
Contents

Preface	xiii
Acknowledgments	xv
1 Introduction	1
1.1 Importance of Blades in Steam Turbines	1
1.2 Brief Historical Perspective of Technological Development	2
2 Steam Turbine Design Process, Performance Estimation, and Determination of Blade Loads ...	11
2.1 Turbine Design Process	12
2.2 Introduction to Steam Turbine Thermodynamics	13
2.3 Velocity Diagrams	17
2.3.1 Euler's Equation	17
2.3.2 Impulse Turbine	19
2.3.3 Reaction Turbine	22
2.4 Application Requirements and Conditions of Service	25
2.5 Preliminary Turbine Design	27
2.5.1 Number of Stages	27
2.5.2 Airfoil Section Shape	29
2.5.3 Number of Blades	32
2.6 Blade Loading	34
2.6.1 Steady Loads	34
2.6.2 Unsteady Blade Loads	37
3 Turbine Blade Construction, Materials, and Manufacture	47
3.1 Airfoils	49
3.1.1 Impulse and Reaction Blades	50
3.1.2 Impulse	50
3.1.3 Reaction	51
3.1.4 Twisted-Tapered Airfoils	52
3.2 Roots	53
3.2.1 Circumferential or Tangential Dovetail Roots	53
3.2.2 Axial Roots	57
3.2.3 Pinned Roots	59

3.3	Shrouds and Auxiliary Dampers	62
3.3.1	Riveted Shrouds	62
3.3.2	Integral Shrouds	63
3.3.3	Z-Lock Shrouds	64
3.3.4	Auxiliary Shroud Dampers	65
3.4	Blade Materials	67
3.4.1	Stainless Steel	68
3.4.2	Titanium	69
3.4.3	Other Blade Materials	70
3.4.4	Material Forms	71
3.5	Manufacturing Processes	73
3.6	Erosion Protection—Condensing Stages	76
3.7	Bladed Disk Assembly Processes	79
3.7.1	Assembly of Bladed Disks with Circumferential Dovetail Roots	79
3.7.2	Bladed Disk Assembly—Axial Fir Tree Roots	83
3.7.3	Bladed Disk Assembly—Pinned Roots	84
3.7.4	Riveted Shroud Installation	86
3.7.5	Integral Shroud Installation	93
3.8	Inspection, Testing, and Quality Assurance	96
4	System of Stress and Damage Mechanisms	99
4.1	Stress-Strain Behavior of Metals	100
4.1.1	Engineering Stress-Strain Properties	105
4.1.2	True Stress-Strain Properties	106
4.1.3	Measure of Material's Engineering Energy Capacity	108
4.2	Stress Tensor and Strain Tensor	109
4.2.1	Stress at a Point and Stress Concentration	110
4.2.2	Three-Dimensional Expression for Stress at a Point	115
4.2.3	Principal Stresses and Direction Cosines	116
4.3	Deformation and Fracture Damage	120
4.3.1	Theories of Failure under Static Loads	121
4.3.2	Creep	125
4.3.3	Damage due to Cyclic Loading	137

5	Review of Fundamentals of Vibration	157
5.1	Discrete Systems	158
5.1.1	Single-Degree-of-Freedom (SDOF) System	158
5.1.2	Multiple-Degree-of-Freedom (MDOF) System	161
5.1.3	System with Equal Frequencies	164
5.2	Continuous Systems	166
5.2.1	Cantilever Beam	166
5.2.2	Circular Plate	169
6	Damping Concepts	171
6.1	Rheological Model	171
6.2	Factors Affecting Damping	172
6.3	Viscous Damping	173
6.4	Critical Damping	173
6.5	Proportional Damping	173
6.6	Frictional Damping and Z-Lock Shroud	174
6.6.1	Simple Estimation Method—Macromodel	177
6.6.2	Dynamic Consideration	181
6.6.3	Equivalent Viscous Damping	184
6.6.4	Macroslip and Microslip	186
6.6.5	Summary of Simple Analysis	188
7	Vibration Behavior of Bladed Disk System	191
7.1	Single Cantilevered Blade	191
7.2	Packet of Blades	192
7.3	Individual Disks	193
7.4	Analysis of a Bladed Disk System	194
7.4.1	Freestanding (Blades with or without a Shroud But Not Connected to One Another)	194
7.4.2	Packeted Bladed Disk	196
7.4.3	Completely Shrouded Design	200
7.5	Evaluation Concepts for Blade Resonant Vibration	201
7.5.1	Campbell Diagram	201
7.5.2	Interference Diagram (SAFE Diagram)	202
7.5.3	Work Done by an Applied Force	203
7.5.4	Interference Diagram When Harmonics of Excitation Are Larger Than One-Half of the Number of Blades	217

