



**RECOMMENDED GOOD PRACTICE**

**INSTRUMENTATION CHECKLIST AND  
CLASSIFICATION GUIDE FOR INSTRUMENTS AND  
CONTROL SYSTEMS USED IN THE OPERATION OF  
BLACK LIQUOR RECOVERY BOILERS**

THE BLACK LIQUOR RECOVERY BOILER ADVISORY COMMITTEE

April 2014

*BLRBAC RECOMMENDED GOOD PRACTICE  
Instrumentation Checklist and Classification Guide  
for Instruments and Control Systems Used in the  
Operation of Black Liquor Recovery Boilers  
February 2023*

---

**Notice and Disclaimer of Liability Concerning Recommended Guidelines and Procedures**

BLRBAC brings together volunteers from operating companies, manufacturers and insurance companies representing varied viewpoints and interests to achieve consensus on Guidelines and Recommended Practices for the safe operation of recovery boilers. While BLRBAC facilitates this process, it does not independently test, evaluate or verify the accuracy of any information or the soundness of any judgments contained in its Recommended Guidelines and Procedures.

BLRBAC disclaims liability for any personal injury, property or other damages of any nature whatsoever, whether special, indirect, consequential or compensatory, directly or indirectly resulting from the publication, use of, or reliance on BLRBAC Guidelines and Recommended Practices. BLRBAC also makes no guaranty or warranty as to the accuracy or completeness of any information published herein.

In issuing and making this document available, BLRBAC is not undertaking to render professional or other services of or on behalf of any person or entity. Nor is BLRBAC undertaking to perform any duty owed by any person or entity to someone else. Anyone using BLRBAC Guidelines and Recommended Practices should rely on his or her own independent judgment or, as appropriate, seek the advice of a competent professional in determining the exercise of reasonable care in any given circumstance.

**USERS OF BLRBAC GUIDELINES AND RECOMMENDED PRACTICES SHOULD CONSULT APPLICABLE FEDERAL, STATE AND LOCAL LAWS AND REGULATIONS RELATING TO THE SAFE MANUFACTURE AND OPERATION OF RECOVERY BOILERS. BLRBAC DOES NOT, BY THE PUBLICATION OF ITS GUIDELINES AND RECOMMENDED PRACTICES INTEND TO URGE ACTION THAT IS NOT IN COMPLIANCE WITH APPLICABLE LAWS, AND ITS PUBLICATIONS MAY NOT BE CONSTRUED AS DOING SO.**

*BLRBAC RECOMMENDED GOOD PRACTICE  
Instrumentation Checklist and Classification Guide  
for Instruments and Control Systems Used in the  
Operation of Black Liquor Recovery Boilers  
February 2023*

---

Table of Contents

<b>CHANGES .....</b>	<b>4</b>
<b>CHAPTER 1 PURPOSE AND SCOPE .....</b>	<b>5</b>
<b>CHAPTER 2 TERMS AND DEFINITIONS .....</b>	<b>7</b>
<b>CHAPTER 3 GUIDELINES FOR RECOVERY BOILER CONTROL SYSTEMS.....</b>	<b>11</b>
3.1 FAIL SAFE MODE .....	11
3.2 ELECTRICAL POWER SOURCES .....	11
3.3 CONTROL SYSTEM RELIABILITY.....	11
3.4 CRITICAL PROCESSES.....	12
3.5 COMMUNICATIONS.....	12
3.6 HUMAN MACHINE INTERFACE .....	12
3.7 HARDWARE JUMPERS AND SOFTWARE FORCES (BYPASSES).....	12
3.8 SYSTEM SECURITY .....	14
3.9 CONTROL SYSTEM ENVIRONMENT .....	15
3.10 APPROVALS .....	15
3.11 GROUNDING.....	15
3.12 PREVENTIVE MAINTENANCE .....	15
3.13 FUNCTIONAL TESTING.....	16
<b>CHAPTER 4 GUIDELINES FOR USING A RECOVERY BOILER SAFETY SYSTEMS.....</b>	<b>17</b>
4.1 GENERAL RECOMMENDATIONS .....	18
4.2 SAFETY INSTRUMENTED SYSTEMS APPLIED TO ESP .....	19
4.3 SAFETY INSTRUMENTED SYSTEMS APPLIED TO BURNER MANAGEMENT.....	20
<b>APPENDIX A INSTALLATION CHECKLIST AND CLASSIFICATION GUIDE FOR INSTRUMENTS AND CONTROLS USED IN THE OPERATION OF BLACK LIQUOR RECOVERY BOILERS .....</b>	<b>21</b>
A. FEEDWATER AND STEAM SYSTEMS .....	22
B. COMBUSTION AIR CONTROL SYSTEMS .....	23
C. FURNACE DRAFT SYSTEM .....	24
D. FIRE PROTECTION SYSTEM.....	25
E. BOILER CLEANING SYSTEM.....	26
F. SMELT SPOUT COOLING SYSTEM.....	27
G. BLACK LIQUOR AND GREEN LIQUOR SYSTEMS .....	28
H. FLUE GAS EMISSIONS .....	37
I. AUXILIARY FUEL AND BURNER SYSTEM .....	38
J1. WASTE STREAMS INCINERATION / DNBCG SYSTEMS.....	40
J2. WASTE STREAMS INCINERATION / CBNCG SYSTEMS FAN DELIVERY.....	41
J3. WASTE STREAMS INCINERATION / CBNCG SYSTEMS STEAM EJECTOR DELIVERY. ...	43
K. WASTE STREAMS INCINERATION / CNCG SYSTEMS.....	45
L. WASTE STREAMS INCINERATION / SOG SYSTEMS.....	47
M. WASTE STREAMS INCINERATION / LIQUID WASTE STREAMS BLENDED WITH BLACK LIQUOR.....	49
N. WASTE STREAMS INCINERATION / LIQUID WASTE STREAMS INCINERATION IN DEDICATED BURNERS.....	51
O. GENERAL SYSTEMS .....	52
<b>APPENDIX B DOCUMENT REVISION HISTORY .....</b>	<b>53</b>

*BLRBAC RECOMMENDED GOOD PRACTICE  
Instrumentation Checklist and Classification Guide  
for Instruments and Control Systems Used in the  
Operation of Black Liquor Recovery Boilers  
February 2023*

---

## **CHANGES**

### **February 2023**

Added 4.12. Details recommended qualifications and knowledge for Electrical and Instrumentation (E&I) technicians that perform maintenance on recovery boilers.

### **April 2014**

Updated document to remove dated language and cleared up descriptive language to convey intent.

### **April 2013**

Revised Chapter 1 to recommend functional testing whenever modifications are made to recovery boiler instrumentation or control systems.

Added definitions for “Functional Test” and “Modifications” in Chapter 2.

Added Section 3.13, Functional Testing.

Deleted references to Safety Instrumented System (SIS) and replaced with new term Recovery Boiler Safety System (RBSS).

Added definitions for Emergency Shutdown Procedure (ESP) System, Process Control System (PCS) and Recovery Boiler Safety System (RBSS).

Deleted definitions for Basic Process Control, PC, and Safety Instrumented System (SIS)

Additional word changes for consistency with the ESP System recommendations in the ESP Recommended Good Practice.

Added checklist:

- J1. Waste streams incineration / dncg systems
- J2. WASTE STREAMS INCINERATION / CBNCG SYSTEMS FAN DELIVERY
- J3. WASTE STREAMS INCINERATION / CBNCG SYSTEMS STEAM EJECTOR DELIVERY
- waste streams incineration / cncg Systems
- WASTE STREAMS INCINERATION / SOG SYSTEMS
- WASTE STREAMS INCINERATION / LIQUID WASTE STREAMS BLENDED WITH BLACK LIQUOR
- WASTE STREAMS INCINERATION / LIQUID WASTE STREAMS INCINERATION IN DEDICATED BURNERS
- GENERAL SYSTEMS

### **February 2012**

“Notice of Disclaimer of Liability” has been added to page 2.

*BLRBAC RECOMMENDED GOOD PRACTICE  
Instrumentation Checklist and Classification Guide  
for Instruments and Control Systems Used in the  
Operation of Black Liquor Recovery Boilers  
February 2023*

---

## **CHAPTER 1 PURPOSE AND SCOPE**

The purpose of this Recommended Good Practice is to provide guidelines for the design, installation, and operation of Recovery Boiler Basic Process Control Systems (RBBPCS) and Recovery Boiler Safety Systems (RBSS) to contribute to operating safely.

