



**Steam boiler – SG model
n.1 x 6 ton/h @10 bar(g)**

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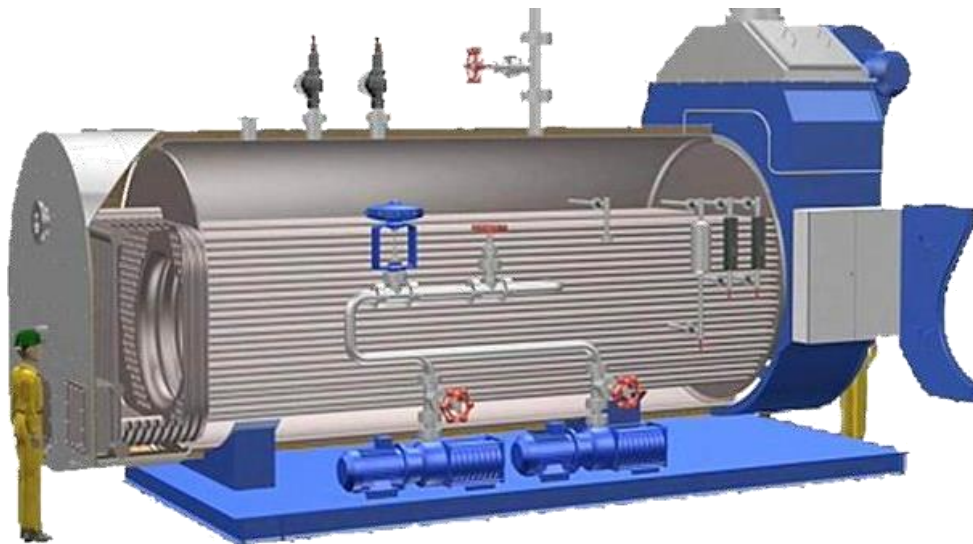
1 TECHICAL HIGHLIGHTS AND SPECIFICATION

1.1 INTRODUCTION TO SG FIRE TUBE STEAM BOILERS

The unique structure of SG boilers is the product of more than 50 years of experience in fire tube and water tube generators, extensively tested with thousands of references around the world.



The SG structure is composed of a strong body with a water tube inversion chamber at the back (membrane type), as shown in the image below.



While ensuring equal, or higher efficiency than traditional three pass boilers, this design provides the following advantages.

A. Easy accessibility to all internal parts of the boiler

In our design, all the internal parts of the boiler are easily accessed from the front doors and the back inspection door, without burner dis-assembly, to allow inspection, cleaning, and repairs. In three pass designs, it is very difficult for the operator to enter the rear gases box, because of the very limited available space. With this design, SG boilers significantly reduce down-time for inspection, cleaning, and maintenance.



SG DESIGN

B. Absence of refractory material on the back

The fumes inversion chamber at the back has no refractory material thanks to the water tube membrane. This solution avoids all problems related to refractory material such as cracking, heat inertias, heat losses etc. The only refractory material used in the SG is the burner tile.

C. Large furnace diameter

In design the furnace diameter is larger compared to three pass boilers, where space is occupied by the third pass tubes bank. This increases the internal flue gas re-circulation (IFGR), decreasing NOx emissions.

D. Robust structure for heavy duty operation

The structure of the boiler does not require the anchoring rods found in three pass boilers. These components may be subject to mechanical thermal stress during working conditions.

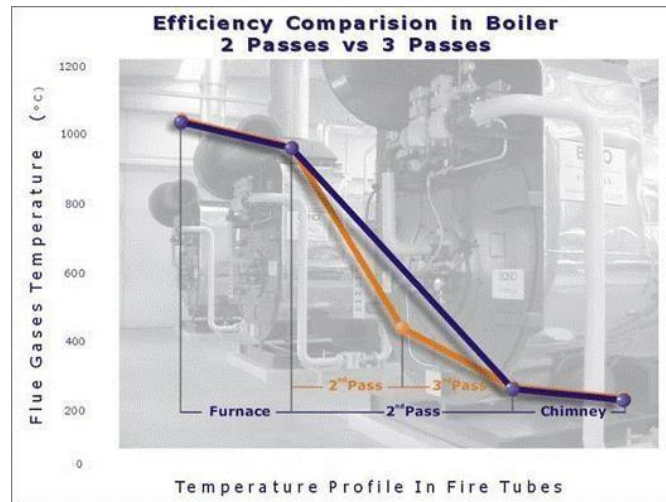


SG DESIGN

A. Optimized heat exchange

In the three-pass design, most of the exchange occurs in the furnace and the second pass, while the third pass has a very limited heat transfer.

