



# Boiler Tube Failure Handbook

## BOILER TUBE FAILURE HANDBOOK

Appearance	Observation	Locations	Mechanism
 Bulging tube adjacent to field weld	Bulging - Deformation	Waterwall	Long-term Overheat
 Metal thinning on fireside	Deformation - Thinning	Superheater Waterwall	Smelt/Slag Attack
 External wastage beneath adherent slag deposit	Deformation - Thinning	Superheater Waterwall	Corrosion From Slag Attack
 External thinning, smooth areas	Deformation - Thinning	Reheater	Fireside Corrosion/Erosion
 Smooth surface	Deformation - Thinning	Reheater Superheater	Fly Ash Erosion
 General pitting	Holes, Pits, Gouges - Waterside (Firetube boiler)	Waterside of firetube boiler	Acid Attack
 ID pitting with corrosion tubercles	Holes, Pits, Gouges - Waterside	Reheater Superheater Waterwall	Oxygen Pitting
 sharply defined hole	Holes, Pits, Gouges - Waterside	Economizer	Corrosion Fatigue
 Severe corrosion on side of tube facing gas turbine/duct burners	Holes, Pits, Gouges - Waterside	Evaporator Section	Multiple Under-Deposit Corrosion Mechanisms Including Caustic Gouging, Phosphate Attack, and Hydrogen Damage
 Undercut corrosion, multi-color deposits (red, white, black). (This is a view of a tube ID following cleaning.)	Holes, Pits, Gouges - Waterside	Waterwall	Acid Phosphate Attack
 Thinning on inside of a U-bend or other change in	Holes, Pits, Gouges	Economizer	Flow Accelerated Corrosion

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**Daniel F McAuley**



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