

WOODHEAD PUBLISHING SERIES IN MATERIALS



European Federation of
Corrosion Publications
Number 72

CORROSION MANAGEMENT OF SEAWATER COOLING SYSTEMS

Edited by

FRANCOIS ROPITAL, VALERIE BOUR-BEUCLER
AND ANTOINE SURBLED

(On behalf of EFC WP15 Corrosion in refinery and
petrochemistry industries and WP9 Corrosion in sea water)



Corrosion Management of Seawater Cooling Systems

This page intentionally left blank

European Federation of Corrosion Publications
Number 72

Corrosion Management of Seawater Cooling Systems

Edited by

Francois Ropital

Valerie Bour-Beucler

Antoine Surbled



WP
WOODHEAD
PUBLISHING
An imprint of Elsevier



Published by Woodhead Publishing Limited on behalf of the European Federation of Corrosion

Woodhead Publishing is an imprint of Elsevier

50 Hampshire Street, 5th Floor, Cambridge, MA 02139, United States
125 London Wall, London EC2Y 5AS, United Kingdom

Copyright © 2024 European Federation of Corrosion Published by Elsevier Ltd. All rights are reserved, including those for text and data mining, AI training, and similar technologies.

Publisher's note: Elsevier takes a neutral position with respect to territorial disputes or jurisdictional claims in its published content, including in maps and institutional affiliations.

No part of this publication may be reproduced or transmitted in any form or by any means, electronic or mechanical, including photocopying, recording, or any information storage and retrieval system, without permission in writing from the publisher. Details on how to seek permission, further information about the Publisher's permissions policies and our arrangements with organizations such as the Copyright Clearance Center and the Copyright Licensing Agency, can be found at our website: www.elsevier.com/permissions.

This book and the individual contributions contained in it are protected under copyright by the Publisher (other than as may be noted herein).

Notices

Knowledge and best practice in this field are constantly changing. As new research and experience broaden our understanding, changes in research methods, professional practices, or medical treatment may become necessary.

Practitioners and researchers must always rely on their own experience and knowledge in evaluating and using any information, methods, compounds, or experiments described herein. In using such information or methods they should be mindful of their own safety and the safety of others, including parties for whom they have a professional responsibility.

To the fullest extent of the law, neither the Publisher nor the authors, contributors, or editors, assume any liability for any injury and/or damage to persons or property as a matter of products liability, negligence or otherwise, or from any use or operation of any methods, products, instructions, or ideas contained in the material herein.

ISBN: 978-0-443-15235-1 (print)

ISBN: 978-0-443-15236-8 (online)

For information on all Woodhead Publishing publications
visit our website at <https://www.elsevier.com/books-and-journals>

Publisher: Matthew Deans

Acquisitions Editor: Gwen Jones

Editorial Project Manager: Emily Thomson

Production Project Manager: Anitha Sivaraj

Cover Designer: Matthew Limbert

Typeset by MPS Limited, Chennai, India



Contents

List of contributors	ix
European Federation of Corrosion publications: Series introduction	xi
Volumes in the EFC Series List	xiii
1 Introduction	1
2 Main seawater heat exchanger systems	3
<i>Valerie Bour-Beucler</i>	
2.1 Introduction	3
2.2 Notions of heat transfer	3
2.3 Shell and tube heat exchangers	4
2.4 Surface steam condensers	9
2.5 Seawater desalination heaters and evaporators	11
2.6 Open racks vaporizers	14
2.7 Plate and frame heat exchangers	14
2.8 Troubleshooting	19
References	20
3 Seawater environment: aggressivity, living organisms, deposits and scale formation, pretreatment	23
<i>Valerie Bour-Beucler</i>	
3.1 Seawater composition	23
3.2 Physical factors	28
3.3 Difference between freshwater and seawater for cooling water systems	31
References	34
4 Different forms of corrosion in seawater heat exchanger systems	35
<i>Valerie Bour-Beucler</i>	
4.1 Introduction	35
4.2 Uniform or “general corrosion”	36
4.3 Pitting corrosion	36
4.4 Galvanic corrosion	36
4.5 Crevice corrosion	38
4.6 Intergranular corrosion	39
4.7 Selective corrosion	39
4.8 Corrosion—erosion or impingement attack	40
4.9 Stress corrosion cracking	40

