Multipoint Probes to Mitigate Stratification
CEMTEK Users Meeting

September 28th, 2016
M&C supplies World Class Custom Designed Probes, Manifold Systems, Sample Tubes, Coolers, Analyzers, Samplers, Smart Controllers, Custom Sample Conditioning Panels, and Multipoint Probes for over 30 years.

US Headquarters
Ventura, CA

New Product Development Center
Reno, NV

M&C Technology Group—Embracing Challenge
Presentation Overview

- Why Use a Multipoint Probe
- Regulatory History
- Gas Laws
- Probe Selection Criteria
- Anatomy of a Multi Point Probe
- Performance Testing, QA, Maintenance
Typical CEMS Power Plant Monitoring Points
Why Use a Multipoint Probe?
Top 10 Reasons

10. **Samples multiple points which allows more precise results than a single point probe**

9. Allows more accurate sampling when SCR operating conditions change

8. **CAN SAMPLE FROM IRREGULAR SHAPED STACKS**

7. SCR seals eventually fail causing NH3 distribution across the Grid to Change-This change of NH3 will affect NOx emissions!

6. **The Stack Testers Van samples by traverse across the stack in an “X” type configuration which may not match up with single point probe**
Why Use a Multipoint Probe?
Top Ten Reasons

5. **CO configuration in a plant changes, NOx changes**

4. Aging plants stack emissions characteristics change

3. **PROACTIVE PLANT POLICY TO GET THE BEST SAMPLE**

2. Its in your Permit-District requires you to.

1. **You Fail your RATA**
Cross Stack Example with 4 Insertion Points
# 9 Changing SCR Conditions

- Issues With NH₃
  - Even Distribution
  - Proper Mixing Temp.
  - Fast start-up
  - Thermal Expansion
  - Balancing manifold
#8 Square Stack with Multipoint Array
#7 SCR & NOx Failure

- Improper Catalyst & Incorrect Catalyst Bed Temperature
- Catalyst Seal Fracture
- Poor AIG Design
- Poor Air Mixing
- Insufficient NH₃ injection capability
- SCR & NOx Failure
#6 Stack Tester Traverse Sampling finds Stratification at Stack

Stratification

Single Point Probes vs. Multi Point Probes
#5 CO Catalyst Issues

CO Catalyst Issues
#4 Aging Plant --Stack Characteristics Change

Gas Turbine Inlet & Outlet NOx
#3 Proactive Plant Policy-Avoiding Excess Emissions Events

What Constitutes Excess Emission Events (>2ppm NOx) and Breakdown?
#2 It’s in Your Permit

- **TITLE V OPERATING PERMIT APCD2006-TVP-XXXXX**
- **Issued To:**
  - Solar Turbines Inc.
  - Site ID: APCD1976-SITE-xxxxx
- **Site Address**
  - 100 Anywhere Road San Diego, CA 92123
- **Mailing Address**
  - P.O. Box 60609 San Diego CA 92186
- **Responsible Official:** John Wayne, President; Paul Mc Cartney, Director Packaging Systems
- **Facility Contact:** Marilyn Monroe, Manager EHS Permit Information
- **Contact:** Sharon Osbourne
- Issued by the San Diego County Air Pollution Control District on This Title V Operating Permit expires on .
- Signed by:
  - John doe, P.E., Chief of Engineering
#1 You Fail Your RATA

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EMTIC GD-031

Allowed for **Different sized holes** that are **only balanced** at **tested flow rate/ambient conditions** (temperature) and would behave differently while in service in some cases.

One of Reference Meters specified in test protocol **Required Very High Pressure Drop** and would **interfere** with **as built conditions** on **standard CEM System Flow Rates**

SCAQMD Supplemental Guidelines

Allowed for alternate flow meters to allow test apparatus to not interfere with **standard CEM System Flow Rates Required Array Sample Line** to be assembled, hot and utilized.
Checklist for Multi-Point Probe Acceptance & Quality Assurance Testing for SCAQMD

