chemical treatment, is the primary defense against steam condensate corrosion.

Volatile corrosion inhibitors, carried through the steam supply lines, help to control condensate corrosion. Film-forming inhibitors coat metal surfaces with a protective film and neutralizing inhibitors act to neutralize carbonic acid. Scavengers act to "mop up" the remaining traces of oxygen in the system.

Attention should also be given to the following: (i) the use of more corrosion-resistant materials; (ii) equipment and piping design; (iii) venting; (iv) preventing air in-leakage; and (v) steam trap selection and positioning.

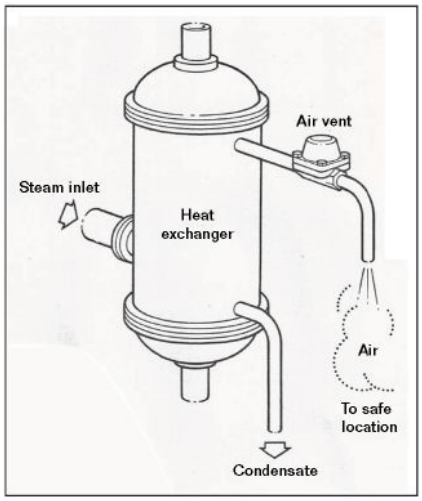

FIGURE 5 Air vent on vertical heat exchanger.

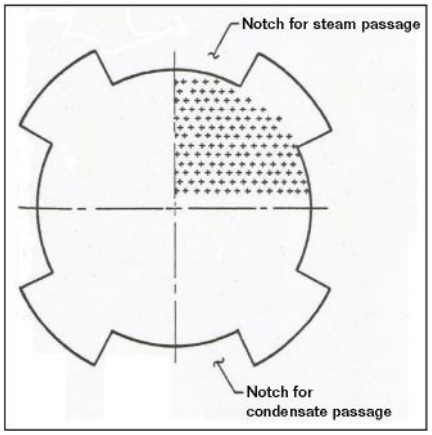

FIGURE 6 Tube support in a shell-and-tube heat exchanger; notch cut-away to assist condensate flow.

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