4.10	Corrosion fatigue	41
4.11	Microbiologically induced corrosion	42
	References	43
5	Seawater fouling and biofouling	45
	<i>Valerie Bour-Beucler</i>	
5.1	Seawater heat exchanger fouling control	45
5.2	Seawater biofouling control	45
5.3	Seawater biocide treatment for cooling systems	46
5.4	Macrofouling control	49
	References	51
6	Corrosion and scale inhibitors in seawater heat exchangers	53
	<i>Philippe Blériot</i>	
6.1	Main deposits in seawater heat exchangers: once-through and recirculated systems	53
6.2	Main antiscalants	53
6.3	Corrosion inhibitors	59
6.4	Adapting the treatment to the type of cooling system	64
6.5	Selected lectures	65
	References	66
7	Materials selection	67
	<i>Antoine Surbled, Nicolas Larché and Dominique Thierry</i>	
7.1	Carbon steels	67
7.2	Stainless steels	71
7.3	Nickel and nickel-based alloys	85
7.4	Copper and copper alloys	88
7.5	Aluminum alloys	99
7.6	Titanium commercially pure and titanium alloys	113
	References	123
8	Corrosion protection	129
	<i>Jianzhong Zhang, Antoine Surbled, Dominique Thierry and Nicolas Larché</i>	
8.1	Introduction	129
8.2	Principles of corrosion protection for seawater heat exchangers	130
8.3	Material selection to avoid galvanic corrosion	130
8.4	Coating protection	131
8.5	Cathodic protection systems	138
	References	142
9	Commissioning, operation cleaning and maintenance	145
	<i>Valerie Bour-Beucler</i>	
9.1	Introduction	145
9.2	Preparation of exchangers	145

9.3	Commissioning	145
9.4	Operations	147
9.5	Maintenance	154
	References	161
10	Seawater heat exchangers' monitoring and inspection	163
	<i>Antoine Surbled</i>	
10.1	Introduction	163
10.2	Heat exchangers' reliability, maintainability, availability, and integrity	163
10.3	Data gathering, data processing, cloud technologies for monitoring	164
10.4	Monitoring	168
10.5	Inspection	188
	Acronyms	214
	Symbols	216
	References	217
	Index	225

This page intentionally left blank

List of contributors

Valerie Bour-Beucler NALCO Water, An Ecolab Company, Downstream Division, 1 rue de l'Espoir, Lezennes, France

Philippe Blériot Cefracor, an EFC member, Bordeaux, France

Nicolas Larché Institut de la Corrosion (French Corrosion Institute), Brest, France

Antoine Surbled Surbled Antoine Consulting, Paris, France

Dominique Thierry RISE Research Institutes of Sweden, Stockholm, Sweden

Jianzhong Zhang SABIC UK Petrochemicals Ltd., Redcar, United Kingdom

This page intentionally left blank

European Federation of Corrosion publications: Series introduction

The European Federation of Corrosion (EFC), founded in 1955, is a federation of 40 organizations with interests in corrosion and is based in 20 different countries throughout Europe and beyond. Its member societies represent the corrosion interests of more than 25,000 engineers, scientists, and technicians. The aim of this Federation is to advance the science of the corrosion and protection of materials by promoting cooperation in Europe and collaboration internationally. Aside from national and international corrosion societies, universities, research centers, and companies can also become Affiliate Members of the EFC.