No recommendations can be promulgated which will guarantee the elimination of furnace explosions. Technology in this area is under continuous development and will be reflected in later revisions to these recommendations.

These recommendations are based upon the present state of the art and therefore may not be applicable in its entirety to older designs and installations. It is recognized that the number of operating personnel, proximity of operator controls to the recovery boiler, whether a remote control room is provided, etc., may influence the requirements for other instruments or instrumented control systems. Accordingly, it is recommended that the operating companies review this Recommended Good Practice and adopt such features as appear applicable and reasonable for existing installations.

The Black Liquor Recovery Boiler presents challenges of service requirements, operation, fuel burning, reliability, and safety margins. Consequently, the instrumentation selected should be chosen with deliberate discrimination.

The importance of proper maintenance, clean, dry, well regulated air, and a reliable regulated source of electricity cannot be over emphasized. The best of instrumentation becomes meaningless without these essentials.

This Recommended Good Practice is intended as a guide and checklist to provide the proper tools for promoting safety and long term unit availability. It is not intended to specify specific hardware, but to recommend the functions desired for proper operation of the unit.

As used in this Recommended Good Practice the term SHALL is intended to mean required for normal operation and the term SHOULD is intended to mean recommended where applicable.

This Recommended Good Practice includes as one of the tabulated items a Classification Index which determines whether a particular operating mode or technique falls within the following defined scopes:

Classification I      **REQUIRED FOR NORMAL OPERATION** - Denotes functions necessary for operations.

*BLRBAC RECOMMENDED GOOD PRACTICE  
Instrumentation Checklist and Classification Guide  
for Instruments and Control Systems Used in the  
Operation of Black Liquor Recovery Boilers  
February 2023*

---

Classification II      RECOMMENDED WHERE APPLICABLE - The choice may be at the option of the designer. Its function or equivalent should be provided.

Operator training, maintenance, and carefully established emergency shutdown procedures are recognized as essential to safe operation of Black Liquor Recovery Boilers.

As a basic requirement to assure good practice in the instrumentation and control aspects of recovery boilers, each mill should prepare and maintain instrument and control system documents for each boiler. The documentation should be accurate and complete in every detail, showing location and connections of all instruments and control elements. Relevant operating information should be included. This documentation will provide the basis for system analysis, technical upgrading and hazard evaluation.

All subsequent changes to the system should be authorized by at least the department superintendent or their designee and the documentation shall be upgraded. A hazard evaluation should be made prior to any system changes. Functional testing should be done any time modification work has been performed.

This Recommended Good Practice is an effort to provide documentation of a minimum acceptable industry practice and should not be interpreted in a manner to reduce the level of specific procedures currently practiced by individual operating companies.

*BLRBAC RECOMMENDED GOOD PRACTICE  
Instrumentation Checklist and Classification Guide  
for Instruments and Control Systems Used in the  
Operation of Black Liquor Recovery Boilers  
February 2023*

---

## **CHAPTER 2 TERMS AND DEFINITIONS**

**Analog:** Continuous variable signals or values.

**Attemperator:** A device to reduce the steam temperature by mixing it with lower temperature steam or water, or by passing it through tubes immersed in water of a boiler drum, generally by means of automatic control. The same as desuperheating.

**Auto-manual Control:** A control station (or selector station) which permits the operator to select either automatic or manual operation of equipment, can be at a location remote from the actual physical hardware, e.g., the operator may make an adjustment in the control room to change the position of a damper in an air duct hundreds of feet away. The operator may place the control station in the automatic mode and permit a controller to position the damper as required to maintain proper control.

**Control Systems:** A control system is a device, or set of devices, that manages, commands, directs or regulates the behavior of other device(s) or system(s). In the black liquor recovery boilers, we generally focus on the Recovery Boiler Basic Process Control System (RBBPCS) and Black Liquor Recovery Boiler Safety Systems (RBSSs). These generally consist of either DCS or PLC programmable logic systems, hard wired relay logic and/or a collection of individual electro-pneumatic controller loops. There may also be sub-control systems of these primary systems as well as other auxiliary control systems.

**DCS:** Distributed Control System - a control system whereby intelligent controllers and associated input/output hardware control different parts of the process, and are interconnected to each other by communication links.

**Desuperheat:** To reduce the temperature of a gas, i.e., steam to a lower temperature or to its saturation temperature. The saturation temperature is the boiling temperature of a liquid at its operating pressure.

**Digital:** Two-state signals or values, i.e., On-Off, High-Low, One-Zero.

**Economizer:** A tubular heat exchanger following the boiler bank. The boiler feedwater flows through the tubes increasing the water temperature just before it enters the boiler drum. The flue gases give up more of their heat as they pass through the economizer. This reduces the fuel required to produce steam; therefore it is called an economizer.

**Emergency Shutdown Procedure (ESP) System:** An operator initiated safety control system, composed of sensors, logic solvers, interconnections, and final control elements that take the boiler to the predetermined conditions as defined in the “ESP Recommended Good

*BLRBAC RECOMMENDED GOOD PRACTICE  
Instrumentation Checklist and Classification Guide  
for Instruments and Control Systems Used in the  
Operation of Black Liquor Recovery Boilers  
February 2023*

---

Practice”. The logic solvers can be comprised of electromechanical relays, independent microprocessors, and/or integrated as part of another Recovery Boiler Safety System (RBSS), such as the Burner Management System (BMS).

**Evaporator, Cascade:** A cylindrical bundle of tubes or plates attached to hubs and rotated by a horizontal axle. The horizontal elements and axle shaft form a wheel much like a paddle wheel, except that the elements provide lower resistance to the black liquor and flue gases. As the wheel rotates, the elements dip into and pass through the black liquor pool in the bottom. The rotation acts like a pump to lift the black liquor out of the pool. The hot flue gases heat the surface film, evaporating the moisture and concentrating the black liquor. The cascade evaporator is a direct contact evaporator because the hot flue gases directly contact the liquor being evaporated.

**Evaporator, Cyclone:** An evaporator in the shape of a cylinder in which the flue gases enter tangentially near the bottom and exit at the center of the top. The black liquor is sprayed into the flue gases at the tangential entrance and around the top of the cylinder. The concentrated black liquor flows down the sides of the cyclone cylinder into a funnel and out the bottom. The evaporated moisture is carried out the top with the flue gases. A cyclone evaporator is a direct contact evaporator.

**Evaporator, Direct Contact:** A heat exchanger (Cascade or Cyclone Evaporators) in which hot flue gases are in direct contact with the black liquor. As the flue gases heat the liquor, water is evaporated. This is used to concentrate the black liquor up to a minimum of 58 percent total solids for firing.

**Final control element:** The field device that alters the process being controlled.

**Functional Test:** A method of proving all elements of a system operate as designed.

**Interconnection:** The physical linking of two or more devices for the mutual exchange of signal, process data, or equipment status.

**Logic solver:** A logic solver is any device that receives input signal(s), makes appropriate decisions based on the nature of the signal(s), and provides an output according to user-defined logic.

**MFT:** A Master Fuel Trip is a function of a Recovery Boiler Safety System (RBSS) that initiates the stoppage of all fuel (oil, gas, black liquor and waste streams) to the boiler.

**Micro Processor:** An intelligent piece of hardware, usually capable of executing only pre-defined programs. It usually cannot store or retrieve data from bulk storage devices.



*BLRBAC RECOMMENDED GOOD PRACTICE  
Instrumentation Checklist and Classification Guide  
for Instruments and Control Systems Used in the  
Operation of Black Liquor Recovery Boilers  
February 2023*

---

**Modification:** A change or alteration that results in a deviation from the original design specifications or criteria.

**Monitor:** A means of showing (or reminding) the operator of conditions as they occur. A monitor displays a condition or measurement.

**Noxious Stack Gas Analyzers:** A group of gas analyzers which measure the presence and concentration of objectionable gases which are contained in the flue gases of a recovery boiler. Examples are: TRS (totally reduced sulfur), SO<sub>2</sub> (sulfur dioxide), NOX (Nitrogen Oxides), etc.

