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Pressure Cycling of Steel Pressure Vessels with Gaseous Hydrogen

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Outline and Objectives

- Demonstrate performance test method for evaluating compatibility of pressure vessel with gaseous hydrogen
- Determine failure characteristics of commercial pressure vessels
  - Do the pressure vessels leak-before-burst when cycled with gaseous hydrogen?
- Compare full-scale testing for steel pressure vessels for gaseous hydrogen with engineering design methods
  - Fracture mechanics-based design
  - Stress-life design
- Describe method proposed in CSA standard

Fracture and fatigue resistance of steels is degraded by exposure to hydrogen

Hydrogen-induced failure of transport cylinder

Ref.: *Barthélémy, 1st ESSHS, 2006*

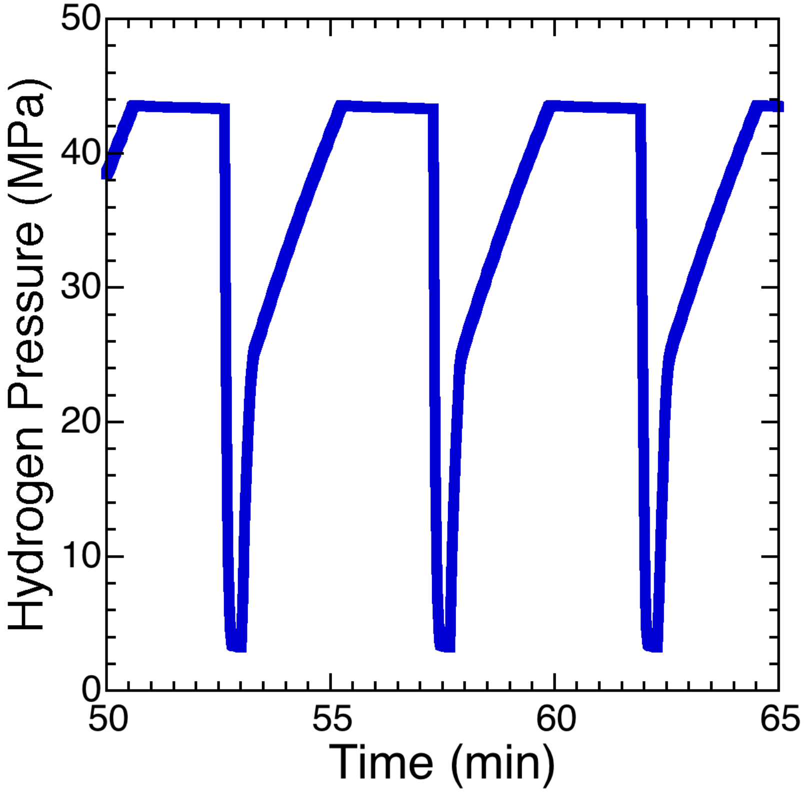
Motivation:
innovative applications are expanding design space beyond engineering experience

>10,000 refueling cycles are anticipated for hydrogen-powered industrial trucks

Accelerated pressure cycling of steel pressure vessels to explore cycle life >10,000

Consider 35 MPa gaseous hydrogen fuel system

- Nominal pressure of 35 MPa
- Allow 25% over-pressure during rapid filling
- Minimum system pressure of ~3 MPa

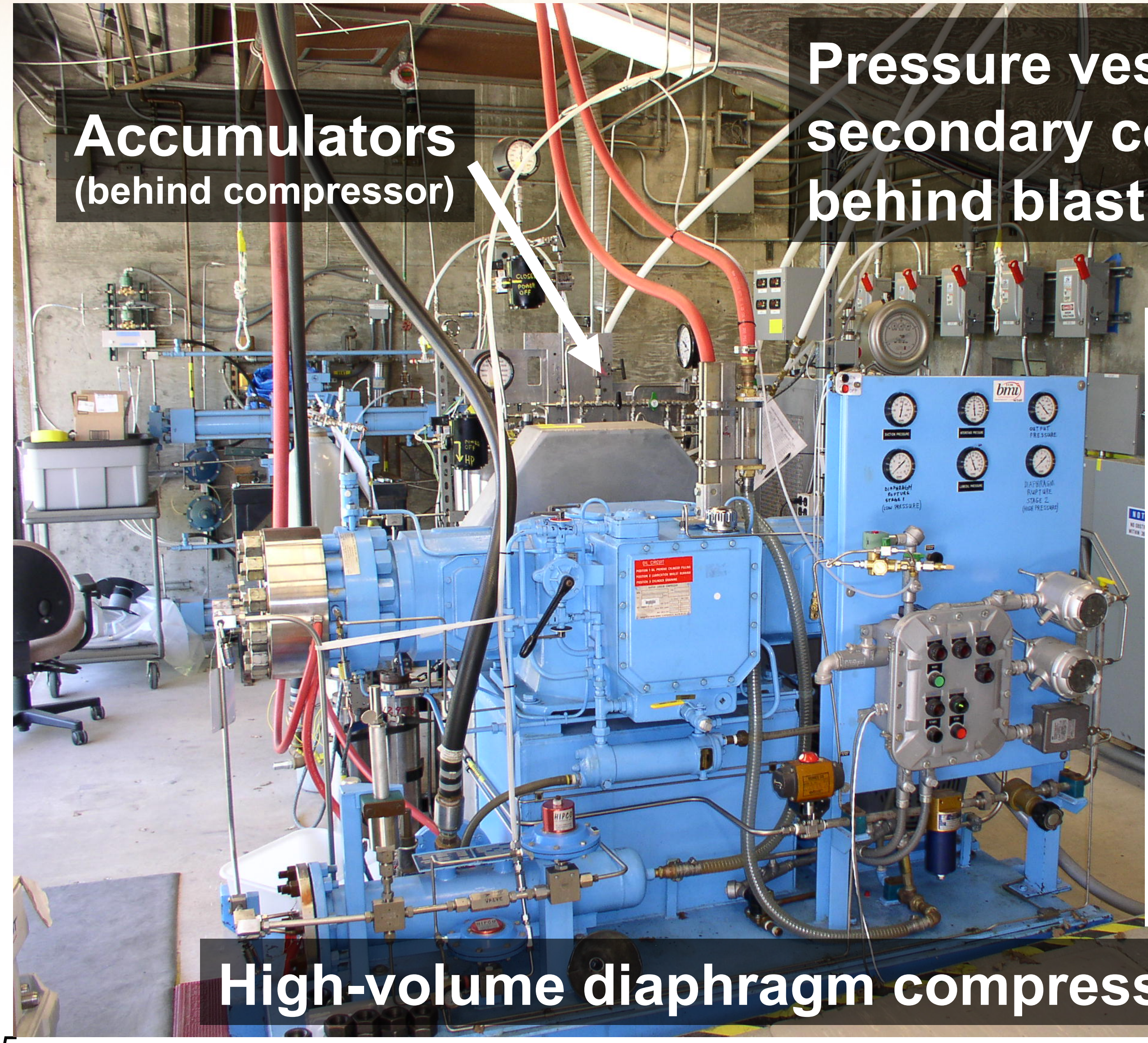


Pressure cycle for testing

- maximum P = 43.5 MPa
- 2-minute hold at maximum P
- rapid depressurization to 3 MPa
- 30-second hold at minimum P
- pressurization time ~ 2 min

4 to 5 minute cycle time
(~300 cycles per day)