The administration of the Federation is in the hands of the Board of Administrators (BoA), chaired by the EFC President, and the scientific and technical affairs are the responsibility of the Science and Technology Advisory Committee (STAC), chaired by the STAC Chairman and assisted by the Scientific Secretary. The General Assembly approves any EFC policy prepared and presented by the BoA. The Federation is managed through its General Secretariat with three shared headquarters located in London, Paris, and Frankfurt.

The EFC carries out its most important activities through its more than 20 active working parties devoted to various aspects of corrosion and its prevention, covering a large range of topics including corrosion and scale inhibition, corrosion by hot gases and combustion products, nuclear corrosion, environment sensitive fracture, surface science and mechanisms of corrosion and protection, physicochemical methods of corrosion testing, corrosion education, marine corrosion, microbial corrosion, corrosion of steel in concrete, corrosion in oil and gas production, coatings, corrosion in the refinery industry, cathodic protection, automotive corrosion, tribo-corrosion, corrosion of polymer materials, corrosion and corrosion protection of drinking water systems, and corrosion of archaeological and historical artifacts. The EFC is always open to formulating new working parties in response to the demands brought about by developing technologies and their ensuing corrosion requirements and applications.

The European Federation of Corrosion's flagship event is EUROCORR, the most important Corrosion Congresses in Europe, which is held annually in a different European country in September of each year. To date, 27 EUROCORR conferences have taken place in 12 different countries and they have gained a reputation for their high technical quality, global perspective, and enjoyable social program. Another channel for the EFC's valuable transfer of knowledge is the EFC "Green" Book Series which are the fruit of the collaboration and high scientific caliber

within and amongst the EFC working party members and are emblematic of the EFC editorial policy.

EFC offices are located at:

European Federation of Corrosion, Institute of Materials, Minerals and Mining,
1 Carlton House Terrace, London SW1Y 5DB, United Kingdom

Federation Européenne de la Corrosion, Fédération Française pour les sciences de
la Chimie, 28 rue Saint-Dominique, F-75007 Paris, France

Europäische Föderation Korrosion, DECHEMA e.V., Theodor-Heuss-Allee 25,
D-60486 Frankfurt-am-Main, Germany

Volumes in the EFC Series List

1. Corrosion in the nuclear industry
Prepared by Working Party 4 on Nuclear Corrosion
2. Practical corrosion principles
Prepared by Working Party 7 on Corrosion Education (out of print)
3. General guidelines for corrosion testing of materials for marine applications
Prepared by Working Party 9 on Marine Corrosion
4. Guidelines on electrochemical corrosion measurements
Prepared by Working Party 8 on Physico-Chemical Methods of Corrosion Testing
5. Illustrated case histories of marine corrosion
Prepared by Working Party 9 on Marine Corrosion
6. Corrosion education manual
Prepared by Working Party 7 on Corrosion Education
7. Corrosion problems related to nuclear waste disposal
Prepared by Working Party 4 on Nuclear Corrosion
8. Microbial corrosion
Prepared by Working Party 10 on Microbial Corrosion
9. Microbiological degradation of materials and methods of protection
Prepared by Working Party 10 on Microbial Corrosion
10. Marine corrosion of stainless steels: chlorination and microbial effects
Prepared by Working Party 9 on Marine Corrosion
11. Corrosion inhibitors
Prepared by the Working Party on Inhibitors (out of print)
12. Modifications of passive films
Prepared by Working Party 6 on Surface Science
13. Predicting CO₂ corrosion in the oil and gas industry
Prepared by Working Party 13 on Corrosion in Oil and Gas Production (out of print)
14. Guidelines for methods of testing and research in high temperature corrosion
Prepared by Working Party 3 on Corrosion by Hot Gases and Combustion Products
15. Microbial corrosion: Proceedings of the 3rd International EFC Workshop
Prepared by Working Party 10 on Microbial Corrosion
16. Guidelines on materials requirements for carbon and low alloy steels for H₂S-containing environments in oil and gas production
Prepared by Working Party 13 on Corrosion in Oil and Gas Production
17. Corrosion resistant alloys for oil and gas production: guidance on general requirements and test methods for H₂S service
Prepared by Working Party 13 on Corrosion in Oil and Gas Production
18. Stainless steel in concrete: state of the art report
Prepared by Working Party 11 on Corrosion of Steel in Concrete
19. Sea water corrosion of stainless steels: mechanisms and experiences
Prepared by Working Party 9 on Marine Corrosion and Working Party 10 on Microbial Corrosion

