. (Celsius)	150	400
Water Discharge Temp. (Celsius)	0	0
Discharge Temp. (Celsius)	1175	1175
Charge Melted (% of Charge)	0	0
Charge Reacted (% of Dry)	0	0
Heat of Reaction (kJ/kg)	0 Endothermic	0 Endothermic
Additional Heat Required (kJ/hr)	0	0
Heat Required (kJ/hr)	45,059,000	34,069,000

Current Net Heat Required (kJ/hr) **54,939,823**

Modified Net Heat Required (kJ/hr) **41,199,435**

- Select the **Type** of material (i.e. Solid, Liquid, and Gas) for load charge.

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

- Select the **Material** from drop down (*Note: if desired material is not available, a new material can be added as described later in this section*)
- Enter the **“Other Information”** in the provided text boxes
- **“Heat Required”** is calculated based on the input provided and displayed at the bottom of the tab.
- Click on **“Next”** to move to next tab. The entered data will be saved automatically.

Add New Material:

Click on **“New”** to enter new material that is not in the list or edit the information about the existing material. A new interface screen as showed below will open up where the users can enter/edit the data.

Note: Please do not change the property values for default material included in the master database. Changes in these values can give inaccurate results when the application is exported and used by other user. It is advisable to add material as a new material with different name.

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Material Type: Solid

Name of the Material: []

Mean Specific Heat (Solid): 0 (kJ/(kg C))

Melting Temperature: 0 (Celsius)

Mean Specific Heat (Liquid): 0 (kJ/(kg-C))

Heat of Melting: 0 (kJ/kg)

Save New Delete

Double Click to Select

N.	Name	MaterialType	Mean Spe...	Melting/V...	Mean Spe
1	Aluminium casting metal	Solid	0.988	621.11	1.00
2	Aluminum	Solid	1.038	657.22	1.00
3	Babbitt, lead base	Solid	0.163	238.89	0.16
4	Babbitt, tin base	Solid	0.297	240	0.29
5	Bismuth	Solid	0.138	270	0.13

List of Available Material

Close

- Select the **Type** of material from drop down list (i.e. Solid, Liquid or Gas)
- Enter the required **Information** such as Mean Specific Heat (Solid), Melting Temperature, Mean Specific Heat (Liquid), and Heat of Melting etc.
- Click on **“Save”** to save the new material. A saved material will appear in the bottom list as well as in the drop down list on the **Furnace Analysis** screen.
- Click on **“New”** to add another new material with required information

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

Note: Name, Mean specific Heat (Solid) and Melting point of the Material are mandatory information for new material. If the final temperature of the process is greater than the melting point of the material, Mean Specific Heat (Liquid) and Heat of Melting will be required for calculations and must be provided here. Otherwise, Heat Loss calculations will be wrong/misleading.

- Click on **“Delete”** to delete the material from the list. The material will not be available for selection from Drop down list on the Furnace Analysis screen. The application will not allow deletion of materials which are in master database or which have been selected in any of the plant.

Fixtures, Trays, Baskets etc. Losses

The screenshot shows the 'Furnace Data' application window. At the top, there is a menu bar with 'File' and 'Help'. Below that is a green banner with the U.S. Department of Energy logo and the text 'U.S. Department of Energy Energy Efficiency and Renewable Energy Bringing you a prosperous future where energy is clean, abundant, reliable and affordable'. The main area has a header with 'Plant Name Test Plant - India' and 'Furnace Name Reheat furnace'. Below this is a grid of tabs: 'Other Losses', 'Flue Gas Losses/Heating System Efficiency', 'Heat Storage', 'Water - Cooling Losses', 'Wall Losses', 'Opening Losses', 'Load/Charge Material', 'Fixtures, Trays, Baskets etc. Losses', and 'Atmosphere Losses'. The 'Fixtures, Trays, Baskets etc. Losses' tab is active, showing a table with two columns: 'Current' and 'Modified'. The table has the following data:

	Current	Modified
Select Type	Aluminum	Aluminum
Fixture Weight (kg/hr)	0	0
Initial Temp. (Celsius)	0	0
Final Temp. (Celsius)	0	0
Correction Factor	1	1
Heat Required (kJ/hr)	0	0

At the bottom of the window, there are several buttons and summary information. On the left, there are icons for help, calculator, and comments. On the right, there are 'Previous' and 'Next' buttons. At the bottom, there is a summary section with the following data:

Current Net Heat Required (kJ/hr)	54,939,823	Furnace Summary	Enter/Edit Modified Data
Modified Net Heat Required (kJ/hr)	41,199,435	Report	Close

- Select the **Material** from drop down. (Note: if desired material is not available, a new material can be added as described later in this section)
- Enter the **“Other Information”** in the provided text boxes.
- **“Heat Required”** is calculated based on the input provided and displayed at the bottom of the tab.
- Click on **“Next”** to move to next tab. The entered data will be saved automatically.

Atmosphere Losses

Furnace Data

File Help

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Plant Name: **Test Plant - India** Furnace Name: **Reheat furnace**

Other Losses Flue Gas Losses/Heating System Efficiency Heat Storage

Water - Cooling Losses Wall Losses Opening Losses

Load/Charge Material Fixtures, Trays, Baskets etc. Losses **Atmosphere Losses**

	Current	Modified
Type of Gases	New Endothermic gas	Endothermic gas
Initial Temp. (Celsius)	0	0
Final Temp. (Celsius)	0	0
Flow Rate (Nm ³ /hr)	0	0
Correction Factor	1	1
Heat Required (kJ/hr)	0	0

Current Net Heat Required (kJ/hr) **54,939,823** Furnace Summary Enter/Edit Modified Data

Modified Net Heat Required (kJ/hr) **41,199,435** Report Close

- Select the **Atmospheric Gas** from drop down. (Note: if desired gas is not available, a new gas can be added as described later in this section)
- Enter the **“Other Information”** in the provided text boxes.
- **“Heat Required”** is calculated based on the input provided and displayed at the bottom of the tab.
- Click on **“Next”** to move to next tab. The entered data will be saved automatically.

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

Add New Gas:

Click on “New” to enter new gas that is not in the list or edit the information about the existing atmosphere gas. A new interface screen as showed below will open up where the users can enter/edit the data.

Note: Please do not change the property values for default gases included in the master database. Changes in these values can give inaccurate results when the application is exported and used by other user. It is advisable to add gas as a new gas with different name.

N.	Name	MaterialType	Mean Specific Heat	Melting/
1	Air	Gas	1.341322049 (kJ...	
2	Endothermic gas	Gas	1.341322049 (kJ...	
3	Exothermic gas	Gas	1.341322049 (kJ...	
4	Hydrogen	Gas	1.274255947 (kJ...	
5	Nitrogen	Gas	1.341322049 (kJ...	

- Enter the required **Information** such as Name of the Gas and Mean Specific Heat
- Click on “**Save**” to save the new gas. A saved gas will appear in the bottom list as well as in the drop down list on the **Furnace Analysis - Atmosphere Losses** tab screen.
- Click on “**New**” to add another new material with required information
Note: Name, Mean specific Heat of the Gas is mandatory information for new gas.
- Click on “**Delete**” to delete the gas from the list. The gas will not be available for selection from Drop down list on the **Furnace Analysis - Atmosphere Losses** tab screen. The application will not allow deletion of materials which are in master database or which have been selected in any of the plant.

Water-Cooling Losses

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Plant Name: **Test Plant - India** Furnace Name: **Reheat furnace**

Water - Cooling Losses

	Current	Modified
Water Flow (l/min)	8000	8000
In Temp. (Celsius)	20	20
Out Temp. (Celsius)	24	23
Correction Factor	1	1
Heat Required (kJ/hr)	8,038,656	6,028,992

Current Net Heat Required (kJ/hr) **54,939,823** Furnace Summary Enter/Edit Modified Data

Modified Net Heat Required (kJ/hr) **41,199,435** Report Close

- Enter the “**Information**” in the provided text boxes.
Note: 1.0 is used as default value of Correction Factor. Use can always change to different number.
- “**Heat Required**” is calculated based on the input provided and displayed at the bottom of the tab.
- Click on “**Next**” to move to next tab. The entered data will be saved automatically.

Wall Losses

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Plant Name Test Plant - India **Furnace Name** Reheat furnace

Load/Charge Material Fixtures, Trays, Baskets etc. Losses Atmosphere Losses

Other Losses Flue Gas Losses/Heating System Efficiency Heat Storage

Water - Cooling Losses **Wall Losses** Opening Losses

	Current	Modified
Surface Area (m ²)	280	280
Average Surface Temp. (Celsius)	132	110
Ambient Temp. (Celsius)	32	32
Correction Factor	1	1
Heat Required (kJ/hr)	1,456,656	1,027,102

Current Net Heat Required (kJ/hr) **54,939,823** Furnace Summary Enter/Edit Modified Data

Modified Net Heat Required (kJ/hr) **41,199,435** Report Close

- Enter the “**Information**” in the provided text boxes.
Note: 1.0 is used as default value of Correction Factor. Use can always change to different number.
- “**Heat Required**” is calculated based on the input provided and displayed at the bottom of the tab.
- Click on “**Next**” to move to next tab. The entered data will be saved automatically.

Opening Losses

Click on the **Opening Losses** tab to display the following main screen from which the user can perform the calculation for fixed and variable opening losses for current as well as modified condition. The calculated result of fixed and variable opening losses are displayed as an individual losses and total of both opening losses is also calculated and displayed on the screen.