- Brief description, summary, critique of testing precedes documented results.
- Multipoint probe is configured and tested exactly as it will be assembled on proposed stack/duct sampling location including properly-sized sample/vacuum pump, valves, rotameters, required AP or vacuum gauges, flow meters, etc. (a simple drawing of this configuration, as tested is provided)
- A drawing or representation showing the probe(s) dimensions and location of points with respect to mounting flange or other point of reference is included.
- Total flowmeter specs (type/make/model/serial no./flow range) and current calibration (if applicable) are included.
- Point flowmeter specs (type/make/model/serial no./flow range) and current calibration (if applicable) are included.
- Sample/Vacuum pump specs (type/make/model/volume) are included.
- All vacuum meter/flowmeter/rotameter readings during test are recorded and included, as well as temperature/pressure corrections, if applicable. Current calibrations for all applicable metering devices are also included.
- All raw readings and data sheets, as well as calculated/summarized information is included.
- An example calculation, using actual data from this test is included.
- All reported deviations are with respect to the sum total of all points on all probes (not each individual probe).
- All applicable pages of the report are annotated as to company, data, time, personnel, run; or otherwise identified to tie the report together.
Gas Laws-How Emissions are Affected

Standard Temperature and Pressure (STP) and Ideal Gas Laws

Fluid flow rates and the volumes of liquids and gases are highly dependent on Temperature and Pressure.

Standard Ambient Temperature (25°C-77°F) and Pressure (1 atm) are utilized with gas analyzers

Gases are made up of molecules in constant random motion

Pressure—is a result of gases colliding and hitting walls of stack, which are perfectly elastic (no loss of kinetic energy)

Temperature—proportional to the average kinetic energy of gases
**Gas Laws**

**Ideal Gas Law**

\[ PV = nrT \]

Boyle’s Law – assumes constant temperature  
Charles Law – assumes constant pressure  
Guy-Lussac’s Law – assumes constant volume  

or  

**“Real” Gas Law**

\[ PV = ZnRT \]

Allows for the compressibility of gas  
Analyzer companies allow for this compressibility factors when developing the programs and factors to calculate results
### Flow Related Forces from Gas Flow

#### Probe Tube Force Calculations

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<td>Probe Projected Area</td>
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<td>Von Karman Force, lbs</td>
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<td>Von Karman Frequency, ( f )</td>
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<td>Drag Force, ( F_D )</td>
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<td>( \text{given} \Delta P = 1.4 \text{ bar} )</td>
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<tr>
<td>( \text{with} N_R = 10^5 )</td>
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<td>( \text{If for other} N_R, \text{compute appropriate} C_D )</td>
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<tr>
<td>Resultant Force</td>
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<td>Resultant Moment, for strength calc's</td>
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Analyzer Bias’s from Pressure

Analyzers are sensitive to the pressure of the gas in the measurement cell. In calibration mode, a high gas flow rate from the calibration gas cylinder can pressurize the cell and lead to subsequent sample measurement biases. In spectroscopic absorption instruments, (NDIR) the gas concentration measured is related to the number of molecules in the light path. If the pressure is increased, the density of the sample gas is increased. The number of molecules in the light path increases correspondingly, even though their true concentration remains the same.

Gas flow rate into the measurement cell must be the same in both calibration and sampling modes.

Most gas manifolds are maintained to exhaust at a fixed pressure, the flow rates in both the calibration and sampling modes should be set so that this pressure is not exceeded.

What Causes Stratification in a Stack

- Sharp 90 degree elbow
- Cavity at Base of Smokestack
- Wet Scrubber
- Flow
- Reverse Flow on inner wall
- Asymmetric Velocity Profile
- Axial Velocity Skewed toward Outer wall
- Recirculation Zone in Cavity
Probe Selection Criteria

• What are the characteristics of the stack-height, size, interior, dimensions, sample locations, area classification?

• Any temporal variations (stratification) in the stack?

• Sample residence time?

From this information the type of probe-traditional, dilution or multipoint can be selected. The correct engineered probe will be designed for your application.
Probe Selection-It’s Complicated cont.

What gases are being measured & at what ppm levels?
Reactive & other gases and temperature in stack are critical!

Dew Point, water vapor in stack?
Acid dew point-high SO₂ may require acid mist catchers, additional filters....

Stack Hazard class-Probe needs to be engineered to fit classification
-Class 1 Div 2...

Impact of final optimal configuration upon CEMS QA/QC plan
Multipoint Design Criteria

- Probe design is based on stack dimensions and conditions.

- Stacks that are < 80 feet typically have flow disturbances in close proximity to sampling range (silencer can cause issues).

- Shorter stacks commonly have temporal variation.