The SG design ensures the same or higher efficiency levels optimizing the heat exchange in the boiler and in the water tube membrane.



B. Integrated heat recovery systems

In the SG design, the flue gas exit is placed on the same side of the burner and the air fan. This means that heat recovery systems of different kinds can be easily integrated on the front side of the boiler in a compact design (economizers and air pre-heaters in series). This increases the combined effectiveness of the systems while reducing overall dimensions.



1.2 HE-SMART® HEAT RECOVERY SYSTEM (OPTIONAL)

The structure of the SG boiler allows the integration of both air and water pre-heating system on the burner side.

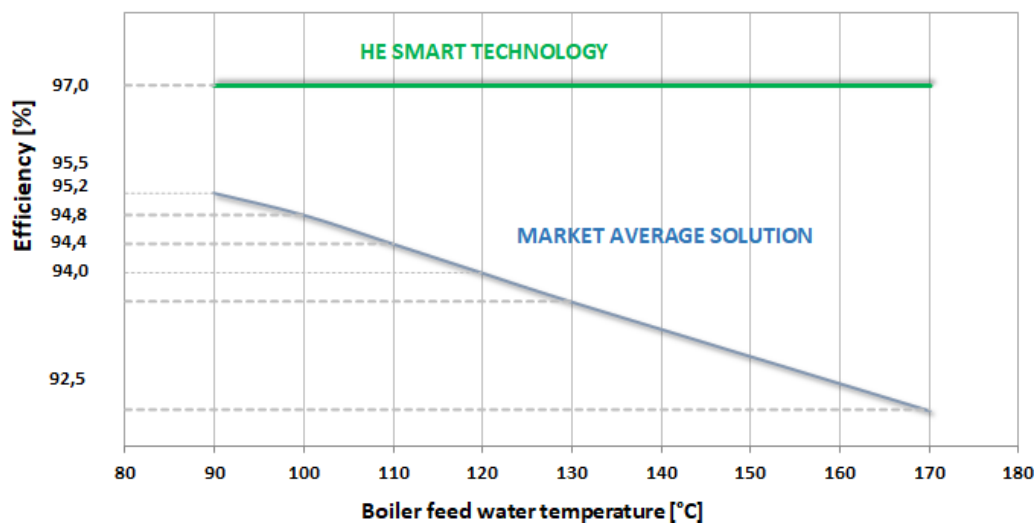
An economizer can be installed inside the flue gas box of the on front of the boiler. The economizer is the most common recovery system for

natural gas working boiler and increase the efficiency using the power still available in the flue gas after the tubes thermal exchanges to heat up the water inlet temperature. BONO uses finned type tubes Economizer, with high heating surface to achieve the best efficiency with this technology. Optispark system manage the burner and the water pump always taking in account the efficiency real value to keep it at the best operation value.

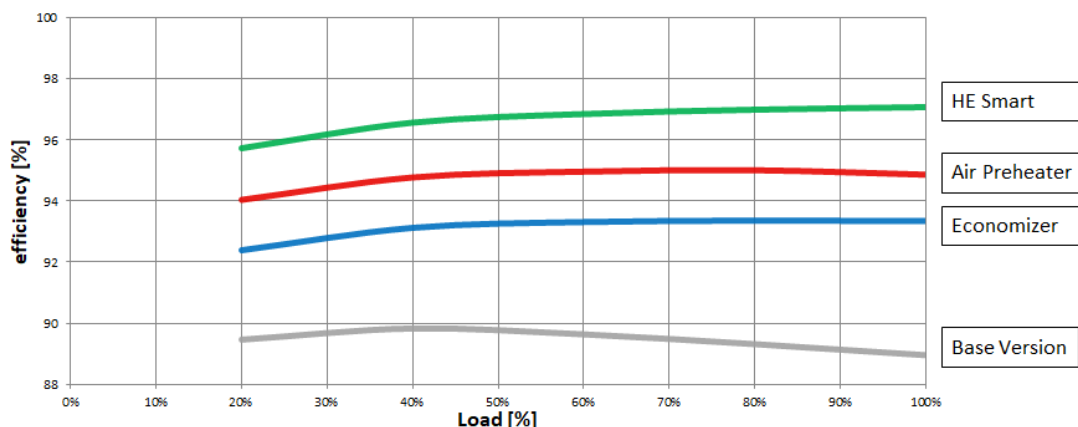
The heat recovery system is pushed up with the HE Smart concept, composed of 2 economizers and 1 air pre-heater. The system is equipped with 3-way valves to balance the system at every load and keeping the efficiency at the best value (**up to 97.5%**) without flue gas acid condensation even with high-temperature feedwater.



