

Table of Contents

Preface	V
List of authors	VIII
List of authors involved in previous editions:	X
1. Introduction	2
2. Materials in refractory engineering	6
2.1 General	6
2.2 Shaped dense materials	9
2.2.1 Refractory bricks based on $\text{SiO}_2\text{-Al}_2\text{O}_3$ system	9
2.2.1.1 Silica bricks and fused silica products	11
2.2.1.2 Fireclay bricks	12
2.2.1.3 High-alumina bricks	14
2.2.1.4 Carbon-containing high-alumina materials	15
2.2.2 Basic refractory bricks	16
2.2.2.1 Fired basic bricks	16
2.2.2.2 Carbon-containing basic bricks	18
2.2.3 Sintered special ceramic bricks	18
2.2.4 Carbon and graphite bricks	20
2.2.5 Silicon carbide bricks	20
2.2.6 Fused cast materials	22
2.3 Shaped heat-insulating materials	25
2.3.1 General	25
2.3.2 Insulating refractory and insulating bricks	27
2.3.2.1 Insulating refractory bricks	33
2.3.2.2 Insulating bricks	34
2.3.3 Plates and shaped parts	36
2.3.3.1 Plates and shaped parts out of vermiculite	36
2.3.3.2 Plates and shaped parts out of calcium silicate	37
2.3.3.3 Plates and shaped parts out of microporous insulation materials	38
2.4 Unshaped refractory materials (monolithics)	40
2.4.1 Definitions, types of bond	40
2.4.2 Classification according to product types and installation methods	41
2.4.2.1 Refractory castables	41
2.4.2.1.1 Standard castables ("regular castables" RC)	41
2.4.2.1.2 Deflocculated refractory castables	41
2.4.2.1.3 Chemically bonded refractory castables	43
2.4.2.2 Gunning mixes	43

2.4.2.3	Moldable refractory materials.	44
2.4.2.3.1	Plastic mixes	44
2.4.2.3.2	Ramming mixes	44
2.4.2.4	Refractory mortars	44
2.4.2.5	Other unshaped refractory products (monolithics).	45
2.4.2.5.1	Dry mixes	45
2.4.2.5.2	Injection mixes	45
2.4.2.5.3	Mixes for surface protection	45
2.4.2.5.4	Taphole mixes	45
2.4.3	Classification according to type of chemical composition	45
2.4.4	Tests (inspections), classification	46
2.4.5	Application of the unshaped refractory products (monolithics)	49
2.4.5.1	Refractory castables	50
2.4.6	Properties of the unshaped refractory materials (monolithics) . .	52
2.4.6.1	Refractory castables	52
2.4.6.2	Plastic mixes	59
2.4.6.3	Ramming mixes	59
2.4.6.4	Gunning mixes	60
2.4.6.5	Special products	62
2.4.7	Fiber additives	64
2.4.7.1	Organic fibers	64
2.4.7.2	Metallic fibers	65
2.4.7.3	Fibers out high temperature wool (HTW)	65
2.5	Materials out of high temperature wool	67
2.5.1	Introduction / history	67
2.5.2	Definition and nomenclature (designation).	68
2.5.3	Technology	69
2.5.4	Finishing process products out of high temperature wools and their application.	72
2.5.5	Classification, service limits, tests and operational behavior. . .	75
2.6	Metals	79
2.6.1	General.	79
2.6.2	Definitions, standards and data sheets	79
2.6.2.1	Structure types of metallic materials	79
2.6.2.2	Classification according to resistance	80
2.6.2.3	Standards and technical data	81
2.6.3	Characteristic properties	82
2.6.3.1	Mechanical test counts (data)	82
2.6.3.2	Corrosion	85
2.6.3.3	Embrittlement	87
2.6.4	Selection criteria and application.	88
2.6.4.1	Selection of materials.	88
2.6.4.2	Applications	89
2.6.4.2.1	Feedstock for metallic anchorings	90