- Shorter stacks make the engineering of a multipoint probe more challenging due to shorter residence time, and shearing stress on the sample tubes.

- M&C has engineered multipoint probes for stacks <80 feet.
Probe Selection Criteria

• Is the sample gas “dirty”, with particulates, oil, or other contaminants?

• How wet is the sample (dew point)?

• What temperature is the stack where gas will be sampled?

• What gases are being measured and at what ppm?

• What other gases/acids will be present, which may cause sampling & measurement issues or require additional components..... Filters?
Multi Point Probe Design

-Its Complicated

Stack coordinates, round or square, height (upstream/downstream distance from flow disturbances (method 1)

The stack temperature, flow, pressure and residence time are critical in designing the correct probe for your application.

-Mechanical Strength of probe required for high velocity and temperature.
-Prepare the correct flow rates and residence time and submit test procedure for approval from district

What fuel is used-oil, coal, natural gas, waste, biofuels, Biomass, Digester Gas, trash, tires...

-The fuel contaminants & Particulates/dust loading will also effect the probe design in selecting the correct filters, shields, separators, acid mist catchers, blow back....
Using the Correct Probe is Critical

NOx measurement at sub 5 ppm is challenging. Sample Extraction is the Key to Good Measurement.

The probe is the most critical component that can be controlled, in getting a representative sample.

Multipoint Probes ensure a representative sample due to their design to sample across the stack at multiple points. More sample points mean a better sample of the gases to be measured even when the sample conditioning vary.
Typical Multi-Point Probe Configuration

Basic & Required Components

- Probe Assembly
- Calibration Gas In (required)
- Vacuum Gage (required)
- Blowback Air Supply In
- Flowmeter (required)
- Gas Sample in the Facility CEMS

Auxiliary Sample Port
Each multipoint probe is custom engineered based on the individual stack characteristics.
Anatomy of a Multipoint Probe

- Probe Tubes or barrel
- Heated/unheated filters
- Probe controller
- Accumulator tank for blow back
- Mixing chamber
- Probe housing dependent on area classification
- Flange
Sample Tubes for Various Applications

Gas sampling requires an extension tube to properly extract sample from a specific point in the gas stream. The correct configuration of tubes and material is critical.

Examples:
Screw-in Tubes
Flange-Welded Tubes
**Multipoint Tubes**
Stainless
Hastelloy
**Silcoat or Sulfinert**
Teflon
Sintered Tubes

The sample tube material is based on the application. Temperature of sample, actual gas sampled, other gases present, width of stack, stratification, all play a critical role in tube or array design.
Cantilever Probe Tube

Cantilever Probe Tubes

(4) Sample Orifice per Tube. Sample Orifice Locations Determined by EPA Method 1 for Stack Dia _____", _____" Ports, _____" Offset Orifice Size(s):_____
(#) Ea. Required Per Stack. (16 Total Points In Array) Materials:
Support Tube:
Sample Tube:
Support Structure:

4" 150# ANSI Raised Face (RF) Flange
Options for Low dust loading <2 g/m³

SP2000/SS stainless steel up to 600°C
SP2000/T teflon up to 160°C
SP200/TI titanium up to 400°C
SP2000/HC hastelloy up to 900°C
Factors to Consider for Filter Selection

**Corrosive** or **Aggressive** Sample Constituents

**Heated Or Unheated Filter**

What **Gases Are To Be Monitored?**

Downstream **Component Operating Temperature**, **Filter Heater**

Downstream **Component Operating Pressure**, **Pressure Regulator** and/or **Relief Valve** Required

Sample **Dewpoint** (Acid, Hydrocarbon, or other), **Separator** and/or **Membrane** Required

Spectral **Interference In Sample**, **Adsorption Material**

**Area Classification**

**Flow Requirement**

Heated filter

Probe tube prefilter
Accumulator Tank

Accumulator Tank

Accumulator Tank in Uninsulated probe housing
Mixing Chamber
Probe Housing

Insulated Housing

Uninsulated Housing
Filters, Separators, Shields

Shield

Heated Filter

Separators

Shield
Multipoint Probe with Mixing Manifold
Arrays are custom designed for stacks with gaseous stratification, or a variation in contaminant and/or diluent gas concentration with temporal variation (inconsistent stack flow). SCAQMD has been requesting multi point arrays for new applications.