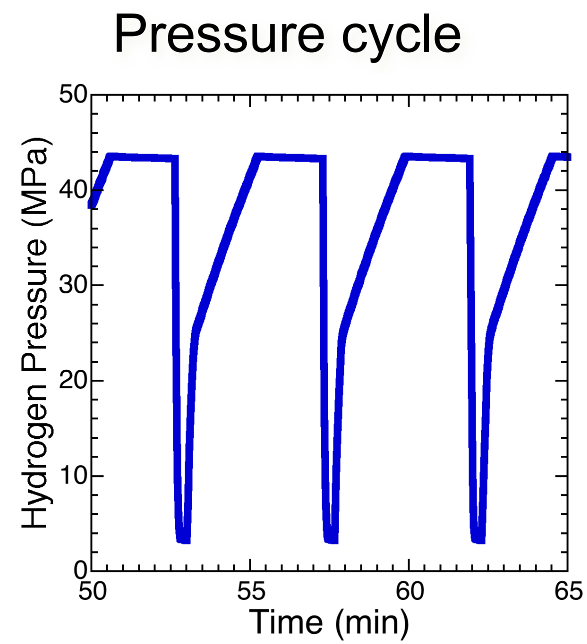
Closed-loop gas-handling system capable of simultaneously pressurizing 10 pressure vessels



Accumulators
(behind compressor)

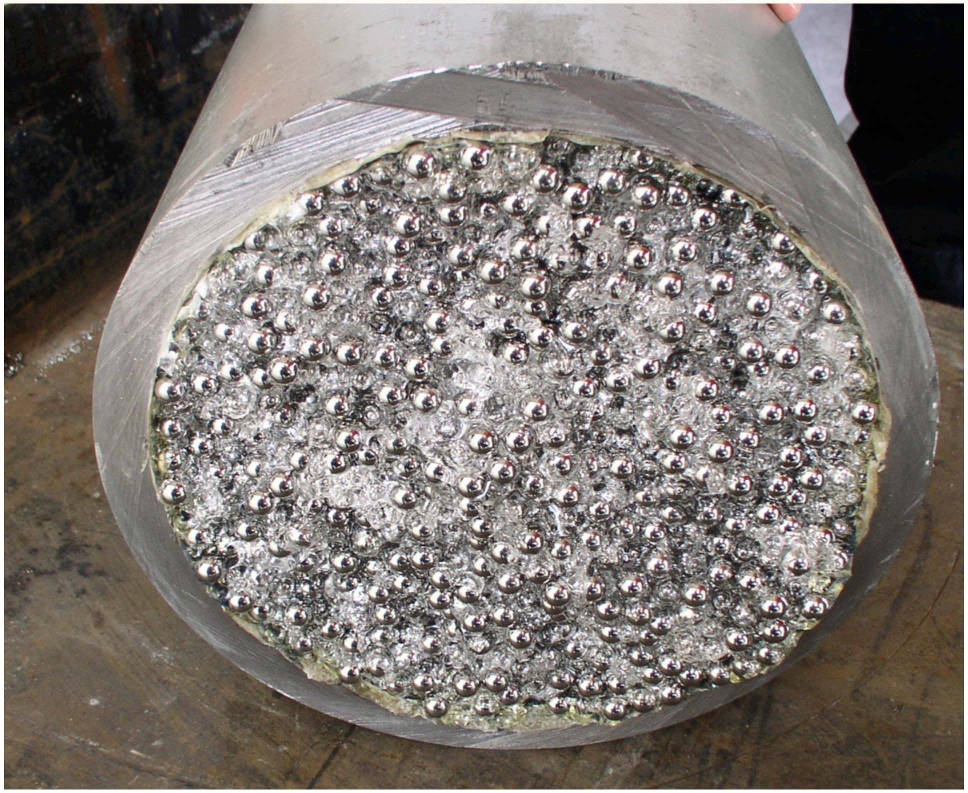
Pressure vessels in secondary containment behind blast door →

High-volume diaphragm compressor



Pressure cycle

Free volume within vessels reduced to facilitate pressure cycling



- Bladder used to isolate PV surface from filler material
- Epoxy and steel used as filler
- Volume reduction 90-95%

- Gas quality inspected periodically

  <u>typical analysis</u>
  - oxygen <2 ppm
  - hydrocarbons <5 ppm
  - water <5 ppm

Sectioned pressure vessel showing vessel, bladder, steel ball bearings and epoxy

Pressure vessels consistent with design rules for transportable gas cylinders

- Two pressure vessel designs from different manufacturers
  - Nominal hoop stress at P = 43.5 MPa
    - T1 design: ~340 MPa
    - T2 design: ~305 MPa

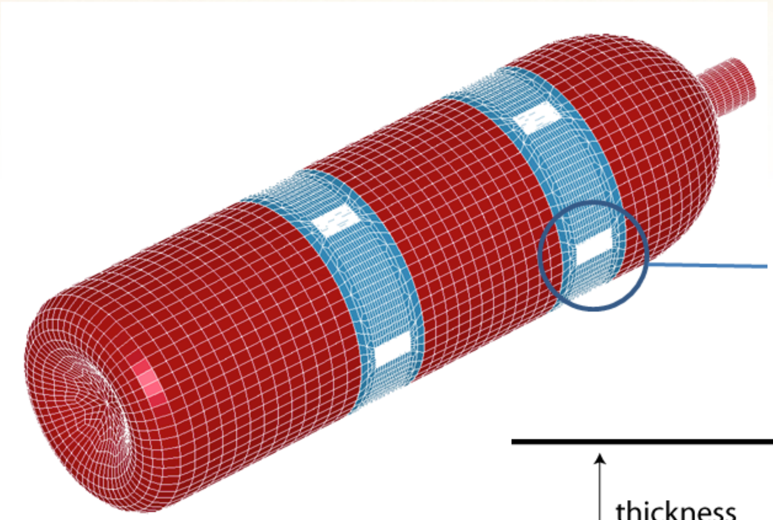
- Steel for both pressure vessels designs: 4130X
  - Quench and tempered, 1 wt% Cr - 0.25 wt% Mo
  - UTS for transport applications: 700 to 900 MPa
    - T1 design: ~750 MPa
    - T2 design: ~850 MPa

Typical design rule: maximum wall stress <40% of UTS

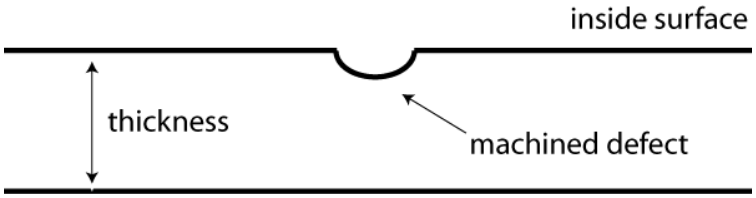
T1 design: 300 MPa

T2 design: 340 MPa

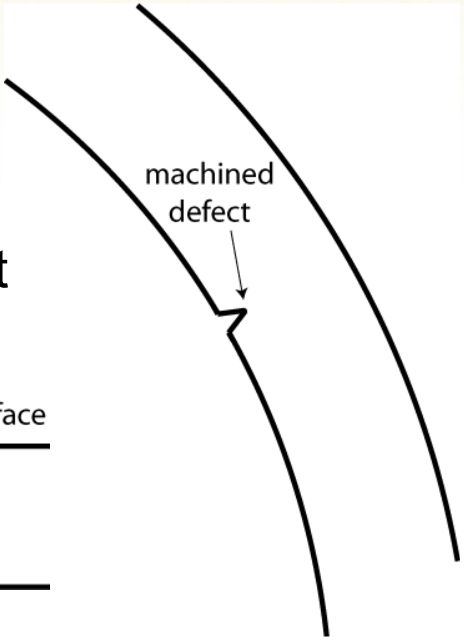
Engineered defects used to initiate failures