Efficiency linked to feed water temperature



Thermal efficiency VS load with @ 150°C feed water temperature
4 different fire tube boiler configurations HE-SMART vs Air-Preheater vs ECO vs basic



Ecodesign Preparatory Study on Steam Boilers (ENTR Lot 7)

Presented by

PricewaterhouseCoopers EEIG's consortium
in cooperation with Fraunhofer ISI and ICCS-NTUA

to
European Commission
Directorate General for Enterprise and Industry
Unit B.1 – Sustainable Industrial Policy

www.eco-steamboilers.eu



The study “Ecodesign Preparatory Study on Steam Boilers (ENTR Lot 7)” states that:

The investment cost of a steam generator for industrial application is equivalent to about 1% of the cost of natural gas necessary to run it through its useful life, estimated equal to 15 years.



1.3 OUR SOLUTIONS FOR EFFICIENCY



Load sharing System: between boilers with common manifold for steam (up to 4)

Inverter on motors: to reduce electrical consumption and noise level. (Electrical consumption reduced up to 40%)

Heat recovery systems: to increase boiler thermal efficiency up to 97,5 % with HE-Smart system

Combustion Control: to reduce fuel consumption and emissions (CO, NOx)

Tele-service: analysis of boiler functioning with optimization of parameters directly from Bono factory.

1.4 OPTISUPPORT (OPTIONAL)

OPTISupport is a service offered by Cannon Bono, to guarantee the **best technical assistance** to the customer.

REMOTE technical support service

technical expertise of a specialized Cannon Bono technician, always by your side to advise and support you + **optisupport** + authorized personnel on site

- ✓ Immediate analysis of problems
- ✓ Reduction of machine downtime
- ✓ Possibility to solve the problem **by saving an inspection on site**
- ✓ Real-time sharing of audio, video, photos, documents and annotations in **augmented reality**
- ✓ Increase of reliability and availability of the machine



If necessary:

Technical support ON SITE



- Programmed Periodical Maintenance (PPM)
- Required Maintenance Activities (RMA)

And:

- Training for technical staff
- Spare Parts management consultancy

2 INTRODUCTION

2.1 DESIGN DATA

This quotation is based on the following data:

Country of destination	Greece
Electrical data	400/230 V - 50 Hz - 3 phase
Area of installation	Indoors, boiler room, free of frost, dust, and sand.
Area classification	Safe area
Elevation	< 600 m.a.s.l.
Type of fluid	Saturated steam
Max capacity required	6.000 kg/h
Design pressure	12,0 bar _g
Max Operating pressure	10,5 bar _g
Fuel	Heavy Fuel Oil (HFO) Viscosity < 50 °E a 50 °C Pressure at battery limit > 1 bar Sulfur content < 2,5%
Feed water quality	According to EN 12953:10
Boiler feed water temperature (mix between make-up water + condensate)	95 °C <i>*to be confirmed</i>

3 STANDARD AND CODES

Pressure parts design, calculation and construction	VSG / EN12953
Pressure parts certification	PED (2014/68/EU)
Electrical equipment	CEI – IEC
Ladders, walkways, supporting structure	EN 14122
Electrical protection degree	IP 54 – IP 55
Alarms sequence	ISA
Electrical protection	Standard, Non-hazardous area
Liquid fuel and BMS	EN 267

