Aspec Newsletter

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INSIDE THIS ISSUE

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Introduction

Since establishing in 2003, Aspec has had a great response from clients to the services we provide, particularly from mining companies and ports. This year, our service range has expanded to include a strong inhouse mechanical engineering capability to compliment our civil/structural engineering services. In addition to our own expertise, we have further developed Strategic Alliances with leading practitioners and organisations to deliver engineering solutions for the most demanding of multidisciplinary assignments.

The objective of this newsletter is to share knowledge and experience gained during the course of our work. This edition contains two articles, the first on cranes and material handling machines and the second on procurement of new equipment. We would be pleased to receive suggestions from readers, via the enclosed fax back form, as to the subjects and types of articles of interest for future Newsletters.

by Frank Gatto *(fgatto@aspec.com.au)*

Fatigue of Bulk Materials Handling Machines

Materials handling machines are complex structures which often rely on load limiting devices to prevent damage. Fatigue damage is a consideration for machines of this type.

An investigation by the authors [1] of the failures of over sixty materials handling machines found that about ten percent of failures can be attributed to fatigue failure. In most cases these failures were unexpected and lead to catastrophic consequences. Figure 1 shows the number of machine failures versus the age of the machine at failure. The failures can be divided into two groups: the first group of failures occurs within the first five years after commissioning and the second group of failures occur when the machines are greater than ten years old. About ten percent of all failures or about one quarter of the failures that occurred when the machine was greater than ten years old can be attributed primarily to fatigue damage.

In this article, the authors discuss the process of fatigue damage relating to cranes and materials handling machines.

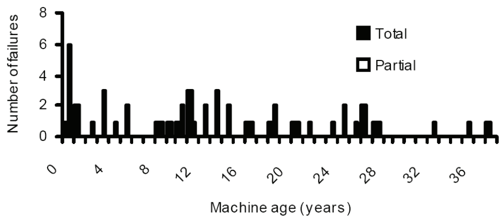

Figure 1: Number of failures versus machine life

2.0 Process of Fatigue Damage

The process of fatigue means that steel strength deteriorates under the action of cyclic loads and this may ultimately lead to cracking and the unexpected failure of structures. The American Society for Testing and Materials [2] defines fatigue as;
The process of progressive localised permanent structural change occurring in a material subjected to conditions which produce fluctuating stresses and strains at some point or points and which may culminate in cracks or complete failure after a sufficient number of fluctuations.

Two key points to note in this definition are:
- Progressive implies that the fatigue process occurs over a period of time. Fatigue failure may be sudden with no warning, however the mechanisms involved have been operating since the beginning of the structures usage.
- Localised implies the fatigue process operated at local areas rather than throughout the entire structure. The ultimate cause of all fatigue failures is that a crack has grown to a point at which the remaining material can no longer tolerate the stresses or strains and sudden fracture occurs.

The fatigue process involves two stages: crack initiation and crack propagation. Crack initiation involves changes to the material microstructure such that distinct crack initiation sites occur. As cycling continues, crack propagation occurs and the fatigue cracks tend to coalesce and grow along planes of maximum stress. The majority of cranes and rail mounted materials handling machines have significant welding and hence small defects (cracks) are already present. To account for this, current design standards assume that small cracks will always be present and that crack propagation is the only part of the fatigue process.

2.1 Statistical Nature of Fatigue

The concept of “remaining fatigue life” can be simplistic and misleading especially for older, deteriorated structures. “Fatigue life” is a statistical quantity - design curves are based on results from test specimens and considerable deviation from the average curve determined from a few specimens occurs.

Figure 2 shows typical results for fatigue tests on a fillet welded T-joint. The tests were performed with different stress ranges and the number of cycles to failure were found. The geometry and weld procedure were the same for all the test pieces. As can be seen, the test data has considerable scatter even though the test pieces and field conditions were very similar.

The usually specified reliability factor for a detail is 0.9773, that is, two standard deviations from the mean. If the structure were subjected to the design cumulative damage, and the details were working to the allowable limit, without intervention one detail in 45 on average would fail. If you consider that a typical bucket wheel reclaimer can have between 5,000 and 10,000 details, this would not be acceptable.

Design standards such as AS4100 recognise the reduced reliability for fatigue versus strength design and stipulate that dynamically loaded structures affected by fatigue must be regularly inspected for code rules to apply. Regular inspection of these structures should increase the reliability of the structure to an acceptable level.

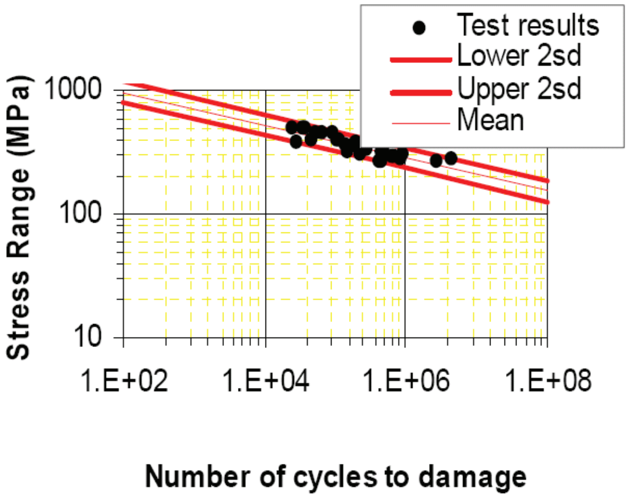

Figure 2: Test results for welded T-joint

Codes also recognise that where parts of the machine susceptible to fatigue are not accessible for inspection, then further conservatism needs to be incorporated in the design.