Engineered defect (10 per vessel)



Elliptical engineered defect
Aspect ratio = 1/3 (depth/length)



V-notch in profile
Nominal root radius 0.05mm
(actual ~0.12mm)

Depth of engineered defects

- Typically all 10 defects similar for a given vessel
- Smallest defects ~2% of wall thickness
- Largest defects ~10% of wall thickness
- For one vessel, aspect ratios were 1/2 and 1/12

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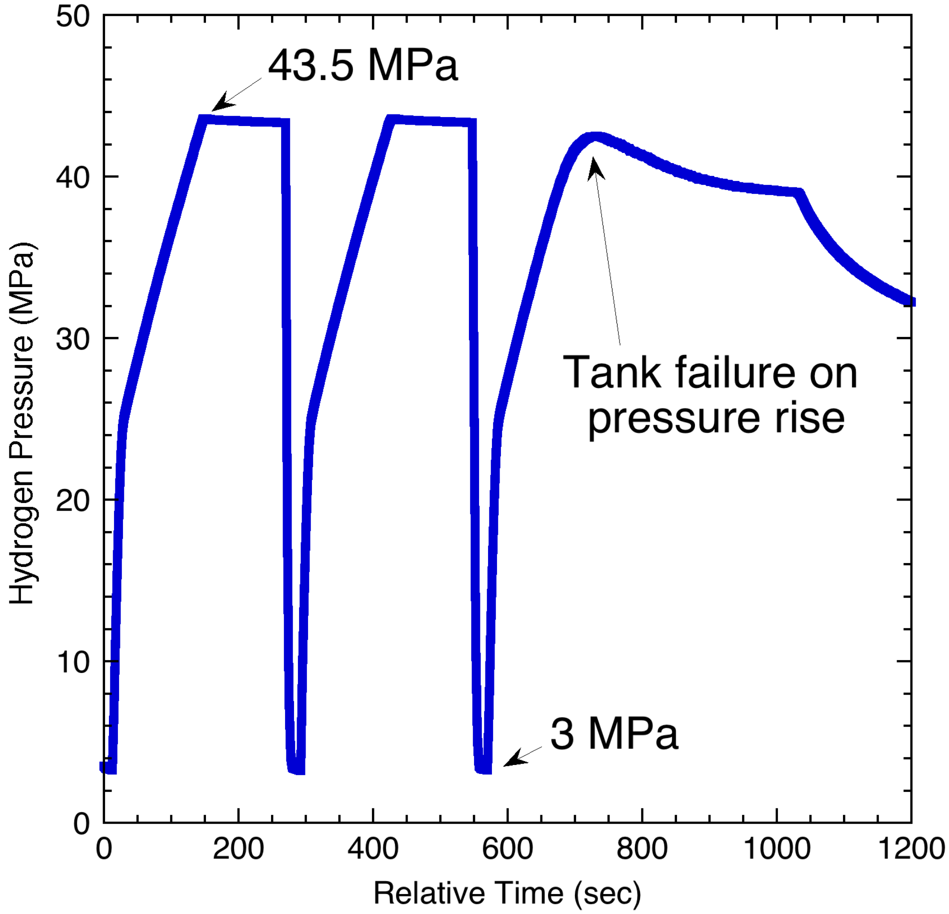
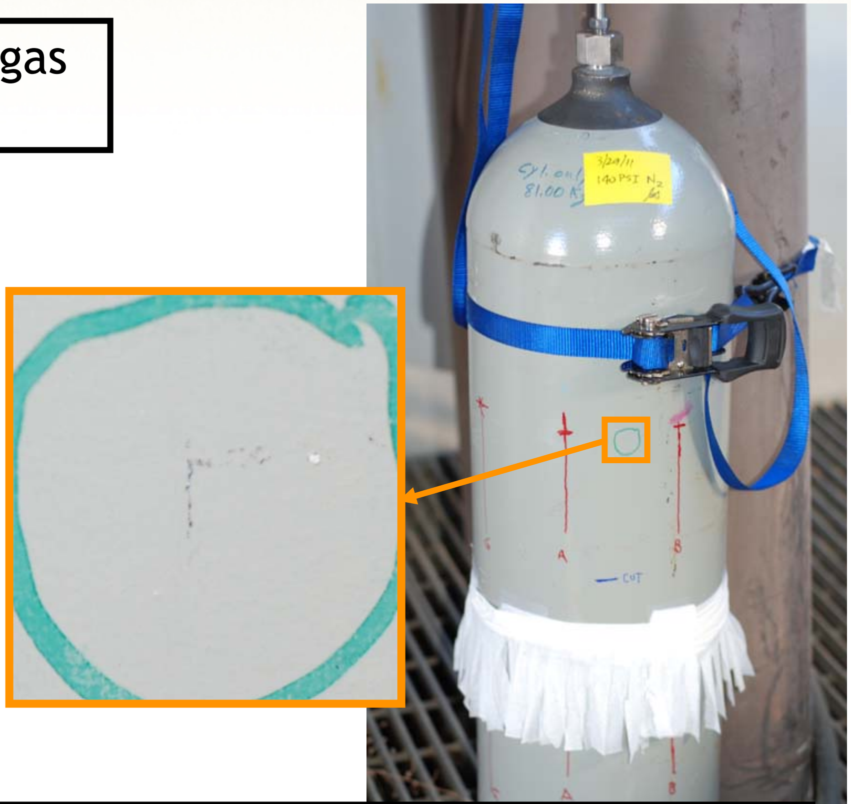
All observed failures are *leak-before-burst*

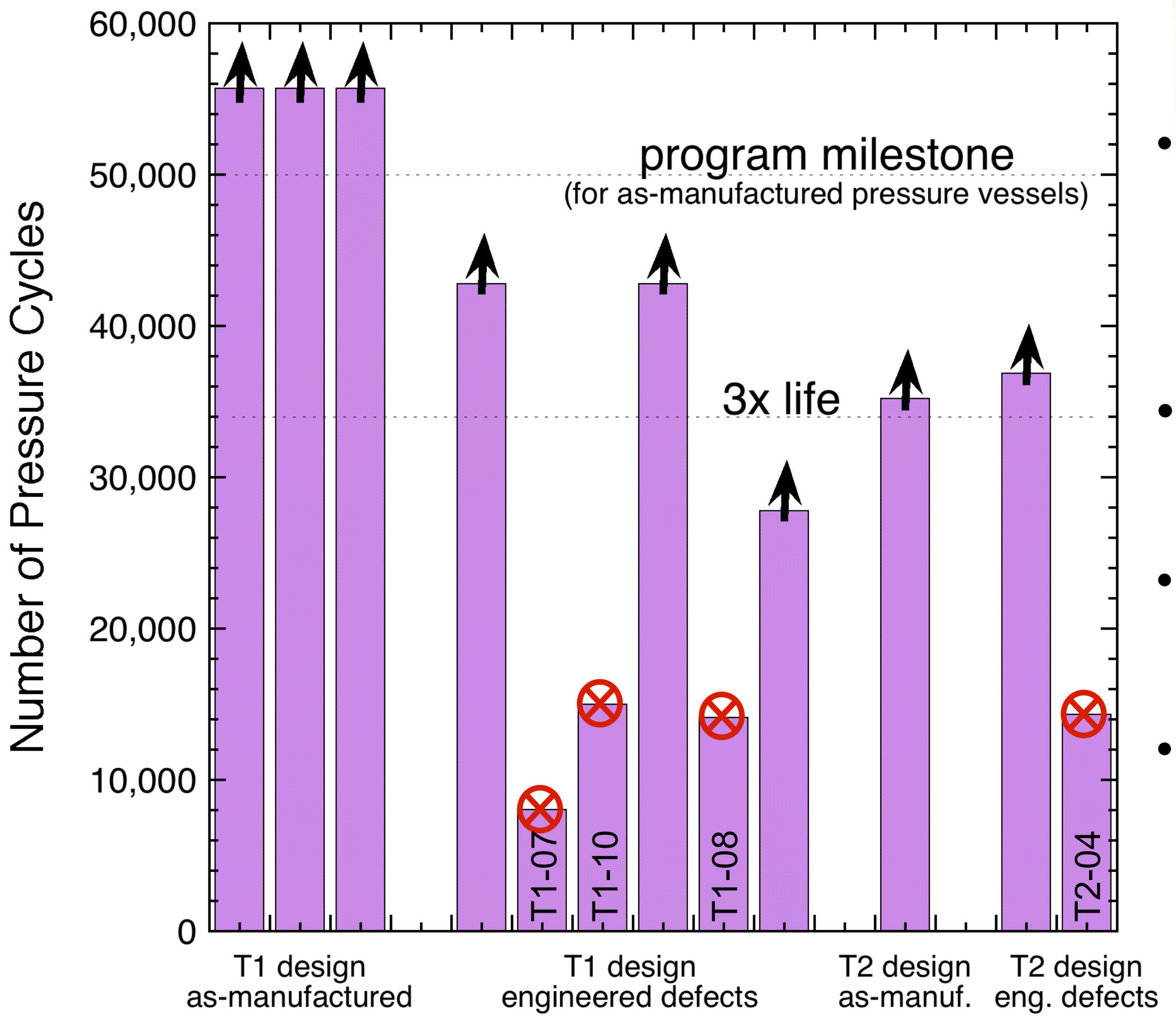
- At failure, pressure vessel “slowly” leaks gas into secondary containment