2.6.4.2.2	Cross-section design of metallic anchoring systems	91
2.7	Surface protection	95
2.7.1	General	95
2.7.2	Protection of metallic surfaces	95
2.7.3	Protection of ceramic surfaces	96
2.8	Other materials	96
2.8.1	Wall tiles and sand-lime bricks	96
2.8.2	Concretes with calcium-silicate cements	96
2.8.3	Fused cast basalt	98
2.8.4	Expansion joint and burnout materials	98
2.8.5	Filler materials	99
2.8.6	Separation layers	99
2.8.7	Mixing water for castables and mortars	100
2.8.7.1	General	100
2.8.7.2	Evaluation criteria	101
2.8.7.3	Water hardness	102
2.8.7.4	Determination of pH value	102
2.8.7.5	Natural and "artificial" water	102
2.9	Packaging, transport and storage of refractory materials	104
2.9.1	Packaging	104
2.9.2	Transport	107
2.9.3	Storage	107
3. Design		110
3.1	General	110
3.2	Preparation	110
3.2.1	Recording of operation data	110
3.2.2	Selection criteria for refractory and heat-insulating materials	111
3.2.3	Regulations and conditions on site	113
3.3	Design with shaped dense materials	113
3.3.1	General	113
3.3.2	Standard shapes	113
3.3.3	Shaped bricks	114
3.3.4	Anchoring with holding (anchor) bricks	116
3.3.5	Joints	118
3.3.6	Designation of courses and bonds	123
3.3.7	Design examples	123
3.4	Design with shaped heat-insulating materials	144
3.4.1	Standard shapes	144
3.4.2	Shaped bricks	144
3.4.3	Anchoring	144
3.4.4	Joints	146
3.4.5	Design examples	146

3.5	Design with unshaped (monolithic) refractory materials	149
3.5.1	General	149
3.5.2	Influence of installation method of different material types on the design	150
3.5.3	Section division	150
3.5.4	Design of joints.	152
3.5.5	Anchoring	152
3.5.6	Load transfer	164
3.5.7	Lining of cylindrical vessels	164
3.5.8	Design examples	165
3.6	Design with materials out of high temperature wool.	166
3.6.1	Forms of delivery	166
3.6.1.1	Wool	166
3.6.1.2	Blankets	166
3.6.1.3	Modules	166
3.6.1.4	Felt	167
3.6.1.5	Plates	168
3.6.1.6	Shaped parts	168
3.6.1.7	Rope.	168
3.6.1.8	Paper	168
3.6.1.9	Paste	168
3.6.1.10	Coatings.	168
3.6.2	Attachment and Fixation	168
3.7	Thermal calculations	174
3.7.1	Problem definition and explanation of terms	174
3.7.1.1	Preliminary remarks	174
3.7.1.2	Temperature	175
3.7.1.3	Heat, heat amount, heat capacity, heat flow, heat flow density	176
3.7.1.4	Intake and discharge of heat, "storage heat".	177
3.7.1.5	Heat transfer via heat conduction, convection and radiation, heat transmission.	177
3.7.2	Heat conduction.	178
3.7.2.1	Thermal conductivity	178
3.7.2.2	Heat conduction in a level and single-layer wall	183
3.7.2.3	Heat conduction in a level and multi-layer wall	184
3.7.2.4	Heat conduction in a cylindrical wall	186
3.7.3	Heat transmission.	188
3.7.3.1	Heat transfer (transmission) coefficient	188
3.7.3.4	Heat transfer (transmission) in a gap, equivalent thermal conductivity coefficient	195
3.7.4	Heat flux (flow)	196
3.7.4.1	Definition, peripheral conditions and specification/ determination factors, objectives.	196

3.7.4.3	Stationary heat flux (flow) through a cylindrical and multi-layer wall	199
3.7.4.4	Calculation examples for heat flux (flow)	201
3.7.4.5	Computer calculation of heat flux (flow).	205
3.7.5	Discussion of wall design.	207
3.7.5.2	Demand for thin wall design.	207
3.7.5.3	Demand for low outside wall temperatures	210
3.7.5.4	Subsequent heat insulation	211
3.7.6	Non-stationary calculation	211
3.7.6.1	The fundamental equations of non-stationary heat flux (flow).	211
3.7.6.4	Calculation example for a level, two-layer wall	213
3.7.6.5	Example for cooling and heating a wall	215
3.7.7	Multi-dimensional problems.	215
3.7.7.1	General mathematical description of the multi-dimensional problem	215
3.7.7.2	Setup of a calculation model	217
3.7.7.3	Presentation of results	221
3.7.7.4	Example of FEM calculation, connection with stress calculation	222
3.8	Static calculations of load-bearing parts taking the temperature influence into consideration	227
3.8.1	General	227
3.8.2	Heating-up speed.	229
3.8.3	Layer (course) stress	235
3.8.4	Beams	239
3.8.5	Crowns and arches	241
3.8.6	Domes	246
3.8.7	Multi-tier furnaces/kilns	246
3.9	Expansion calculations	252
4.	Working/Application.	260
4.1	General	260
4.2	Preparation for working.	260
4.2.1	General	260
4.2.2	Order documents	260
4.2.3	Order calculation and work record.	263
4.2.4	Work schedule and work schedule for personnel	263
4.2.5	Equipment on construction site	263
4.2.6	Schedule for preparing the construction site.	265
4.2.7	Start of work on construction site	268
4.3	Shaped dense and heat-insulating materials	269
4.3.1	General	269
4.3.2	Tools	269
4.3.3	Basic guidelines for brickwork in refractory engineering	269