4 TECHNICAL SPECIFICATION

4.1 STEAM BOILER DATASHEET

DIMENSIONAL DATA

		SG 600
Length (with burner)	mm	6.310
Width (with accessories)	mm	2.860
Height (basic version)	mm	2.600
Stack diameter (i)	mm	500
Empty weight	tonn	11,7

FUNCTIONAL DATA

Design pressure	bar _g	12,0
Maximum operating pressure	bar _g	10,5
Steam quality	%	> 99,5
Feed water temperature <i>*to be confirmed</i>	°C	95
Steam production capacity	kg/h	6.000
Heat transferred to steam	MW	4,0
Thermal Efficiency (basic version) @100%	%	89,0 ± 0,5
Thermal Efficiency (ECO version) @100%	%	93,5 ± 0,5
Combustion air fan installed power	kW	15,0
Pump flow rate (each)	m ³ /h	7,0
Pump static pressure (each)	mcl	150
Pump installed power	kW	5,5

Thermal efficiency and steam production capacity are calculated according to EN 12953-11 "indirect method".

4.2 FEED WATER QUALITY SPECIFICATION

A proper feed water treatment system is mandatory for the issuing and validity of the manufacturer's guarantee. Therefore, it is necessary to carry out a complete analysis of the raw feed water, to select the correct water treatment system. Equally important is the periodic analysis of feed water and boiler water.

If the water treatment is not carried out properly, elements dissolved in the water such as calcium, magnesium or silica can deposit on the iron surfaces of the coil at higher temperatures, causing incrustations and blocking the pipes. In addition, if the feed water is rich in oxygen, the iron in contact with the water will suffer corrosion, leading to holes in the coil. The table below shows the limits values for boiler feed water according to EN 12952-12 and EN 12953-10. In order to maintain the values shown, it is necessary to use water conditioners in addition to water treatment units.

Table 4-1

Parameter	Unit	Feedwater for steam boilers		Make-up water for hot water boilers
Operating pressure	bar (= 0,1 MPa)	> 0,5 to 20	> 20	total range
Appearance	—	clear, free from suspended solids		
Direct conductivity at 25 °C	µS/cm	not specified, only guide values relevant for boiler water see table 5-2		
pH value at 25 °C ^a	—	> 9,2 ^b	> 9,2 ^b	> 7,0
Total hardness (Ca + Mg)	mmol/l	< 0,01 ^c	< 0,01	< 0,05
Iron (Fe) concentration	mg/l	< 0,3	< 0,1	< 0,2
Copper (Cu) concentration	mg/l	< 0,05	< 0,03	< 0,1
Silica (SiO ₂) concentration	mg/l	not specified, only guide values for boiler water relevant, see table 5-2		—
Oxygen (O ₂) concentration	mg/l	< 0,05 ^d	< 0,02	—
Oil/grease concentration (see EN 12953-6)	mg/l	< 1	< 1	< 1
Organic substances (as TOC) concentration	—	see footnote ^e		

^a With copper alloys in the system the pH value shall be maintained in the range 8,7 to 9,2.

^b With softened water pH value > 7,0 the pH value of boiler water according to table 5-2 should be considered.

^c At operating pressure < 1 bar total hardness max. 0,05 mmol/l shall be acceptable.

^d Instead of observing this value at intermittent operation or operation without deaerator if film forming agents and/or excess of oxygen scavenger shall be used.

^e Organic substances are generally a mixture of several different compounds. The composition of such mixtures and the behaviour of their individual components under the conditions of boiler operation are difficult to predict. Organic substances may be decomposed to form carbonic acid or other acidic decomposition products which increase the acid conductivity and cause corrosion or deposits. They also may lead to foaming and/or priming which shall be kept as low as possible.