Furnace Data

File Help

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Plant Name: **Test Plant - India** Furnace Name: **Reheat furnace**

Load/Charge Material Fixtures, Trays, Baskets etc. Losses Atmosphere Losses

Other Losses Flue Gas Losses/Heating System Efficiency Heat Storage

Water - Cooling Losses Wall Losses **Opening Losses**

Current		Modified	
Fixed Opening Losses		Fixed Opening Losses	
<input type="button" value="Calculate"/>		<input type="button" value="Calculate"/>	
Calculated Heat Losses (kJ/hr)	118,209	Calculated Heat Losses (kJ/hr)	7,388
Variable Opening Losses		Variable Opening Losses	
<input type="button" value="Calculate"/>		<input type="button" value="Calculate"/>	
Calculated Heat Losses (kJ/hr)	10,819	Calculated Heat Losses (kJ/hr)	4,072
Total Heat Required (kJ/hr)	129,028	Total Heat Required (kJ/hr)	11,460

Current Net Heat Required (kJ/hr) **54,939,823**
 Modified Net Heat Required (kJ/hr) **41,199,435**

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

Fixed Opening Losses

Click on “**Calculate**” in the fixed opening area will display the secondary screen as shown below. User has an option to choose from round or rectangular opening

The screenshot shows the 'Furnace Data' application window. At the top, it displays the U.S. Department of Energy logo and the slogan 'Energy Efficiency and Renewable Energy'. Below this, the 'Plant Name' is 'Test Plant - India' and the 'Furnace Name' is 'Reheat furnace'. The main area is a tree view of loss categories: Load/Charge Material, Fixtures, Trays, Baskets etc. Losses, Atmosphere Losses, Other Losses, Flue Gas Losses/Heating System Efficiency, Heat Storage, Water - Cooling Losses, Wall Losses, and Opening Losses. The 'Opening Losses' category is expanded to show the 'Fixed Opening Losses Information' dialog. This dialog has two radio buttons for 'Round' (selected) and 'Rectangular (Square)'. It features two columns: 'Current' and 'Modified'. The 'Current' column has input fields for Furnace Wall Thickness (380), Diameter of Openings (610), View Factor (0.616), View Factor - User Defined (0.616), Total Opening Area (0.80), Inside Temp. (1200), Outside or Ambient Temp. (35), and % of Time Open (100). The 'Modified' column has corresponding fields with values: 380, 610, 0.616, 0.616, 0.05, 1200, 35, and 100. At the bottom of the dialog, it shows 'Fixed Opening Losses (kJ/hr)' as 118,209 for current and 7,388 for modified. There are 'Return' buttons for both columns. Below the dialog are icons for help, calculator, and comments, along with 'Previous' and 'Next' navigation buttons. At the very bottom of the window, it shows 'Current Net Heat Required (kJ/hr)' as 54,939,823 and 'Modified Net Heat Required (kJ/hr)' as 41,199,435. There are also buttons for 'Furnace Summary', 'Enter/Edit Modified Data', 'Report', and 'Close'.

Parameter	Current	Modified
Furnace Wall Thickness (mm)	380	380
Diameter of Openings (mm)	610	610
View Factor	0.616	0.616
View Factor - User Defined	0.616	0.616
Total Opening Area (m ²)	0.80	0.05
Inside Temp. (Celsius)	1200	1200
Outside or Ambient Temp. (Celsius)	35	35
% of Time Open	100	100
Fixed Opening Losses (kJ/hr)	118,209	7,388

- Select the **Type** of opening i.e. Round or Rectangular
- Enter the **dimensions** for openings.
- Modify “**View Factor-User Defined**” (Optional)

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

Note: A view factor is calculated based on the input and set as default value for View Factor-User Defined. User can refer “Look Up” next to the input box for further information

- Enter “**Other Information**” related to fixed opening.
- Based on the input provided, a **fixed opening loss** is calculated and displayed.
- Click on “**Return**” to bring the calculated number of fixed opening losses to the main screen.

Variable Opening Losses:

Click on “**Calculate**” in the variable opening area will display the secondary screen as shown below. User has an option to choose from round or rectangular opening

The screenshot shows the 'Furnace Data' application window. The title bar reads 'Furnace Data'. Below the title bar is a menu bar with 'File' and 'Help'. A green banner at the top contains the U.S. Department of Energy logo and the text 'U.S. Department of Energy Energy Efficiency and Renewable Energy Bringing you a prosperous future where energy is clean, abundant, reliable and affordable'. The main area displays 'Plant Name: Test Plant - India' and 'Furnace Name: Reheat furnace'. Below this are several tabs: 'Load/Charge Material', 'Fixtures, Trays, Baskets etc. Losses', 'Atmosphere Losses', 'Other Losses', 'Flue Gas Losses/Heating System Efficiency', 'Heat Storage', 'Water - Cooling Losses', 'Wall Losses', and 'Opening Losses'. The 'Opening Losses' tab is active, showing a sub-section titled 'Variable Opening Losses Information'. This section has two radio buttons: 'Round' (unselected) and 'Rectangular (Square)' (selected). Below these are two columns of input fields: 'Current' and 'Modified'. The 'Current' column has values: Furnace Wall Thickness (mm) 380, Length of Openings (mm) 6096, Height of Openings (mm) 152, View Factor 0.485, View Factor - User Defined 0.485 (with a 'Look Up' button), Total Opening Area (m²) 0.93, Inside Temp. (Celsius) 1200, Outside or Ambient Temp. (Celsius) 35, % of Time Open 10, and Variable Opening Losses (kJ/hr) 10,819. The 'Modified' column has values: 380, 6096, 152, 0.485, 0.35, 1200, 35, 10, and 4,072. At the bottom of the 'Variable Opening Losses Information' section are two 'Return' buttons. Below this section are icons for help, calculator, and comments, along with 'Previous' and 'Next' navigation buttons. At the very bottom of the window, it shows 'Current Net Heat Required (kJ/hr) 54,939,823' and 'Modified Net Heat Required (kJ/hr) 41,199,435'. To the right are buttons for 'Furnace Summary', 'Enter/Edit Modified Data', 'Report', and 'Close'.

Parameter	Current	Modified
Furnace Wall Thickness (mm)	380	380
Length of Openings (mm)	6096	6096
Height of Openings (mm)	152	152
View Factor	0.485	0.485
View Factor - User Defined	0.485	0.485
Total Opening Area (m ²)	0.93	0.35
Inside Temp. (Celsius)	1200	1200
Outside or Ambient Temp. (Celsius)	35	35
% of Time Open	10	10
Variable Opening Losses (kJ/hr)	10,819	4,072

- Select the **Type** of opening i.e. Round or Rectangular
- Enter the **dimensions** for openings.
- Modify “**View Factor-User Defined**” (Optional)
*Note: A view factor is calculated based on the input and set as default value for View Factor-User Defined. User can refer “**Look Up**” next to the input box for further information*
- Enter “**Other Information**” related to variable opening.
- Based on the input provided, a **variable opening loss** is calculated and displayed.
- Click on “**Return**” to bring the calculated number of variable opening losses to the main screen.

Other Losses

Furnace Data

File Help

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Plant Name **Test Plant - India** Furnace Name **Reheat furnace**

Water - Cooling Losses Wall Losses Opening Losses

Load/Charge Material Fixtures, Trays, Baskets etc. Losses Atmosphere Losses

Other Losses Flue Gas Losses/Heating System Efficiency Heat Storage

Exposed Hot Parts	Current	Modified
Approx. Area (m ²)	11	11
Average Temp. (Celsius)	290	140
Ambient Temp. (Celsius)	35	35
Additional Losses (kJ/hr)	0	0
Heat Required (kJ/hr)	256,483	62,881

Current Net Heat Required (kJ/hr) **54,939,823** Furnace Summary Enter/Edit Modified Data

Modified Net Heat Required (kJ/hr) **41,199,435** Report Close

- Enter the “**Information**” in the provided text boxes.
- Enter the “**Additional Losses**” (optional).
- “**Heat Required**” is calculated based on the input provided and displayed at the bottom of the tab.
- Click on “**Next**” to move to next tab. The entered data will be saved automatically.

Flue Gas Losses/System Heating Efficiency

Furnace Data

File Help

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Plant Name: **Test Plant - India** Furnace Name: **Reheat furnace**

Water - Cooling Losses Wall Losses Opening Losses

Load/Charge Material Fixtures, Trays, Baskets etc. Losses Atmosphere Losses

Other Losses **Flue Gas Losses/Heating System Efficiency** Heat Storage

Select Heat Source: Fuel-Air (O2) Fired Electric Steam

	Current	Look Up	Modified
Furnace Flue Gas Temp. (Celsius)	760	760	760
Oxygen in Flue Gases (%)	4	2	2
Excess Air (%)	21.06	9.42	9.42
Combustion Air Temp. (Celsius)	45	426.67	426.67
Available Heat (%)	56.06	73.70	73.70
Available Heat User Defined (%)	56.06	73.70	73.70
Gross Heat (kJ/hr)	98,001,825	55,901,540	55,901,540
Flue Gas Losses (kJ/hr)	43,062,002	14,702,105	14,702,105

Current Net Heat Required (kJ/hr) **54,939,823** Furnace Summary Enter/Edit Modified Data

Modified Net Heat Required (kJ/hr) **41,199,435** Report Close

- Select the **Heat Source** of the system i.e. Fuel-Air (O2) fired, Electric or Steam
- Enter “**Other Information**” in the provided text boxes. Refer “**Look Up**” next to each text box for further, related information.
- Modify “**Available Heat-User Defined**” (Optional)
Note: An Available Heat is calculated based on the input and set as default value for Available Heat-User Defined. User can refer “Look Up” next to the input box for further information

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

- Based on the input provided, a **flue gas loss** is calculated and displayed.
- Click on “**Next**” to move to next tab. The entered data will be saved automatically.

Heat Storage

Click on the **Heat Storage tab** to display the following screen from which the user can perform the calculation for heat storage and theoretical heat loss for current as well as modified condition. The result is displayed in the respective text boxes of Heat storage and Theoretical heat loss.

