Control Valves

Guy Borden, Jr., Editor
Paul G. Friedmann, Style Editor

Practical Guides for Measurement and Control
# Table of Contents

<table>
<thead>
<tr>
<th>Section</th>
<th>Page</th>
</tr>
</thead>
<tbody>
<tr>
<td>About This Series</td>
<td>iii</td>
</tr>
<tr>
<td>Acknowledgments</td>
<td>v</td>
</tr>
<tr>
<td>Preface</td>
<td>xiii</td>
</tr>
<tr>
<td>About the Volume Editors</td>
<td>xv</td>
</tr>
<tr>
<td>Contributors</td>
<td>xvii</td>
</tr>
<tr>
<td><strong>Chapter 1</strong> Introduction to Control Valves</td>
<td>1</td>
</tr>
<tr>
<td>References</td>
<td>12</td>
</tr>
<tr>
<td><strong>Chapter 2</strong> The History of Control Valves</td>
<td>15</td>
</tr>
<tr>
<td>Acknowledgement</td>
<td>23</td>
</tr>
<tr>
<td>References</td>
<td>23</td>
</tr>
<tr>
<td><strong>Chapter 3</strong> Terminology</td>
<td>25</td>
</tr>
<tr>
<td>Part One: Control Valving Terminology Not Included in ISA Standard</td>
<td>25</td>
</tr>
<tr>
<td>Part Two: ANSI/ISA S75.05 &quot;Control Valve Terminology&quot;</td>
<td>28</td>
</tr>
<tr>
<td>References</td>
<td>72</td>
</tr>
<tr>
<td><strong>Chapter 4</strong> Valve Bodies</td>
<td>73</td>
</tr>
<tr>
<td>Globe-Style Bodies</td>
<td>73</td>
</tr>
<tr>
<td>Rotary Valves</td>
<td>82</td>
</tr>
<tr>
<td>Special-Purpose Valves</td>
<td>91</td>
</tr>
<tr>
<td>References</td>
<td>92</td>
</tr>
<tr>
<td><strong>Chapter 5</strong> Control Valve Actuators</td>
<td>93</td>
</tr>
<tr>
<td>Signals and Power Sources</td>
<td>93</td>
</tr>
<tr>
<td>Basic Styles</td>
<td>94</td>
</tr>
<tr>
<td>Motion Conversion</td>
<td>100</td>
</tr>
<tr>
<td>Linear-to-Rotary Torque/Travel Relationships</td>
<td>100</td>
</tr>
<tr>
<td>Power Failure Modes</td>
<td>101</td>
</tr>
<tr>
<td>Actuator Valve Sizing Factors</td>
<td>101</td>
</tr>
<tr>
<td>Actuator Accessories</td>
<td>101</td>
</tr>
<tr>
<td>References</td>
<td>103</td>
</tr>
</tbody>
</table>
Chapter 6  **Sizing 105**

Required Calculations 105
ANSI/ISA S75.01 Standard "Flow Equations for Sizing Control Valves" 112
References 162

Chapter 7  **Cavitation and Flashing 163**

Cavitation Fundamentals 164
Cavitation in Valves 170
Testing 178
Cavitation Applications for Control Valves 183
Special Fluid Considerations 208
Flashng 211
Nomenclature and Glossary 216
References 220

Chapter 8  **Control Valve Noise 223**

Introduction 223
Valve Noise Sources 227
Valve Noise Prediction 233
User Caveat 235
Valve Noise Categories 236
Possible Solutions 237
Conclusion 266
References 266

Chapter 9  **Control Valve Trim 269**

Selection of Valve Trim Material 269
Characterizing of Valve Plugs or Cage Ports 271
Seat Leakage 273
Soft Seat Trim Design 278
Seating of Rotary Valves 283
Low Flow Trim 285
Trim for Abrasive-Erosive Service 288
Plug Guiding 294
Dynamic Torque of Rotary Valves 301
Bistable Flow and Plug Instability 308
Elastomeric Trim 310
References 310

Chapter 10  **Control Valve Features 313**

Process Conditions that Influence Valve Design 314
Piping End Loadings that Influence Valve End Connection Design 315
Valve End Connection Concerns 316
Valve End Connection Types 317
Bonnets 327
Fluid Solidification Protection 333
Chapter 11  Materials for Control Valves 363

Material Properties 363
Environmental Considerations 365
Materials of Construction 380
Materials for Pressure Retaining Parts 382
Coatings 391
Trim Material Selection 393
Valve Packing 401
Gaskets 403
Sealants 405
Paint and External Coatings 406
Trademarks 408
References 408

Chapter 12  Control Valve Applications 411

The Application Categories 412
Valves in Parallel 423
Valves in Series 432
Frequent Application Problems 434
References 446

Chapter 13  Safety 449

Automated Valve Selection 449
On-Off Valves 449
Materials of Construction 450
Valve Piping 451
Valve and Actuator Sizing and Selection 452
Valve Positioners, Transducers, Position Transmitters, and Accessories 453
Valve Failure Modes 456
Other Safety Considerations 458
References 458
Chapter 18  Case Histories 585

Specification and Selection 585
Materials 590
Installation and Location 591
Testing 595
Operation and Maintenance 595
External Causes 596
Multiple Problems 599
Stupidity 599
References 599

Chapter 19  Maintenance 601

Philosophy 601
Warranty 601
Planning 602
Safety 602
Instructions 603
Maintenance Choices 604
What Goes Wrong with Control Valves? 606
Alternatives to Repair 614
References 616

Chapter 20  Control Valve Testing 619

Part One: Manufacturer's Testing 619
Less Common Tests 626
Conclusions for Manufacturer's Testing 629
Part Two: Field Testing Of Installed Valves 630
Diagnostic Testing 630
Other Control Valve Tests 649
Motor-Operated Valves: Diagnostic Testing 651
Summary of Post-installation Testing 657
References 658

Chapter 21  Codes and Standards 659

Definitions and Descriptions 659
Subjects of Codes and Standards 663
References 669
Chapter 22  Computerized Control Valve Sizing 671

The Development of Valve Sizing Aids 671
Important Features 673
Valve Sizing Worksheets 674
Gas and Vapor Sizing Worksheet 675
Liquid Sizing Worksheet 684
Two-Phase Sizing Worksheet 692
Valve Sizing Procedure 696
References 698

Chapter 23  Everything You Ever Wanted to Know About Regulators 699

Operation 699
Performance 701
Designs 702
Sizing 711
Performance Comparison with Control Valves 711
References 714

Appendix A  Units Conversion 717
Appendix B  Organizations That Sponsor Codes, Standards and Recommended Practices 719
Appendix C  Bibliography of Control Valve Standards 725

ISA  725
EC  727
ASME  729
API  729
ASTM  730
FCI  731
IEEE 731
ISO  731
MSS  732
UL  733
Miscellaneous  734

Index 735