



THE TEN COMMANDMENTS OF BOILER WATER TREATMENT

1. Keep feedwater soft.
2. Maintain proper blowdown (bottom, continuous, and water columns).
3. 1 Boiler Horsepower = 34.5 pounds of steam production/hr. 1 gallon of water = 8.34 pounds of steam.
4. Test representative samples of make-up, soft water, feedwater, boiler, and condensate.
5. Record pressures, temperatures, pump and controller settings, and feed rates.
6. Know percent blowdown, percent return condensate and steam production.
7. Maintain proper treatment levels: appropriate Conductivity / TDS, Hydroxyl Alkalinity (OH) > 200 PPM, Condensate pH 8.3 – 8.9, Sulfite (SO₃) 30 – 60 PPM.
8. Establish testing and treatment procedures, train operators, and keep daily logs.
9. Know the operating characteristics of equipment (softeners, DAH, boilers, etc.) under treatment.
10. Have full knowledge of, communication with, and training of operating, supervisory, and management personnel.



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