Furnace Data

File Help

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Plant Name: **Test Plant - India** Furnace Name: **Reheat furnace**

Water - Cooling Losses Wall Losses Opening Losses

Load/Charge Material Fixtures, Trays, Baskets etc. Losses Atmosphere Losses

Other Losses Flue Gas Losses/Heating System Efficiency **Heat Storage**

Furnace Shape: Rectangular Cylindrical

Width (m): Length (m): Height (m):

	Current	Modified
Furnace Temp (Celsius)	<input type="text" value="1200"/>	<input type="text" value="1200"/>
Ambient Temp (Celsius)	<input type="text" value="35"/>	<input type="text" value="35"/>
Starting Wall Temp (Celsius)	<input type="text" value="100"/>	<input type="text" value="100"/>
Correction Factor	<input type="text" value="1"/>	<input type="text" value="1"/>
	<input type="button" value="Layer Info"/>	<input type="button" value="Layer Info"/>
Wall-Outside Temp-Top (Celsius)	170.35	170.35
Wall-Outside Temp-Sides (Celsius)	112.50	112.50
Wall-Outside Temp-Ends (Celsius)	112.50	112.50
Wall-Outside Temp-Bottom (Celsius)	153.28	153.28
Total Furnace Wall Heat Storage (kJ)	148,888,366	148,888,366
Furnace Wall Heat Storage Gross Heat Input Required (kJ)	<input type="text" value="265,587,524"/>	<input type="text" value="202,019,493"/>

Current Net Heat Required (kJ/hr) **54,939,823**

Modified Net Heat Required (kJ/hr) **41,199,435**

- Enter the **Information** about furnace shape, dimensions and temperatures.

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

- Click on “**Layer Info**” to open a new screen (as shown below) that can be used to enter the required information. This button is enabled once information about furnace shape, dimensions and temperatures

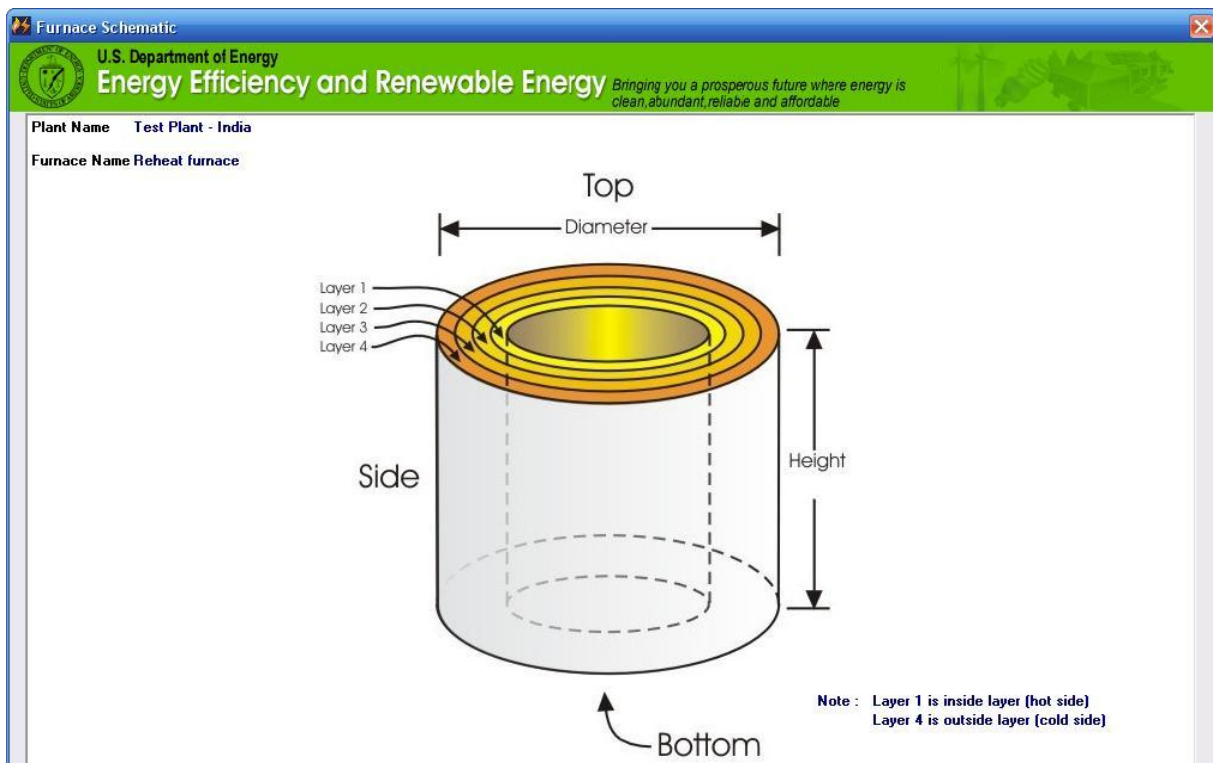
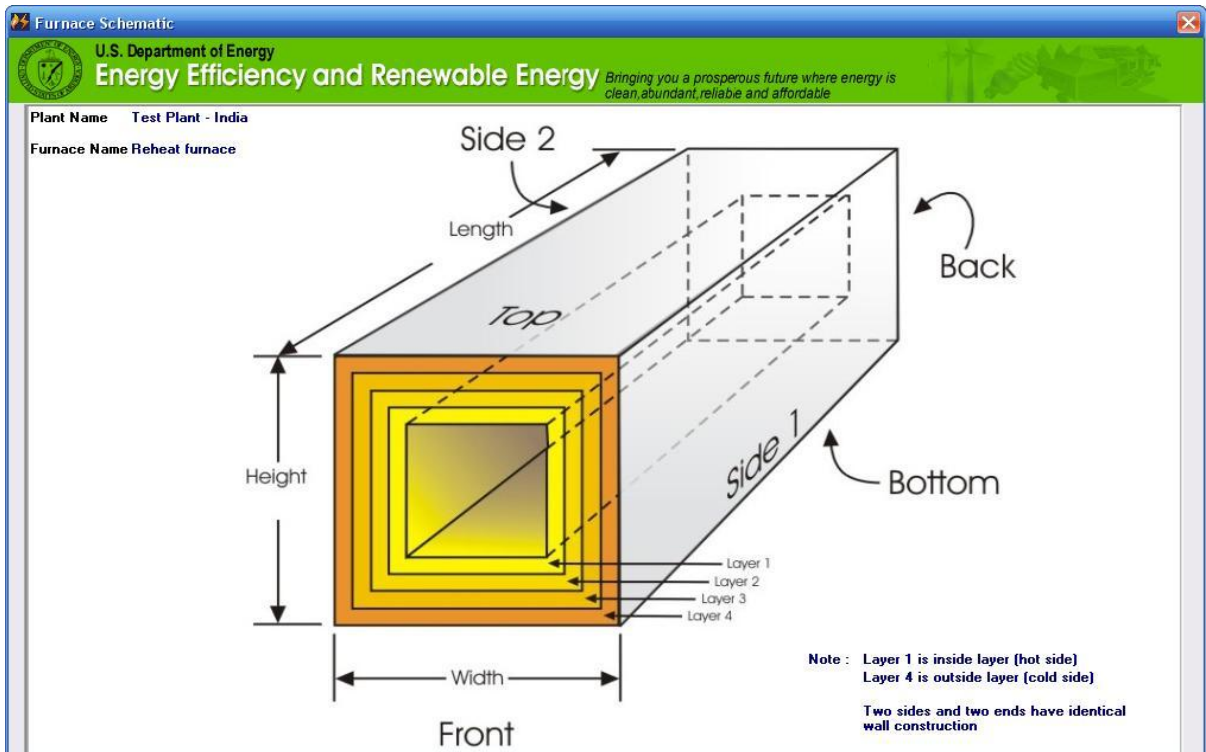
Note: The user can select the up to four layers for the furnace wall, the material from the list and enter the thickness of each layer. The user can edit the information or change the selection before performing calculations. The selection and data input will be available later when the user is selecting the same furnace for review.

The screenshot displays the 'Heat Storage' software window, which is split into two panels: 'Current' and 'Modified'. Each panel contains four sections for furnace wall layers: Top, Sides, Ends, and Bottom. Each section includes radio buttons for 'Opening?' (Yes/No), radio buttons for 'No. of Layer' (One, Two, Three, Four), a 'Select Material' dropdown menu, and a 'Thickness (cm)' input field. In the 'Current' panel, the 'Top' layer is 'High density castable (150-1425C)' with a thickness of 38 cm, 'Sides' is 'Hi temp insulating firebrick (150-1540C)' with 38 cm, 'Ends' is 'Hi temp insulating firebrick (150-1540C)' with 38 cm, and 'Bottom' is 'High density castable (150-1425C)' with 48 cm. The 'Ends' section also has an 'Area (m^2)' input field set to 0.37. The 'Modified' panel shows identical settings. At the bottom right of the window are 'Calculate' and 'Close' buttons.

- Select an option of **Opening**. Provide the area of opening if there is an opening.
- Select the **Number of Layers**. (*Note: Based on this selection, the drop down for material selection and input box for thickness will appear*)
- Select **Material** for each layer
- Enter **Thickness** for each layer
- Click on “**Calculate**” to calculate the heat storage from the given input and return to the furnace analysis-heat balance screen. The calculated results are displayed on the furnace analysis-heat balance screen.
- Click on “**Close**” to return to the Furnace- Heat balance analysis screen without performing calculations and without saving the newly entered data.

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

- Click on “ Furnace Schematic” or “ Furnace Schematic” (depends on selection of furnace shape). It will open up a new window where use can refer the schematics of rectangular or round furnace.



Reports:

This section provides four summary reports in the form of tables and charts. The **Plant Summary** report includes a table of energy used, expected cost of operation for the furnaces surveyed and their comparison. The **Furnace Analysis** report includes a table of energy used in various parts of the furnace analyzed, their relative importance in terms of the percentage of the total energy used and the effect of changes in key operating parameters on the energy used for the furnace. The **Furnace Summary** report presents schematic of heat loss/use distribution of the selected furnace. The **Input Data** report presents all the data that has been given as input for selected plant.