Table 4-2

Parameter	Unit	Boiler water for steam boilers using			Boiler water for hot water boilers
		Feedwater direct conductivity > 30 $\mu\text{S/cm}$	Feedwater direct conductivity $\leq 30 \mu\text{S/cm}$		
Operating pressure	bar (= 0,1MPa)	> 0,5 to 20	> 20	> 0,5	total range
Appearance	—	clear, no stable foam			
Direct conductivity at 25 °C	$\mu\text{S/cm}$	< 6 000 ^a	see Figure 5-1 ^a	< 1 500	< 1 500
pH value at 25 °C	—	10,5 to 12,0	10,5 to 11,8	10,0 to 11,0 ^{b, c}	9,0 to 11,5 ^d
Composite alkalinity	mmol/l	1 to 15 ^a	1 to 10 ^a	0,1 to 1,0 ^c	< 5
Silica (SiO ₂) concentration	mg/l	pressure dependent, according to figure 5-2			—
Phosphate (PO ₄) ^e	mg/l	10 to 30	10 to 30	6 to 15	—
Organic substances	—	see footnote ^f			—

^a With superheater consider 50 % of the indicated upper value as maximum value,
^b Basic pH adjustment by injecting Na₃PO₄, additional NaOH injection only if the pH value is < 10.
^c If the acid conductivity of the boiler feedwater is < 0,2 $\mu\text{S/cm}$, and its Na + K concentration is < 0,010 mg/l, phosphate injection is not necessary. Under the conditions AVT (all volatile treatment, feedwater pH $\geq 9,2$ and boiler water pH $\geq 8,0$) can be applied, in this case the acid conductivity of the boiler water is < 5 $\mu\text{S/cm}$.
^d If non-ferrous materials are present in the system, e. g. aluminium, they may require lower pH value and direct conductivity, however, the protection of the boiler has priority.
^e If coordinated phosphate treatment is used; considering all other values higher PO₄-concentrations are acceptable (see also clause 4).
^f See ^e in table 5-1.

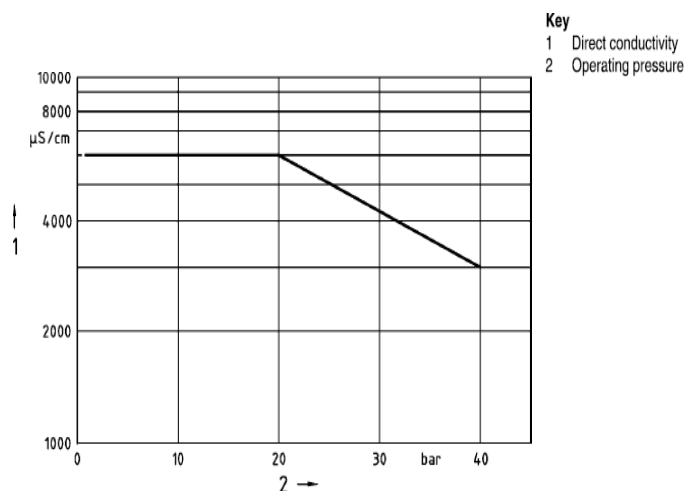


Figure 4-1: Maximum acceptable direct conductivity of the boiler water depending on pressure; feed water direct conductivity

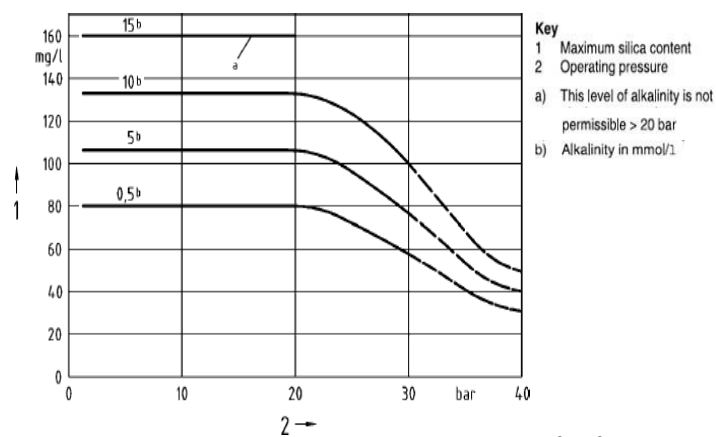


Figure 4-2: Maximum acceptable silica content (SiO₂) of the boiler water depending on pressure.

4.3 STEAM BOILERS TECHNICAL DESCRIPTION

1) BODY SG

1.1) BOILER BODY

Boiler structure with 2 passes and WET back; water tube reversing chamber connected to the tube sheet, complete with external insulation and access door.