**Opacity (Smoke, Particulate):** The measurement of light transmittance through a duct or stack. By proper calibration methods an opacity meter can measure particulate matter solids suspended in a gas stream, i.e., flue gases. An opacity meter can also measure smoke density, turbidity in liquids, etc. It is basically a means of measuring the loss of light between a light source and a light receiver.

**Percent Total Solids in Black Liquor:** The percentage of solids by weight in black liquor fluid in the recovery system. For example, if the black liquor is 70% solids, then 30% is water.

**Powered Relief Valve:** An electrically or pneumatically operated quick opening valve which relieves excess steam pressure. It is generally set at a lower pressure than mechanically (spring) operated relief valves.

**Precipitator:** A means (usually electrostatic) for collecting dust in the flue gases just before they go up the stack. The flue gases pass through a high voltage electric field and dust particles take on an electrostatic charge. The charged dust particles are then attracted to oppositely charged plates or wire in the chamber. The dust particles attached themselves to the wire where they precipitate into large groups or clumps which are too heavy to be carried by the flue gas stream. These clumps fall into a hopper where they are removed.

**Primary Black Liquor Heater:** Usually a direct contact heater which injects steam directly into the low temperature black liquor. This heater is normally located on the suction side of the black liquor nozzle pump. Indirect heaters may be used to avoid dilution of the black liquor.

**Process Control System (PCS):** A system that responds to input signals from the equipment under control and/or from an operator and generates output signals that cause the equipment under control to operate in the desired manner.

*BLRBAC RECOMMENDED GOOD PRACTICE  
Instrumentation Checklist and Classification Guide  
for Instruments and Control Systems Used in the  
Operation of Black Liquor Recovery Boilers  
February 2023*

---

**Programmable Logic Controller (PLC):** A digital first level control device utilized for sequencing operations which are configured using ladder logic and may have limited analog or continuous control capability.

**Record:** A measurement that is continuously collected over a given time sample, using a chart recorder or trend log in a DCS system. **NOTE:** The time sample rate selected represents the most accurate record.

**Recovery Boiler Basic Process Control System (RBBPCS):** A system composed of sensors, logic solvers, interconnections and final control elements for the purpose of maintaining continuous safe operation of the recovery boiler within predefined operating parameters.

**Recovery Boiler Safety System (RBSS):** A system composed of sensors, logic solvers, interconnections, and final control elements for the purpose of placing the process in a defined safe state when predetermined conditions are violated. Recovery Boiler Safety Systems include, but are not limited to:

- Emergency Shutdown Procedure (ESP) System
- Burner Management System (BMS)
- Flame Supervisory System (FSS)
- Black Liquor Divert (BLD) System

**SAMA Logic:** Represents the total control loop philosophy with symbols and a diagramming format. (SAMA- Scientific Apparatus Manufacturers Association).

**Secondary Black Liquor Heater:** Usually a direct contact heater which injects steam directly into the warm black liquor. This heater is between the discharge of the black liquor nozzle pump and the black liquor spray nozzles in the furnace. Indirect heaters may be used to avoid dilution of the black liquor.

**Sensor:** A device that measures a physical quantity or property and converts it into a signal which can be read by an observer or by an instrument.

**Smelt Bed Camera:** A video camera to observe smelt bed and combustion conditions.

**Smelt Spout:** A trough which drains the molten smelt from the furnace into the dissolving tank. It is cooled to retard spout wastage by molten smelt. Water is commonly used as the cooling medium.

**Soot Blower:** A device using steam or compressed air for blowing dust, soot and ash from the fire side of the boiler tubes. Most soot blowing systems operate automatically and usually have a sequence control to blow in a specific pattern or arrangement.

## **CHAPTER 3 GUIDELINES FOR RECOVERY BOILER PROCESS CONTROL SYSTEMS**

### **3.1 Fail Safe Mode**

Fail safe is a designed property of an item which prevents failures from becoming critical failures. A critical failure is one which is likely to cause injury to persons or significant damage to equipment. In process control applications, fail safe refers to the pre-determined safe state each control component reverts to upon loss of motive power or its control.

The change that actuates the particular fail safe mode is an automatic response to an undesirable operating condition and it is not operator initiated.

Final control elements of any material that enters the boiler such as black liquor, auxiliary fuels, air, water, waste streams, etc., shall be fail safe.

Control systems that actuate the combustibles final control element are to be fail safe. The intent is to maintain integrity of applicable BLRBAC firing starting logic and tripping logic schemes.

### **3.2 Electrical Power Sources**

Firm power feed is required to the controls, system components, including primary elements and human machine interface (HMI). Firm power is any uninterruptible AC power supply or two independently supplied AC sources not susceptible to the same interruption.

### **3.3 Control System Reliability**

Fail safe design is the first level of protection in preventing critical failures. The next level of protection is the degree of reliability of the process control system. Reliability is the probability that a device will function without failure over a specific time period.

Safe control system design practices should be utilized to ensure that the operator can retain control of boiler processes during all operating conditions, including the ability to safely shut down the boiler during control system failures. Manual control is an acceptable mode of operation.

*BLRBAC RECOMMENDED GOOD PRACTICE  
Instrumentation Checklist and Classification Guide  
for Instruments and Control Systems Used in the  
Operation of Black Liquor Recovery Boilers  
February 2023*

---

Control system architecture which consolidates multiple control functions could render many control elements inoperable with a common failure. In recognition of common failure points in consolidated control systems, transfer of control from the faulted unit to an alternate unit or method shall be considered. Failure of one control system component shall not render more than one instrument loop or motor control inoperable. The transfer to the back-up control may be automatic or initiated by the operator.

An alternate unit or method maintains reliability inherent in the single loop, single motor controls. This would apply to control loops identified in the applicable BLRBAC publications.

### **3.4 Critical Processes**

Critical loops are processes that must have a back up. Back up consists of an automatic or alternate ability to continue running that process safely or bring that system to a safe state. The following are the minimum closed process control loops identified as critical: Drum Level, Furnace Pressure, Fuel Supply (Black Liquor Auxiliary Fuel and Waste Fuels), and Combustion Air Flow Regulation as applicable.

### **3.5 Communications**

Redundant communications paths shall be required. Each communication path external to the cabinets should be routed separately so that damage to one will not necessarily cause damage to both.

### **3.6 Human Machine Interface**

The intent of this section is to define HMI (Human Machine Interface) and to provide an operator interface to the process without a single point of failure.

HMI is defined as a means for an operator (HUMAN) to interact with various processes from devices as simple as single loop controllers to more complex systems interfacing with multiple signals and controls via processor based systems.

Regardless of the method(s) selected, arrangements shall ensure the operator always has at least one available and accessible method of control at all times.

### **3.7 Hardware Jumpers and Software Forces (BYPASSES)**

- Normal Operations

Bypassing of operational control system functions should not be part of normal operating procedures.

*BLRBAC RECOMMENDED GOOD PRACTICE  
Instrumentation Checklist and Classification Guide  
for Instruments and Control Systems Used in the  
Operation of Black Liquor Recovery Boilers  
February 2023*

---

- Routine Maintenance

Routine maintenance that may require temporarily bypassing part of a process control system should be planned for in the design. Bypasses to modify the logic, alarms to notify operating personnel of the bypass and appropriate procedures shall all be in place to assure that safe operating conditions are maintained.

- Non-Routine Maintenance

In order to provide for orderly maintenance of a process control system, it may be necessary at times to bypass individual functions. Whenever a process control system function must be bypassed, a formalized jumper management system should be used. This would apply to physical hardwired jumpers as well as software logic bridges/branches and/or bit forces. It would also include any hardwired bypass switches or software logic toggles and any sensing line valves. Bypassing of process control system functions should only be conducted when alternate methods remain available for continuous monitoring and control of that process. There must always be the ability to monitor and correct for conditions that run out of bounds.

The use of a bypass shall be considered a priority condition and necessary repairs shall be expedited.

A jumper management system shall meet the following minimum requirements:

- Approval of the Facility Management Personnel or their designee for each jumper or force.
- Clearly indicate what process/interlock is being bypassed
- Clearly indicate why that process/interlock is being bypassed.
- Clearly indicate the anticipated time of restoration
- Procedures for performing the needed maintenance and
- A system for notification of effected operators, maintenance and supervisory personnel so that safe operations are maintained.
- A method of administration that identifies and documents when the bypass was installed and when it was removed as well as who installed the bypass and who removed it and provides for a routine of follow up and review.

