



**INSTALLATION, OPERATION AND MAINTENANCE INSTRUCTIONS FOR THE WORLD HEAT  
RANGE OF NON-STORAGE STEAM/WATER HEAT EXCHANGER**

**1.0 DESCRIPTION**

World Heat standard range of Non-Storage Steam/Water Heat Exchangers are typically used within heating systems to utilise steam. Low Temperature Hot Water (LTHW) is usually generated, although our standard unit can also be used to generate Medium Temperature Hot Water (MTHW) and Hot Temperature Hot Water (HTHW).

World Heat manufacture Non-Storage Steam/Water Heat Exchangers in the following materials; Mild Steel, Stainless Steel (various grades) and Galvanised Mild Steel.

**2.0 PED INFORMATION**

The World Heat standard range of Non-Storage Steam/Water Heat Exchangers are designed and manufactured in accordance with the requirements of the Pressure Equipment Directive 2014/68/EU. As per the requirements of the directive, units that fall within the SEP (Sound Engineering Practice) category are not supplied with a CE Mark. Units that fall within categories I to IV are CE Marked and provided with the necessary markings, certification and inspectorates.

It is the responsibility of the user and/or installer to ensure that the unit is installed and operated safely, and in accordance with the instructions detailed within this document.

**3.0 COSHH**

Research has suggested that there are no specific items to highlight during normal operating conditions. However, during manufacture, dye-penetrant may be used as part of our pre-inspection process of welds. It is therefore essential that adequate flushing and sterilization is carried out before use and that the water produced is to an acceptable standard.

**4.0 INSTALLATION**

**4.1 LIFTING AND HANDLING**

- a) Lifting lugs, where fitted, should be used for lifting purposes.
- b) For units without lifting lugs, the user must arrange suitable lifting arrangements (i.e. the use of slings, lifting eyes etc.) to avoid damaging the vessel or its attachments during installation, taking into consideration the weight and design of the unit.
- c) Where fitted, insulation should not be used for lifting purposes.
- d) Due to the insulation and case characteristics, care should be taken when lifting and handling the unit to prevent damage.
- e) Avoid the use of lifting straps where insulation is fitted, as they may damage or crush the insulating material or case.
- f) Do not lift the unit using chains which are directly in contact with the shell.
- g) Do not allow operatives to stand on the shell.

**WARNING: When lifting, please ensure a clean lift of the unit using the lifting lugs provided. The legs/ring stand/vessel supports are not designed for pivoting during lifting/siting/installation. Units should be kept in the upright position.**



#### 4.2 STORAGE – ***If storing the unit for any period of time before installation***

- a) Upon receipt of the unit, please check the packaging to ensure that it has not been damaged during transport. Any damage to the packaging should be fixed or replaced as necessary.
- b) It is recommended that the unit be stored indoors within a dry frost-free environment with ambient temperatures between 4°C and 40°C.
- c) The integrity of the packaging should be checked monthly. Should the external seal be found to have broken or its condition deteriorated (i.e. become wet, hardened or split), the packaging should be repaired or replaced.
- d) Once sited and the packaging has been removed, the condition of the unit should be thoroughly examined for any signs of corrosion or contaminant ingress.

#### 4.3 SITING

- a) Unless specified at enquiry stage and specifically ordered to suit an external installation, the unit must be sited indoors.
- b) Foundations or plinths must be firm and level to prevent settling, pipe strain or distortion of shell.
- c) Unless specified at enquiry stage and specifically ordered, the unit must be installed in a level position.
- d) Ensure that there is sufficient maintenance space surrounding the unit.

#### 4.4 INSTALLATION

- a) Protective covers and plugs may be fitted to connections to protect them in transit, these must be removed prior to use.
- b) If a connection is not required for any reason, the connection must be sealed appropriately.
- c) Check for any signs of contaminant ingress which may have got into the unit during transportation or storage on site.
- d) Pipe-work connected to the unit must be adequately supported to prevent any loads being transmitted to the unit. Consideration must be taken with regards to thermal expansion through the use of bends and expansion joints.
- e) Isolation valve should be fitted prior to the unit's pipe-work (EXCLUDING THE VENT CONNECTION) to facilitate future maintenance and servicing.
- f) To avoid corrosion, use appropriate pipe materials to suit the vessel material.
- g) To connect to the vessel screwed connections, a suitable thread sealant should be used.
- h) To connect to the vessel flanged connections, bolts should be tightened in a diametrically opposite sequence in order to load the flanges evenly onto the gasket. The gasket should be suitably chosen for the application.
- i) A suitable safety relief valve should be fitted to prevent over-temperature and over-pressure. The discharge should be piped away to a safe disposal point, preferably an air break and tundish so that the discharge is unrestricted and easily visible.



#### **4.5 CHLORINATION & SYSTEM CLEANING**

We highly recommend that our vessels are bypassed if carrying out any chlorination and chemical cleaning to the hot water or heating systems. Chlorine and other cleaning chemicals such as hydrogen peroxide can be extremely corrosive to stainless steel. If chemical cleaning is taking place, then the chemical must be thoroughly flushed through with water to clear the chemical, then the vessel should be fully drained and jet washed internally to ensure no chemical is present inside the vessel wall. Remove any electrical elements prior to chemical cleaning and plug the holes and only refit the elements after the vessels have been drained and jet washed internally. Please contact your chemical cleaning provider to ensure anything you are using is not corrosive to stainless and mild steel material prior to use. Our warranty does not cover failure due to corrosion, therefore if the vessels are corroded by something present in the water, they will not be covered under a manufacturing warranty.