Plating (laminated steel P355 EN10028 or equivalent) equipped with manhole for cleaning and internal inspection, n° 2 hand holes, service sockets (Drawn steel ASTM A 106 Gr. B) flanged (Forged steel ASTM A105): steam outlet, safety valves, drain, power supply with internal distributor, instrument and probes sockets, surface blowdown. Flanged connections according to PN16/40 EN 1092-1 (the water supply ramp is always PN40).

Nr. 2 lifting eyebolts.

Moisture separator for steam.

Furnace with large diameter for reduced NOx emissions (Laminated steel P355 EN 10028 or equivalent).

Tube plates (P355 EN 10028 or equivalent) DISHED and BUTT WELDED to shell and furnace.

Fire tubes (seamless type, drawn steel ASTM A 210 Gr. A1 or equivalent), expanded and welded to the tube sheets, complete with extractable turbulators for the intensification of heat exchange.

Front flue gas box consisting of a carbon steel sheet body with reinforcement rib profiles; bolted and thermally insulated doors, with hinged opening for full access to the tube sheet and for cleaning and inspection operations. Circular flue gas outlet flange, suitable for direct connection to the chimney.

Flue gas outlet box suitable for economizer mounting available as an **option**; included if boiler in ECO or HE-SMART version. N° 2 connections 1/2" NPT-F for flue gas temperature measurement. Connection for burner installation and refractory concrete throat.

Rear sight glass for the observation of the flame with high temperature crystal. Pressure measurement connection in combustion chamber.

Base frame of the generator in metal section bar consisting of: fixed front saddle, mobile rear saddle with sliding devices; metal section bar supporting the ground and nr. 4 lifting points by means of hydraulic jacks; complete with fixing points for pump support; nr. 2 stainless steel plates for grounding connection.

Painting for non-insulated carpentry: RAL 7016.

CE PED certification as an ASSEMBLY; risk class IV, verification module B+F (EC type-examination and product verification) or G. Hydraulic test attended by a notified body. Pressure parts calculation according to EN12953 standard.

Metal plate riveted to the boiler body reporting factory number, CE mark and technical data.

1.2) INSULATION

Insulation of plating in mineral wool: thickness 100 mm, density 100 kg/m³; cladding in Aluzinc or stainless steel (**on request**).

Galvanized steel screws.

2) ELECTRICAL PANEL / AUTOMATION

Electrical panel compliant with EN 60204 and EN 61439 installed on the machine, IP54 metal carpentry powder coated RAL 7035 (gray) with front door, complete with forced ventilation. CE plate with identification data.

Start, stop, reset, and lock buttons. Limiting safety chains with SIL relays.

Acoustic and visual lockout signal. 230V auxiliary section for the management of safety and regulation logics. Signal wiring carried out with 1.5 mm² cables complete with lugs and tagged with numbering shown in the diagram. Grounding clamp or ground bar for equipotential connection of field electrical utilities. Power section with devices for the control and protection of the burner and field utilities (if supplied). Numbered terminal block for connection between the panel and the field.

Multiple pages single-line wiring diagram for immediate reference. TN-S power supply system with

ground cable.

Power section with electric motors protections: supply voltage 400V 3 phases + N. Frequency 50Hz.

Environmental conditions: for installation sheltered from bad weather and direct sunlight, Tmin 10°C, Tmax 40°C.

Safety tests and CE electrical conformity certificate.

Electrical board machine system compliant with EN 60204 standards with wiring in closed plastic cable ducts or open metallic cable ladders. Degree of protection of electrical system and field instrumentation: IP54.

Electric panel installed on the generator side, fully wired and complete with metal support, detachable for field positioning on boiler front or accessories side (about 1,5m cables length available).

2.1) CONTROL SYSTEM (PLC)

Boiler control system by means of Optispark F3 PLC, complete with 10.4" HMI graphic interface.

Predisposition of remote interlock contacts, minimum deaerator level, chemicals pump control.

2.2) BURNER MANAGEMENT SYSTEM (BMS)

Burner Management System embedded in the burner (for dual block burners, BMS is installed in the control panel).

3) INSTRUMENTATION AND ACCESSORIES

3.1) STANDARD INSTRUMENTATION AND ACCESSORIES (Valid for 24h exemption)

Manual valves with started flow type with packing seal, flanged according to PN16/40 - EN1092-1 (Always PN40 for valves on the boiler feed water supply line).