*BLRBAC RECOMMENDED GOOD PRACTICE  
Instrumentation Checklist and Classification Guide  
for Instruments and Control Systems Used in the  
Operation of Black Liquor Recovery Boilers  
February 2023*

---

- Design

Designing a system to automatically disable an interlock that is not needed during certain operating modes is permitted.

### **3.8 System Security**

Interlocks, algorithms, alarm points, and other characteristics of controls should not be altered by unauthorized personnel or equipment failure.

It is not possible to define a procedure to guarantee the security of a modern control system. The extensive hardware available along with the flexibility of software does not permit a single set of rules for all installations. These guidelines express the intent, but do not define a detailed procedure.

Each installation shall be selected and installed with “Security” as important criteria. The user, system supplier, consultant and insurance carrier should all contribute to the decisions governing security.

The control system shall control and monitor the critical loops (including critical motor circuits) while providing the operator with dependable and accurate information. The direct control functions for critical loops shall not be altered by the operator.

Logic changes should only be performed when authorized by the superintendent after their review of the changes with the plant control specialist. Procedures for notification of operators, maintenance and supervisory personnel should be established and implemented so that safe operations are maintained. A functionality test shall be performed to verify proper operation of the system.

A software back-up procedure should be implemented by the mill.

Controlled access and environmentally correct storage should be provided for backup software.

At least two employees should be thoroughly familiar with the system, programming, spares, etc.

**System Security shall include the following:**

- Manage changes to settings and logic
- Manage the access of portable external data devices (i.e. thumb drives).
- Functionality testing after all changes
- Software back up.
- Personnel back up.

- Change Management
- Current updated documents

### **3.9 Control System Environment**

Hardware shall be installed in atmospheres conducive to promoting longevity of electronic components and consistent with manufacturer's specifications. (Reference applicable ISA documents)

### **3.10 Approvals**

The control system equipment and associated hardware shall be subjected to, and have passed the testing of, at least one approved standards organization such as UL, CSA, ULC, FM, NOC, etc. for use in industrial applications.

### **3.11 Grounding**

The grounding of the control system generally must be kept separate from the equipment and electrical power distribution grounding system. The manufacturer's recommendations should be followed in detail.

### **3.12 Preventive Maintenance**

#### Field devices:

A preventive maintenance program should be established for all control system components associated with the recovery boiler. A program should identify inspection tasks, inspection/calibration frequency, and reporting procedures necessary to schedule, track, and document individual devices.

Documentation shall include the following information as a minimum:

- date of inspection/calibration
- name of the person who performed the test or inspection
- serial number or other unique identifier of equipment
- current design parameters (baseline calibration specifications including end user engineering units and set points (alarm, trip points))
- results of inspection/test (design, "as-found" and "as-left" conditions)
- Inspector comments on overall integrity of inspected system
- A procedure should be used for maintaining, testing and repairing a system

*BLRBAC RECOMMENDED GOOD PRACTICE  
Instrumentation Checklist and Classification Guide  
for Instruments and Control Systems Used in the  
Operation of Black Liquor Recovery Boilers  
February 2023*

---

Control systems:

Preventive maintenance of control systems shall include:

- ◆ Maintaining environmental conditions
- ◆ Maintaining operator printing capability
- ◆ Maintaining regularly scheduled software/firmware backups
- ◆ Reviewing equipment life cycle and manage upgrades
- ◆ Maintaining / Service UPS (monitor UPS load)
- ◆ Checking on-line monitoring for system errors/problems
- ◆ Maintaining system documents (drawings, component information troubleshooting procedures)
- ◆ Managing and maintain adequate spare parts
- ◆ Checking redundant components for backup reliability
- ◆ Check firm power supplies
- ◆ Reviewing and updating vendor support contracts and contacts
- ◆ Maintaining field I/O integrity (i.e. corrosion, connections, etc...)

### **3.13 Functional Testing**

Functional testing of Recovery Boiler Safety Systems is intended to provide the recovery boiler owners and operators with confidence that the system will operate as designed. Functional testing should be conducted within the scope and frequency outlined in the following recommended good practices: Emergency Shutdown Procedures, Safe Firing of Auxiliary Fuels, Safe Firing of Black Liquor and Thermal Oxidation of Waste Streams. Functional Logic test plans shall be developed for each boiler based on the starting permissive and tripping interlock block diagrams from the recommended good practices referenced above. Functional testing should be done any time a modification or work has been performed on a Recovery Boiler Safety System that might reasonably affect its integrity. All testing should be documented and dated with detailed records maintained on file.

Functional testing shall verify that the safety systems field devices, wiring, hardware and logic are in sound conditions (i.e. no jumpers, bridges or forces in place, no plugged sensing lines, no broken actuators nor stuck valves or dampers, no damaged instruments nor burnt or corroded wiring, no inadvertent undocumented and/or improper software changes, etc..)



*BLRBAC RECOMMENDED GOOD PRACTICE  
Instrumentation Checklist and Classification Guide  
for Instruments and Control Systems Used in the  
Operation of Black Liquor Recovery Boilers  
February 2023*

---

A “complete” trip/interlock test incorporates a signal test from the sensing line (or initiating device for manual trips) through all associated circuitry and logic, and includes actuation of the final elements (valves, pumps, dampers, etc.) being interlocked. It should create or simulate, as safely as possible, the actual conditions being monitored at the sensing lines.

Note: Provided that a complete test through a common output (e.g. MFT) is performed, a test of the remaining individual trip conditions, to that common output only is acceptable.

While boiler start up, following a shutdown, provides the most feasible time for these tests, it is perfectly acceptable to conduct such tests throughout the planned operating interval, when possible. This would be applicable for auxiliary fuel and waste stream systems and possibly others depending on operating arrangements of the unit. Any unscheduled trips occurring during boiler start-up or operation may be applied toward meeting the intent of testing for that particular trip or permissive, provided the event is properly documented and a first out system is provided which verifies the source of the trip.

#### **CHAPTER 4 GUIDELINES FOR USING RECOVERY BOILER SAFETY SYSTEMS (RBSS)**

Recovery Boiler Safety Systems are provided to interrupt a process and initiate a pre-determined safe response in the event of an unsafe condition.

The system scope includes sensors, logic, final devices, interconnections and interfaces to other systems. Logic may be performed in an electrical, electronic or programmable electronic system. Technologies include:

- electronic relays and timers
- solid state logic types
- programmable electronic systems
- motor driven timers
- solid state relays and timers
- hard wired logic
- pneumatic components
- combinations of the above

Initiation may be manual, semi-automatic, or automatic. Applications include:

- ESP, Rapid Drain
- Safe Firing of Black Liquor
- Safe Firing of Auxiliary Fuel

*BLRBAC RECOMMENDED GOOD PRACTICE  
Instrumentation Checklist and Classification Guide  
for Instruments and Control Systems Used in the  
Operation of Black Liquor Recovery Boilers  
February 2023*

---

- Waste Stream Incineration

#### **4.1 General Recommendations**

These recommendations are in addition to specific recommendations outlined in all other BLRBAC Recommended Good Practices.

1. The RBSS shall be optimized for fault detection within the limits of the applied technology and all detected faults shall provide operator notification of a fault occurrence. This includes communication gateways.
2. System failures shall result in outputs faulting to and maintaining predetermined fail-safe operations.
3. System program protection shall be provided, to protect the system from unauthorized access.
4. On-line logic modifications of a RBSS are not permitted.
5. A written procedure/checklist shall be used for maintaining, functionally testing, and repairing a RBSS. The entire RBSS should be functionally tested including the sensor(s), the logic solver, and the final element(s).
6. System memory shall be non-volatile or battery backed (memory will retain program instructions on loss of system power).
7. Changes of state in the field elements shall be available to the logic in a RBSS in one second or less.
8. The elapsed time from logic realization of an operator command or trip condition to initiation of field action shall be two seconds or less. This is exclusive of input signal filtering.
9. Any RBSS used for ESP and/or safe firing of fuels shall not be subject to a shared single fault failure with other control and RBSS.
10. It is acceptable for control systems and RBSS to share Human Man Machine Interfaces.