3.0 Issues with Fatigue Damage

Some of the issues associated with fatigue damage that are specific to materials handling machines are discussed in this section.

3.1 Environment

Fatigue crack growth rates are strongly influenced by the environment. Corrosion can have a significant effect on "fatigue life" which can be reduced by half in corroded areas. Higher stresses can be caused by pitting or reduced plate thickness. Also corroded structural steel has no fatigue limit, that is, a corroded component will fail regardless of the magnitude of the stress range [3]. In general, good fatigue design and detailing is closely linked to high corrosion resistance.

3.2 Weld Quality and Details

Poor weld quality significantly increases the probability of fatigue damage development. For example, the fatigue life of a component can be shortened by 2½ times if a fillet is too near an edge of a member. Welding procedure affects fatigue life considerably. Occurrences such as weld spatter, accidental arc strikes, weld flaws, poor fit-up, misalignment can lead to lower performance than its classification would indicate [3].

3.3 Secondary Members

The fatigue analysis usually only considers the global effects on the machine and accounts for primary structural steel alone. International research [4] shows that up to 70% of fatigue damage occurs in secondary members, which are not usually checked in the design stage (eg. brackets carrying electrical cables, welded cover plates). Damage due to effects from secondary members is not necessarily detrimental to the performance of the structure provided it is found early, via regular inspections, and repaired before the damage propagates to the main structural sections leading to failure of the structure.

3.4 Inspection

Dynamically loaded structures affected by fatigue must be regularly inspected for fatigue damage for design code rules such as Australian Standard AS4100 to apply. The limit of detectable crack size in the field is 6mm long by 2mm depth [5]. However the detection of cracks above this "detectable size" is not a certainty. Reliable crack detection is affected by many factors [6]:

- The skill of the inspector. Experienced inspectors should have a higher likelihood of detecting cracks compared to an inexperienced person.
- The specific area to be inspected. It is easier to detect cracks in a specific location such as a particular component compared to the total machine
- The accessibility of the detail including details that may be hidden behind other structural components. Some details may be difficult to access or may be completely hidden from view by other structural members. Corrosion products or paint that may be inside the crack.

3.5 What to Do If Cracks are Found

Where cracks are found on a structure in service, owners need informed advice on how long they can continue to operate before undertaking repairs, replacements or further inspection and monitoring. A fracture mechanics assessment allows crack growth curves to be developed for particular details.

Figure 3 shows a typical crack growth curve on a welded structure with the crack size given on the vertical axis and the number of cycles on the horizontal axis. It can be seen that the crack growth is exponential. Once a detectable crack is found on a critical details, there may be "limited time" available to undertake remedial works.

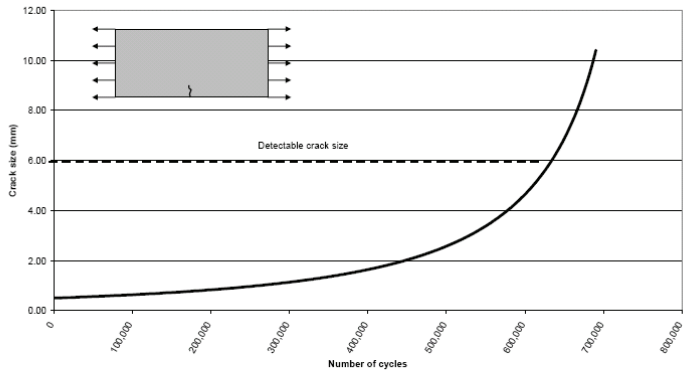

Figure 3 - Crack growth rate for single edge crack in tension

4.0 Conclusions

It is important to note that the following points:

- Cracks are to be expected. Current fatigue design codes have details with a reliability of 0.9773 or a 1 in 45 probability of cracking at the end of their design life. This compares to structural strength design which has a reliability of 0.999. Also the reliability decreases with age of the structure.
- Satisfactory control of fatigue damage relies on adequate methods of fatigue crack detection and the ability to repair or replace the damaged component.

An effective methodology for the structural appraisal of large structures should consider -

- Structural analysis. Locate areas of high stress and investigate possible failure mechanisms.
- Fatigue analysis. Locate areas where there is a high likelihood of fatigue cracking occurring.
- Inspection. NDT of critical areas and visual inspection of non-critical and secondary members.
- Fracture mechanics assessment to predict crack growth rates and inspection regimes in critical areas.

5.0 References

[1] Morgan, R & F. Gatto, Defying Time, World Coal, May 2002.
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[4] Fisher, J.W., Fatigue Cracking in Bridges, I.E. Aust, Civil Engineering Transactions, 1983, pp. 223-235.
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[6] Broek, D., The Practical Use of Fracture Mechanics, Kluwer Academic Publishers, 1989.