Click on **Reports** on the main screen to open a new user interface. Here the user can opt to view or print four pre-formatted reports.

Report Selection

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Select the Plant
Test Plant - India

Select Report Type
 Plant Summary Furnace Analysis Furnace Summary Input Data

Select the Furnace

	Furnace Name	% of Total Cost
<input checked="" type="checkbox"/>	Electric Arc Furnace	60.46
<input checked="" type="checkbox"/>	Reheat furnace	34.41
<input checked="" type="checkbox"/>	Ladle heater 1	1.74
<input checked="" type="checkbox"/>	Tundish heater 2	1.32
<input checked="" type="checkbox"/>	Ladle heater 2	1.09
<input checked="" type="checkbox"/>	Tundish heater 1	0.98

Close Show Report

- Select a **Plant** from the drop down list. All furnaces of the selected plant will be displayed as a list with the percentage of total cost of the plant.
- Select an **Option** of the reports

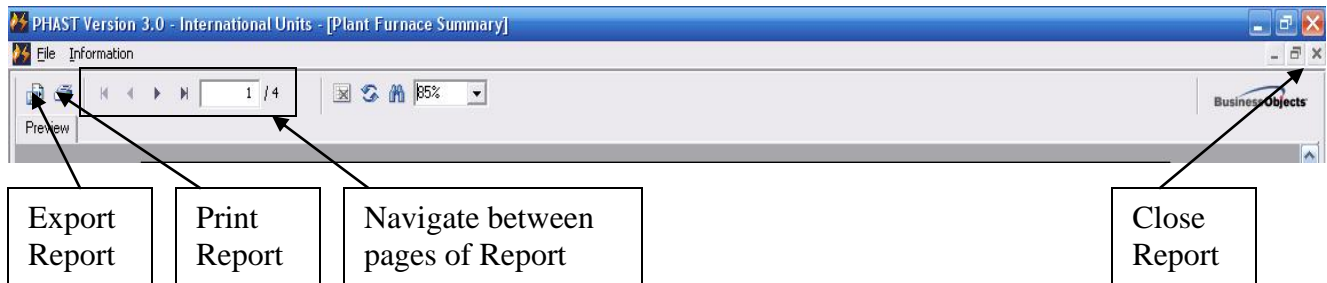
Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

- Select the **Furnace/s** from the displayed list.
 - For **Plant Summary** option, the user can select any number of furnaces that are required for analysis.
 - For **Furnace Analysis** or **Furnace Summary** option, the user can select any one furnace for detailed analysis..
 - For **Input Data** option, the user will not have a choice to select furnaces and report is generated for all the furnaces of the plant.
- Click “**Show Report**” to generate a pre-formatted report with actual data and calculations with graphs/images. (*Note: Generating a report calls for intensive calculation in background and may take time to display a report. A status bar with a note on the screen indicates the progress of opening of report*)
- Click “**Close**” to return to the main screen without displaying the report

Common Instructions for Report Viewer Window:

Each report is opened in a window that has header tool bar (as shown below). User has following options for working with reports.

- Navigate between the pages of the reports
- Print the displayed report
- Export the displayed report in PDF for electronic transfer or later analysis



Following pages shows the representative images of actual reports generated from the application.

Plant Summary:

Initiation Date : 3/6/2008

Plant Summary

Company Name	NEW STEEL CORPORATION		
Plant Name	Test Plant - India		
Address	1234 Main street Pune	Maharashtra	India 23456-7889
Contact Information	Raj Joshi Email rjoshi@newsteel.in.com	Phone (228) - (652 3456) Fax (228) - (652 3000)	
Currency	India - INR - Rupee	Conversion Rate Used (Equivalent to USD)	0.0220

Summary of Energy Sources Used

Energy Name	Heating Value	Heating Value Units	Cost (INR per Unit)	Cost Units
Electricity	3,600	kj/kWh	8.00	/kWh
Fuel Oil	137,000	kj/l	120.00	/GJ
Natural Gas	38,000	kj/m ³	300.00	/GJ
Steam	2,790	kj/kg	250.00	/GJ

Print Date : 10/22/2010

PHAST v2.0

Page 1 of 4

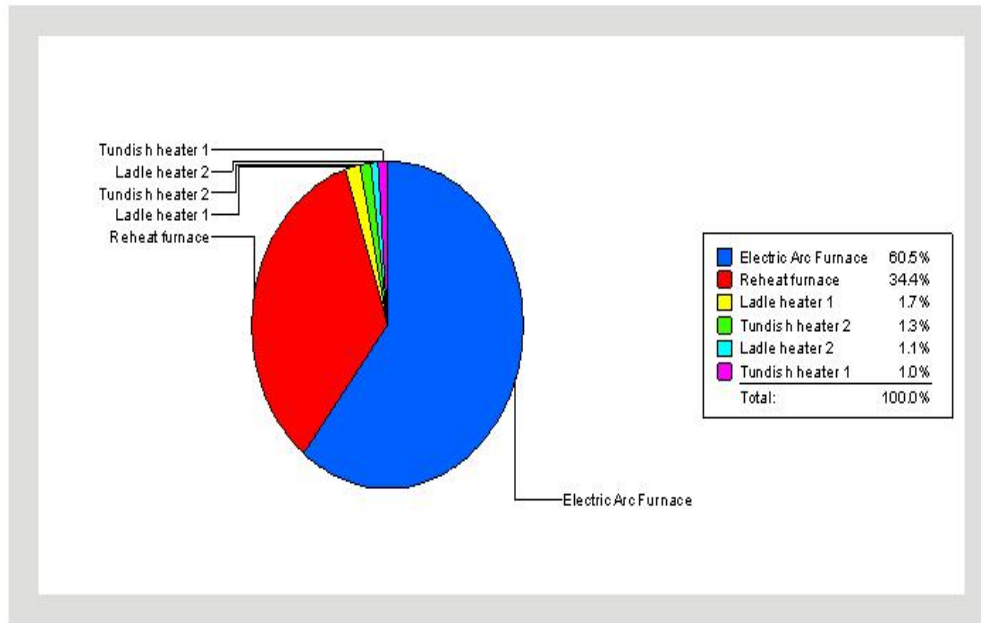
Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

Initiation Date : 3/6/2008

Plant Summary

Company Name	NEW STEEL CORPORATION
Plant Name	Test Plant - India

Process Heating Equipment - Energy Cost Distribution



Print Date : 10/22/2010

PHAST v2.0

Page 2 of 4

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

Initiation Date : 3/6/2008

Plant Summary

Company Name	NEW STEEL CORPORATION
Plant Name	Test Plant - India

Process Heating Equipment-Energy Used and Cost Distribution

Heating Equipment	Fuel Energy Use (GJ/Year)	Annual Cost (INR/Year)	Electric Energy Use (Thousand kWh/Year)	Annual Cost (INR/Year)	Steam Energy Use (GJ/Year)	Annual Cost (INR/Year)	Annual Total Cost (INR/Year)	Annual Cost (USD/Year)	% of Total Cost
Electric Arc Furnace	0	0	58,800	470,400,000	0	0	470,400,000	10,348,800	60.46
Reheat furnace	820,000	246,000,000	2,718	21,744,000	0	0	267,744,000	5,890,366	34.41
Ladle heater 1	108,000	12,960,000	73	583,200	0	0	13,543,200	297,950	1.74
Tundish heater 2	84,375	10,125,000	22	172,800	0	0	10,297,800	226,552	1.32
Ladle heater 2	67,200	8,064,000	49	392,000	0	0	8,456,000	186,032	1.05
Tundish heater 1	61,440	7,372,800	29	230,400	0	0	7,603,200	167,270	0.96
Total	1,141,015	284,521,800	61,690	493,522,400	0	0	778,044,200	17,116,972	100.00

Print Date : 10/22/2010

PHAST v2.0

Page 3 of 4

Initiation Date : 3/6/2008

Plant Summary

Company Name	NEW STEEL CORPORATION
Plant Name	Test Plant - India

Comments / Notes

Furnace Name : Electric Arc Furnace

This is an older furnace

Furnace Name : Reheat furnace

Walking hearth furnace data from the design manual and the furnace operators

Furnace Name : Ladle heater 1

Horizontal heater used regularly.

Furnace Name : Tundish heater 2

This is larger unit with capability to be used as a dryer also.