*BLRBAC RECOMMENDED GOOD PRACTICE  
Instrumentation Checklist and Classification Guide  
for Instruments and Control Systems Used in the  
Operation of Black Liquor Recovery Boilers  
February 2023*

---

11. Operator indications of the field device functions shall be based on field device positive feedback.
12. Qualified electrical and instrumentation technicians should be readily available to always cover issues with the recovery boiler. Qualified should be defined as a technician that:
  - Understands the recommended good practices of BLRBAC.
  - Understands the basics of NFPA-85 requirements for boilers.
  - Understands the basics of recovery boiler process, operation, control, and safety interlocking.
  - Understands the individual unique and specialized control equipment and systems associated with the recovery boiler such as the solids control, burner management, drum level control, etc.
  - Has a working knowledge of all instruments associated with recovery boilers?
  - Can quickly identify where all instrument/devices and supporting documents are.

The following may be considered when determining the above qualifications.

- Understands proper calibration and testing procedures for these instruments.
- Has a working knowledge of electrical circuits and relay systems
- Has a working knowledge of microelectronic control systems (DCS, PLCs, etc.)
- Has received basic E&I system “trade school’ type training.
- Has received training on specialized systems as developed by the vendor.
- Receives continuous and ongoing refresher training on existing systems as needed.
- Receives immediate update training on any new devices or systems.

#### **4.2 Recovery Boiler Safety Systems Applied to ESP**

1. Redundant methods shall be utilized to insure a timely ESP when initiated by the operator.
2. No single failure shall cause or prevent an ESP occurrence.
3. Redundancy designs should incorporate “bumpless” transfer that does not cause an improper ESP action.
4. Backup processors and auto transfer should be tested preferably twice a year, but, as an absolute minimum once per year for operational integrity.

*BLRBAC RECOMMENDED GOOD PRACTICE  
Instrumentation Checklist and Classification Guide  
for Instruments and Control Systems Used in the  
Operation of Black Liquor Recovery Boilers  
February 2023*

5. System designs should allow for repair of failed components without upset to boiler operations.
6. Faults in backup processors should disable transfer until faults are corrected.
7. If a digital control system is utilized for initiation of an ESP, an alternate entry point to the ESP system should be provided to initiate an ESP. Redundant communication networks are acceptable.
8. It is recommended that the RBSS should not rely on continuous power to retain logic states for the ESP system.
9. When a rapid drain system utilizes a UPS system as a back-up power source, time delay functions should be allowed only when the UPS system is providing power to the drain valves. These time delays are for the purpose of minimizing the in-rush current demand placed on the UPS system and shall not significantly delay an ESP.
10. Bypassing of any ESP component shall not be allowed while the boiler is operating With any amount of smelt bed. Any safety interlock bypass applied at other times Shall follow the jumper management process described in section 3.7.

### **4.3 Recovery Boiler Safety Systems Applied to Burner Management**

1. The use of a RBSS for Burner Management on a recovery boiler shall conform to the requirements of the appropriate standards committee such as BLRBAC, FM, NFPA, UL, etc.
2. A Master Fuel Trip (MFT) relay shall be provided in the system and be functional To operate from commands of the RBSS and a dedicated hardwired Master Fuel Trip (MFT) switch accessible to the boiler operator.
3. First out trip sequence indication shall be incorporated in the system design.
4. Bypassing of any auxiliary fuel safe firing burner management component by use of temporary jumper or force shall not be allowed while the boiler is in operation and burning auxiliary fuel. An exception would be for a redundant interlock where the integrity of the interlock remains with one device or interlock taken out of service, such as dual feed water interlocks or dual high furnace pressure switches. Another exception would be a condition protected by an interlock that can be verified “absolutely” to not be in an unsafe status and to remain that way, such as a burner inserted interlock. Any recovery boiler safety interlock bypass installed under these exceptions or at any other time shall mandate immediate repairs and shall follow the jumper management procedures described in section 3.7.
5. Bypassing of any black liquor safe firing burner management component by use of temporary jumper or force shall not be allowed while the boiler is in operation and burning black liquor or whenever a smelt bed exists. An exception would be for a redundant interlock where the integrity of the interlock remains with one device or interlock taken out of service such as dual refractometer interlocks. Another exception would be a condition protected by an interlock that can be verified “absolutely” to not be in an unsafe status and to remain that way, such as a liquor gun door interlocks. Any recovery boiler safety interlock bypass installed under these exceptions or at any other times shall mandate immediate repairs and shall follow the jumper management procedures described in section 3.7.

*BLRBAC RECOMMENDED GOOD PRACTICE  
Instrumentation Checklist and Classification Guide  
for Instruments and Control Systems Used in the Operation of Black Liquor Recovery  
Boilers*

*April 2014*

---

**APPENDIX A INSTALLATION CHECKLIST AND CLASSIFICATION GUIDE  
FOR INSTRUMENTS AND CONTROLS USED IN THE OPERATION OF  
BLACK LIQUOR RECOVERY BOILERS**

In addition to the instruments and controls listed in the following sections, there is a need to establish proper practices for the design, installation and operation of black liquor firing systems for promoting safety and, in particular, prevention of furnace explosions from the introduction of low solids black liquor and/or water into the furnace. Specific recommendations for these systems should be obtained from the Recommended Good Practices as issued by the Black Liquor Recovery Boiler Advisory Committee.

## **APPENDIX B DOCUMENT REVISION HISTORY**

### **February 2012**

“Notice of Disclaimer of Liability” has been added to page 2.

### **October 2004**

Revised Chapter 1 to recommend functional testing whenever modifications are made to recovery boiler instrumentation or control systems.

Added definitions for “Functional Test” and “Modifications” in Chapter 2.

Added Section 3.13, Functional Testing.

### **April 2002**

This document has been revised to provide a consistent format.

The word “Master” has been added as appropriate to “fuel trip” in various items in the instrumentation checklist.

Section G, Black Liquor and Green Liquor Systems: Clarified items 30 and 31 by adding the term “Direct contact.”

Section I, Auxiliary Fuel and Burner System: Added item 20, Soot Blower water wash spoolpiece.

(Note: Prior revision history not provided.)

BLRBAC RECOMMENDED GOOD PRACTICE  
Instrumentation Checklist and Classification Guide  
for Instruments and Control Systems Used in the Operation of Black Liquor Recovery Boilers  
Appendix A

**A. FEEDWATER AND STEAM SYSTEMS**

Instrument or Control System		Major Function	Operating Modes or Techniques	I	II	Comments
1.	Drum level control	Maintain drum level by control of feedwater flow for stable & safe operation	Auto-Manual control	X		3 element feedwater control systems are generally preferred for better performance. Separate taps are required for each level measurement.
2.	Drum level	Drum level monitor with safety back-up independent of drum level control	Record Indicate, 2 required High level alarm Low level alarm High level - Master fuel trip Low level - Master fuel trip, 2 required	X X X X X X	X	Back-up protection. It is recommended that direct connected instruments which contain process fluids should not be piped to the Control Room. Separate taps are required for each level instrument.
3.	Drum level gauge glass	Indication of drum level	Indicate(Local)	X		A gauge glass level must be visible at the steam drum.
4.	Steam flow	Part of drum level control system and used to determine load on boiler  Steam Flow <30% (Liquor Firing Only)	Record Indicate Integrate Master Fuel Trip	X X X X	X X	Essential operational data and useful for efficiency check. Comparison of steam and water flow to detect pressure part leaks. Soot-blower steam flow may have to be incorporated into total steam flow. Refer to "Recommended Practice for Safe Firing of Black Liquor" and "Recommended Practice for Safe Firing of Auxiliary Fuels" for application.
5.	Feedwater flow	Part of drum level control system	Record Indicate Integrate	X X X	X	Essential operational data & useful for efficiency check.
6.	Feedwater Quality	Monitor water quality to the boiler Conductivity  pH Dissolved Oxygen Content	Indicate Record Alarm Indicate Indicate	X X X X X	X X	Required if not a part of feedwater preparation & condensate return control systems. Integrity of freshwater supply must be assured.
7.	Feedwater supply header pressure	Indicate feedwater pressure available	Indicate Record Low-Pressure Alarm	X X X	X	
8.	Feedwater supply temperature	Indicate feedwater temperature	Indicate Record	X X	X	Monitors feedwater heater and condensate systems.
9.	Feedwater pump pressure control.	Means for control of feedwater supply pressure	Control of: -Variable Speed Pumps -Number of Pumps -Pressure Control Valve	X X X	X X X	Separate taps are required for each control.
10.	Feedwater pump(s) tripped	Monitor feedwater pump operation	Alarm	X		
11.	Economizer (if used) water outlet temperature	Fluid temperature and operating guide	Indicate Record	X X	X	Detects economizer plugging.
12.	Deaerator level low	Monitor deaerator level low	Alarm	X		
13.	Deaerator pressure low	Monitor deaerator pressure low	Alarm	X		

