

## Contents

<b>Chapter I - Establishing the Fundamentals</b>	<b>1</b>
Introduction	1
Some Early Investigations	2
Empirical Methods of Determining Boiler Size	11
Some Influential French Tests	17
Some important Concepts Derived from the Nord Boiler Tests	22
Professor Goss' Experiments into Boiler Behaviour	24
The Tests Conducted at St Louis	26
Lawford Fry's Analysis of the St Louis Results	28
Summary and the Significance of Mr. Fry's Contribution	36
<b>Chapter II - Calculating a Heat Balance</b>	<b>41</b>
Introduction	41
The Constituents Forming the Heat Balance	41
Constructing a Heat Balance Using the Initial 'Fry Method'	46
Comparing Heat Balances Determined by the Two Methods	48
The Rugby Method	50
Considering the Various Efficiencies	56
Boiler Efficiency Curves	59
<b>Chapter III - Some Revealing Relationships</b>	<b>65</b>
Introduction	65
Determining the Maximum Evaporation	65
Great Western Development of Mr Fry's Method	69
The Combustion and Absorption Efficiencies	72
Performance of the Heating Surfaces	88
<b>Chapter IV - The Response to Changes in Output</b>	<b>91</b>
Introduction	91
Changes in Firebox Temperature with Output	91
Distribution of the Heat Absorption between the Direct & Indirect Surfaces	94
Boiler Performance Diagrams	99
Some of the Factors Serving to Influence Boiler Performance	113
<b>Chapter V - Predicting Performance - I</b>	<b>129</b>
Introduction	129
Prediction Methods	129
Sample Design Procedures	146
Comparing Steam Output Predictions	177
Summary	179
<b>Chapter VI - Heat Transmission within the Firebox</b>	<b>187</b>
Introduction	187
Specific Heat Availability and Furnace Liberation Rate	187
Stationary Boiler Furnaces	188

Firebox Volume and Proportions	191
The nature of the Heat Transfer within the Firebox	194
Quantifying the Heat Absorbed and the Firebox Gas Exit Temperature	197
Combustion Chambers	205
Brick Arches and Firebox Refractory, Arch Tubes and Syphons	208
Summary	220
<b>Chapter VII - The behaviour of the Firebox in Service</b>	<b>223</b>
Introduction	223
Predicting Heat Transfer in the Firebox	224
The influence Excess Air, Scaling, etc. on the Heat Transferred	228
Determining a Thermal Loading Limit for a Boiler	235
The Woes of the Locomotive Firebox	240
Inner Firebox Movement	241
The Impact that High Heat Fluxes with or without Scaling had on Plate Temperatures	249
Summary	283
<b>Chapter VIII - Heat Transmission across the Tubular Surfaces</b>	<b>287</b>
Introduction	287
Some Characteristics of Tube Performance	287
Heat Transfer Within the Tubes	291
The Heat Transfer Process	295
Using Heat Transfer Formulae to Compare Tube Performance	301
Practical tube Performance	303
Special Profile Tubes	309
Tube and Flue Gas Exit Temperatures	319
Considering the Interaction Between the Tubes and Flues with Tubeplates	322
Why Tubular Heating Surface Behaves in the way it Does	327
<b>Chapter IX - Superheater Behaviour</b>	<b>331</b>
Introduction	331
Overview	331
Superheater Characteristics	337
The Paradox in Superheater Performance	343
Pennsylvania Railroad Superheater Tests	345
Superheater Elements	349
Metal Temperatures, Steam Velocity and Element Life	361
Steam Circuit Size vs Pressure Drops	
Superheater Temperature Control	368
Obtaining the Characteristic Curve and the Final Steam Temperature	374
Factors Influencing Superheater Performance	383
<b>Chapter X - Pressure Drop through the Boiler</b>	<b>399</b>
Introduction	399
Boiler Resistance and Heat Transfer	399
The Impact on Gas flow by Altering Individual Resistances	405

On the Nature of the Tubular Resistance	408
Concerning the Gas-Side Pressure Drop	414
Calculating the Pressure Drop in a Constant Diameter Tube System	418
Obtaining the Pressure Drops in the Tubes and Flues	421
The Pressure Drops in the Remaining Sections	435
<b>Chapter XI - Predicting Performance - II</b>	<b>439</b>
Introduction	439
Establishing Firebox Performance	441
Considering some Firebox Heat Transfer Predictions	447
Quantifying the Heat transfer within the Barrel	452
Using the Effectiveness-NTU Method to Predict Barrel Heat Transfer	459
Using the LMTD Method to Predict Barrel Heat Transfer	465
Observations and Comments Concerning the Two Prediction Methods	472
Other Superheater Designs	482
Other Possible Predictions	495
<b>Appendices</b>	<b>503</b>
A. Steam Tables and Superheat	503
B. The It - Diagram	507
C. Example Combustion Calculations	510
D. Enthalpy and Other Waste Gas Properties	515
E. The Traditional Heat Balance	518
F. Some Notes Concerning Heat Transfer within the Firebox	520
G. Roland Bond's Averaging Method	525
H. Lawford Fry's Initial Method	527
I. Fry's Revised Methods for Determining Superheat and Heat Transfer	532
J. William Roland's Method	539
K. D W Sanford's Method for Determining the Gas Flow through Tubes and Superheater	542
L. Some Great Western Boiler Calculations	545
M. German Approaches	549
N. Some Metallurgical Considerations	557
O. Boiling Phenomena	564
P. Complete Boiler Prediction Example	568