4.3.4	Working and application suggestions for brickwork in refractory engineering	271
4.4	Unshaped (monolithic) refractory materials	272
4.4.1	Supply and storage	272
4.4.2	Placing in forms (molds) and division.	273
4.4.2.1	General.	273
4.4.2.2	Insulating refractory and dense refractory castables.	275
4.4.2.3	Gunning and shotcrete mixes	278
4.4.2.4	Plastic and ramming mixes	278
4.4.3	Working with and application of unshaped (monolithic) materials.	279
4.4.3.1	Mixing, casting and compaction	279
4.4.3.2	Pumps	282
4.4.3.3	Gunning, hot gunning.	282
4.4.3.4	Shotcreting.	284
4.4.3.5	Ramming	286
4.4.4	Removal of forms (molds)	287
4.4.5	Subsequent treatment/finishing	288
4.4.6	Summer and winter conditions	289
4.5	Materials out of high temperature wool (HTW)	291
4.5.1	General.	291
4.5.2	Module construction	292
4.5.3	Layer construction (blanket lining)	295
4.5.4	Shaped parts and plates	295
4.5.5	Repair/maintenance possibilities	297
4.6	Welding of anchors	299
4.6.1	General.	299
4.6.2	Arc stud welding.	300
4.6.2.1	General principle	300
4.6.2.2	Types of stud weld joints	302
4.6.2.3	Welding with atypical joints and material combinations	304
4.6.2.4	Shape of studs and retaining tools	304
4.6.2.5	Welding positions and setting parameters.	306
4.6.2.6	Workpiece thickness	307
4.6.2.7	Types of equipment and operation of the equipment	308
4.6.2.8	Execution of stud weld joints	309
4.6.2.9	Testing of the stud weld joint	312
4.6.2.9.1	Non-destructive tests.	313
4.6.2.9.2	Destructive tests	315
4.6.2.10	Insufficient conformity and correction measures.	315
4.6.2.11	Quality assurance.	318
4.6.3	Manual welding process – fusion welding	322
4.6.3.1	General principle	322
4.6.3.1.1	Arc welding (manual metal arc welding).	322

4.6.3.1.2	Shielding gas welding	322
4.6.3.1.3	Welding equipment for arc welding	323
4.6.3.1.4	Types of weld joints and positions connected to arc welding . .	323
4.6.3.1.5	Welding parameters	325
4.6.3.1.6	Defects when welding	326
4.6.3.1.7	Testing of weld joints	327
4.6.3.1.8	Additive materials for welding	328
4.6.3.2	Quality assurance.	329
4.6.3.2.1	Welding requirements in refractory engineering	329
4.6.3.2.2	Primary quality requirements	329
4.6.3.2.3	Work (production) control.	330
4.6.3.3	Occupational health and safety when welding	332
4.6.3.3.1	Danger due to smoke and gas.	332
4.6.3.3.2	Danger due to ultraviolet radiation and infrared radiation	332
4.6.3.3.3	Danger due to electricity	332
4.6.3.3.4	Danger of fire and explosion	332
4.6.3.3.5	Personal protective gear for the welder	333
5.	Application examples.	336
5.1	Bottoms	336
5.1.1	General.	336
5.1.2	Large-shaped bottom bricks in hearth furnaces	337
5.1.3	Bottoms out of graphite and carbon bricks	338
5.1.4	Large-shaped bottom bricks in glass furnaces	339
5.1.5	Bottoms in bogie hearth and rotary hearth furnaces	342
5.2	Walls	344
5.2.1	General.	344
5.2.2	Walls connected with the furnace shell (casing)	344
5.2.2.1	Walls out of shaped refractory materials connected with the furnace shell (casing)	344
5.2.2.2	Walls out of unshaped (monolithic) refractory materials connected with the furnace shell (casing)	350
5.2.2.3	Walls out of high temperature wool connected with the furnace shell (casing)	350
5.2.3	Self-supporting walls	351
5.3	Arches and crowns	353
5.3.1	General.	353
5.3.2	Design and working suggestions	355
5.3.3	Installation of a flat (arch) roof taking a multi-tier oven as example	363
5.3.4	Bricking center and bricking scaffolding	364
5.4	Suspended roofs.	366
5.4.1	General.	366
5.4.2	Suspended roofs out of shaped and dense materials	366