Classification I - Required for Normal Operation  
Classification II - Recommended Where Applicable



BLRBAC RECOMMENDED GOOD PRACTICE  
Instrumentation Checklist and Classification Guide  
for Instruments and Control Systems Used in the Operation of Black Liquor Recovery Boilers  
Appendix A

**A. FEEDWATER AND STEAM SYSTEMS**

Instrument or Control System		Major Function	Operating Modes or Techniques	I	II	Comments
14.	Primary superheater outlet temperature (if used with attemperator or desuperheater)	Measure steam temperature leaving primary superheater	Record Indicate High Temperature Alarm	X X	X	Provides warning of abnormal temperatures.
15.	Attemperator or desuper-heater outlet steam temperature	Measure steam temperature.	Record Indicate	X X		
16.	Superheated outlet steam temperature	Measure final steam temperature	Record Indicate High Temperature Alarm Low Temperature Alarm	X X X X		Provides warning of abnormal temperatures to prevent damage to turbines.
17.	Interstage attemperator or desuperheater temperature control (if used)	Control final steam temperature under varying load or firing conditions	Auto-Manual control Trip off water spray with ESP	X X		To prevent spray water from possible entry into furnace or external steam equipment (turbines, etc.) during ESP.
18.	Attemperator or desuperheater water flow (if used)	Measure spray water flow	Record Indicate Integrate High Flow Alarms	X X X X		
19.	Steam pressure at superheater outlet	Measure steam pressure	Auto-Manual Control Record Indicate	X X X		
20.	Steam drum pressure	Measure steam pressure & provide essential operating guide	Record Indicate	X X		
21.	Powered vent valve (relief valve)	Relieve excess pressure. Control pressure and steam flow during startup	Auto-Manual Open on ESP (after 8 ft level on rapid drain) Indicate Open	X X X	X	Establish flow through superheater, reduce safety valve maintenance, & relieve pressure following an ESP.
22.	Superheater and steam drum metal temperature	Monitor tube temperature during startup and operation	Indicate Record High Temperature Alarm (Superheater Only)	X X X		Metal temperatures may be monitored by individual tube metal measurement or by superheater inlet gas temperature.
23.	Metal temperature monitors for emergency drain	Monitor hearth tube metal temperatures below the 8 foot level during an emergency shutdown and drain.	Indicate Record	X X		Recording and indicating of metal temperatures is required only during periods of abnormal conditions.
24.	Water wall metal temperatures	Monitor metal temperature of water wall tubes	Indicate Record	X X		
25.	Mill condensate return(s) conductivity	Monitor conductivity of mill condensate return	High Conductivity Alarm	X		
26.	ESP System Drain Valves		Indicate Open Indicate Closed	X X		Refer to ESP Good Practice
27.	ESP System Stop Valves		Indicate Open Indicate Closed	X X		Refer to valves required under ESP Good Practice

Classification I - Required for Normal Operation  
Classification II - Recommended Where Applicable

**BLRBAC RECOMMENDED GOOD PRACTICE**  
**Instrumentation Checklist and Classification Guide**  
**for Instruments and Control Systems Used in the Operation of Black Liquor Recovery Boilers**  
**Appendix A**

**B. COMBUSTION AIR CONTROL SYSTEMS**

Instrument or Control System	Major Function	Operating Modes or Techniques	I	II	Comments
1. Forced draft control	Maintain constant discharge pressure or control combustion air flow.	Auto-Manual	X		Fan damper or fan speed control.
2. FD fan(s) discharge pressure.	Indicate combustion air pressure available.	Indicate Record Low Pressure Alarm Master Fuel Trip if validating FD fan running	X X X X	X X X	For trips refer to Auxiliary Fuel Good Practice.
3. Combustion air flow & control	Measure & control combustion air flow including primary, secondary, and tertiary (or higher, if used) ratios.	Auto-Manual Indicate Record Low Flow Interlock & Master Fuel Trips Low Flow Alarm	X X X X X		Low air flow is 30% of normal air flow at rated load. Quantity and location of flow measuring devices depends on boiler design.
4. Oxygen	Measure combustion efficiency & detect furnace blackout.	Indicate Record Alarm Oxygen Low Alarm Oxygen High	X X X X	X	See "Recommended Good Practice Safe Firing of Auxiliary Fuel in Black Liquor Recovery Boilers".
5. Combustibles/CO	Measure combustion efficiency and detect furnace blackout	Indicate Record Alarm Combustibles High	X X X	X X X	
6. Combustion air temperature	Measure combustion air temperatures.	Indicate Record Alarm	X X X	X X X	Aid to minimizing operating problems due to cold combustion air.
7. Air heater outlet pressure	Measure combustion air pressure available.	Indicate		X	Detects pressure drop across air heater in conjunction with FD fan pressure.
8. Secondary air duct pressure	Measure secondary air pressure.	Indicate Alarm	X X	X X	Aids in detecting plugged ports.
9. Primary air duct(s) pressure	Measure primary air pressure.	Indicate Alarm	X X	X X	Aids in detecting plugged ports.
10. Tertiary, or higher, air duct pressure (if used)	Measure tertiary (or higher) air pressure.	Indicate Alarm	X X	X X	Aids in detecting plugged ports
11. FD fan failure	Monitors FD fan operation.	Alarm Master Fuel Trip (If below liquor guns)	X X		Essential to operating safety. See "Recommended Good Practice Safe Firing of Auxiliary Fuel in Black Liquor Recovery Boilers".
12. Direct-fired air-heater temperature	Monitor direct fired air-heater temperature.	Indicate High Temperature Alarm Low Temperature Alarm	X X X		

Classification I - Required for Normal Operation  
Classification II - Recommended Where Applicable

**BLRBAC RECOMMENDED GOOD PRACTICE**  
**Instrumentation Checklist and Classification Guide**  
**for Instruments and Control Systems Used in the Operation of Black Liquor Recovery Boilers**  
**Appendix A**

**C. FURNACE DRAFT SYSTEM**

Instrument or Control System		Major Function	Operating Modes or Techniques	I	II	Comments
1.	Furnace draft control	Control furnace draft.	Auto-manual	X		Provide essential operating control.
2.	Furnace pressure	Measures furnace pressure.	Indicate	X	X	See "Recommended Good Practice Safe Firing of Auxiliary Fuel in Black Liquor Recovery Boilers."
			High Pressure Alarm	X		
			High Pressure Master Fuel Trip	X		
			Record	X		
			Low Pressure Alarm	X		
			Low Pressure Master Fuel Trip (If required by furnace or system design)	X		
3.	Boiler draft	Measures draft loss across various sections of boiler.	Indicate	X		Detects plugging in boiler. Quantity & location of indicators depend on boiler design.
4.	Boiler outlet gas temperature	Measure outlet gas temperature.	Indicate	X		
5.	Economizer outlet gas temperature or direct contact evaporator inlet gas temperature.	Measures gas temperature to the direct contact evaporator (if used).	Record	X		
			Indicate	X		
6.	Direct contact evaporator outlet gas temperature.	Measures gas temperature at direct contact evaporator outlet (if used).	Indicate	X	X	See also Items D1 & D2.
7.	Direct contact evaporator inlet & outlet draft	Measures draft at inlet and outlet of direct contact evaporator (if used).	Record	X		
			Indicate	X		
8.	ID fan failure	Monitors ID fan operation.	Alarm	X		Essential to operating safety. Loss of <u>all</u> ID fans requires Master Fuel Trip and FD Fan(s) Trip.
9.	ID fan discharge pressure	Measures ID fan discharge pressure	Master Fuel Trip	X		
			FD Fan Trip	X		
10.	Stack temperature	Measures temperature of gases at the stack.	Indicate	X	X	
			Record	X		
			Alarm	X		
11.	Instrument air pressure low	Monitor instrument air pressure.				

