

All about Failure Mechanisms of C-steels according to API 571

Failure Mechanism	Description	Affected Mat. Properties	Critical factors related to service	Affected Units	Appearance Morphology	Prevention Mitigation	Inspection Monitoring	Remarks acc. to API 571 and 579
Creep and Stress Rupture (API 571/ GALICOM)	Creep at Temperature >370°C depending on material. Deformation may lead to a rupture Related Mechanism: 1. Short term overheat. Stress Rupture 2. Reheat cracking in heavy wall equipm.	1. All metals 2. Low creep ductility 3. Cut of remaining life	1. Material 2. Load 3. Temperature	1. Heater tubes in fired heaters 2. Tube support 3. Other furnace internals 4. HAZ	1. Hardening 2. Creep voids at grain bound. 3. fissures 4. cracks (bulging)	1. Design 2. Material Selection 4. PWHT	visual UT,RT,EC, WFMT	API 571: Chapter: 4.2.8 Table 4-2 Figure:4-9, 4-10 API 579: G.3.5 Subsurface Crack and Microfissuring Microvoid Format.
Mechanical Fatigue (API 571) Corrosion Fatigue Cracking (GALICOM) consider also Therm. Vibration Fatigue (API 571)	sudden, unexpected failure exposed to cyclic stresses for an extended period Related Mechanism: Vibration induced fatigue, Thermal fatigue	1. All metals 2. Fatigue limit 3. Endurance limit	1. Geometric 2. Stress level (Temp.) 3. Number of cycles 4. Material strength 5. Material Hardness 6. Material Microstruct.	1. small nozzles 2. rotating shafts on pumps and compressors	concentric rings (waves) emanating from the crack initiation site	1. Good Design 2. Material Selection 3. Minimize weld defects 4. use of LIT 5. Min. Stress concentration	PT, MT and SWUT (shear wave US testing) Vibration Monitoring	API 571: Chapter: 4.2.16 Fig. 4-29 to 34 API 579: G.3.4 Surface connected cracking
Erosion/ Erosion-Corrosion (API 571/ GALICOM)	Erosion: mechanical removal of surface material Erosion- Corrosion: removing protective films Related Mechanism: Cavitation, Fretting	1. All metals 2. Hardness of the surface 3. Free corrosion potential (V)	1. Velocity 2. Concentration of impacting medium 3. Size and hardness of impacting particles 4. Hardness and corrosion resistance 5. Angle of impact	1. Bends 2. Tees 3. Reducers 4. Nozzles 5. Valves 6. Pumps 7. Heatersch.	localized loss in thickness, in the form of pits, grooves, waves, rounded holes and valleys	1. Geometry 2. Material Selection 3. Surface Hardening 4. Inhibitors	1. Visual inspection of suspected areas 2. UT, RT (metal loss)	API 571: Chapter:4.3.14 Table: 4-3 Fig. 4-23, 24, 25 API 579: G.3.3 Localized metal loss

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Daniela Niemeyer



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