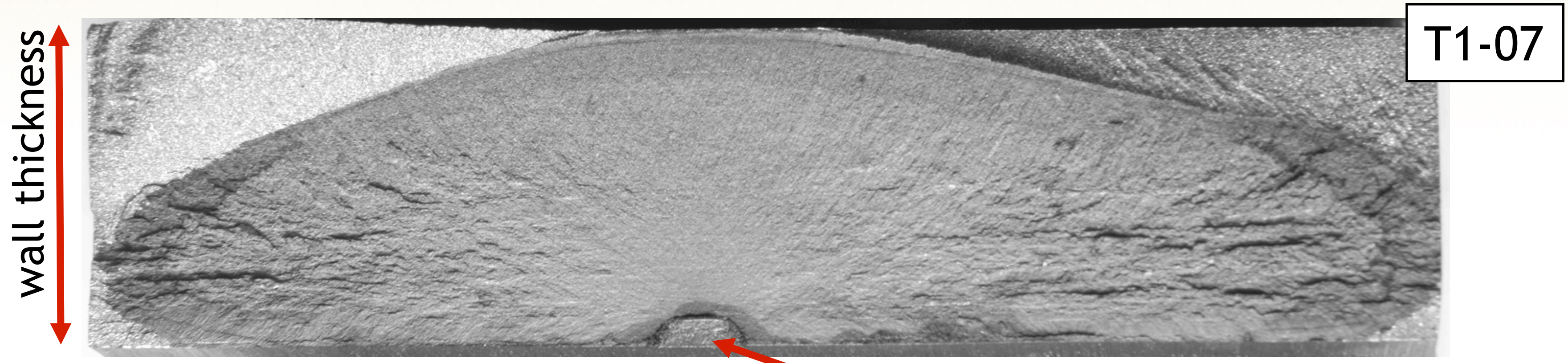
- Through-wall crack cannot be detected visually

Commercial pressure vessels exceed lifetime target of 11,250 cycles by >3x

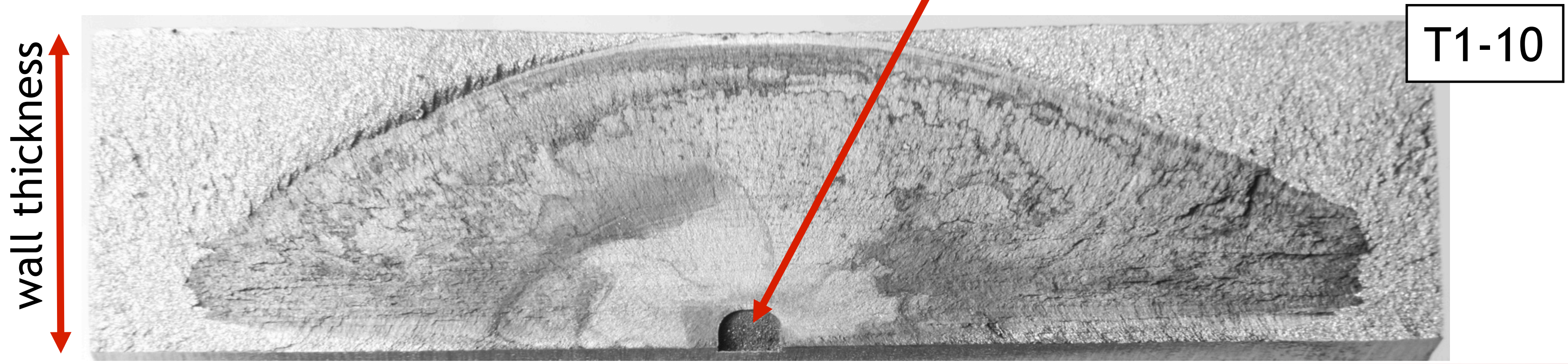


- Each pressure vessel with engineered defects contains 10 nominally equivalent defects
- Arrows indicate pressure vessels that did not fail
- In failed vessels, all defects initiate a crack
- All four failures were leak before burst

