

APPENDIX “A”
Standard Sizes, Numbers, Materials and Allowable Length of Tracers
(Low Pressure Steam)

Process Line Size	Maintain Temperature														Tracer Material	Tracer Length					
	5° C		20°C		35°C		50°C		65°C		80°C		95°C			In Process Units		In Interconnecting Pipe racks, Pipe ways, Tank Areas			
	Tracer Size	Number of Tracers	Tracer Size	Number of Tracers	Tracer Size	Number of Tracers	Tracer Size	Number of Tracers	Tracer Size	Number of Tracers	Tracer Size	Number of Tracers	Tracer Size	Number of Tracers		Efficient Max. Length (m)	Total Max. Length from Lead Block Valve To Tail Block Valve (m)	Efficient Max. Length (m)	Total Max. Length from Lead Block Valve To Tail Block Valve (m)		
1/2"	3/8"	1	3/8"	1	3/8"	1	3/8"	1	3/8"	1	3/8"	1	3/8"	1	3/8"	1	ASTM B68 Wall THK. 0.86mm	35	+2x10=55	50	+2x10=70
2"	1/2"	1	1/2"	1	1/2"	1	1/2"	1	1/2"	1	1/2"	1	1/2"	1	1/2"	1	Carbon steel Pipe as per piping class ASA2 of "Engineering Specification for Piping Material"	50	+2x15=80	70	+2x15=100
3"	1/2"	1	1/2"	1	1/2"	1	1/2"	1	1/2"	1	1/2"	1	1/2"	2	1/2"	2		50	+2x15=80	70	+2x15=100
4"	1/2"	1	1/2"	1	1/2"	1	1/2"	1	1/2"	1	1/2"	1	1/2"	2	1/2"	2		50	+2x15=80	70	+2x15=100
6"	1/2"	1	1/2"	1	1/2"	1	1/2"	1	1/2"	1	1/2"	2	1/2"	2	1/2"	2		50	+2x15=80	70	+2x15=100
8"	1/2"	1	1/2"	1	1/2"	1	1/2"	1	1/2"	1	1/2"	2	1/2"	3	1/2"	3		50	+2x15=80	70	+2x15=100
10"	1/2"	1	1/2"	1	1/2"	1	1/2"	1	1/2"	2	1/2"	2	1/2"	3	1/2"	3		50	+2x15=80	70	+2x15=100
12"	1/2"	1	1/2"	1	1/2"	1	1/2"	2	1/2"	2	1/2"	3	1/2"	3	1/2"	3		50	+2x15=80	70	+2x15=100
14"	1/2"	1	1/2"	1	1/2"	1	1/2"	2	1/2"	2	1/2"	3	1/2"	3	1/2"	3		50	+2x15=80	70	+2x15=100
16"	1/2"	1	1/2"	1	1/2"	1	1/2"	2	1/2"	2	1/2"	3	1/2"	3	1/2"	3		50	+2x15=80	70	+2x15=100
18"	1/2"	1	1/2"	1	1/2"	1	1/2"	2	1/2"	2	1/2"	3	1/2"	3	1/2"	3		50	+2x15=80	70	+2x15=100
20"	1/2"	1	1/2"	1	1/2"	2	1/2"	2	1/2"	2	1/2"	3	1/2"	3	1/2"	3		50	+2x15=80	70	+2x15=100
24"	1/2"	1	1/2"	1	1/2"	2	1/2"	2	1/2"	2	1/2"	3	1/2"	3	1/2"	3		50	+2x15=80	70	+2x15=100
28"	1/2"	1	1/2"	1	1/2"	2	1/2"	2	1/2"	2	1/2"	3	1/2"	4	1/2"	4		50	+2x15=80	70	+2x15=100
30"	1/2"	1	1/2"	1	1/2"	2	1/2"	2	1/2"	3	1/2"	3	1/2"	4	1/2"	4		50	+2x15=80	70	+2x15=100
32"	1/2"	1	1/2"	2	1/2"	2	1/2"	2	1/2"	3	1/2"	3	1/2"	4	1/2"	4		50	+2x15=80	70	+2x15=100
34"	1/2"	1	1/2"	2	1/2"	2	1/2"	2	1/2"	3	1/2"	4	1/2"	4	1/2"	4		50	+2x15=80	70	+2x15=100
36"	1/2"	1	1/2"	2	1/2"	2	1/2"	3	1/2"	3	1/2"	4	1/2"	4	1/2"	4		50	+2x15=80	70	+2x15=100
38"	1/2"	1	1/2"	2	1/2"	2	1/2"	3	1/2"	3	1/2"	4	1/2"	4	1/2"	4	50	+2x15=80	70	+2x15=100	

Appendix “A” Notes:

- 1) Basis of Sizing:
 - a) Low pressure steam 6.0 Bar / 175°C.
 - b) Minimum ambient temperature = 5°C.
 - c) Insulation thickness & material as per “Engineering Specification for Thermal Insulation.”
- 2) Steel pipe shall be used for tracing line from manifold to tracers, interconnecting lines between two parts of a tracer, which are not adjacent and from tracer through trap to condensate manifold in accordance to Engineering Specification for Piping Material.
- 4) Maximum depth of pocket shall be 2000mm.