The array consists of a number of sample extraction points or holes on one or more probes, configured to equally cover the proposed stack or duct cross sectional area of interest. The probe(s) are manifolded together to a high volume, positive displacement sample pump, must have flow and vacuum meters to monitor probe performance, as well as an audit Port.

Stream selection Manifold for SCR tuning in stratified flow

Arrays are common in applications <10 ppm NOx, in SCAQMD
Probe Placement in Stack is Critical

Method 1—Sample and Velocity Traverses for Stationary Sources

Method 1 will provide guidance for the selection of sampling ports and traverse points at which sampling for air pollutants will be performed. Two procedures are provided a simplified and alternate. Acceptable for gas streams flowing in ducts, stacks or flues.

Not Applicable for conditions where:
- the flow is cyclonic or swirling
- a stack is smaller than 12 in. in diameter, or 113 in.2 in cross-sectional area
Probe Placement in Stack is Critical

Simplified Procedure

Sampling or flow velocity site located at least **eight stack or duct diameters downstream** and **two diameters upstream** from any flow disturbance (bends, expansion or contractions in the stack or visible flame)

- 12 traverse points required circular/rectangular >24 inch stacks
- 8 traverse points required circular 12 to 24 inch stacks
- 9 traverse points required rectangular 12 to 24 inch stacks
EPA METHOD 1 CALCULATION, 16 PT TRAVERSE

Calculates (8) traverse point locations across circular stack
Mount probes (traverses) on two axis at 90° to complete traverse
Calculation per 40CFR part 60, Method 1

Enter Stack Diameter (inches) 140
Enter Port Offset (inches) 12

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Performance Testing Criteria

With flow being critical to the operation of a multi-point probe, the total flow rate of which the probe is certified or will be the minimum allowable volumetric flow rate for the CEMS to operate.

Performance Criteria for Acceptable Operation is Dictated by Statistical Criteria Specified in EMTIC GD-031

Array Differential Pressure is also recorded during test procedure and the as tested differential pressure can be monitored on a periodic basis to insure that the multi-point probe is operating in a balanced flow condition during field operations.
Bench Testing is required in accordance with EPA/EMTIC Guidance Document (GD)-031 Evaluation Procedures for Multi-Hole Sample Probes

Assures that high-volume sample pumps can provide constant & equal flow to all points of the probe array

Test Measures Total & Individual Point Flow with:
- each individual sample point being within 10% of the overall flow average
- the sum of all individual point flows must be within 10% of the overall flow

Formal notification of CEMS initial approval or Probe recertification must be received by AQMD before the multi-point probe is installed.
Probes: Correct Design is Necessary

Probe Filter is not correct for application—too much particulate

Probe has cold spots, poor temperature controller—results in moisture in sampled gas and loss of sample gas in moisture

Probe Mounted Incorrectly or installed in wrong place in stack—does not meet method 1 requirements, non representative sample

Blowback not setup correct—need properly sized tank

Stratification in stack causes poor sampling—need multipoint probe

Array setup incorrectly—various configurations custom engineered
Quality Assurance

The following must be addressed in the QA document for the Multi-point probe

1. Periodic system Blowback
2. Visual inspection for corrosion, plugging, leaking
3. Periodic Pump/Conditioning system PM (by vendor, or visual problems see 2)
4. Total flow & vacuum readings must be periodically recorded
5. Periodic AQMD audit of probe performance (by AQMD or 3rd party)

Multi-point probes with reference method audit ports can not be used as a QA RM CEMS/ Audit tube can not be used to validate performance of the probe to acquire a representative gas sample, since any errors (leaks, point bias) would be Mirrored by both CEMS
Good Maintenance Practices

- Check probe prefiltter, if plugged replace
- Check probe temperature
- Check flow through to the sample
- Confirm CEMS operation by daily calibration
- Check Calibration and zero gas cylinders, pressure >200lbs.
The M&C Difference

• M&C Tech Group has worked with SCAQMD when Multi Point Probes were originally designed to meet the correct sampling guidelines.

• Design for each Multipoint Probe is custom to users application.

• M&C communicates and supports customers every step of the process from design to RATA.

• Over 15 years experience with every Multi Point Probe units, with all passing their RATA.

• Multi Point Probe support continues after certification.
Thanks for Listening
Questions?

Bernadette Shahin
M&C Technology Group North America

805-256-5818
bshahin@mac-products.com

M&C Technology Group—Embracing Challenge