Furnace Name : Ladle heater 2

Vertical heater used as secondary heater

Furnace Name : Tundish heater 1

Used frequently

Print Date : 10/22/2010

PHAST v2.0

Page 4 of 4

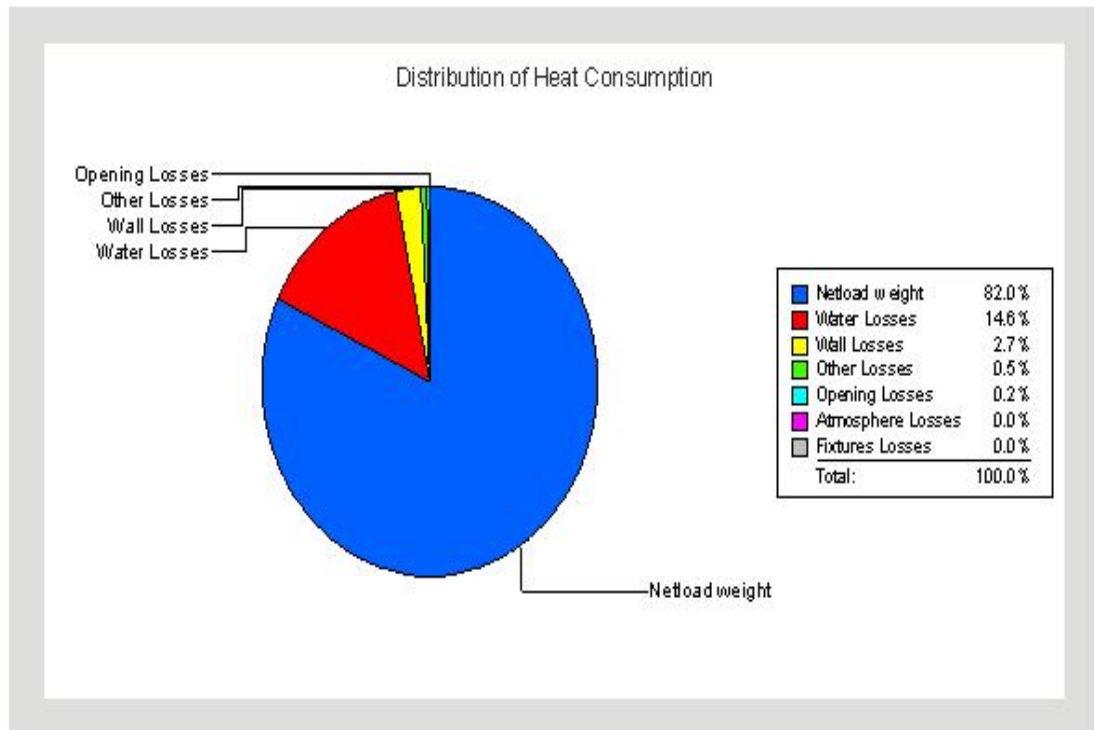
Furnace Analysis:

Initiation Date : 3/6/2008

Furnace Analysis

Company	NEW STEEL CORPORATION	Furnace	Reheat furnace
Plant	Test Plant - India	Heat Source	Fuel-Air (O2) Fired

Current Condition Heat Consumption (kJ/hr) Net Heat Consumption Data



Heat Storage (kJ) : 50,539,732

Thermal Efficiency (%) : 45.98

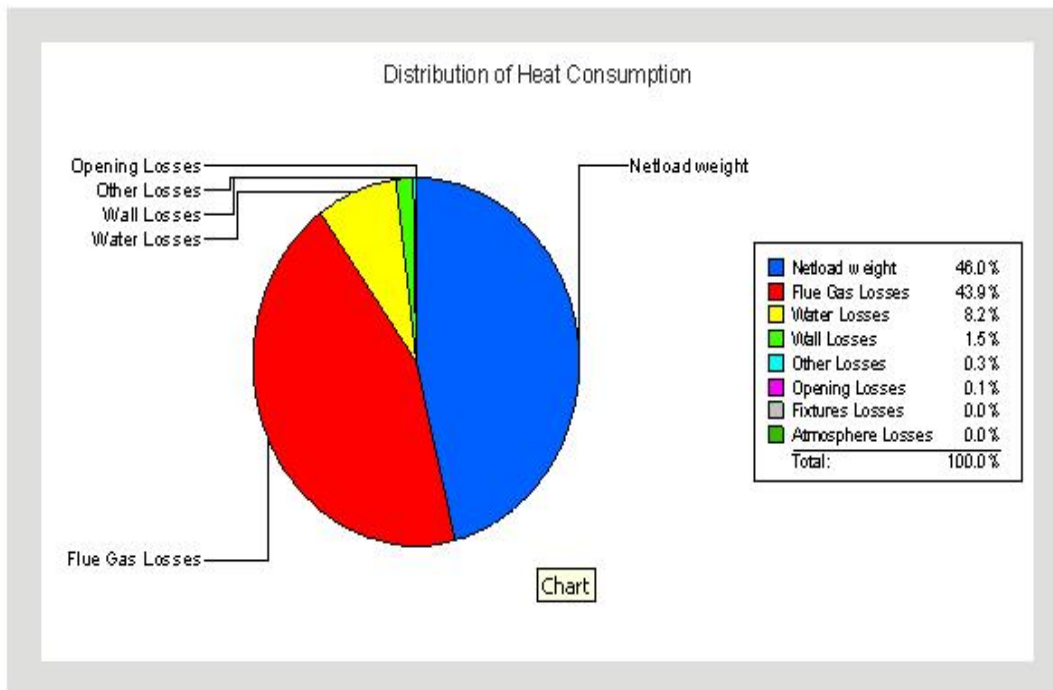
Area of Heat Consumption	kJ/hr
Netload weight	45,059,000
Water Losses	8,038,656
Wall Losses	1,456,656
Other Losses	256,483
Opening Losses	129,028
Atmosphere Losses	0
Fixtures Losses	0
Total	54,939,823

Initiation Date : 3/6/2008

Furnace Analysis

Company	NEW STEEL CORPORATION	Furnace	Reheat furnace
Plant	Test Plant - India	Heat Source	Fuel-Air (O2) Fired

Current Condition Heat Consumption (kJ/hr) Gross Heat Consumption Data



Heat Storage (kJ) : 90,152,929

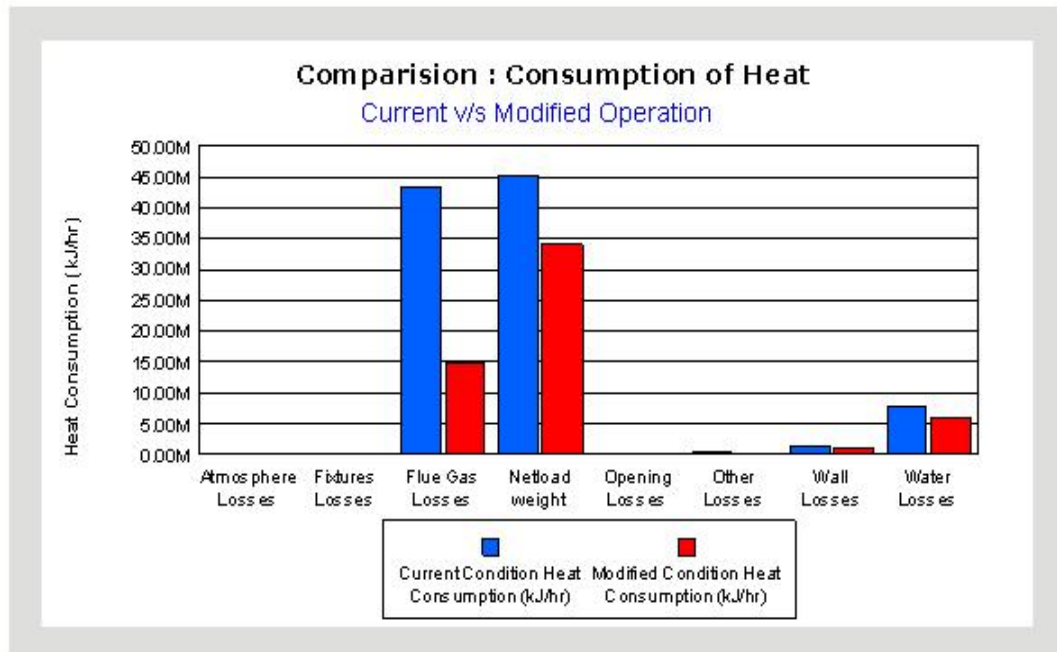
Thermal Efficiency (%) : 45.98

Area of Heat Consumption	kJ/hr
Netload weight	45,059,000
Flue Gas Losses	43,062,002
Water Losses	8,038,656
Wall Losses	1,456,656
Other Losses	256,483
Opening Losses	129,028
Fixtures Losses	0
Atmosphere Losses	0
Total	98,001,825

Initiation Date : 3/6/2008

Furnace Analysis

Company	NEW STEEL CORPORATION	Furnace	Reheat furnace
Plant	Test Plant - India	Heat Source	Fuel-Air (O2) Fired



	Current Condition Heat Consumption (kJ/hr)	Modified Condition Heat Consumption (kJ/hr)
Atmosphere Losses	0	0
Fixtures Losses	0	0
Flue Gas Losses	43,062,002	14,702,105
Netload weight	45,059,000	34,069,000
Opening <small>Subreport:funacefinal3.rpt</small>	129,028	11,460
Other Losses	256,483	62,881
Wall Losses	1,456,656	1,027,102
Water Losses	8,038,656	6,028,992
Total	98,001,825	55,901,540