5.4.3	Suspended roofs out of insulating refractory bricks	368
5.4.4	Suspended roofs out of unshaped (monolithic) materials	370
5.4.5	Suspended roofs out of high temperature wool (HTW)	370
5.5	Piping	372
5.5.1	General	372
5.5.2	Design and working suggestions	373
5.6	Pipe walls	376
5.6.1	General	376
5.6.2	Application and working with patching material	376
5.6.3	Repairs	383
5.7	Hexmesh (Hexrost) linings	384
5.7.1	General	384
5.7.2	Application examples	385
5.8	Rotary kilns	387
5.8.1	General	387
5.8.2	Work preparation	388
5.8.3	Repair of the kiln lining	388
5.8.4	General lining work guidelines	388
5.8.4.1	Simple support/propping	392
5.8.4.2	Jack method	392
5.8.4.3	Gluing method	395
5.8.4.4	Kiln rig	397
5.9	Application and working with dry mixes in foundry furnaces	398
5.9.1	General	398
5.9.2	Materials, selection and supply	400
5.9.3	Dry mixes in crucible induction furnace	400
5.9.3.1	General	400
5.9.3.2	Preparing the crucible induction furnace	404
5.9.3.3	Drying of the rear lining	406
5.9.3.4	Compaction	406
5.9.3.4.1	Compaction with hand rammers	406
5.9.3.4.2	Compaction with hand-guided vibrating rammers	409
5.9.3.4.3	Compaction with electric and pneumatic (compressed-air) vibrators	410
5.9.4	Lining forms/molds	413
5.9.5	Repair of crucible induction furnaces	415
5.9.6	Dry mixes in channel induction furnaces (for melting, holding and casting)	418
5.9.7	Repair of channel induction furnaces (for holding, melting and casting)	421
5.9.7.1	Repair of inlet and outlet	421
5.9.7.2	Repair of furnace vessel	423
5.9.7.3	Replacement of the inductor	423
5.9.8	Further linings out of dry mixes	426

5.10	Drying, heating, heating-up and cooling-down of dry mixes	426
5.10.1	Dry mixes based on quartzite, so-called acid dry mixes	426
5.10.1.1	Inductive heating-up taking a cast iron melting furnace as example	427
5.10.1.2	Heating-up with the gas burner	427
5.10.1.3	Cooling-down and heating-up as part of the production process	427
5.10.2	Dry mixes on an Al_2O_3 or MgO base	428
5.10.2.1	Heating-up of a crucible induction furnace	428
5.10.2.2	Heating-up channel induction (for melting, holding and casting)	428
6.	Drying, heating, heating-up and cooling down	430
6.1	General	430
6.2	Processes during drying	431
6.2.1	Preliminary comments	431
6.2.2	Capillary network processes	432
6.2.3	Steam pressure	433
6.2.4	Volatilization, evaporation, condensation	434
6.2.5	Thermal stress	434
6.2.6	Drying shrinkage	436
6.3	Dry heating media and equipment	436
6.4	Principles of drying	438
6.4.1	Requirements	438
6.4.2	Preparations	439
6.5	Execution	441
6.6	Principles of heating, heating-up and cooling down	444
6.6.1	Heating	444
6.6.2	Heating-up and cooling down	444
6.7	Special considerations when drying different furnaces/plants	444
6.7.1	Cement plants with preheater towers	444
6.7.2	Circulating fluidized bed	446
6.7.3	Thermal refuse incinerators	448
6.7.4	Aluminium melting furnaces	448
7.	Project management	452
7.1	Introduction and historical development	452
7.2	General information, definitions, terms	453
7.3	Basics	454
7.3.1	Process groups of the project management	455
7.3.2	Fields of knowledge of the project management	455
7.4	Introduction to the process groups of the project management	457
7.4.1	Initiation process group	457
7.4.2	Planning process group	457

