



CGA G-4.13—2023
CENTRIFUGAL COMPRESSORS
FOR OXYGEN SERVICE

SECOND EDITION

PREFACE

As part of a program of harmonization of industry standards, the Compressed Gas Association (CGA) has issued CGA G-4.13, *Centrifugal Compressors for Oxygen Service*, jointly produced by members of the International Harmonization Council and originally published by the European Industrial Gases Association (EIGA) as EIGA Doc 27, *Centrifugal Compressors for Oxygen Service*.

This publication is intended as an international harmonized standard for the worldwide use and application of all members of the Asia Industrial Gases Association (AIGA), Compressed Gas Association (CGA), European Industrial Gases Association (EIGA), and Japan Industrial and Medical Gases Association (JIMGA). Each association's technical content is identical, except for regional regulatory requirements and minor changes in formatting and spelling.

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NOTE—Technical changes from the previous edition are underlined.

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1 Introduction

This publication has made a significant contribution to the safe compression of oxygen primarily because the manufacturers and users have shared their philosophies and experiences. It is recognized by the Working Group members that the feedback of operating experiences makes a powerful contribution to safe operation and design.

Oxygen compression represents a risk in that the compressor can burn violently. This publication defines design and operating parameters for centrifugal oxygen compressors. Compliance with this publication can reduce the likelihood of, and the hazards arising from, a fire in a compressor to a level equal to or less than those commonly accepted in the air separation industry.

The publication requires that all those who build and operate centrifugal oxygen compressors specified to comply with this publication should contribute towards it by fully reporting the circumstances surrounding oxygen fires. For the purpose of safe operation of the compressor and its auxiliaries, the user and the manufacturer shall establish full agreement on the possible and expected modes of compressor operation (for example, specified operating points, normal operating range, startup and shutdown, etc.)

2 Scope and purpose

This publication applies to single shaft horizontally split casing and vertically split casing (barrel) type compressors and integrally geared compressors. Operating experience exists in compressors up to 71 000 Nm³/hr (2 700 000 scfh) at pressures up to 1230 psi (8.5 MPa) for single shaft compressors and up to 650 psi (4.5 MPa) for integrally geared compressors with oxygen purity of 90% or greater and with maximum 10 ppm water (volume basis).^{1, 2}

The use of axial compressors in oxygen service is not covered by this publication.

The purpose of this publication is to provide guidance on the design, manufacture, installation, operation, and maintenance of centrifugal oxygen compressors, thereby safeguarding personnel and equipment. Fire in an oxygen compressor can be caused by a variety of reasons, which include mechanical deterioration resulting in excessive vibration and/or loss of running clearances within the compressor, ingress of oil (for example, through the seal system), foreign bodies passing through the machine, and surge.

An oxygen compressor shall be provided with a safety support system that shall minimize the development of a potentially dangerous operating condition. In the event of an incident on the compressor that results in combustion of the materials of construction, the safety systems shall be designed to minimize the effect of the fire.

The safe and reliable compression of oxygen using centrifugal compressors can only be achieved by the successful combination of many factors. This publication identifies and addresses the following factors.

2.1 Management of hazards

- identification of the hazard;
- hazard area, safety barriers, and enclosures;
- location of the compressor; and
- emergency procedures.

¹ psi, bar, and kPa/MPa shall indicate gauge pressure unless otherwise noted as (psia; bar, abs; and kPa/MPa, abs) for absolute pressure or (psid; bar, dif; and kPa/MPa dif) for differential pressure. All kPa values are rounded off per CGA P-11, *Guideline for Metric Practice in the Compressed Gas Industry* [1].

² References are shown by bracketed numbers and are listed in order of appearance in the reference section.