20. Organic and inorganic coatings for corrosion prevention: research and experiences
Papers from EUROCORR '96
21. Corrosion–deformation interactions
CDI '96 in conjunction with EUROCORR '96
22. Aspects of microbially induced corrosion
Papers from EUROCORR '96 and EFC Working Party 10 on Microbial Corrosion
23. CO₂ corrosion control in oil and gas production: design considerations
Prepared by Working Party 13 on Corrosion in Oil and Gas Production
24. Electrochemical rehabilitation methods for reinforced concrete structures: a state of the art report
Prepared by Working Party 11 on Corrosion of Steel in Concrete
25. Corrosion of reinforcement in concrete: monitoring, prevention and rehabilitation
Papers from EUROCORR '97
26. Advances in corrosion control and materials in oil and gas production
Papers from EUROCORR '97 and EUROCORR '98
27. Cyclic oxidation of high temperature materials
Proceedings of an EFC Workshop, Frankfurt/Main, 1999
28. Electrochemical approach to selected corrosion and corrosion control
Papers from the 50th ISE Meeting, Pavia, 1999
29. Microbial corrosion: proceedings of the 4th International EFC Workshop
Prepared by the Working Party on Microbial Corrosion
30. Survey of literature on crevice corrosion (1979–1998): mechanisms, test methods and results, practical experience, protective measures and monitoring
Prepared by F. P. Ijsseling and Working Party 9 on Marine Corrosion
31. Corrosion of reinforcement in concrete: corrosion mechanisms and corrosion protection
Papers from EUROCORR '99 and Working Party 11 on Corrosion of Steel in Concrete
32. Guidelines for the compilation of corrosion cost data and for the calculation of the life cycle cost of corrosion: a working party report
Prepared by Working Party 13 on Corrosion in Oil and Gas Production
33. Marine corrosion of stainless steels: testing, selection, experience, protection and monitoring
Edited by D. Féron on behalf of Working Party 9 on Marine Corrosion
34. Lifetime modelling of high temperature corrosion processes
Proceedings of an EFC Workshop 2001
Edited by M. Schuëtz, W. J. Quadackers and J. R. Nicholls
35. Corrosion inhibitors for steel in concrete
Prepared by B. Elsener with support from a Task Group of Working Party 11 on Corrosion of Steel in Concrete
36. Prediction of long term corrosion behaviour in nuclear waste systems
Edited by D. Féron on behalf of Working Party 4 on Nuclear Corrosion
37. Test methods for assessing the susceptibility of prestressing steels to hydrogen induced stress corrosion cracking
By B. Isecke on behalf of Working Party 11 on Corrosion of Steel in Concrete
38. Corrosion of reinforcement in concrete: mechanisms, monitoring, inhibitors and rehabilitation techniques
Edited by M. Raupach, B. Elsener, R. Polder and J. Mietz on behalf of Working Party 11 on Corrosion of Steel in Concrete