Classification I - Required for Normal Operation  
Classification II - Recommended Where Applicable

**BLRBAC RECOMMENDED GOOD PRACTICE**  
**Instrumentation Checklist and Classification Guide**  
**for Instruments and Control Systems Used in the Operation of Black Liquor Recovery Boilers**  
**Appendix A**

**D. FIRE PROTECTION SYSTEM**

Instrument or Control System	Major Function	Operating Modes or Techniques	I	II	Comments
1. Direct contact evaporator temperature	Warns of high temperature and activates fire protection	High Temperature Alarm High High Temperature Alarm High High Temperature Master Fuel Trip High High Temperature Admit Smothering Media	X X X X		Refer to BLRBAC "Recommend Good Practice Fire Protection in Direct Contact Evaporators and Associated Equipment."
2. Precipitator outlet temperature	Warns of high temperature and activates fire protection	High Temperature Alarm High High Temperature Alarm High High Temperature Master Fuel Trip High High Temperature Admit Smothering Media	X X X	X	Refer to BLRBAC "Recommend Good Practice Fire Protection in Direct Contact Evaporators and Associated Equipment" <u>and</u> "Recommended Good Practice for Safe Firing of Auxiliary Fuel"

Classification I - Required for Normal Operation  
Classification II - Recommended Where Applicable

**BLRBAC RECOMMENDED GOOD PRACTICE**  
**Instrumentation Checklist and Classification Guide**  
**for Instruments and Control Systems Used in the Operation of Black Liquor Recovery Boilers**  
**Appendix A**

**E. BOILER CLEANING SYSTEM**

Instrument or Control System		Major Function	Operating Modes or Techniques	I	II	Comments
1.	Soot blower controls	Keep firesides clean.	Control System Failure Alarm		X	Avoid damage due to hand lancing. Save manpower.
2.	Automatic soot blower blowing sequence control	Continuous blowing on set pattern.	Auto-Manual Control Forward-Reverse Indicators Low Steam Pressure Alarm & Interlock Trip Steam & Retract on ESP Trip Steam & Retract on MFT		X X X X X	Free operator for other duties. Tripping of soot blower steam insures against possibility of water entering furnace under or during adverse conditions.
3.	Soot blower steam flow	Measures steam flow to soot blower.	Indicate Record Integrate High Flow Alarm	X X X X		Operating data. Soot blower steam flow may have to be incorporated as a part of the drum level control. High alarm indicates soot blower lance failure.

Classification I - Required for Normal Operation  
Classification II - Recommended Where Applicable

**BLRBAC RECOMMENDED GOOD PRACTICE**  
**Instrumentation Checklist and Classification Guide**  
**for Instruments and Control Systems Used in the Operation of Black Liquor Recovery Boilers**  
**Appendix A**

**F. SMELT SPOUT COOLING SYSTEM**

Instrument or Control System	Major Function	Operating Modes or Techniques	I	II	Comments
1. Cooling water supply pressure.	Indicates cooling water available.	Indicate Record Alarm Low	<b>X</b>	<b>X</b>	Loss of cooling water can result in spout failure.
2. Cooling water temperature at spout outlet	Provides warning of cooling water temperature problems.	Indicate (Local) Record High Temperature Alarm	<b>X</b>	<b>X</b>	
3. Cooling water flow	Indicate adequate flow of cooling water.	Indicate (Local) Record Minimum Flow Alarm	<b>X</b>	<b>X</b>	Equip each smelt spout with individual visual indicator or flow indicator
4. Cooling water supply tank level control (if tank used)	Maintain proper water level.	Auto-Manual Control Low Level Alarm Indicate	<b>X</b>	<b>X</b>	
5. Loss of any smelt spout cooling water pump	Provide warning of loss of operating spout cooling water pump	Alarm	<b>X</b>		
6. Emergency spout cooling water makeup on	Backup to primary cooling system	Auto-Manual Control Alarm	<b>X</b>	<b>X</b>	
7. Cooling water conductivity high	Monitor cooling water conductivity	Alarm		<b>X</b>	

Classification I - Required for Normal Operation  
Classification II - Recommended Where Applicable

**BLRBAC RECOMMENDED GOOD PRACTICE**  
**Instrumentation Checklist and Classification Guide**  
for Instruments and Control Systems Used in the Operation of Black Liquor Recovery Boilers  
Appendix A

**G. BLACK LIQUOR AND GREEN LIQUOR SYSTEMS**

Instrument or Control System		Major Function	Operating Modes or Techniques	I	II	Comments
1.	Heavy black liquor storage tank level (includes oxidizer & concentrator surge tanks where used)	Continuous tank level measurement	Record Indicate Low Level Alarm High Level Alarm	X X X X	X X X	Essential indication of fuel supply.
2.	Heavy black liquor storage tank temperature	Continuous liquor temperature measurement.	Indicate		X	Monitors pumping capability of heavy liquor.
3.	Precipitator liquor level control (if wet bottom) or ash tank level (if used with dry bottom)	Maintain proper liquor level.	Auto-Manual Control Record Indicate Low Level Alarm High Level Alarm	X X X X X	X X X X	Essential to operations in maintaining fuel supply. In some cases, where weirs are used, instruments may not be required.
4.	Precipitator dust removal system failure	Monitor precipitator dust removal system operation.	Alarm		X	
5.	Cascade evaporator level control (if cascade is used)	Maintain black liquor level.	Auto-Manual Control Record Indicate Low Level Alarm High Level Alarm	X X X X X	X X X	Essential to operation in maintaining fuel supply. Where weirs are used, level control instruments may not be required.
6.	Cyclone evaporator sump level control (if cyclone is used)	Maintain black liquor level.	Auto-Manual Control Record Indicate Low Level Alarm High Level Alarm	X X X X X	X X	Aids in fire protection.
7.	Cyclone evaporator wall wash pressure control	Maintain black liquor pressure to ensure adequate nozzle flow.	Auto-Manual Control Indicate Low Pressure Alarm	X X X	X	Essential to operation. Aids in fire protection.
8.	Primary black liquor heater temperature control	Maintain black liquor at efficient pumping temperature.	Auto-Manual Control Record Indicate High Temperature Alarm Trip Steam Supply on ESP	X X X X X	X X X	Essential to operation. Temperature must be maintained within close operating range. High temperature can cause flashing in fuel supply pump and tank.
9.	Salt cake mix tank level (if used)	Maintain salt cake mix tank level.	Auto-Manual Control Indicate Record Low Level Alarm	X X X X	X X	Indicates plugged screen or loss of liquor supply.
10.	Secondary black liquor heater temperature control	Maintain black liquor at optimum temperature for burning.	Auto-Manual Control Record Indicate Low Temperature Alarm High Temperature Alarm Trip Steam Supply on ESP	X X X X X X	X X X	Essential to operation. Nozzle feed liquor temperature must be maintained within close operating range. Assists in stabilizing operating conditions and maintaining low levels of total reduced sulfur and sulfur dioxide.
11.	Black liquor strainer drive(s) stopped	Monitor black liquor strainer drive operation.	Alarm		X	

Classification I - Required for Normal Operation  
Classification II - Recommended Where Applicable

**BLRBAC RECOMMENDED GOOD PRACTICE**  
**Instrumentation Checklist and Classification Guide**  
**for Instruments and Control Systems Used in the Operation of Black Liquor Recovery Boilers**  
**Appendix A**

