



ENGINEERING SPECIFICATIONS FOR INDUSTRIAL HEAT TRACE SYSTEMS

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1.0 Scope

This specification covers the requirements for materials and support services for electric heat-tracing systems supplied by the vendor. Neither the supply of the

materials related to the connection of the power supply nor the installation of the entire system is part of this specification.

2.0 Codes, Approvals and Standards

The Electric Heat Tracing system shall conform to the following specification. It shall be designed, manufactured, and tested in accordance with the applicable re-

quirements of the latest edition of the CSA, FM, IEEE, ATEX/IEC, UL standards and US National and Canadian Electrical Codes.

3.0 Materials

3.1 Self-Regulating Heating Cables

All heat-tracing systems for use at temperatures up to a continuous exposure (maintain) from 150°F (65°C) to 302°F (150°C) and intermittent exposure temperature from 185°F (85°C) to 420°F (215°C) shall use a self-regulating heating cable.

1. Self-regulating heating cable shall vary its power output relative to the temperature of the surface of the pipe or the vessel. The cable shall be designed such that it can be crossed over itself and cut to length in the field.
2. Self-regulating heating cable shall be designed for a useful life of 20 years or more when operated according to manufacturer's standards.
3. All cables shall be capable of passing a 2.2 kV dielectric test for one minute after undergoing a 10 ft-lb. impact (IEC 60079-30-1:2015, clause 5.1.5.1)
4. A warranty period against manufacturing defects for a period of 10 years shall be available.

3.1.1 Freeze Protection Systems (With No Steam Exposure)

1. The heating cable shall consist of two 16 AWG or larger nickel-plated copper bus wires, embedded in a self-regulating polymeric core that controls power output so that the cable can be used directly on plastic or metallic pipes. Cables shall have a temperature identification number (T-rating) without the use of thermostats of the following.

Table 1 – Freeze Protection T-Ratings

Heating Cable	T-Rating	Maximum Temperature
3 W/ft	T6	185°F (85°C)
5 W/ft	T6	185°F (85°C)
8 W/ft	T5	212°F (100°C)
10 W/ft	T4A	248°F (120°C)

2. The heating cable shall have a tinned copper braid with a resistance less than 8 mΩ/ft as determined by metallic covering conductivity test (IEEE 515-2017 test 4.1.13). The braid may be protected from chemical attack and mechanical abuse by an optional polyolefin or fluoropolymer outer jacket.

- In order to provide rapid heat-up, to conserve energy, and to prevent overheating of fluids and plastic pipe, the heating cable shall have the following minimum self-regulating indices:

Table 2 – Minimum Self-Regulating Indices

Heating Cable	S.R. Index (W/°F)	S.R. Index (W/°C)
3 W/ft	-0.020	-0.036
5 W/ft	-0.045	-0.080
8 W/ft	-0.058	-0.104
10 W/ft	-0.071	-0.127

Note : The self-regulating index is the rate of change of power output in watts per degree Fahrenheit or watts per degree Celsius, as measured between the temperatures of 50°F (10°C) and 100°F (38°C) and confirmed by the type test and published data sheets.

- The self-regulating heating cable shall maintain between 75 and 110 percent of its original power output after having been cycled 500 times between 50°F (10°C) and 150°F (65°C), allowing no more than 12 minutes of dwell time at each temperature.
- The heating cable shall be type SRL with continuous exposure (maintain) capability up to 150°F (65°C) and continuous exposure capability up to 185°F (85°C) with power off, as manufactured by Chromalox.

3.1.2 Process Temperature Maintenance (With No Steam Exposure)

- The heating cable shall consist of two 16 AWG nickel plated copper bus wires, embedded in a self-regulating polymeric core that controls power output so that the cable has a temperature identification number (T-rating), without the use of thermostats, of the following:

Table 3 – Process Temperature Maintenance T-Ratings

Heating Cable	T-Rating	Maximum Temperature
3 W/ft	T3	392°F (200°C)
5 W/ft	T3	392°F (200°C)
8 W/ft	T3	392°F (200°C)
10 W/ft	T2D	419°F (215°C)
15 W/ft	T2D	419°F (215°C)
20 W/ft	T2D	419°F (215°C)

- The heating cable shall have a tinned copper braid with a resistance less than 8 mΩ/ft as determined by metallic covering conductivity test (IEEE 515-2017 test 4.1.13). The braid may be protected from chemical attack and mechanical abuse by an optional fluoropolymer outer jacket.