7.4.3	Implementation process group	458
7.4.4	Supervision and control process group	459
7.4.5	Conclusion process group	459
7.5	Assessment of the fields of knowledge of the project management	460
8.	Quality, safety and environmental protection	462
8.1	Management systems in refractory engineering	462
8.1.1	Basics	462
8.1.2	Quality management systems	464
8.1.3	Occupational health and safety management systems	465
8.1.4	Environmental management systems	468
8.2	Quality assurance	469
8.2.1	General	469
8.2.2	Inspection plan procurement of materials	471
8.2.3	Inspection plan installation of refractory materials	473
8.2.4	Inspection plan welding	474
8.2.5	Testing/inspection of materials	478
8.2.5.1	General	478
8.2.5.2	Explanation of terms	479
8.2.5.3	Shaped refractory materials	483
8.2.5.3.1	General	483
8.2.5.3.2	Inspection by attributes or good/bad inspection	485
8.2.5.3.3	Outer appearance	485
8.2.5.3.4	Dimensional accuracy	488
8.2.5.3.5	Evaluation of results	489
8.2.5.3.6	Inspection by variables	489
8.2.5.3.6.1	Execution	489
8.2.5.3.6.2	Evaluation of results of inspection by variables	492
8.2.5.3.6.3	Practical execution of sampling	494
8.2.5.4	Unshaped (monolithic) refractory materials	502
8.2.5.4.1	General	502
8.2.5.4.2	Sampling	502
8.2.5.4.3	Evaluation	505
8.2.6	Inspection of installation	508
8.2.6.1	Introduction	508
8.2.6.2	Comments on the preliminary inspection	508
8.2.6.2.1	Technical documentation, installation manual	508
8.2.6.2.2	Preliminary inspection of construction part	509
8.2.6.2.3	Inspection of incoming materials, material storage, transport at the construction site	509
8.2.6.2.4	Readiness of equipment and scaffolds	510
8.2.6.2.5	Qualification of personnel	510
8.2.6.3	Comments on production inspections	510
8.2.6.3.1	Compliance with engineering requirements	510

8.2.6.3.2	Compliance with application/working guidelines.	511
8.2.6.3.3	Proof of installation.	511
8.2.6.3.4	Sampling	511
8.2.6.4	Final and intermediate inspections, acceptance	514
8.2.6.5	Inspection records and inclusion in inspection plan	515
8.3	Occupational health and safety	517
8.3.1	Legal base	517
8.3.2	Organization within the company.	519
8.3.2.1	Obligations and commitments of the employer.	519
8.3.2.2	Transfer of obligations and commitments	520
8.3.2.3	General obligations and commitments of all employees	520
8.3.2.4	Safety engineer responsible for occupational health and safety	521
8.3.2.5	Occupational medical services and appointed company physician	522
8.3.2.6	Appointed safety representatives.	523
8.3.2.7	Works council.	524
8.3.3	Occupational health and safety in the project	524
8.3.3.1	Planning phase, invitation to tender and offer	524
8.3.3.2	Preparation of construction execution, personnel planning, work scheduling	526
8.3.3.3	Occupational health and safety during construction work	531
8.3.4	Hazardous material/substances in refractory engineering.	534
8.3.4.1	Importance of the ordinance governing hazardous material/ substances	534
8.3.4.2	Comments on specific material groups in refractory engineering.	535
8.3.4.2.1	Shaped and unshaped (monolithic) refractory materials	536
8.3.4.2.2	Binders and additives containing polycyclic aromatic hydrocarbons (PAHC).	536
8.3.4.2.3	Mixtures containing solvents	536
8.3.4.2.4	Products containing asbestos	537
8.3.4.2.5	Materials out of synthetic mineral fiber	537
8.3.4.2.6	Contaminated refractory linings (breakout)	541
8.4	Environmental protection	541
8.4.1	Preliminary comments	541
8.4.2	Objectives of environmental protection	541
8.4.3	Environmental protection policy, guidelines, laws and ordinances	542
8.4.4	General measures for environmental protection, environmental aspects	544
8.4.5	General responsibilities	544
8.4.6	Environmental aspects for project implementation	544
8.4.6.1	General.	544
8.4.6.2	Materials management.	544

8.4.6.3	Setup of construction site, use of equipment	548
8.4.6.4	Breakout work	548
8.4.6.5	Further activities at the construction site which call for careful consideration of environmental aspects.	549
8.4.6.6	Disposal	549
8.4.6.7	Checklist for the project manager	552
8.4.7	Environmental aspects at the company construction yard and in the office	552
8.4.8	Environmental policy of the company, environmental protection objectives and program	552
Appendix		562
	Appendix index	626
	Appendix literature	628
Glossary		630
Literature		638
Index		642
Alphabetical Listing of Companies		662
Advertisers' index		667