**G. BLACK LIQUOR AND GREEN LIQUOR SYSTEMS**

Instrument or Control System	Major Function	Operating Modes or Techniques	I	II	Comments
12. Black liquor mix tank(s) agitator drive(s) stopped	Monitor black liquor agitator drive operation.	Alarm	X		
13. Black liquor to furnace	Control black liquor flow to furnace.	Auto-Manual Control Record Indicate Integrate Liquor Header Flow 25% or greater. Liquor Header Flow <30% (Liquor Firing Only) Liquor Header Purge Permissive Master Fuel Trip	X X X X X X	X	Essential to operation in maintaining and controlling furnace load. Assists in stabilizing operating conditions and maintaining low levels of total reduced sulfur & sulfur dioxide. Refer to "Recommended Practice for Safe Firing of Black Liquor" and "Recommended Practice for Safe Firing of Auxiliary Fuel" for application.
14. Black liquor supply pump(s) stopped	Monitor black liquor supply (pumps) operation.	Alarm	X		
15. Black liquor nozzle pump(s) stopped	Monitor black liquor nozzle pump operation.	Alarm Divert Interlock	X X		
16. Black liquor nozzle supply pressure low	Monitor black liquor nozzle pressure low.	Alarm Liquor Header Purge Permissive	X X		
17. Black liquor nozzle temperature low	Monitor black liquor nozzle temperature low.	Alarm Liquor Header Purge Permissive	X X		
18. Black liquor nozzle temperature high	Monitor black liquor nozzle temperature high.	Alarm		X	
19. Black liquor oscillator(s) drive failure	Monitor black liquor oscillator drive operation.	Alarm		X	
20. Black liquor percent solids 2 refractometers required	Monitor black liquor solids content to furnace spray nozzle. Essential to safe operation.	Alarm on minimum 60% Black Liquor Solids Automatic Liquor Diversion on low solids, minimum 58% Alarm (Audible and Visible) on deviation between two devices >2% Refractometer Inoperative/Malfunction Alarm	X X X X X		Better solids control helps reduce blackouts. Insures against admitting weak liquor into furnace. (See BLRBAC "Recommended Good Practice Safe Firing of Black Liquor in Black Liquor Recovery Boilers" - Chapter 4).
21. Black Liquor Gun Position Interlock (one or more)	Prove liquor guns out of furnace	Permissive Interlock Indicate	X X		
22. Black Liquor Header valve shut & Divert valve open	Prove liquor isolated from furnace	Indicate	X		
22.a Black Liquor Header Recirculation valve open	Prove open in preparation for Black Liquor Header Purge	Indicate	X		
23. Black Liquor Header Purge		Purge in Process-Indicate Purge Complete-Indicate	X X		
24. Non-operating Water Sources Open	Prevent introduction of water into furnace	Interlock Indicate	X X		

Classification I - Required for Normal Operation  
Classification II - Recommended Where Applicable



**BLRBAC RECOMMENDED GOOD PRACTICE**  
**Instrumentation Checklist and Classification Guide**  
for Instruments and Control Systems Used in the Operation of Black Liquor Recovery Boilers  
Appendix A

**G. BLACK LIQUOR AND GREEN LIQUOR SYSTEMS**

Instrument or Control System		Major Function	Operating Modes or Techniques	I	II	Comments
25.	Black Liquor Header Wash System Switch in Wash Position	Establish conditions are safe to initiate a ring header wash	Interlock Indicate	X	X	
26.	Manual Black Liquor Trip		Indicate	X		
27.	Smelt bed camera	Monitor smelt bed	Indicate		X	Monitors smelt bed condition & aids in avoiding blackouts.
28.	Direct contact evaporator density control	Controls dilution source to direct contact evaporator sump.	Auto-Manual High-Density Alarm		X	Detect evaporator dilution.
29.	Direct contact evaporator dilution flow control	Controls and monitors dilution source flow to direct contact evaporator sump.	Auto-Manual Indicate	X	X	
30.	Direct contact evaporator drive(s) stopped	Monitor evaporator drive operation.	Alarm	X		
31.	Direct contact evaporator circulating pump(s) stopped	Monitor circulating pump(s) operation.	Alarm	X		
32.	Dissolving tank level control (if used)	Maintain adequate green liquor level in smelt dissolving tank. Essential to operation.	Auto-Manual Control Record Indicate High Level Alarm Low Level Alarm	X	X	Dissolving tank pumps should have suction located at minimum safe level to prevent draining of tank in event of control failure. Depending upon system design, some instruments may not be required.
33.	Dissolving tank temperature	Continuous temperature measurement.	Record Indicate	X	X	Aid manual operation of green liquor density control.
34.	Green liquor density control	Control dilution to dissolving tank and maintain optimum and uniform green liquor density.	Auto-Manual Control Indicate Record Alarm-High Alarm-Low	X	X	Aid to recausticizing operations. Regulates proper pumping controls.
35.	Dissolving tank agitator malfunction.	Monitor dissolving tank agitator current.	Alarm-Low Alarm-High	X	X	Indication of mechanical failure. Indication of high density.
36.	Green liquor transfer pumps stopped	Monitor green liquor transfer pump(s) operation.	Alarm		X	
37.	Green liquor recirculation pumps stopped	Monitor green liquor recirculation pump(s) operation.	Alarm		X	
38.	Salt cake feed system failure	Monitor salt cake feed system operation.	Alarm		X	

Classification I - Required for Normal Operation  
Classification II - Recommended Where Applicable

**BLRBAC RECOMMENDED GOOD PRACTICE**  
**Instrumentation Checklist and Classification Guide**  
**for Instruments and Control Systems Used in the Operation of Black Liquor Recovery Boilers**  
**Appendix A**

**H. FLUE GAS EMISSIONS**

Instrument or Control System		Major Function	Operating Modes or Techniques		I	II	Comments
1.	Flue gas particulates, concentration or opacity	Monitor solids emission or smoke density.	Indicate Record Alarm			X X X	Air quality & efficiency control.
2.	Flue gas analyzer for noxious stack gases	Monitors gaseous emissions including reduced sulfur, sulfur dioxide, nitrous oxides, etc.	Indicate Record Alarm			X X X	Air quality & efficiency control.
3.	Precipitator power failure	Monitor precipitator power operations.	Alarm			X	
4.	Precipitator insulator compartment fan failure	Monitor precipitator insulator compartment fan failure.	Alarm			X	

Classification I - Required for Normal Operation  
 Classification II - Recommended Where Applicable

**BLRBAC RECOMMENDED GOOD PRACTICE**  
**Instrumentation Checklist and Classification Guide**  
for Instruments and Control Systems Used in the Operation of Black Liquor Recovery Boilers  
Appendix A

**I. AUXILIARY FUEL AND BURNER SYSTEM**

Instrument or Control System	Major Function	Operating Modes or Techniques	Classification		Comments
			I	II	
1. Purge Progress		Indicate Interlock	X X		
2. Purge Complete		Indicate Interlock	X X		
3. Individual Burner Tripped		Alarm Interlock	X X		Refer to Auxiliary Fuel document Chapter 5.
4. Individual Burner Valves Closed		Indicate Interlock	X X		Applies to Automatic Burner Safety Shutoff Valves
5. Purge Credit Lost (Master Fuel Trip)		Alarm Interlock	X X		
6. Main Header and Main Igniter Safety Shutoff Valves Closed		Indicate Interlock	X X		
7. Failure of Auxiliary Fuel Trip Valve to Close (MHSSV, IHSSV, BHSSV, BSSV, RSSV)		Alarm Interlock	X X		
8. Individual Igniter or Burner Flame Failure		Alarm Interlock	X X		
9. Fuel-Gas Pressure		High Pressure Alarm Low Pressure Alarm High Pressure Interlock Low Pressure Interlock	X X X X		
10. Fuel-Oil Pressure		High Pressure Alarm Low Pressure Alarm High Pressure Interlock Low Pressure Interlock	X X X X		
11. Fuel-oil Temperature		Temperature Low Alarm Temperature Low Interlock Temperature High Alarm	X X X	X	
12. Burner fuel-oil atomizing medium pressure low		Alarm Interlock	X X		
13. Igniter oil-Atomizing medium pressure low		Alarm Interlock	X X		
14. Burner system energized		Indicate Interlock	X X		
15. Burner airflow low		Alarm Interlock	X X		
16. NCG stream isolated from furnace		Indicate Interlock	X X		
17. ESP activated		Alarm Interlock	X X		
18. Manual actuation Master Fuel Trip		Alarm Interlock	X X		

Classification I - Required for Normal Operation  
Classification II - Recommended Where Applicable

**BLRBAC RECOMMENDED GOOD PRACTICE**  
**Instrumentation Checklist and Classification Guide**  
for Instruments and Control Systems Used in the Operation of Black Liquor Recovery Boilers  
Appendix A

**I. AUXILIARY FUEL AND BURNER SYSTEM**

Instrument or Control System	Major Function	Operating Modes or Techniques	I	II	Comments
19. Manual actuation Auxiliary Fuel Trip		Alarm	X		
		Interlock	X		
20. Soot Blower water wash spoolpiece		Indicate	X		
		Start up permissive Interlock	X		

Classification I - Required for Normal Operation  
Classification II - Recommended Where Applicable