- In order to provide rapid heat-up, and to prevent overheating of fluids, the heating cable shall have the following minimum self-regulating indices:

Heating Cable	S.R. Index (W/°F)	S.R. Index (W/°C)
3 W/ft	-0.010	-0.018
5 W/ft	-0.016	-0.029
8 W/ft	-0.022	-0.039
10 W/ft	-0.028	-0.050
15 W/ft	-0.042	-0.075
20 W/ft	-0.058	-0.104

Note: The self-regulating index is the rate of change of power output in watts per degree Fahrenheit or watts per degree Celsius, as measured between the temperatures of 50°F (10°C) and 200°F (93°C) and confirmed by the type test and published data sheets.

- In order to confirm 3.1B, the self-regulating heating cable shall retain at least 85 percent of its original power output after having been cycled between 70°F (21°C) and 375°F (190°C) for 3 weeks. Eight hours of dwell time at 70°F (21°C) and 16 hours of dwell time at 375°F (190°C) shall be conducted with a minimum test of 500 hours.
- The heating cable shall be type SRM/E with continuous exposure (maintain) capability up to 302°F (150°C) and continuous exposure capability up to 420°F (215°C) power off, as manufactured by Chromalox.

3.1.3. Freeze Protection and Process Temperature Maintenance (with Steam Exposure)

- The heating cable shall consist of two 16 AWG nickel plated copper bus wires, embedded in a self-regulating polymeric core that controls power output so that the cable has a temperature identification number (T-rating), without the use of thermostats, of the following:

Heating Cable	T-Rating	Maximum Temperature
3 W/ft	T3	392°F (200°C)
5 W/ft	T3	392°F (200°C)
8 W/ft	T3	392°F (200°C)
10 W/ft	T2D	419°F (215°C)
15 W/ft	T2D	419°F (215°C)
20 W/ft	T2D	419°F (215°C)

2. The heating cable shall have a tinned copper braid with a resistance less than 8 mΩ/ft as determined by metallic covering conductivity test (IEEE 515-2017 test 4.1.13). The braid may be protected from chemical attack and mechanical abuse by an optional fluoropolymer outer jacket.
3. In order to provide rapid heat-up, and to prevent overheating of fluids, the heating cable shall have the following minimum self-regulating indices:

Heating Cable	S.R. Index (W/°F)	S.R. Index (W/°C)
3 W/ft	-0.010	-0.018
5 W/ft	-0.016	-0.029
8 W/ft	-0.022	-0.039
10 W/ft	-0.028	-0.050
15 W/ft	-0.042	-0.075
20 W/ft	-0.058	-0.104

Note: The self-regulating index is the rate of change of power output in watts per degree Fahrenheit or watts per degree Celsius, as measured between the temperatures of 50°F (10°C) and 200°F (93°C) and confirmed by the type test and published data sheets.

4. The self-regulating heating cable shall retain at least 85 percent of its original power output after having been cycled between 70°F (21°C) and 375°F (190°C) for 3 weeks. Eight hours of dwell time at 70°F (21°C) and 16 hours of dwell time at 375°F (190°C) shall be conducted with a minimum test of 500 hours.
5. The heating cable shall be type SRM/E with continuous exposure (maintain) capability up to 302°F (150°C) and continuous exposure capability up to 420°F (215°C) with power off, as manufactured by Chromalox.

3.1.4. Systems for Division 1 Hazardous (Classified) Locations

The following requirements shall apply in addition to the criteria specified in paragraph 3.1.1, 3.1.2, or 3.1.3.