Initiation Date : 3/6/2008

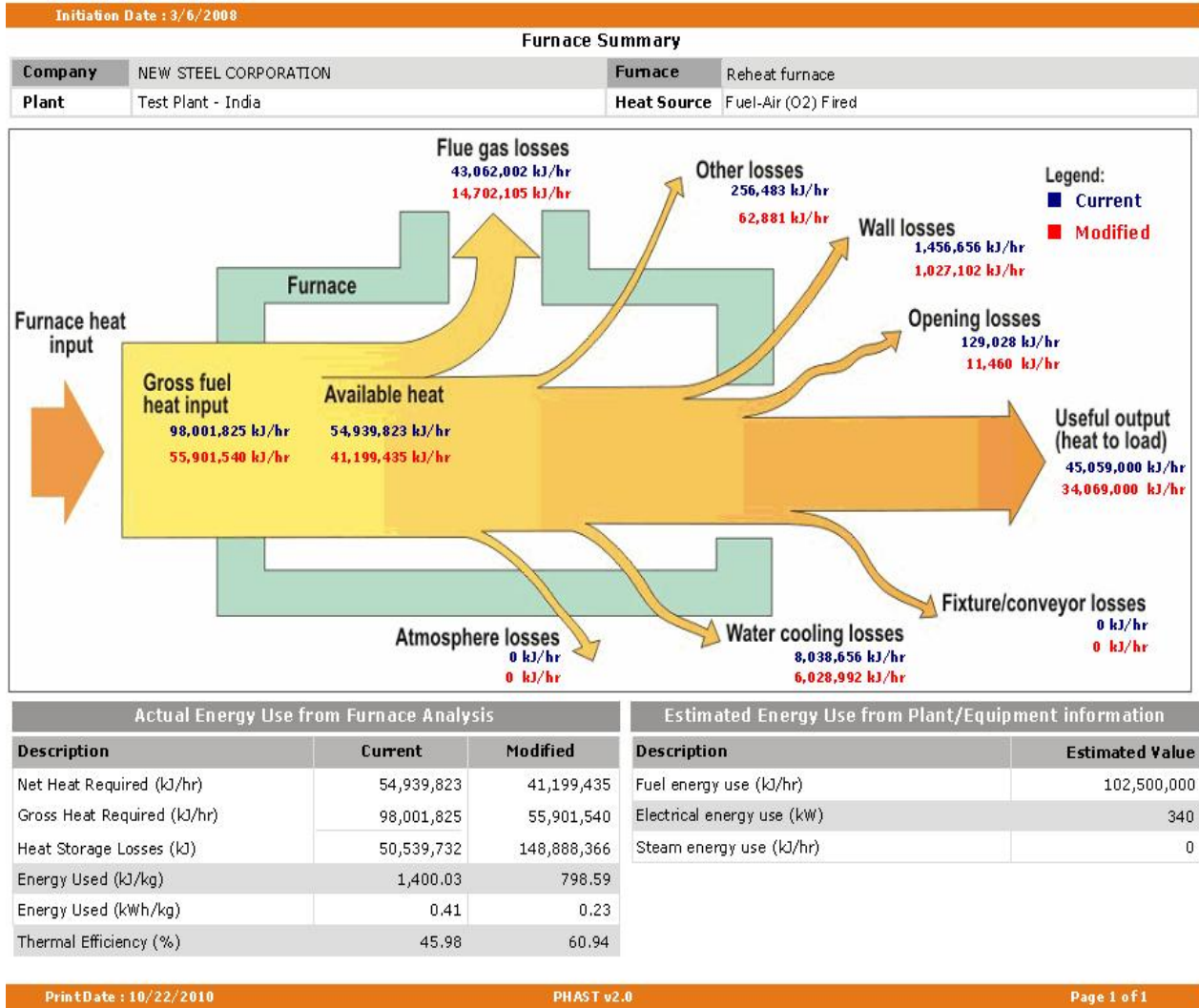
Furnace Analysis

Company	NEW STEEL CORPORATION	Furnace	Reheat furnace
Plant	Test Plant - India	Heat Source	Fuel-Air (O2) Fired

Comments / Notes

Section Name : Load/Charge Material
None
Section Name : Fixtures, Trays, Baskets etc. Losses
None
Section Name : Atmosphere Losses
None
Section Name : Water - Cooling Losses
None
Section Name : Wall Losses
None
Section Name : Opening Losses
None
Section Name : Other Losses
None
Section Name : Flue Gas Losses/Heating System Efficiency
None
Section Name : Heat Storage
None

Furnace Summary:



Note: The diagram shown above is a “Static Sankey” diagram. The values shown for each arrow, representing a category of heat loss or heat content, give the value of the heat content for each category under current and modified operating conditions. Please note that the width of the arrows do not represent the relative magnitude of the quantity the arrow represents.

Input Data:

Initiation Date : 3/6/2008

Input Data

Plant General Information

Company Name	NEW STEEL CORPORATION		
Plant Name	Test Plant - India		
Plant Description	Mini-mill to produce structural components		
Final Product	structural components		
Contact Name	Raj Joshi		
Phone	(228) - (652 3456)	E-Mail	rjoshi@newsteel.in.com

Fuel (Energy Source) Information

Name of Fuel-Energy	Heating Value Units	Heating Value	Cost Unit	Cost (INR per Unit)
Electricity	kJ/kWh	3,600	/kWh	8.00
Fuel Oil	kJ/l	137,000	/GJ	120.00
Natural Gas	kJ/m ³	38,000	/GJ	300.00
Steam	kJ/kg	2,790	/GJ	250.00

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

Initiation Date : 3/6/2008

Input Data

Company Name	NEW STEEL CORPORATION				
Plant Name	Test Plant - India				
Furnace Information					
Furnace Name	Electric Arc Furnace				
Furnace Description	Operating Hour Information				
Arc furnace for melting	Weeks / Year	Days / Week	Shifts / Day	Hours / Shift	Hours / Year
	50	7	3	8	8,400
Auxiliary Equipment Information					
	Total Nos.	Total Connected HP (all equipment)	% of Cycle Time	% Loading	
Compressors	0	0	0	0	
Vacuum Pumps	0	0	0	0	
Pumps	0	0	0	0	
Fans / Blowers	2	500	100	80	
Other Motors	0	0	0	0	
Heat Zone Information					
Zone Name	Furnace zone				
Fuel Firing					
<i>Type of Fuel</i>				<i>No. of Burners / Zone</i>	0
<i>Zone Burner Rating for All Burners (GJ/hr)</i>	0.00	<i>% of Rated Capacity Used</i>	0	<i>% Loading Factor</i>	100
Electric Heating					
<i>Type of Electricity</i>	Electricity				
<i>kW Rating for All Sections</i>	20,000.00	<i>% of Rated Capacity Used</i>	60	<i>% Loading Factor</i>	55
Steam Heating					
<i>Type of Steam</i>					
<i>Steam Pressure-Absolute (MPa)</i>	85.00	<i>Steam Temperature (Celsius)</i>	350	<i>Steam Flow (kg/hr)</i>	0
<i>Total Heat for Steam (kJ/kg)</i>	1,200	<i>% of Rated Capacity Used</i>	0	<i>% Loading Factor</i>	100
Comments / Notes					
This is an older furnace					

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

Import Plant Information:

This section provides the capability of importing and integrating the entire information of other plant into the existing database of PHAST. **This feature can be used once the user receives the Microsoft Access Application file (PHAST.mdb or with any name as sent by another user) from the plant for which information is to be imported and integrated. Please note that plant exported with earlier versions of PHAST cannot be imported in this version.** The Microsoft Access Application file can be received through Email or any media and should be stored on the computer or local network from where it can be accessed later. (User can save the received file with same or different name)

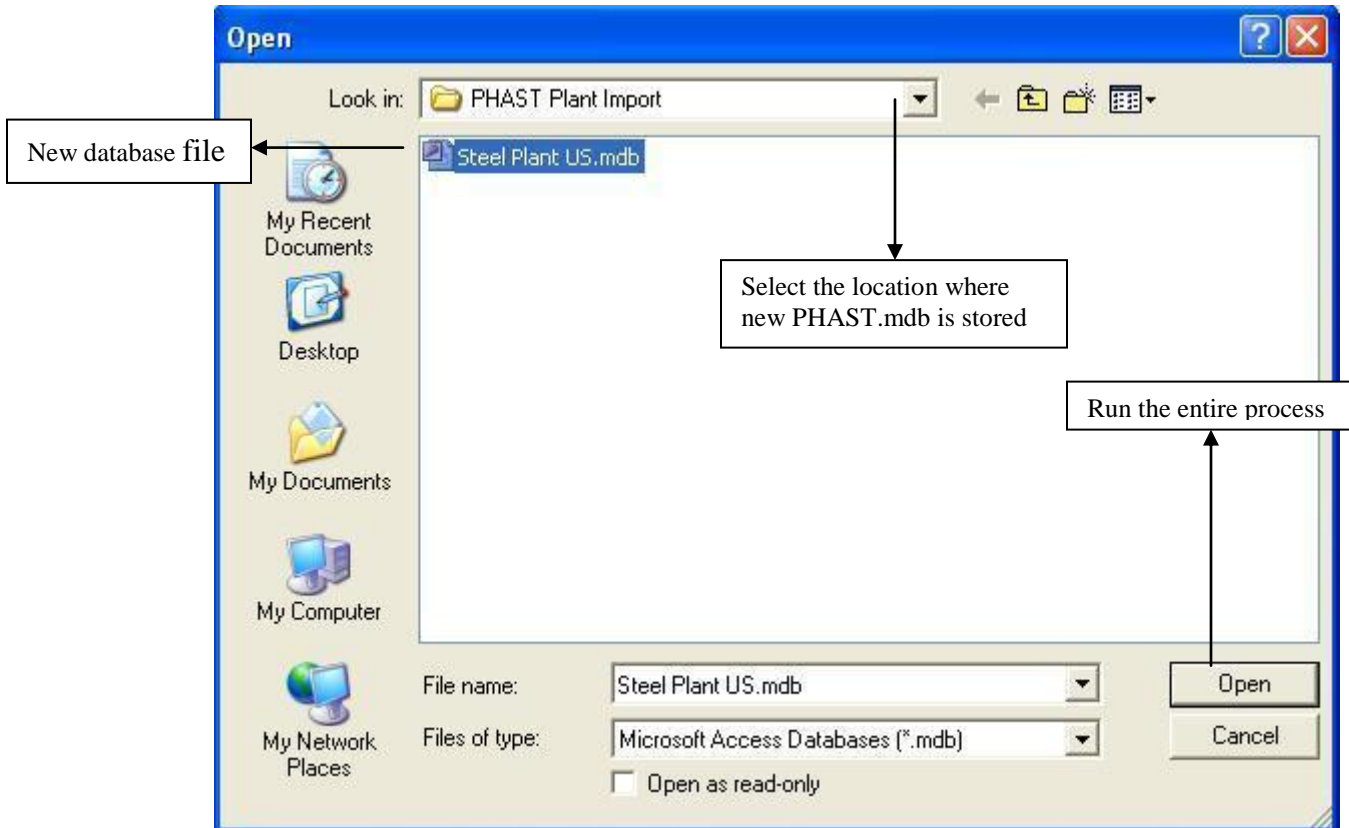
Note:

This is mandatory step and must be performed before using the feature of importing data.

Do not save the new database file with name as “Phast.mdb” at default location. It will replace the existing database. Save the new database file either with different name or at different location.