-
39. The use of corrosion inhibitors in oil and gas production
Edited by J. W. Palmer, W. Hedges and J. L. Dawson on behalf of Working Party 13 on Corrosion in Oil and Gas Production
 40. Control of corrosion in cooling waters
Edited by J. D. Harston and F. Ropital on behalf of Working Party 15 on Corrosion in the Refinery Industry
 41. Metal dusting, carburisation and nitridation
Edited by H. Grabke and M. Schütze on behalf of Working Party 3 on Corrosion by Hot Gases and Combustion Products
 42. Corrosion in refineries
Edited by J. D. Harston and F. Ropital on behalf of Working Party 15 on Corrosion in the Refinery Industry
 43. The electrochemistry and characteristics of embeddable reference electrodes for concrete
Prepared by R. Myrdal on behalf of Working Party 11 on Corrosion of Steel in Concrete
 44. The use of electrochemical scanning tunnelling microscopy (EC-STM) in corrosion analysis: reference material and procedural guidelines
Prepared by R. Lindström, V. Maurice, L. Klein and P. Marcus on of Working Party 6 on Surface Science
 45. Local probe techniques for corrosion research
Edited by R. Oltra on behalf of Working Party 8 on Physico-Chemical Methods of Corrosion Testing
 46. Van roij, Corrosion in Amine Treating Units, second edition
Prepared by working party 15 and 13 on corrosion in the refinery and petrochemical industry
 47. Novel approaches to the improvement of high temperature corrosion resistance
Edited by M. Schütze and W. Quadackers on behalf of Working Party 3 on Corrosion by Hot Gases and Combustion Products
 48. Corrosion of metallic heritage artefacts: investigation, conservation and prediction of long term behaviour
Edited by P. Dillmann, G. Béranger, P. Piccardo and H. Matthiesen on behalf of Working Party 4 on Nuclear Corrosion
 49. Electrochemistry in light water reactors: reference electrodes, measurement, corrosion and tribocorrosion
Edited by R.-W. Bosch, D. Féron and J.-P. Celis on behalf of Working Party 4 on Nuclear Corrosion
 50. Corrosion behaviour and protection of copper and aluminium alloys in seawater
Edited by D. Féron on behalf of Working Party 9 on Marine Corrosion
 51. Corrosion issues in light water reactors: stress corrosion cracking
Edited by D. Féron and J-M. Olive on behalf of Working Party 4 on Nuclear Corrosion
 52. Progress in corrosion: the first 50 years of the EFC
Edited by P. McIntyre and J. Vogelsang
 53. Standardisation of thermal cycling exposure testing
Edited by M. Schütze and M. Malessa on behalf of Working Party 3 on Corrosion by Hot Gases and Combustion Products
 54. Innovative pre-treatment techniques to prevent corrosion of metallic surfaces
Edited by L. Fedrizzi, H. Terryn and A. Simões on behalf of Working Party 14 on Coatings