1. The self-regulating heating cable shall be FM or CSA approved for use in Division 1 locations.
2. A ground fault protection device set at 30 mA, with a nominal 100 ms response time, shall be used to protect each circuit.
3. The temperature identification number (T-rating) of the cable used shall comply with FM and CSA requirements as applicable.
4. Connection methods used with the cable shall be compatible and approved as a part of the system manufactured and supplied by the heating cable vendor for use in Division 1 locations.
5. For plastic pipe and vessel applications, the heating cable shall be HSRL-CT or SRL-CT (Canada),

for maintain temperatures up to 150°F (65°C) and continuous exposure capability up to 185°F (85°C) with power off, as manufactured by Chromalox

6. The heating cable shall be HSRM-CT, SRM/E-CT (Canada), for maintain temperatures up to 302°F (150°C) and continuous exposure capability up to 420°F (215°C) with power off, as manufactured by Chromalox.

3.2. Termination for Nonhazardous and Hazardous Class I, Division 2 Locations

1. All connection components used to terminate self-regulating heating cables, including power connectors, splices, tees, and connectors, shall be approved for the respective area classification and approved as a system with the particular type of heating cable in use. Under no circumstances shall terminations be used which are manufactured by a vendor other than the cable manufacture.
2. In order to keep connections dry and corrosion resistant, connection kits shall be constructed of nonmetallic, electrostatic, charge-resistant, glass-filled, engineered polymer enclosure rated TYPE 4X.
3. Components shall be rated to a minimum installation temperature of -40°F (-40°C) and a maximum pipe temperature of 500°F (260°C)
4. The connection kit shall be Chromalox manufactured UPC or RTPC for power connections. RTPC-SL* complete with integral LED power indicating light. The UMC connection kit shall serve as complete power, splice, or tee connection for up to three SRL or SRM/E industrial parallel heating cables. The UES or RTES shall serve as an end termination and a UESL or RTST-SL* shall be used when an integral power indicating light is needed.

3.3. Mineral Insulated Cable Systems

All heat-tracing applications with continuous exposure (maintain) temperatures above 302°F (150°C) or intermittent exposure temperatures above 420°F (215°C) shall use factory-terminated, mineral insulated (MI) cables.

1. MI cable shall be magnesium oxide insulated with an INCOLOY 825 sheath. The heated section of the cable shall be joined to a cold lead also made of INCOLOY 825.
2. Each cable shall be factory-terminated to the required length, consisting of the lengths required for the pipe or equipment, plus an allowance for areas of additional heat loss such as valves, flanges, fittings, supports, etc. plus a reasonable excess to allow for field variations. The cold lead section shall be seven feet long unless otherwise specified.

3. Maximum heating cable sheath temperature, per approved engineering design software, shall be submitted with the bid or design for all Division 1 (Zone 1) and Division 2 (Zone 2) applications
4. Each cable shall be shipped with the catalog number marked on the outside of the package, and a cable tag containing the heating cable length, wattage, and voltage.
5. A warranty against manufacturing defects for a period of 10 years shall be available.
6. The heating cable shall be Chromalox (Alloy 825), mineral insulated heating cable with a maximum application temperature for the heating units of 1022°F (550°C) and a maximum exposure temperature for the heating cable of 1200°F (650°C).

3.4. Longline Systems

Constant-Wattage Series Resistance, Freeze Protection and Process Temperature Maintenance with Steam Exposure for circuit lengths 500–7500 feet. For process temperature maintenance and freeze protection with steam exposure, a constant wattage series resistance heater is often the best choice, particularly when more than one run of self-regulating heater is needed.

1. The heating cable shall be a series resistance constant wattage heater. It shall consist of two copper conductors or copper alloy conductors insulated with high temperature heavy-walled fluoropolymer.
2. The heating cable shall have a tinned or nickel-plated copper braid to provide a ground path. The braid shall be protected from chemical attack and mechanical abuse by a fluoropolymer outer jacket.

4.0 Control Monitoring and Power Distribution

4.1 Freeze Protection with Power Distribution and Continuity Monitoring

1. For freeze protection systems, power distribution panels shall consist of an enclosure, including a mini breakers with ground-fault protection devices (30 mA trip level).
2. The panels shall provide ground-fault alarm capabilities.
3. If more than one circuit is required, a main contactor shall be used.
4. The panels shall be capable of operating with ambient-sensing or proportional ambient-sensing controllers.
5. The panels shall be capable of alarming of individual heat-tracing circuits.
6. The panels shall be approved for use in nonhazardous or hazardous locations as required by the installation environment.
7. The panels shall be capable of providing audible and visible alarms.
8. The panel shall be the Chromalox FPAS heat-tracing power distribution panel.
9. If panels need to be capable of alarming of individual heat-tracing circuits then the panel shall be the Chromalox FPASM.