Do not save the Database file as Read-Only.

- Click on the “**Import Plant Information**” on the main screen of PHAST. This will open a new user interface as shown below. Here the user can select the Microsoft Access Application file (Phast.mdb or file with any name sent by other user) received from the other plant and stored locally as mentioned above. This file contains the information of the plant to be imported and to be integrated with existing database.

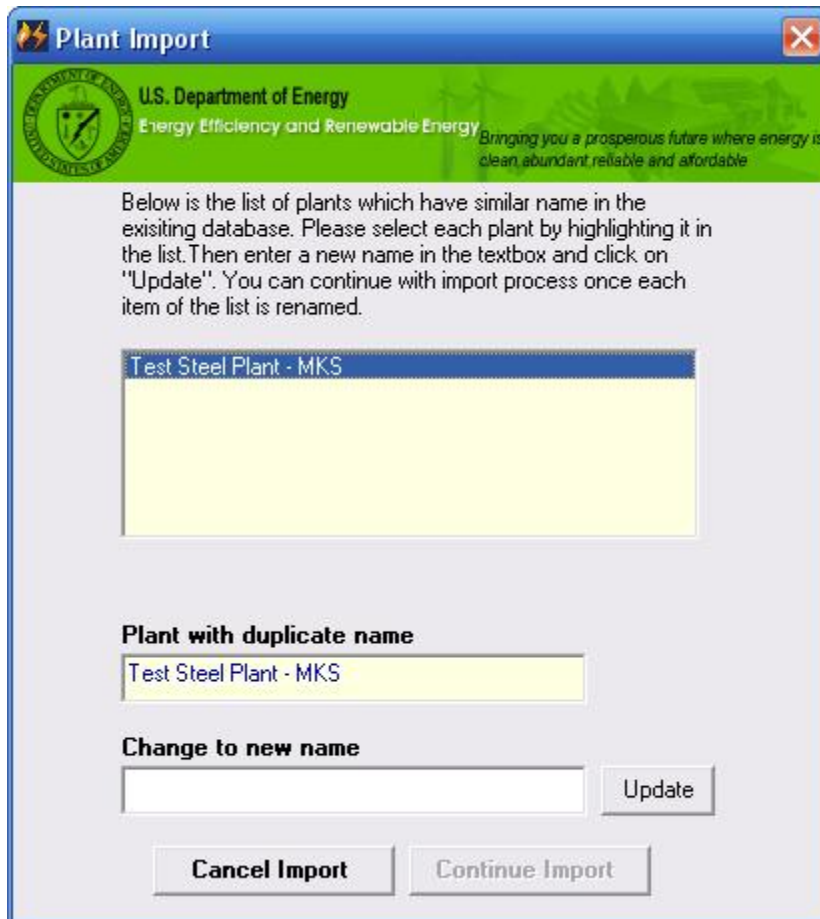


Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

- Select the location from the **Look-in** drop-down menu where the received file is stored upon receipt (as described above) and select this file.
- Click on **“Open”** to carry out the entire process of importing the new database and integrating it with existing database of PHAST.

*Note: It may be noted that above screen image is of WindowsXP operating system file **Open** dialog box. User having different operating system will have different layout of the open dialog box. Do not open the saved database file as a Read-only.*

If new file information contains the plant with similar name it will display the list of plant that are having similar name (duplicating with existing PHAST database) otherwise will continue with import process.



- Select each **Plant Name** from the list by clicking on it and change to new plant name (by entering the name in the text box provided)
- **“Update”** will change the plant’s name to the new name as entered in the text box and take out the name from the list.
- *Note: If list has more than one plant with duplicate name, User must update each one by entering new name and clicking “Update”*
- Click on **“Continue Import”**. (*Note: This button will be enabled once all duplicate plants’ names are changed to new name.*)
- Click on **“Cancel Import”** to cancel the process. No information will be imported/integrated to PHAST.

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

Once the information is imported successfully, it can be viewed/analyzed/modified as discussed in the earlier sections of the PHAST. Reports can also be generated for the new plant's information. System will display an informational message if the information is not imported successfully.

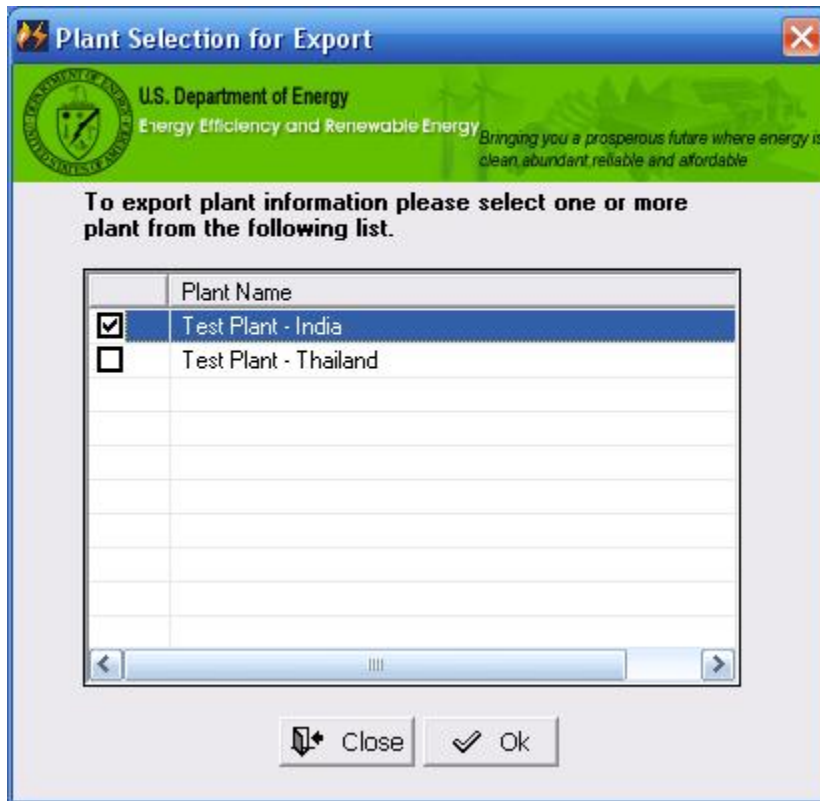
Note: The data of the US Units version of PHAST 3.0 cannot be imported into the International Units version of PHAST 3.0. Before aborting the action, system will display an appropriate message if that is attempted.

Export Plant Information:

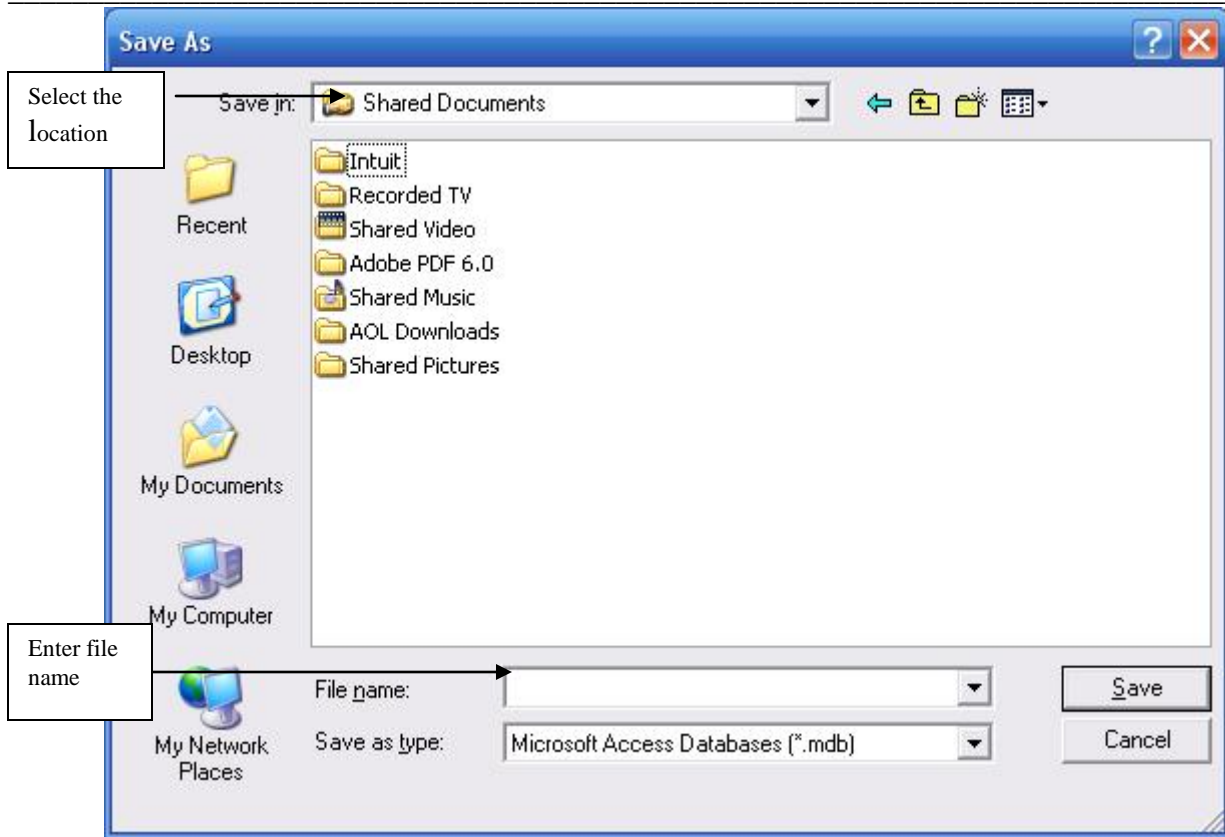
This note is for the PHAST User who is sending the file containing all information.

This feature will make Microsoft Access Application file (.mdb) of selected plants from the entire information. The same file can be sent to other PHAST User through Email or any other media.