55. De Landtsheer, Corrosion under insulation (CUI) guidelines, third edition: technical guide for managing CUI
Prepared by working party 15 on corrosion in the refinery and petrochemical industry
56. Corrosion monitoring in nuclear systems
Edited by S. Ritter and A. Molander on behalf of Working Party 4 on Nuclear Corrosion
57. Protective systems for high temperature applications
Edited by M. Schütze on behalf of Working Party 3 on Corrosion by Hot Gases and Combustion Products
58. Self-healing properties of new surface treatments
Edited by L. Fedrizzi, W. Fürbeth and F. Montemor on behalf of Working Party 14 on Coatings
59. Sulphur-assisted corrosion in nuclear disposal systems
Edited by F. Druyts, D. Féron and B. Kursten on behalf of Working Party 4 on Nuclear Corrosion
60. Methodology of crevice corrosion testing for stainless steels in natural and treated seawaters
Edited by U. Kivisäkk, B. Espelid and D. Féron on behalf of Working Party 9 on Marine Corrosion
61. Inter-laboratory study on electrochemical methods for the characterisation of CoCrMo biomedical alloys in simulated body fluids
Edited by A. Munoz and S. Mischler on behalf of Working Party 18 on Tribo-Corrosion
62. Testing tribo-corrosion of passivating materials
Edited by J-P. Celis and P. Ponthiaux on behalf of Working Party 18 on Tribo-Corrosion
63. The corrosion performance of metals for the marine environment
Edited by R. Francis and C. Powell on behalf of Working Party 9 on Marine Corrosion
64. Recommended practices for corrosion management of pipelines
Edited by B. Kermani and C. Chevrot on behalf of Working Party 13 on Corrosion in Oil and Gas Production
65. Corrosion and conservation of cultural heritage metallic artefacts
Edited by P. Dillmann, D. Watkinson, E. Angelini and A. Adriaens on behalf of Working Party 21 on Corrosion of Archaeological and Historical Artefacts
66. Understanding Biocorrosion: Fundamentals and Applications
Edited by T. Liengen, D. Féron, R. Basse guy and I. B. Beech on behalf of Working Party 10 on Microbial Corrosion
67. Stress Corrosion Cracking of Nickel Based Alloys in Water-Cooled Nuclear Reactors
Edited by D. Féron and R. Staehle on behalf of Working Party 4 on Nuclear Corrosion
68. Engineering Tools for Corrosion: Design and Diagnosis
Prepared by L. Lazzari
69. Ritter, Nuclear Corrosion: Research, Progress, and Challenges, prepared by working party 4 on Nuclear Corrosion
70. Ponthiaux and Celis: Mechanical and Electro-chemical interactions under tribocorrosion: From measurements to modelling for building a relevant monitoring approach, edited by working party 18 on Tribocorrosion
71. Corrosion Modelling with Cellular Automata, edited by Damien Feron and Di Caprio Dung

Seawater is considered an attractive resource for utilities in many industries such as power plants, refineries, and chemical plants. Seawater cooling systems are used in heat exchangers, for once-through cooling water systems, or for recirculating cooling water systems. The metallurgy and materials used for these facilities need to be compatible with seawater and allow good corrosion control.

The evolution of practices in terms of sustainability, materials choice, treatment selection and changes to regulations have demonstrated the need to establish this new guide on recommended best practices to support the corrosion management and development of seawater heat exchangers.

Corrosion Management of Seawater Cooling Systems provides an overview of the main seawater heat exchanger systems; different forms of corrosion; biocide treatments, corrosion, and inhibitors; and the materials used, coatings and cathodic protection and maintenance, and monitoring and control.

The book will be a valuable reference resource for academics, technicians, and engineers who are interested in the corrosion management of seawater cooling systems.

Key Features

- Covers key technological developments in corrosion management of seawater cooling systems
- Covers seawater heat exchangers
- Presentation of different forms of corrosion
- Covers selection of materials, corrosion protections (inhibitors, coatings, cathodic protection)
- Covers maintenance, control, monitoring, and inspection

About the Editors

Francois Ropital works at IFP Énergies nouvelles on the behavior of materials for energy technologies within the Applied Physico-Chemistry and Mechanics Department and is an associate professor (PAST) at INSA-Lyon, in the Department of Materials Science and Engineering. He is also past chairman of the Working Party 15 *Corrosion in Refinery and Petrochemistry*, the European Federation of Corrosion (EFC).

Valerie Bour-Beucler works as a senior industry technical consultant (Technical Headquarters) in the Energy Services Division in Nalco Water and is an associate professor at IFP School (ENEP). She is also the chairman of the Working Party *Corrosion Inhibitors of CEFRACOR and Petrochemistry*, the European Federation of Corrosion (EFC).

Antoine Surbled is a consultant in materials and corrosion sciences and technology and works on several projects in the domain of energy technologies. He is a member of CEFRACOR, active in commission Corrosion in Energy and Process Industries and a member of the Working Party 15 *Corrosion in Refinery and Petrochemistry*, the European Federation of Corrosion (EFC).

*Published for the European Federation of Corrosion by Woodhead Publishing,
an imprint of Elsevier S&T Books*



WP

WOODHEAD
PUBLISHING

An imprint of Elsevier • elsevier.com

ISBN 978-0-443-15235-1



9 780443 152351