Procurement of Cranes and Bulk Materials Handling Machines

1. General
Cranes and materials handling machines for the mining, metallurgical and associated industries have shown failure rates much higher than standard static structures. Such failures, as well as being highly dangerous and in cases causing injury to personnel, represent a significant economic loss.

Under workplace health and safety legislation, owners and operators of such equipment have significant responsibilities for on-going risk management of the machines. Studies of failures have shown that the most common latent organisational factor contributing to machine failures is poor risk identification and assessment. Hence there is a strong need for owners, operators, designers and manufacturers to adopt a pro-active approach to risk management throughout the asset life-cycle including procurement, design, manufacture, installation and on-going asset management and maintenance.

When procuring new cranes and bulk materials handling machines, the following stages need to be considered:
- Determination of configuration and performance parameters
- Specification of procurement documents
- Proof engineering
- Assessment of tenders and award of contract
- Commissioning and hand-over to operation

2. Determination of Configuration and Performance Parameters
Determination of a suitable configuration of a crane or machine and performance parameters such as outreach, throughput rate, utilisation, design life etc is intimately linked to the business objectives and process/quality requirements for the materials being handled. Future trends in business, shipping etc are also important and allowance for flexibility and responsiveness to the market may need to be considered in the equipment selection and specification.

3. Specification
The standard method for procuring cranes and bulk materials handling machines is a design and construct contract with the contractor having responsibility for design, manufacture, supply and installation. In some cases the contracts may be split to suit the logistics of construction or for commercial reasons. However if this is contemplated, care should be taken to keep the responsibility for final performance with one party.

The specification for the crane or machine should cover design, material and quality requirements for manufacture and installation, commissioning and hand over to operations, provision of spare parts and requirements for ongoing maintenance. The specification needs to be written to ensure that the configuration and performance parameters upon which the requirements for the machine were determined can be met realistically in practice.

Specification of the design requires a good knowledge of the design standards, their limitations and interpretations of the design standards commonly used within the industry. Industry experts should be consulted to ensure that problems commonly encountered on equipment of this type are not repeated and should review the specification. The operators and maintainers of the plant have a large influence on the ongoing safe performance of the machine and should also be involved in review of the specification.

4. Proof Engineering
Proof Engineering involves design auditing and certification by an independent 3rd party proof engineering consultant. This may be by means of independent calculations or in some cases by checking and review of the original design calculations and computer analyses. Independent calculations are the preferred method. In conjunction with the proof engineering, it is desirable to hold one or more facilitated workshops with key staff from the designer, operator, maintainer and proof audit-engineering consultant present. This should be carried out under the guidance of an experienced facilitator.

The proof engineer should ideally be engaged before the specification for the crane or machine is finalised to allow for a review by the proof engineer prior to issue. AS 4324.1 Appendix K gives guidance for engagement of a proof engineer for structural auditing. However it is also desirable to carry out a mechanical audit in conjunction with the structural audit. Involvement of the proof engineer by the client in the tender review process is also desirable.

5. Assessment of Tenders and Award of Contract
It is desirable to select a short list of tenderers to ensure that only reputable manufacturers with suitable experience are included in the tendering process. This may be by invitation or by pre-qualification, depending on the client's procurement policies.

Assessment of tenders should consider factors such as; type of machine offered, design standards, comparison with configuration and performance requirements, standardisation of components, spares and maintenance requirements, recent experience on similar machines, performance and client feedback for similar machines supplied by the tenderer, and pricing details. If possible the proof audit engineer should be involved in the tender review process to highlight design issues, which may require clarification. Negotiations may be required to develop tender offers to an acceptable standard for award of contract.

6. Supervision and Administration of Contract
During supervision and administration of contract, the Superintendent will carry out monitoring of the design process and the proof audit engineer will be involved with detailed checking of the design components. It is desirable to hold facilitated workshops with the clients operations and maintenance staff as the design progresses.

The contractor should prepare inspection and test plans for all items on the machine and this should be approved and witnessed in full or in part by representatives of the superintendent.

7. Commissioning
Commissioning will generally involve the following stages:
- Pre-commissioning tests
- No-load tests
- Load tests
- Performance tests

In addition weighing of the crane or machine may be called for to accurately measure the overall mass and to determine the centre of gravity and overturning moments due to dead load.

8. Ongoing Asset Management and Maintenance
AS 2550, the Australian Standard for safe use of cranes requires the following inspections and assessments in addition to a pre-operation inspection. These requirements are mandatory for cranes but should also be used as a guide for materials handling machines.
- Periodic inspection, maximum being 12 months interval, including a visual inspection of the structure, inspection for wear on mechanical components and NDT in critical areas.
- Major inspection, carried out at the end of the nominal design life of the crane before continued use past this time.
- Assessment for continued safe use. This should be carried out at the end of the nominated design life which if not known should be taken as a maximum of 25 years for structural components and 10 years for mechanical items.
- Assessment for changed operation should be carried out whenever a change in use of a crane is proposed.