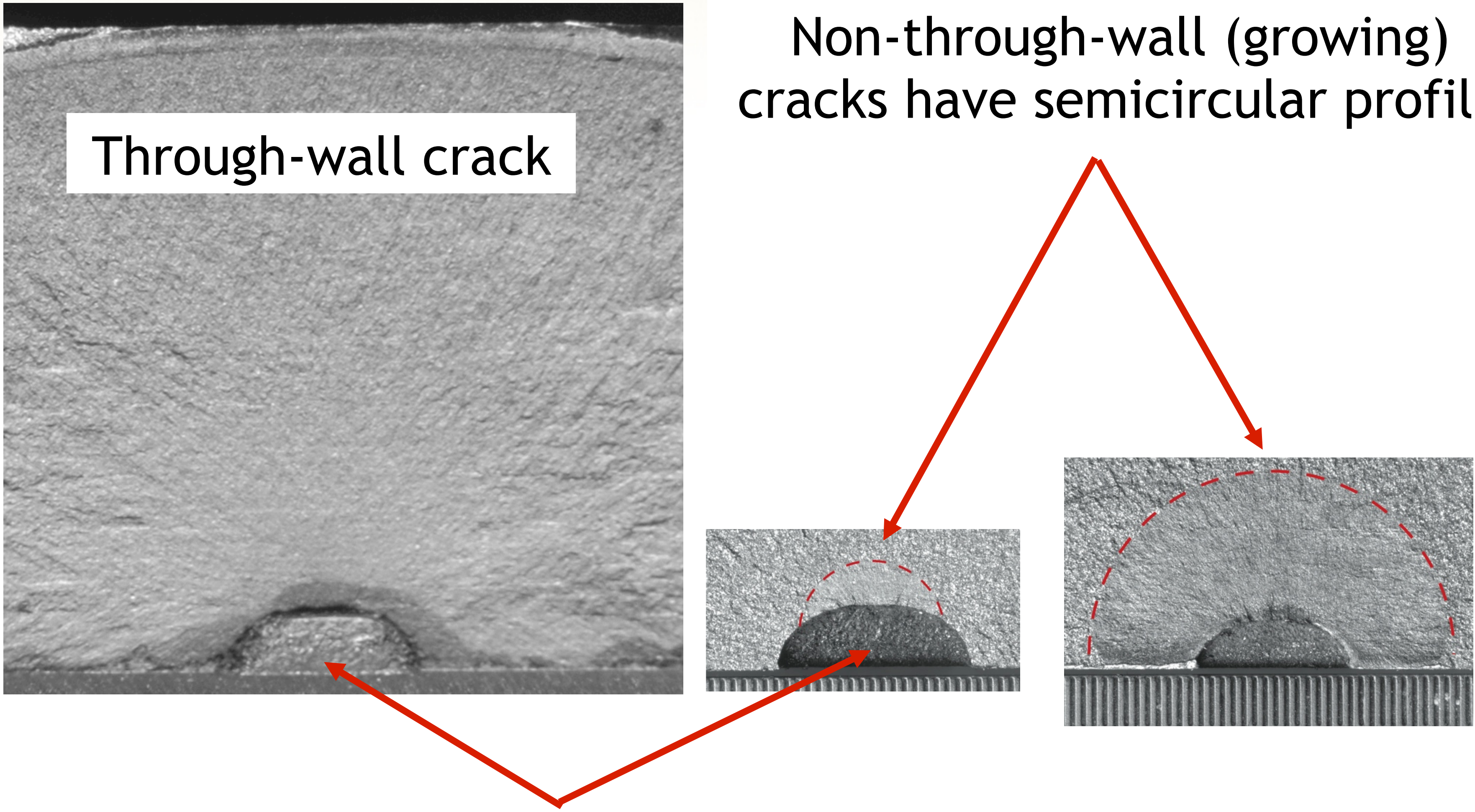
Through-wall cracks extend from "critical" engineered defect



engineered defect



Cracks extend from all engineered defects



Through-wall crack

Non-through-wall (growing) cracks have semicircular profile

Same size engineered defect
(same vessel)

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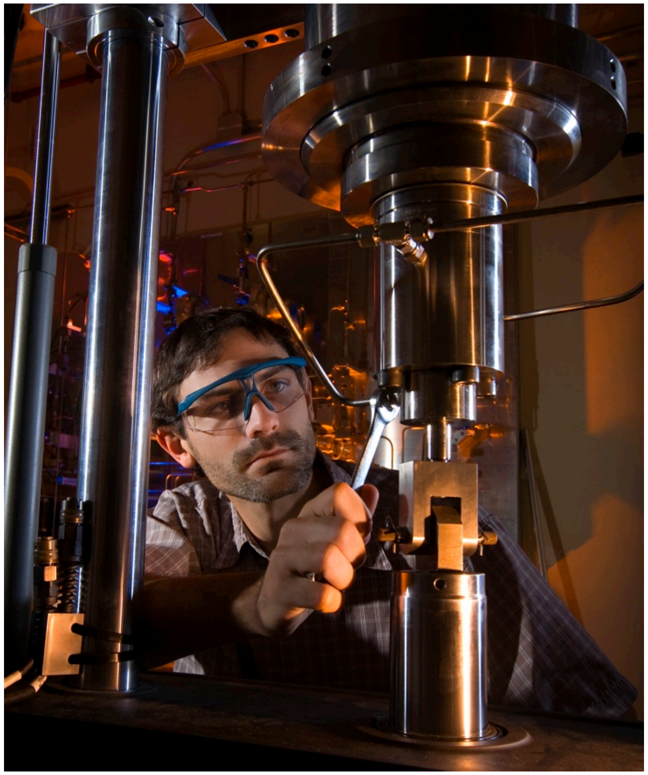
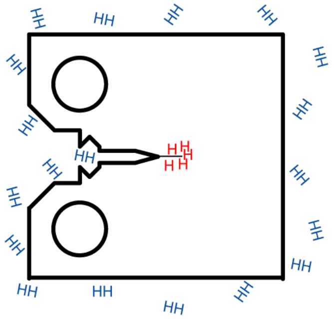
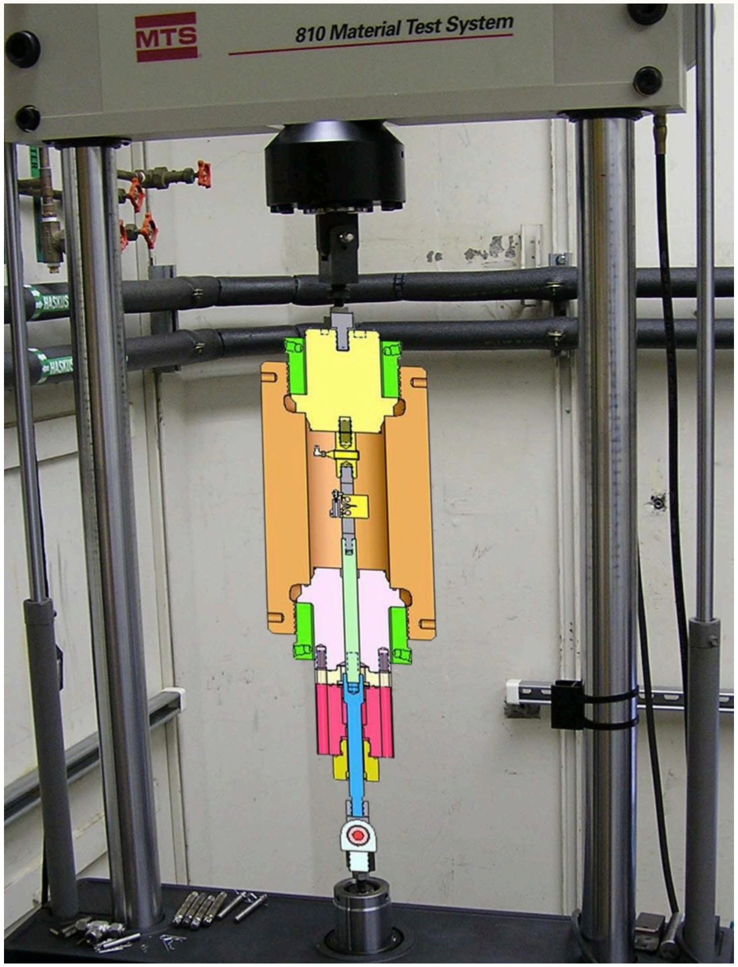
Fracture mechanics tests can be conducted in gaseous hydrogen at high pressure

- Fatigue crack growth: da/dN
  - ASTM E647, constant load amplitude
- Fracture resistance: K_{IH}
  - ASTM E1820, elastic-plastic analysis using J-R curve determination



