

## WHAT IS CORROSION ALLOWANCE?

By knowing the expected general corrosion rate and the anticipated plant or service life of a part, the designer can calculate the extra thickness required for corrosion resistance of the process equipment being designed.

After determining a wall thickness that meets mechanical requirements, such as pressure, temperature and weight of equipment, an extra thickness called "corrosion allowance" is added to the wall thickness to compensate for the metal expected to be lost over the life of the equipment. Then, because the penetration depth can vary, a corrosion allowance is assigned a safety factor of two.

### EXAMPLE:

A tank wall required a 5 mm wall thickness for mechanical considerations. The designer has determined that the corrosion rate will be 0.4 mm/yr and the expected life of the tank will be 10yr. The total corrosion allowance is the corrosion rate per year (0.4 mm x 10 yr = 4 mm). The corrosion allowance is doubled to 8 mm as a safety consideration.

## CALCULATION OF CORROSION ALLOWANCE

Corrosion allowance is not only determined by the designer, but also and especially by a state or local agency. The latter often have years of experience with local conditions and especially the weather conditions in a relevant area.



Humidity, temperature, rain, wind, impurities and metal wet times have an effect on the corrosion rate. Corrosion occurs when the relative humidity of the air is 70 to 80%. Corrosion reaction is possible generally when the temperature is above 0°C and the relative humidity is over 80% (the surface is wet). Air impurities that dissolve in condensed water or rain water

may accelerate corrosion. Settling of dust and dirt on the metal surface accelerates atmospheric corrosion.

Corrosion rates are expressed in terms of mm per year of surface wastage and are used to provide a corrosion allowance in the design thickness of equipment such as vessels and pipework.

Operators will often use data based on historical experience from plant operations to aid them in determining appropriate corrosion allowances. Alternatively corrosion charts are widely available that give corrosion rates for many combinations of materials of construction and process fluids and normally a range of values will be provided for various process temperatures.

In some instances, particularly where there is a mixture of chemicals present, appropriate data may not exist and corrosion tests may be necessary in order to determine the suitability of equipment. Operators should be able to demonstrate the use of corrosion allowances in equipment specification and design. The sources of data used should be traceable.

# Corrosion Allowance Corrosion Pipe Fluid Conveyance

**Victor M. Corman**



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