#### **5.0 COMMISSIONING & OPERATION**

Do not operate the equipment at pressures or temperatures in excess of those specified on the nameplate of the unit. Do not subject the unit to conditions of vacuum or partial vacuum. For example, partial vacuum may occur if the cold feed or vent is restricted during draw off or drain down.

a) Assumptions

- It is assumed that the secondary pipe-work is already full of water.
1. All isolating valves isolating the unit from the system should be closed and any circulation pumps turned off.
  2. Close the unit drain valve.
  3. Open any manual air vents fitted.
  4. Open the fill connection valve and slowly fill the unit with cold water.
  5. When water appears at the manual vent valve, close it.  
(If the vessel is open vented and shares a vent with other units, connect it to the common vent using a 3-way valve).
  6. Turn on the secondary re-circulation pump.
  7. Slowly introduce the hot fluid to the primary side tube bundle.
  8. Allow the unit to heat up.
  9. Adjust the temperature control gradually and ensure that the correct operating temperature is maintained.

Whilst the unit is operating, check that all of the gaskets supplied with the unit are effective. Some bolt tightening may be required after the unit has been subjected to its first heating cycle and subsequently maintained.

Following installation and commissioning, it is advisable to remove, clean and reassemble any strainers prior to operation.

When the unit is taken out of operation, all fluids must be drained from the vessel to prevent freezing or possible corrosion.



## 6.0 MAINTENANCE

Annual maintenance of the unit should consist of internal inspection of the heater shell and inspection of the gaskets supplied as part of the unit. As per guidelines regarding Legionella proliferation, it is recommended that the vessel internals are cleaned. Site insurers may also require annual inspection of the shell conditions.

It is also recommended to regularly clean the primary tube bundle. The standard World Heat Non-Storage Steam/Water Heat Exchanger is designed to minimise fouling of the heat exchanger, however regular cleaning can ensure maximum efficiency. Fluid characteristics can determine the rate of scale accumulation, high operating temperatures and hard untreated water can increase fouling. Therefore, the maintenance regime should be designed to suit each application.

In order to drain the unit down to carry out annual maintenance;

1. It is assumed that all isolating valves isolating the unit from the system are open.
2. Isolate the primary fluid inlet and outlet – switch off the primary pump and boilers if necessary. Do not drain down the primary side while the secondary side remains under pressure, this could cause the tube bundles to be crushed.
3. Switch off any secondary circulating pumps.
4. Isolate the unit by closing the isolating valves installed.
5. Allow the unit to cool to a safe temperature.
6. On seal systems, reduce the residual pressure within the unit by manually operating the safety valve.  
**Please Note: Some water will be produced by the safety valve.**
7. Open the manual vent valve and allow air into the unit during drain down.  
(If the unit is open vented and shares a common vent with other units, isolate the vessel from the common vent using a 3-way valve and vent to atmosphere).
8. Ensure that the drain is piped away appropriately to a designated drain point before opening the drain valve and allowing the vessel contents to drain.  
(If the drain connection is positioned on the side of the unit, it will not completely drain the unit. The residual water should be pumped or siphoned out appropriately).
9. The vessel internals should be inspected by removing the primary tube bundle to allow visual examination.
10. Re-fill the unit as per the instructions provided in Section 5.0 of this document.

In order to remove and clean the tube bundles;

[Tube bundles are typically condensed making chemical cleaning the most effective method of cleaning. Ensure that the chemicals used do not adversely affect the tube-bundle material; seek professional advice if you have any concerns or doubts.]

1. Drain the vessel as per the instructions provided above.
2. Allow the primary pipe-work to cool to a safe temperature.
3. Disconnect the primary pipe-work and remove the primary header.  
**WARNING: The tube bundle may be heavy, ensure adequate lifting equipment is available to withdraw it without distortion or damage.**
4. Avoid damaging the surfaces of the flanges.
5. Once the bundle has been removed, it should be positioned so that it is not supported using the tubes. The use of support plates or wooden blocks (shaped to the bundle) is recommended to protect the tubes and baffles from damage or distortion.
6. Clean the bundle as required.



7. Re-fit the tube bundle and associated gaskets, and re-fill the vessel as per the instructions provided in Section 5.0 of this document.

#### 6.1 FAULT FINDING

If a loss of performance or increase in the primary pressure drop is observed, the following are possible causes;

- Primary fluid restriction (i.e. faulty control valve, blocked strainer etc.)
- Air lock on primary side
- Scale deposited on the heat exchanger surfaces (both internally and externally)

If excessive noise is heard this may be caused by;

- Excessive flow-rates (both on the primary or secondary side)
- Over-wet steam
- Insufficient secondary flow-rate causing overheating and "kettling"

#### 7.0 RECYCLING

For details on the end of life disassembly, recycling and disposal requirements of the unit, please consult the general assembly drawing and technical data sheet issued at quote/order stage, to determine the materials used.

All materials should be disposed of responsibly and in accordance with local regulations.

Please consult our technical team for further information.

#### 8.0 SPARES

World Heat recommends the following spares for a standard Non-Storage Steam/Water Heat Exchanger;

- Set of Heater Gaskets

Please contact our sales department for recommended spares prices and availability, please quote the vessel serial number in order for our sales team to correctly specify the spares required.