

from a radiator. Arranging the piping so the total distance from the boiler to the radiation is the same as the return piping distance from the heating unit back to the boiler tends to obtain such a result. The condensation which occurs in steam piping as well as in radiators must be drained to prevent impeding the ready flow of the steam and air. The effect of back pressure in the returns and excessive reevaporization, such as occurs where condensation is released from pressures considerably higher than the vacuum or pressure in the return, must be avoided.

It is important that steam piping systems distribute steam not only at full *design* load but during excess and partial loads. Usually the average winter steam demand is less than half of the demand at the *design* outside temperature. Moreover, in rapidly warming up a system even in moderate weather, the load on the steam main and returns may exceed the maximum operating load for severe weather due to the necessity of raising the temperature of the metal in the system to the steam temperature and the building to the *design* indoor temperature. Investigations of the

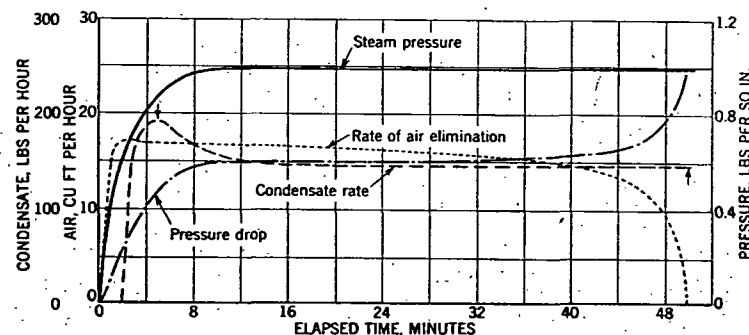


FIG. 1. RELATION BETWEEN ELAPSED TIME, STEAM PRESSURE, CONDENSATE AND AIR ELIMINATION RATES

return of condensation have revealed that as high as 143 per cent of the design condensation rate may exist under conditions of actual operation.

The piping design of a heating system is greatly influenced by its operating characteristics. Heating systems do not operate under constant conditions as they are continually changing due to variation in load. As the system is being filled with steam the pressures existing in various locations may be different from those which exist for appreciable periods at other locations although at equilibrium conditions the pressures are approximately the same. In designing piping it is of especial importance to arrange the system to preclude trouble caused by such pressure differences. The systems which readily release the air permit uniform pressures to be attained in much shorter time intervals than those which are sluggish. Results are given in Fig. 1 from investigations¹ to determine the rate of condensate and air return from a two-pipe gravity heating system. Variations in the steam pressure during the warming-up period when the rate of air elimination and condensation is high are clearly indicated in these curves.

It is evident that the condensation flow during the initial warming-up period reaches a peak which is greater than the constant condensation rate eventually reached when the pressure becomes uniform. Moreover,

the peak condensation rate is obtained when the system steam pressure is lower than that existing during a period of constant condensing rate. It will also be noted that the peak rate of air elimination does not coincide with the higher condensing rate.

STEAM FLOW

The rate of flow of dry steam or steam with a small amount of water flowing in the same direction is in accordance with the general laws of gas flow and is a function of the length and diameter of the pipe, the density of the steam, and the pressure drop through the pipe. This relationship has been established by Babcock in the formula given at the top of Table 1. In Columns 1, 2, 3, and 4 of this table, the numerical values of the factors for different pressure losses, pipe diameters, steam densities and lengths of pipe have been worked out in convenient form so that the steam flowing in any pipe may be calculated by multiplying together the proper factors in each column as shown in the example at the bottom of the table.

PIPE SIZES

The determination of pipe sizes for a given load in steam heating depends on the following principal factors:

1. The initial pressure and the total pressure drop which may be allowed between the source of supply and the end of the return system.
2. The maximum velocity of steam allowable for quiet and dependable operation of the system, taking into consideration the direction of condensate flow.
3. The equivalent length of the run from the boiler or source of steam supply to the farthest heating unit.
4. The direction of flow of the condensate, whether against or with the steam.

Initial Pressure and Pressure Drop

Theoretically there are several factors to be considered, such as initial pressure and pressure required at the end of the line, but it is most important that: (1) the total pressure drop does not exceed the initial gage pressure of the system and in actual practice it should never exceed one-half of the initial gage pressure; (2) the pressure drop is not so great as to cause excessive velocities; (3) there is a constant initial pressure, except on systems specially designed for varying initial pressures, such as the sub-atmospheric, which normally operate under controlled partial vacua, and orifice and vapor systems which at times operate under such partial vacua as may be obtained due to the condition of the fire; and (4) the equivalent head due to pressure drop does not exceed the difference in level, for gravity return systems, between the lowest point on the steam main, the heating units, or the dry return, and the boiler water line.

All systems should be designed for a low initial pressure and a reasonably small pressure drop for two reasons: *first*, the present tendency in steam heating unmistakably points toward a constant lowering of pressures even to those below atmospheric; *second*, a system designed in this manner will operate under higher pressures without difficulty. When a system designed for a relatively high initial pressure and a relatively high pressure drop is operated at a lower pressure, it is likely to be noisy and have poor circulation.

The total pressure drop should never exceed one-half of the initial gage pressure when condensate is flowing in the same direction as the steam. Where the condensate must flow counter to the steam, the governing