7.6	Effect of Temperature and Speed on Natural Frequencies	221
7.7	Effect on Natural Frequency due to Centrifugal Stiffening	221
7.8	Lacing Wire Construction	222
7.8.1	Determination of Effects of Number of Blades in a Packet	225
7.8.2	Quick Check for Requirement of a Lacing Wire Construction	225
7.8.3	Sizing and Positioning of a Lacing Wire	227
7.8.4	Check of Stress in the Hole in the Blade	229
7.9	Partial Admission Stage	232
7.9.1	Damped Free Vibration	238
7.9.2	Damped Forced Vibration	238
7.10	Effect of Mistuning of a Bladed Disk System on Vibration Response	243
7.11	Impure Mode Shapes (Packeted Bladed Disk)	245
7.11.1	Graphical Method	250
7.11.2	Mathematical Expression	253
7.11.3	Effect on Response	254
8	Reliability Evaluation for Blade Design	257
8.1	Loads, Stress, and Evaluation	257
8.2	Stress due to Centrifugal Load	258
8.3	Stress due to Steam Forces	259
8.4	Resonant Vibration	262
8.5	Blade Frequency Evaluation	263
8.6	Exciting Forces	264
8.6.1	Running Speed Harmonic Excitation	264
8.6.2	Nozzle Passing Frequency (NPF) Excitation	265
8.6.3	Partial Admission Excitation	267
8.7	Factor of Safety Calculation	268
8.8	Influence of Tolerance Stack Up in Root-Disk Attachment	272
8.9	Summary of Design Criteria	277
8.10	Checklist for Auditing a Blade Design	278
9	Life Assessment Aspects for Blade	283
9.1	Assessment of Useful Life of Blade in Presence of High Cycle Fatigue	283

9.2	Factor of Safety Concept for High Cycle Fatigue	289
9.3	Life Estimation	289
9.4	Process of Shot Peen and Laser Peen to Improve Fatigue Life	294
9.5	Basic Explanation for Increase in Fatigue Life	294
9.6	Residual Stress due to Shot Peen	296
9.6.1	Linear Approximation of Compressive Layer Profile	296
9.6.2	Exponential Approximation of Compressive Layer Profile	299
9.7	Combination of Applied and Residual Compressive Stress	302
9.7.1	Linear Approximation of Combined Stress	303
9.7.2	Exponential Approximation of Combined Stress	304
9.8	Mechanistic View of Improvement in Fatigue Life due to Shot Peen	306
9.8.1	Improvement during High Cycle Fatigue	306
9.8.2	Improvement during Low Cycle Fatigue—Zero Mean Stress	308
9.9	Process of Laser Peen	308
10	Estimation of Risk	313
10.1	Probabilistic Concept to Quantify Risk of a Proposed Design	313
10.2	Probabilistic Treatment of Factor of Safety Based on Goodman Equation	320
10.3	Transformation of Random Variables	324
10.3.1	Single Cantilever Beam	325
10.4	Probabilistic Low Cycle Fatigue Concept	330
11	Summary	333
11.1	Deterministic Reliability Estimation	333
11.1.1	Stress and Fatigue Analysis	333
11.1.2	Creep Analysis	334
11.1.3	Modal Analysis	334
11.1.4	Response Analysis	335
11.1.5	Goodman Factor of Safety Based on Above Analysis	335
11.2	Deterministic Life Estimation	335

11.3	Probabilistic Reliability Analysis	338
11.3.1	Probabilistic Goodman Analysis	338
11.3.2	Probabilistic Frequency Analysis ...	340
11.4	Probabilistic Life Estimation	340
	Appendix: Fourier Series	343
	Bibliography	347
	Index	351