

**TABLE 1**

**SUGGESTED WATER QUALITY LIMITS**

**BOILER TYPE:** Industrial watertube, high duty, primary fuel fired, drum type

**MAKEUP WATER PERCENTAGE:** Up to 100% of feedwater

**CONDITIONS:** Includes superheater, turbine drives, or process restrictions on steam

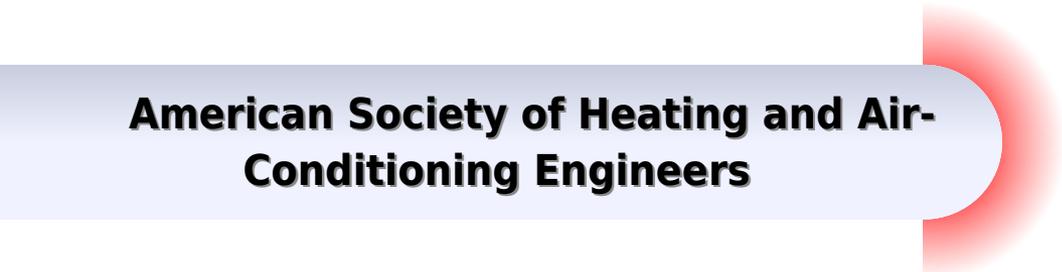
**SATURATED STEAM PURITY TARGET:** See footnote

Drum Pressure (psig)	0-300	301-450	541-600	601-750	751-900	901-1000	1001-1500	1501-2000
<b>Feedwater</b>								
Dissolved Oxygen (mg/l)	<0.04	<0.04	<0.007	<0.007	<0.007	<0.007	<0.007	<0.007
Total iron (mg/l Fe)	≤0.1	≤0.05	≤0.03	≤0.025	≤0.02	≤0.02	≤0.01	≤0.01
Total Copper (mg/l Cu)	≤0.05	≤0.025	≤0.02	≤0.02	≤0.015	≤0.015	≤0.01	≤0.01
Total Hardness (mg/l CaCO <sub>3</sub> )	≤0.3	≤0.3	≤0.2	≤0.2	≤0.1	≤0.05	None detected	
pH range @ 25°F	7.5-10	7.5-10	7.5-10	7.5-10	7.5-10	8.5-9.5	9.0-9.6	9.0-9.6
Nonvolatile TOC (mg/l C)	<1	<1	<0.5	<0.5	<0.5	<0.2	<0.2	<0.2
Oily Matter (mg/l)	<1	<1	<0.5	<0.5	<0.5	<0.2	<0.2	<0.2
<b>Boiler Water Limits</b>								
Silica (mg/l SiO <sub>2</sub> )	≤150	≤90	≤40	≤30	≤20	≤8	≤2	≤1
Total Alkalinity (mg/l CaCO <sub>3</sub> )	<350	<300	<250	<200	<150	<100	Not specified	
Free Hydroxide (mg/l CaCO <sub>3</sub> )	Not specified						None detectable	
Unneutralized Conductivity (µmho/cm @ 25°F)	<3500	<3000	<2500	<2000	<1500	<1000	≤150	≤100

Footnote: No values given because steam purity achievable depends on many variables, including boiler water total alkalinity and specific conductance as well as boiler design, steam drum internals and operating conditions. Since boilers in this category require relatively high steam purity, operating parameters must be set as low as necessary for the protection of the superheaters and turbines.

# Asme Boiler Water Quality Guidelines

**American Society of Heating and Air-  
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*Practical Wastewater Treatment* David L. Russell, 2019-03-21 The updated and expanded guide for handling industrial wastes and designing a wastewater treatment plant The revised and updated second edition of *Practical Wastewater Treatment* provides a hands on guide to industrial wastewater treatment theory practices and issues It offers information for the effective design of water and wastewater treatment facilities and contains material on how to handle the wide variety of industrial wastes The book is based on a course developed and taught by the author for the American Institute of Chemical Engineers The author reviews the most current industrial practices and goals describes how the water industry works and covers the most important aspects of the industry In addition the book explores a wide range of approaches for managing industrial wastes such as oil blood protein and more A comprehensive resource the text covers such basic issues as water pollution wastewater treatment techniques sampling and measurement and explores the key topic of biological modeling for designing wastewater treatment plants This important book Offers an updated and expanded text for dealing with real world wastewater problems Contains new chapters on Reverse Osmosis and desalination Skin and Membrane Filtration and Cooling tower water treatment Presents a guide filled with helpful examples and diagrams that is ideal for both professionals and students Includes information for handling industrial wastes and designing water and wastewater treatment plants Written for civil or chemical engineers and students *Practical Wastewater Treatment* offers the information and techniques needed to solve problems of wastewater treatment

*Sustainable Process Engineering* David Brennan, 2012-10-01 This book introduces chemical engineering students to key concepts strategies and evaluation methods in sustainable process engineering The book is intended to supplement chemical engineering texts in fundamentals and design rather than replace them The key objectives of the book are to widen system boundaries beyond a process plant to include

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