Valves and instruments:

- N°1 steam intake PN16 (PN25/40 for stamp pressure > 12 bar-g)
- N°2 Valves for boiler body drain
- N°2 wet back drain valves
- N°1 manual water inlet valve in the boiler
- N°1 flanged valve for feedwater inlet
- N°1 manual valve for continuous surface blowdown
- N°1 manual boiler water sampling system, including cooling barrel with stainless steel coil.
- N°2 direct acting safety valves, spring closure, with flanged inlet and discharge connections
- N°1 pressure gauge with stainless steel case for local boiler pressure indication, dial diameter 150 mm.
- N°1 Safety pressure switch SIL2, as a limiter with blocking intervention for high pressure with manual reset (from boiler panel).
- N°1 temperature steam pressure transmitter with 4-20 mA signal connected to the boiler control PLC, for modulating burner load and standby threshold control.
- N°2 level indicators with reflex crystal and metal armor. Flanged connections with purge and shut-off taps
- N°1 capacitive probe 4-20 mA connected to Optispark F3 for electro-pneumatic valve regulation and pump run-stop control.
- N.2 SELF-CHECKED safety conductive probes for boiler very low water level. Control panel safety relay switching at boiler very low water level, with boiler lock, manual reset. The safety chain is Class IV PED certified, SIL3 safety level according to IEC61508-2.
- N°1 chimney base thermometer (replaced by thermocouple with signal transmission 4-20 mA of flue gas temperature to the chimney if boiler with ECO or HE-SMART recovery system).
- N°1 pressure gauge with stainless steel case for boiler feed water pressure indication, dial diameter 100 mm.
- For SG 300-600: external *Levelstop* barrel for mounting: one of the two minimum level probes, the level transmitter, the boiler pressure gauge, the shut-off pressure switch; with predisposition for mounting a glass level gauge.

The *Levelstop* barrel is pre-wired on a dedicated JB and can be supplied loose in case of transport restrictions.

Accessories assembly and functional test, including the assembly certification and verification of the compliances by No.Bo where prescribed by international standards.

3.2) AUTOMATIC BOTTOM BLOWDOWN - OPTION

Automatic Bottom Blow Down system consisting of:

- automatic bottom discharge valve DN40 with electro-pneumatic control (replaces one of the two manual boiler body discharge valves indicated in paragraph 3.1)
- discharge timing function managed by PLC

3.3) TDS CONDUCTIVITY CONTROL - OPTION

Boiler total dissolved salts (TDS) concentration control system consisting of:

- conductivity probe mounted on the side of boiler body with dedicated nozzle for measuring the conductivity of boiler water
- conductivity regulator/limiter mounted on board of control panel, with indication of process variables
- pneumatic surface purge valve DN15, complete with connection and manual valve for boiler water sampling

3.4) CONTINUOUS SELF-CHECKING FLAME PROBE - OPTION

Flame probe with continuous self-verification, suitable for 72h unmanned operation, UV type.

3.5) INSTRUMENT PACKAGE 72h unmanned operation - OPTION

Instrumentation necessary for boiler management with exemption from the presence of the licensed conductor up to 72h.

The instrumentation includes:

- Automatic Sludge Removal as specified in paragraph 3.2);
- TDS conductivity control as specified in paragraph 3.3);
- Continuous self-verification photocell as specified in paragraph 3.4);

In addition to the safety chains already described, the following are also provided:

- Safety control for shutdown in case of very high conductivity feed water/condensate return (signal charged to installer)
- safety chain for stop in case of feed water system fault (signal charged to installer)

N.B. For the operation under partial exemption regime up to 72 hours, the analysis of the risks related to the system associated with the generator, with regards to feed water, are charged to the User, as well as the equipment necessary for the related periodic checks.

Failure to comply with the periodic checks precludes the operation of the generator in the absence of the Conductor.

Contacts for the management of signals related to:

- Quality of make-up water;
- Condensates quality.

4) BURNER

The refractory throat and burner mounting flange (to be defined according to the selected burner model) are always included.