- Click on “**Export Plant Information**” on the main screen to open a new interface as shown below. It will display the list of plant for which information is entered through PHAST (Version 3.0).



- Select one or more **Plant** from the list for which information is to be exported.
- Click “**Ok**” to proceed further. This will open a new user interface as shown below. (*Note: The file can be saved and stored with any name and location.*)



- Select the location from the **Look-in** drop-down menu where you want to save/store the exported file
- Enter the name of the file that you want to save.
- Click on “**Save**” to carry out the entire process of exporting the selected plant database.
*Note: It may again be noted that users having operating system different than WindowsXP will see different layout of **Save As** dialog box.*

The same file can be sent through Email or other media to other PHAST3.0 Users. Other users can import this file by using the import feature as discussed earlier.

Appendix – A: Units for Conversion

Both unit converters have got following categories of units.

Sr. No.	Units
1.	Temperature
2.	Heat Input Rate - Power
3.	Length
4.	Calorific Value of Gas
5.	Pressure
6.	Volumetric Flow Rate
7.	Mass Flow Rate
8.	Heat of Reaction
9.	Liquid Flow
10.	Area
11.	Specific Heat - Entropy
12.	Electrical Power
13.	Heat Rate
14.	Heating Value of Gas
15.	Calorific Value of Liquid Fuel
16.	Thermal Conductivity
17.	Energy
18.	Density
19.	Mass
20.	Heat Transfer Coefficient
21.	Heat Flux Density
22.	Velocity - Speed
23.	Volume
24.	Heating Value of Electricity

Though both converters are essentially same, unit category is selected automatically based on from where it was invoked.

Appendix – B: Currency and Default Conversion Rate

Country Name	Currency ID	Currency Symbol	Exchange Rate
Australia	Dollar	AUD	0.796
Canada	Dollar	CAD	0.85
China	Yuan	CNY	0.129
European Union	Euro	EUR	1.331
Hong Kong	Dollar	HKD	0.128
India	Rupee	INR	0.022
Indonesia	Rupiah	IDR	0.017
Japan	Yen	JPY	0.009
Malaysia	Ringgit	MYR	0.285
Mexico	Peso	MXN	0.089
New Zealand	Dollar	NZD	0.697
Pakistan	Rupee	PKR	0.017
Philippines	Peso	PHP	0.021
Poland	Zloty	PLN	0.342
Russia	Ruble	RUB	0.038
Saudi Arabia	Riyal	SAR	0.268
South Africa	Rand	ZAR	0.134
South Korea	Won	KRW	0.001
Sweden	Kronor	SEK	0.144
Taiwan	Dollar	TWD	0.03
Thailand	Baht	THB	0.03
Trinidad and Tobago	Dollar	TTD	0.5
Turkey	Lira	TRY	0.7065
United Arab Emirates	Dirham	AED	0.272
United Kingdom	Pound	GBP	1.96
United States	Dollar	USD	1.00
Venezuela	Bolivar	VEB	0.001
Vietnam	Dong	VND	0.017

Appendix – C: Default Energy Sources (Fuel, Electricity, Steam)

Energy Name	Unit	Heating Value unit	Default Heating Value
Electricity	/kWh	kJ/kWh	3600
Natural Gas	/GJ	kJ/m ³	38000
Fuel Oil	/GJ	kJ/l	137000
Coal	/tonne	kJ/kg	14030
Blast Furnace Gas	/GJ	kJ/m ³	90
Coke Oven Gas	/GJ	kJ/m ³	570
Coke	/tonne	kJ/kg	12700
Propane	/GJ	kJ/m ³	2500
Steam	/GJ	kJ/kg	2790

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

Appendix – D: Properties of Default Material/Gas Used for Furnace Analysis

Substance	Density (kg/m ³)	Mean Specific Heat of solid (kJ/(kg °C))	Latent Heat of Fusion kJ/kg	Mean Specific Heat of Liquid (kJ/(kg °C))	Melting Point (Deg. C.)	Average Pouring Temp (Deg. C)	Heat Content of Solid at Melting Point (kJ/kg)	Heat Content of Liquid at Melting Temp (kJ/kg)	Heat Content of Liquid at Pouring Temp (kJ/kg)
SOLID									
Aluminum	2670.53	1.038	393.094	1.089	657.22	748.89	665.236	1058.330	1156.022
Babbitt, lead base	0.00	0.163	60.941	0.159	238.89	329.44	36.751	97.692	111.648
Babbitt, tin base	7401.24	0.297	79.317	0.264	240.00	491.11	66.524	157.470	211.666
Bismuth	9804.24	0.138	43.031	0.147	270.00	326.67	35.123	78.154	86.527
Brass, Muntz metal	8394.48	0.440	160.494	0.523	887.78	1010.00	383.790	544.284	607.086
Brass, red	8746.92	0.435	201.199	0.482	1066.67	1232.22	458.222	659.421	739.203
Brass, yellow	8458.56	0.440	165.146	0.515	920.00	1065.56	397.746	562.892	637.789
Bronze, bearing	8907.12	0.398	185.847	0.456	1000.00	1121.11	391.466	577.313	632.672
Bronze, aluminum	8170.20	0.528	229.344	0.523	1050.00	1204.44	546.610	775.954	855.968
Bronze, bell metal	8650.80	0.419	177.474	0.498	890.00	1037.78	366.112	543.586	617.320
Bronze, gun metal	8811.00	0.448	195.849	0.444	1010.00	1148.89	445.429	641.278	702.452
Bronze, Tobin	8410.50	0.448	170.961	0.519	885.00	1010.00	389.605	560.566	625.461
Carbon Steel	7689.60	0.628	139.560	0.000	1537.78	-17.78	0.000	0.000	0.000
Copper	8955.18	0.435	211.666	0.465	1083.33	1204.44	465.200	676.866	732.690
Die casting metal	2819.52	0.988	379.138	1.009	621.11	760.00	598.480	977.618	1118.806
Die casting metal	2819.52	0.159	40.705	0.155	315.56	437.78	47.683	88.388	339.596
Die casting metal	2819.52	0.293	70.245	0.260	232.22	343.33	64.198	134.443	162.820
Die casting metal	2819.52	0.431	111.648	0.578	415.56	526.67	172.124	283.772	348.900
German silver	2819.52	0.456	200.501	0.515	1010.00	1148.89	451.244	651.745	723.386
Gold	19304.10	0.138	66.291	0.142	1062.78	1176.67	144.677	210.968	227.250
Inconel - 600	7689.60	0.586	0.000	0.000	1371.11	-17.78	0.000	0.000	0.000
Iron, cast, gray	7689.60	0.796	96.296	0.000	1230.00	1537.78	965.290	1060.656	1356.058
Iron, cast, white	7689.60	0.754	140.258	0.000	1150.00	1593.33	855.968	995.528	1423.512
Iron, pig	7689.60	0.641	194.454	0.000	1100.00	1260.00	695.474	893.184	1046.700
Iron, pure	7865.82	0.703	272.142	0.628	1538.89	1704.44	1049.026	1321.168	1456.076
Lead	11342.16	0.134	23.260	0.142	327.22	382.22	41.868	65.128	72.106
Linotype	11214.00	0.151	50.009	0.151	252.22	326.67	35.588	85.597	96.762
Magnesium	1739.77	1.139	194.686	1.114	651.11	748.89	723.851	918.537	1027.394
Manganese	7433.28	0.716	153.516	0.804	1230.00	1315.56	869.924	1023.440	1090.894
Monel metal	8811.00	0.540	273.072	0.582	1323.89	1510.00	707.104	980.176	1088.568
Nickel 60 to 2644 F	8907.12	0.561	305.869	0.557	1451.11	1565.56	804.796	1110.665	1174.630
Silver	10493.10	0.264	108.857	0.293	961.11	1065.56	248.882	357.739	388.442

Process Heating Assessment and Survey Tool (PHAST 3.0) FF: International Units

solder, bismuth	9291.60	0.167	38.146	0.163	111.11	165.56	21.632	59.778	68.617
Solder, plumbers	9291.60	0.214	53.498	0.205	212.22	260.00	41.868	95.366	104.670
Stainless Steel - 300 series	7689.60	0.586	0.000	0.000	1398.89	-17.78	0.000	0.000	0.000
Stainless Steel - 410	7689.60	1.047	111.648	0.000	1537.78	1537.78	1744.500	293.076	330.292
Tin	7289.10	0.289	58.150	0.267	232.22	343.33	62.802	120.952	148.864
Zinc	7128.90	0.448	111.648	0.611	418.89	482.22	180.963	292.611	330.292
LIQUID									
Water - std. atmospheric pressure		4.187	2256.918	1.968	100.00				
Water - 150 psig		4.396	2018.968	2.261	185.00				
Acetic Acid		2.135	404.724	1.675	118.00				
Acetone		1.453	555.914	1.675	54.44				
Alcohol- ethyl		2.713	858.294	1.884	77.78				
Alcohol - methyl		2.516	1118.806	1.382	66.11				
Benzene		1.771	395.420	1.382	80.00				
Bromine		0.448	190.732	0.230	61.11				
Carbon tetrachloride		0.900	194.221	1.047	76.67				
Fuel oil no. 2 (average)		2.387	244.230	2.303	190.56				
Fuel oil no. 6 (average)		2.428	251.208	2.303	315.56				
Kerosene		2.387	604.760	2.596	126.67				
Methanol		2.512	1093.220	2.512	64.44				
GAS									
Water vapor - near atm. pressure		1.968							
Steam - 50 psig, 400 Degree F.		2.052							
Steam - 150 psig, 500 Degree F.		2.135							
Steam - 600 psig, 700 Degree F.		2.470							
Air - low pressure		1.026							
Nitrogen - low pressure		1.047							
Oxygen - low pressure		0.963							
Carbon dioxide - low pressure		1.005							
Carbon monoxide - low pressure		1.047							
Hydrogen - low pressure		14.445							