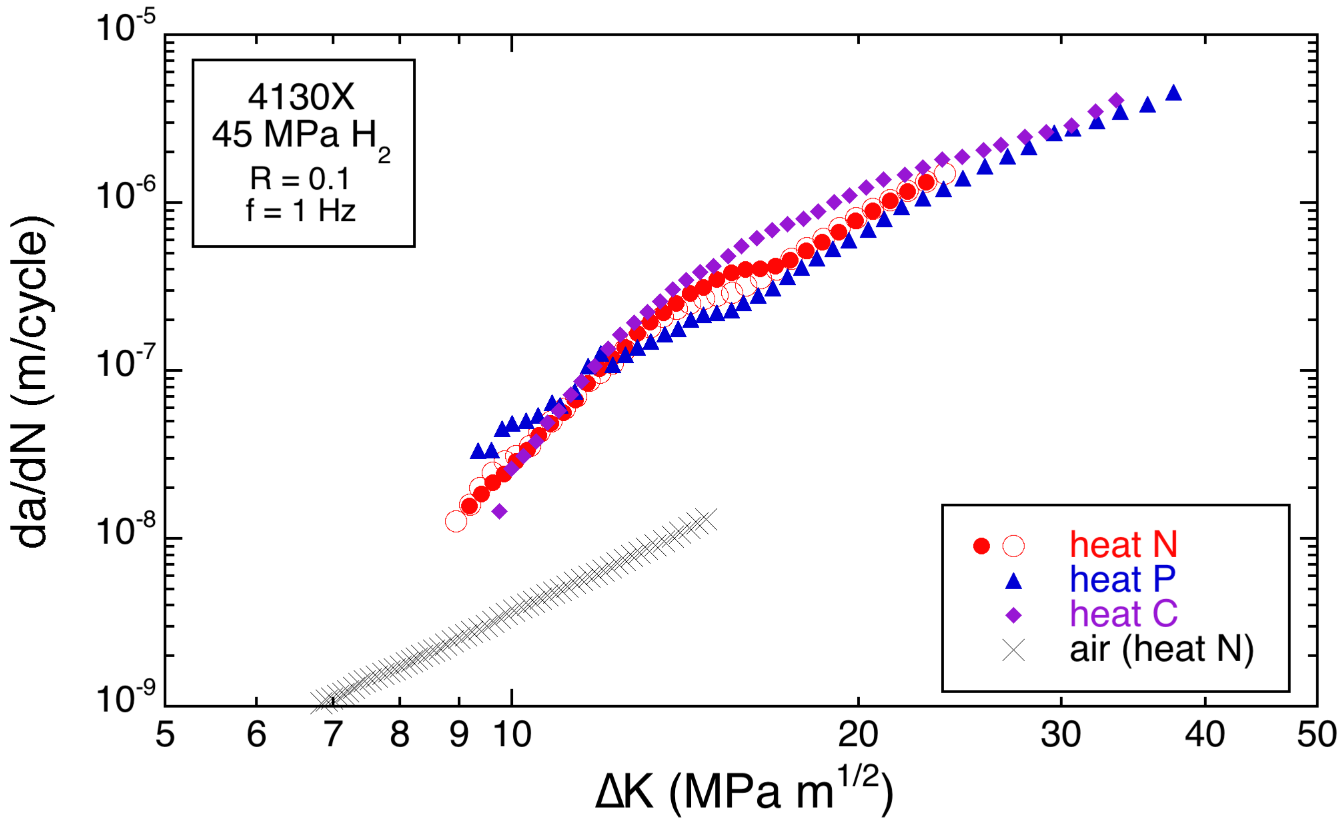


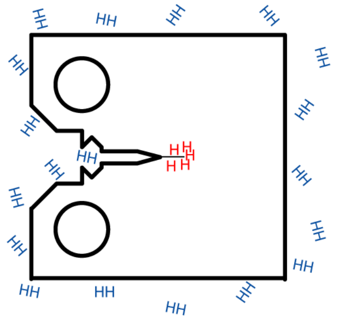


Fatigue crack in gaseous hydrogen is an order of magnitude greater than in air

Fatigue crack growth rates measured in gaseous hydrogen at pressure of 45 MPa

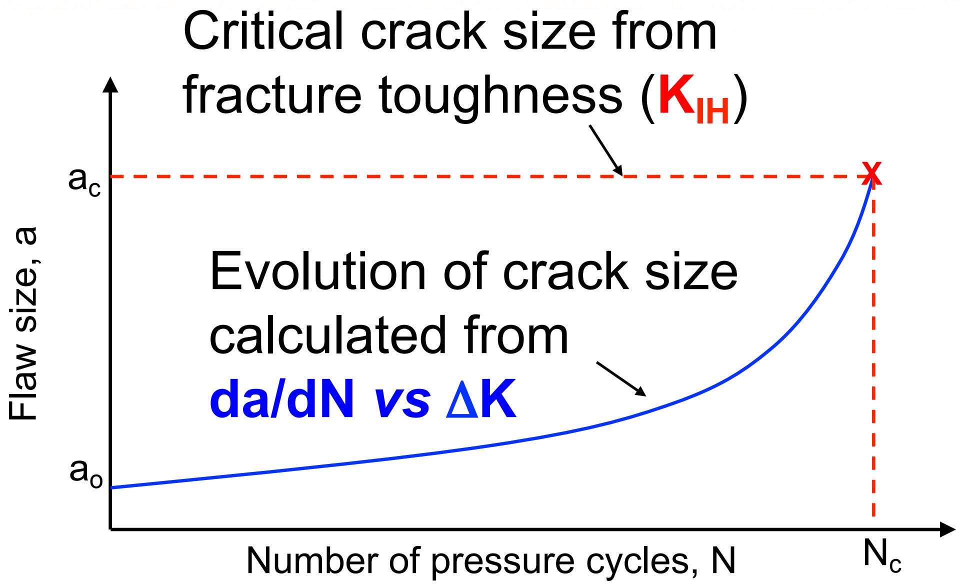
- 3 heats of 4130X steel from pressure vessels
- (unlike fracture resistance, fatigue crack growth in ferritic steels appears to be relatively insensitive to hydrogen pressure)





Fatigue life qualification by fracture mechanics (crack growth methodology)

ASME BPVC VIII.3 KD-10 (KD-4)



Critical crack size from fracture toughness (**K_{IH}**)

Evolution of crack size calculated from **da/dN *vs* ΔK**

Stress intensity at a/t = 0.8

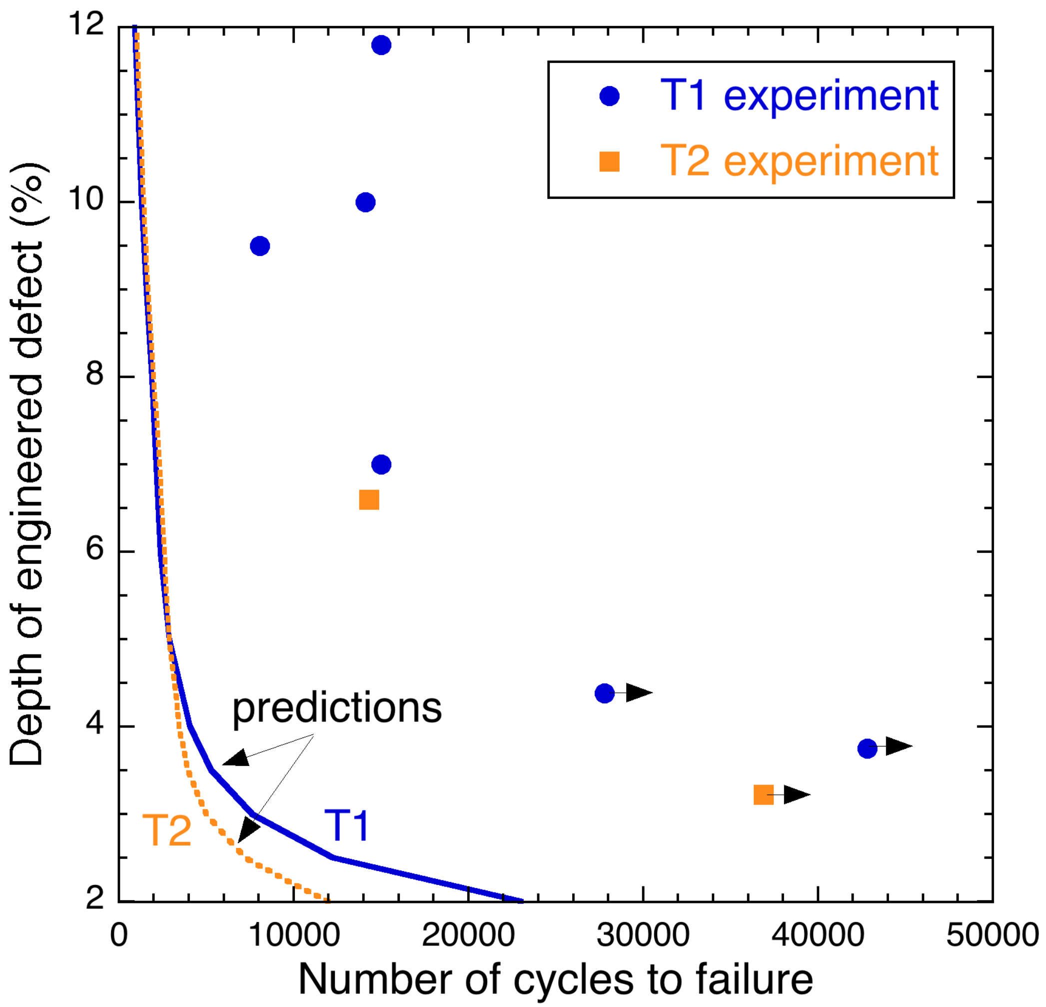
T1: 55 MPa $m^{1/2}$
T2: 64 MPa $m^{1/2}$