4.1) MONOBLOCK BURNER

Monoblock burner compliant with EN267 with built-in fan and electronic controls. The burner is equipped with a metal case for containing and conveying combustion air, safety and flame adjustment devices, sight glass, refractory steel flame tube and diffuser disc, gas distributor with multiple nozzles. (The electrical protection power supply of the burner is provided by the boiler's panel).

The burner is supplied assembled on the boiler and functionally tested.

Burner control is modulating type, with electronic cam.

Standard photocell of non-self-checking type; self-checking photocell included only if options 3.4) or 3.5) are selected.

Combustion system completes with HFO pre-heating system and pumping system.

On demand burners brand or dual-block type burners are available **on request**.

5) **HEAT RECOVERY SYSTEM - OPTION**

5.1) **ECONOMIZER**

Heat recovery system from flue gases to increase the overall efficiency of the boiler. Includes:

- N°1 heat exchanger (flue gas - feedwater exchanger), installed in the structure of the front flue gas box and removable in case of maintenance, consisting of:
 - o air containment frame with rectangular section in carbon steel sheet with reinforcement ribs;
 - o bolted flange for mounting on the front flue gas box;
 - o horizontal partial finned tubes in carbon steel, welded to end manifolds;
 - o EN 1092 flanged nozzles for water inlet/outlet;
 - o threaded sockets for drains and vent.
- Modulating level control valve.
- Shut-off and bypass valves, certified safety valve and drain and vent valves.
- Pre-assembled piping for connection to the feed water line.
- N° 1 Thermocouple for measuring the temperature of chimney flue gases.

The economizer is PED certified as pressure equipment.

The option includes the adjustment of the front flue gas box for connection to economizer.

Flue gas outlet box with circular flanged connection, complete with counter-flange.

Additional boiler feed water pre-heating with coil placed on boiler body.

6) **FEEDWATER PUMPS**

6.1) **DOUBLE PUMP (ONE AS BACKUP)**

Two centrifugal pumps, vertical, directly coupled to IE3 electric motor; supplied mounted on a base directly connected to the boiler (can be disassembled for transportation).

Each pump processes the entire flow rate required by the boiler, so that a pump is always available as a backup to be able to use the boiler at full load in case of failure of the other.

The pumps are complete with pre-assembled pipe up to the boiler inlet with threaded connection for possible connection of the chemical dosing unit (1/2" NPT-F). Pump control and automatic switch-over are managed by PLC.

The pipe is manufactured with welded elbows, not with bent piping. The pipe is supplied painted, not insulated.

Power supply circuit with magneto-thermic switch installed inside the electric panel.

On-demand pumps suppliers can be evaluated as **on request**.

6.2) **DOUBLE PUMP (ONE AS BACKUP) WITH VFD - OPTION**

In addition to what is included in option 6.1) two VFDs are included for modulation of the rotation speed of the pumps, for fine control of the feed water flow and electricity saving with the generator running at reduced loads.

Standard degree of protection IP54.

A pressure transmitter on feed water line to the pump is included.

7) **LADDER AND PLATFORM**

Ladder and platform for access to the upper part of the generator, complete with supports, in aluminum, EN 14122 certified. The ladder is of the ship's type with a protective cage.

8) TEST

The steam generator is always functionally tested at the factory (electrical and software tests, functional tests of safety chains) before shipment.

9) TECHNICAL DOCUMENTATION

- ✓ Equipment drawing with foundation loads (ENGLISH – digital)
- ✓ Transport drawing with dimensions, weights and indications on handling (ENGLISH – digital)
- ✓ P&ID for water/steam and combustion (ENGLISH – digital)
- ✓ Electrical diagrams (ENGLISH – digital and paper)
- ✓ Boiler Instruction and maintenance manual (ENGLISH and GREEK – digital and paper)

Note: instruction manual of instruments and accessories in English only (in Romanian only where available from suppliers).

- ✓ Boiler management system “Optispark” manual (ENGLISH– digital)
- ✓ Boiler control panel HMI language: ENGLISH
- ✓ Boiler and Control Panel CE Certification (ENGLISH – digital)
- ✓ Boiler main components documentation and CE Certification (ENGLISH – digital)
- ✓ Signals serial list (ENGLISH – digital)

Standard of documentation: BONO STANDARD