# Troubleshooting Centrifugal Pumps

ffective troubleshooting should be an integral part of any plant's equipment reliability and maintenance program.

Before you examine the system, however, take time to review maintenance records. The performance history of your pumps will point you in the right direction. Also, pump operators can provide clues to what is happening. Troubleshooting should focus on these areas of investigation:

#### 1. THE FOUNDATION

Poor foundations, grouting and baseplate design often cause problems.

#### 2. DRIVER

Vibrations of the driver (motor, steam turbine, gearing) can be transmitted to other components.

### 3. MECHANICAL POWER TRANSMISSION

Excitations from the coupling area, especially because of driver misalignment or eccentrically bored coupling hubs, can also be transmitted to other parts of the pump and/or system. Users should note any incorrect positioning of the driver and pump such that the distance between shaft ends (DBSE) exceeds the axial flexing limits of the coupling.

#### 4. THE DRIVEN PUMP

Pump design has a major influence on the hydraulic interaction between the rotor and the casing and consequently the problems encountered. Misconceptions about pump thermal-growth can create problems.

#### 5. SUCTION PIPING AND VALVES

Improper design and layout of suction piping and valves can create flow disturbances such as cavitation, intake vortexing or suction recirculation.

#### DISCHARGE PIPING AND VALVES

Unfavorable dynamic behavior of piping resulting from loads traceable to dynamic, static or thermal causes tincluding resonance excitation) can create trouble.

#### 7. INSTRUMENTATION FOR CONTROL OF PUMP FLOW

Pressure pulsations can result from control system-pump interaction during start-ups, periods of low flow and valve changes.

#### 8. M AINTAINING ALIGNMENT

Once the alignment is established, dowells into the baseplate must hold the pump in alignment.

Troubleshooting centrifugal pumps begins with observing operating conditions at the site. While a myriad of problems can exist with any pumping system, here are some of the more typical scenarios, possible causes and corrective actions.

Ed Nelson has more than 40 years of experience with industrial pumping systems as a former end-user at a major petrochemical company, and today as a turbomachinery consultant. He is a member of the Pumps and Systems Editorial Advisory Roard.

# Cavitating-type Problems

A cavitating sound is heard in a pump that does not normally cavitate, and it is not clear whether it is pumping into the system.

#### POSSIBLE CAUSES

The suction piping layout is poor. There may be too many ells in too many planes or not enough straight run before the suction flange of the pump.

Suction piping configuration causes fluid to rotate adversely when approaching impeller.

Flow rate is high enough above design that NPSH, has increased above NPSH,.

Pump is operating at a low-flow, producing suction recirculation in the impeller eye, resulting in a cavitation-like sound

The suction screen is cloqued.

Piping gaskets with undersized IDs have been installed—a common problem in installations of small pumps.

Pipelines are constricted because of buildup of corrosion materials.

#### CORRECTIVE ACTION

Redesign piping layout, using fewer ells and laterals for tees, and have five or more diameters of straight pipe before suction flange.

Install enough straight run of suction piping, or install vanes in piping to break up prerotation.

Reduce flow rate to the level for which the pump was designed.

Install bypass piping back tosuction vessel to increase flow through pump. Note: Bypass flow may have to be as high as 50% of design flow.

If screen is present, remove and clean it.

Install properly sized gaskets.

Replace deteriorated pipe.

# **Troubleshooting Handbook For Centrifugal Pumps**

Heinz P. Bloch, Fred K. Geitner

#### **Troubleshooting Handbook For Centrifugal Pumps:**

**Trouble-shooting** Dušan Florjančič, 2008 **Pump User's Handbook** Heinz P. Bloch, Allan R. Budris, 2004-07-13 A valuable reference Pump User's Handbook Life Extension explains just how and why the best of class pump users are consistently achieving superior run lengths low maintenance expenditures and unexcelled safety and reliability The book conveys in detail what must be done to rapidly accomplish best of class performance and low life cycle cost Simply put the text explains what exactly needs to be done if a facility wants to progress from being a one two or three year pump MTBF plant and wishes to join the leading money making facilities that today achieve a demonstrated pump MTBF of 8 6 years Written by two practicing engineers whose combined 80 year working career included all conceivable facets of pumping technology book provides experience based details data guidance direction explanations and firm recommendations Implementing what this text explains will allow a plant to move from yesterday s demonstrably unprofitable and costly repair focus to tomorrow s absolutely necessary reliability focus Power Plant Centrifugal Pumps Maurice L. Adams, 2017-03-16 In the critical work of maintaining power plant machinery operating difficulties with centrifugal pumps will inevitably occur because of the essential requirement for electric power plants to operate at all times throughout the year The root causes and solutions for pump failure comprise major areas of study for engineers in seeking the highest availability of electricity generating units extending time between major machinery overhauls and providing early detection of potential failure modes well in advance of machine degradation This guide for engineers provides a comprehensive overview of the fundamentals of centrifugal pumps addressing the range of pump operating problems encountered in both fossil and nuclear power plants The book is divided into three sequential parts Part I Primer on Centrifugal Pumps Part II Power Plant Centrifugal Pump Applications and Part III Trouble Shooting Case Studies Employing effective research models developed through years of experience the author draws on an extensive range of scholarship that covers the detrimental impact of power plant pump failures on overall plant performance as well as the preventative measures that aid in successful pump maintenance After covering the performance and components of centrifugal pumps operating failure modes are covered both for fossil and nuclear power plants This is followed by the presentation of several power plant pump troubleshooting case studies The text also walks readers through the various other industrial applications of centrifugal pumps as in their use within petrochemical plants and in ocean vessel propulsion systems Recognizing the warning signs of specific impending pump failure modes is essential to minimizing the financial costs of dealing with pump operating problems To this end the author lays out a range of theoretical models and relevant examples in support of the essential work of power plant pump use and maintenance Handbook of Pulping and Papermaking Christopher J. Biermann, 1996-08-01 In its Second Edition Handbook of Pulping and Papermaking is a comprehensive reference for industry and academia The book offers a concise yet thorough introduction to the process of papermaking from the production of wood chips to the final

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their machines are failing The next step is to continuously modify machines processes and methods to avoid common failures Process Machinery Handbook For Field Personnel Decision Makers and Students gives students and professionals alike the tools they need to understand the fundamentals of working with rotating machinery **Practical Machinery Management for Process Plants: Volume 2** Heinz P. Bloch, Fred K. Geitner, 1997-09-11 This newly expanded edition discusses proven approaches to defining causes of machinery failure as well as methods for analyzing and troubleshooting failures

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