$^{\dagger}K_{JIH}$ = 59 MPa $m^{1/2}$

Assumptions:
- a_c = thickness
- semicircular propagating cracks
- use data† for R = 0.1 and f = 0.1 Hz

† 4130X steel measured in gaseous H_2 at pressure of 45 MPa
Nibur et al. (PVP2010-25827)

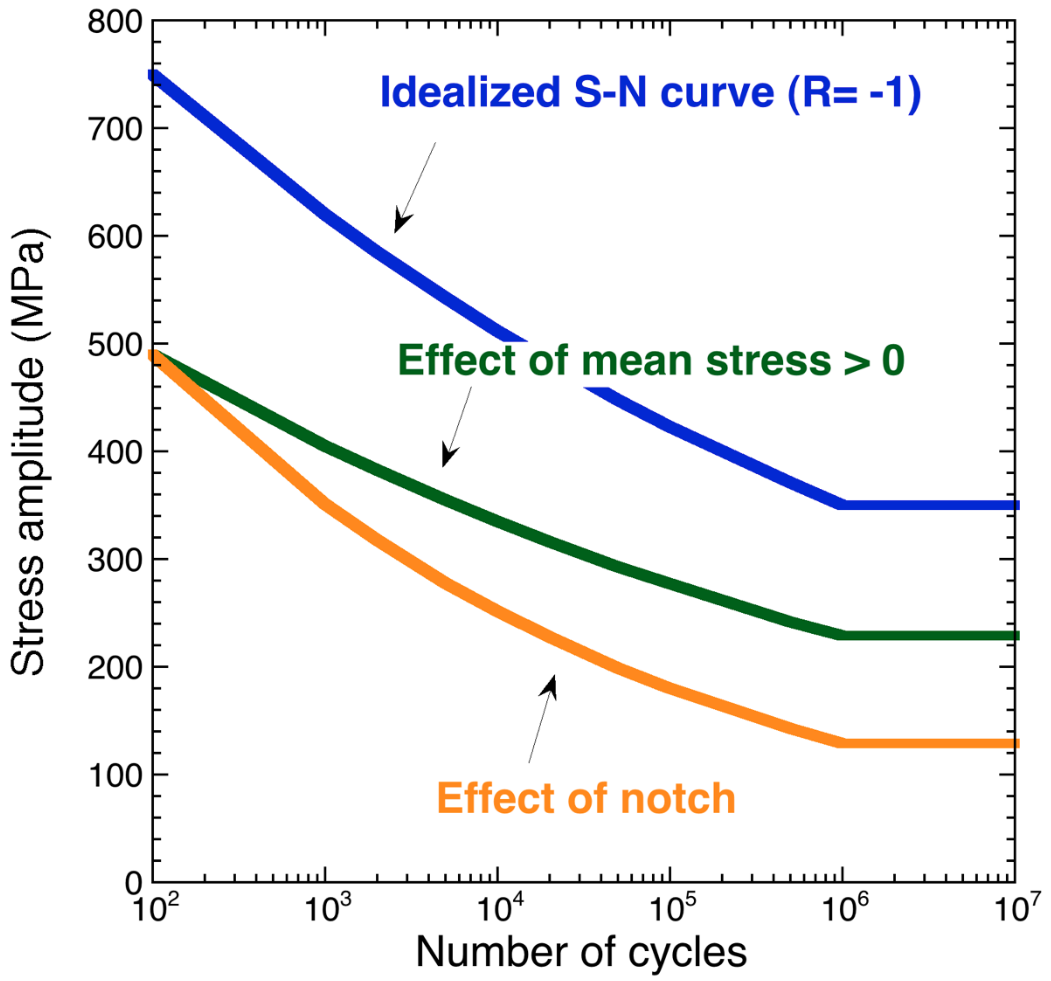
Fracture mechanics is overly conservative when defects are not initially growing



- Curves are predictions based on *crack growth* only (of semicircular flaw)
- Arrows indicate vessels that did not fail
- Failures use measured dimensions (others assume nominal dimensions)

- Fatigue life calculation is conservative by factor of 4 or more
- For small initial defects, effective safety factor approaches 10

Fatigue life methods offer framework for incorporating crack initiation



- Idealized S-N curves based on
  - Materials properties: S_u (UTS) and S_f
  - Geometry and loading: K_f and S_m

Effect of mean stress:

$$S_f^* = S_f\left[1 - S_m/S_u\right]$$

Effect of notch:

$$S_f^N = S_f/K_f$$

Effect of hydrogen on S-N curve and fatigue limit is unknown

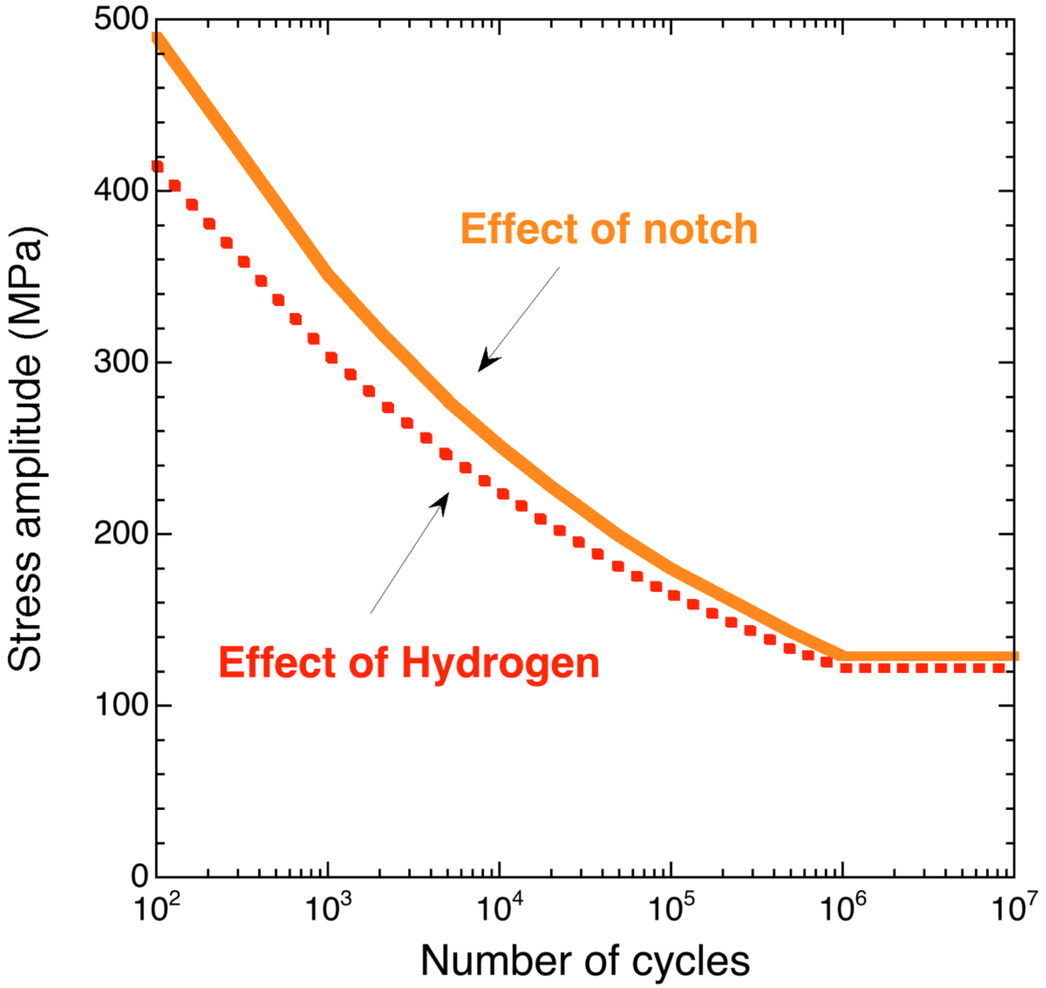
Data for Cr-Mo steels in tension-compression fatigue *suggests*

$$S_f(H_2) \approx S_f(\text{air})^\dagger$$

Implication: at low stress hydrogen does not affect fatigue crack initiation

Conservative assumption based on notched tension‡ in gaseous hydrogen:

$$S_u(H_2) \sim 0.9\, S_u$$



† Ref. Wada et al. ICHS 2005

‡ Ref. Steinman et al. Welding J Res Supp 44 (1965)

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Draft CSA Standard for Compressed Hydrogen Powered Industrial Truck On-Board Fuel Storage and Handling Components (HPIT1)

Performance requirements

- Leak-before-break requirements
  - type 1, 2 and 3: ASME VIII.3 KD-141 using K_{IC}
  - type 4: ISO 15869 Annex B.8

- Two performance options:
  - Fatigue life verification by ***testing***

  OR

  - Fatigue life qualification by ***analysis***

Draft CSA Standard for Compressed Hydrogen Powered Industrial Truck On-Board Fuel Storage and Handling Components (HPIT1)

- Fatigue life verification by ***testing***

  Requirement: 3X maximum fill cycles specified by manufacturer
  - Pressure cycling with gaseous hydrogen
  - Artificial defect: depth ≥ NDE; aspect ratio >3:1 (length:depth)
  - 10 to 125% service pressure

- Fatigue life qualification by ***analysis***

  Requirement: maximum fill cycles determined from ASME VIII.3 KD-3
  - Design pressure = 125% service pressure (25 or 35 MPa service)
  - DOT 3AA 4130X or ASME SA-372 (Cr-Mo) steels
  - $S_u < 890$ MPa
  - Wall stress (hoop stress) < 0.4 S_u
  - Surface roughness: $R_a < 6.4$ μm and $R_{max} < 20$ μm

Fatigue life qualification by analysis

Proposed requirements for type 1 steel pressure vessels in gaseous hydrogen service

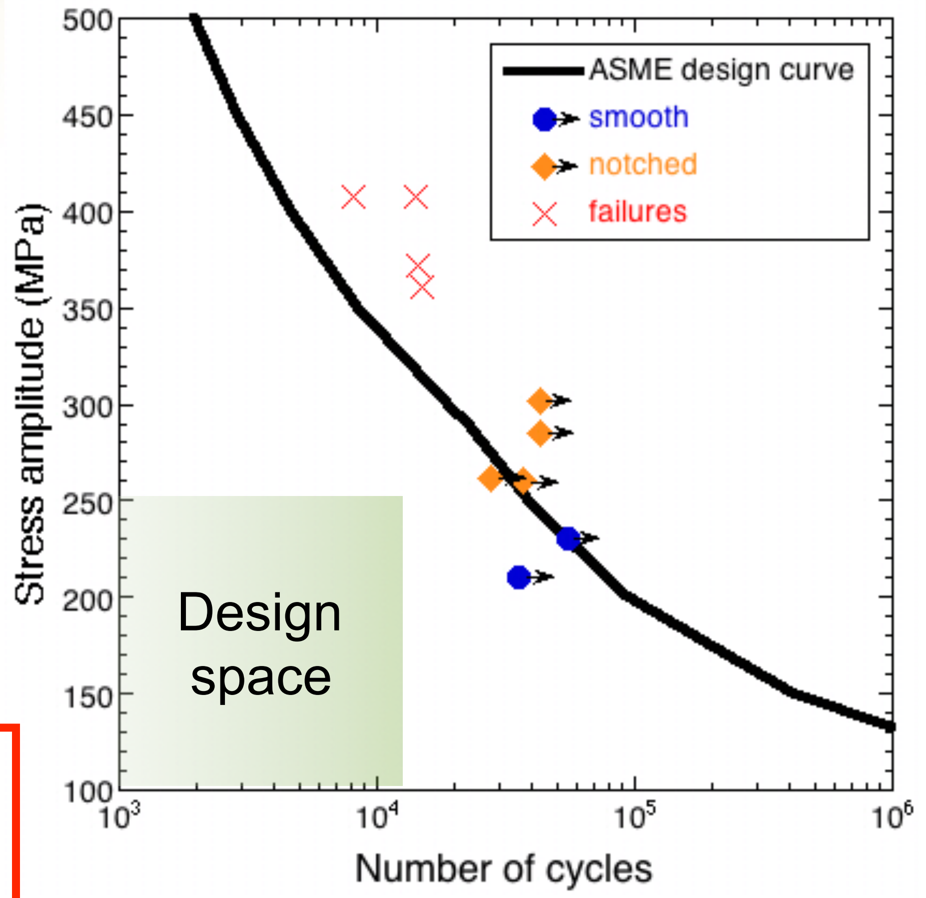
- S_u < 890 MPa
- hoop stress ≤ 0.4 S_u = 356 MPa

From ASME VIII.3 KD-3

- assume: K_r = 1.25
- T1 design
- $S_m \approx 260$ MPa & $S_a \approx 230$ MPa

<u>Engineering Significance</u> of these requirements

- Stress intensity < ~400 MPa
- Stress amplitude < ~250 MPa
- Design life > 40,000 cycles



ASME design curve: carbon and low alloy steels with UTS = 620 MPa

Summary

- Vessels being used for hydrogen storage were subjected to more than 55,000 pressure cycles with gaseous hydrogen at a peak pressure of 43.5 MPa
- Engineered defects with depth >6% of the wall thickness failed between 8,000 and 15,000 cycles
- Leak-before-burst was observed for all failures
- Fatigue crack growth assessment is very conservative for idealized defects
  - Cycles to failure due to engineered defects is >4 times design calculation using ASME VIII.3
  - Crack initiation dominates the cycle life even with internal defects
- Fatigue life curves based on testing in air have been proposed for design of hydrogen pressure vessels (CSA HPIT1)