4.2 Freeze Protection and Process Maintenance with Full Monitoring

For single and multiloop applications, a UL listed microprocessor based temperature control, monitoring and power distribution system shall be used. The sensors shall be of the type resistance temperature detector RTD (0 – 500°C/32 – 900°F) and shall be wired to the panel. The system shall be compatible with self-regulating and MI cables and shall have the following features.

1. NEMA 4/4X/12 enclosure.
2. Supply voltage: (select: 120, 208, 220, 240, 277 or 480 Vac single phase).
3. The system must have a color touch screen operator interface.
4. Field power connection terminal block and RTD input connection terminal block for (select: 6, 12, 18, 24 or 36 circuits – optional expansion panel in 6, 12, 18 24, or 36 circuits must be made available).
5. Select (32-104°F) (0-40°C) operating environment without Cabinet Heater) (-40 to 104°F with Optional Cabinet heater).
6. Solid State Output Relays for each circuit rated 40 Amps .
7. Select (Optional RS-485 MODBUS® communications for interfacing with personal computers and PLC's).

8. The system must be capable of checking cable continuity without use of a monitor wire.
9. Ground fault alarm must be adjustable between (25 – 500 mA).
10. The system must have selectable capability for ground fault alarm only or ground fault and trip.
11. The system must have Non-Latching, High/low programmable temperature alarms.
12. The system must have Open Sensor Alarm with Programmable Open Sensor Output Setting (0 – 100%).
13. The System must have capability to graphically display circuit currents.
14. The system must have load managing start-up capability.
15. The system must have user selectable soft start capability.
16. The system must have programmable self-test capability from 0 to 720 hours with full system alarm capability including ground fault, high/low temp and continuity
17. The system must have user selectable control modes including automatic, manual, On/Off Control with adjustable Deadband (1 – 10) or PID control.
18. The system must be field programmable for °F or °C.
19. The system must have capability for global programming of all setpoints and alarms.
20. The system must have capability for graphic displays of Loop Status, Alarm conditions, Process Temperature, Setpoints, and Currents.
21. The system must have one set of dry alarm contacts.
22. The system must have selectable Hand/Off/Auto control modes.
23. The system must have a control Loop Enable/Disable Feature.
24. The system must have sensor mapping capability such that any sensor can be mapped to control any circuit or combination of circuits via user selection
25. All features including temperature control, contactors, and power distribution must be contained in one enclosure.
26. The system must be modular in-design, such that individual components can be replaced in the field if necessary.
27. The system must be UL & cUL approved.
28. Control, Monitoring and Power Distribution Systems shall be IntelliTrace ITLS / ITAS as supplied by Chromalox.

4.3 Controllers

4.3.1 Single/Dual Point Control and Monitoring

For single or dual loop applications, a UL listed micro-processor based temperature control, monitoring and power distribution system shall be used. The controller shall accept (2) 100 ohm platinum RTD sensor inputs per circuit. The system shall be compatible with self-regulating and MI cables and shall have the following features.

1. NEMA 4X fiberglass enclosure
2. Supply voltage: (select: 120, 240 or 277 Vac single phase).
3. Field power connection terminal block must accept (2) RTD sensor inputs per circuit.
4. Control must operate in 32-104°F (0-40°C) environments.
5. Solid state relay rated 40A at 104°F (40°C) output.
6. Optional RS-485 MODBUS® communications capable with interfacing with personal computers and PLC's.
7. Low current alarm: 0-30A in 1A increments.
8. Optional 5-100mA ground fault alarm trip.
9. Process, deviation, band, high/low and latching/non-latching (manual/automatic reset) programmable temperature alarms.
10. On/Off and PID control modes.
11. Selectable Soft start control mode to reduce nuisance tripping due to self-regulating cable in-rush current.
12. High Resolution TFT display for ease of programming and monitoring (single/dual line LCD display is not acceptable)
13. Separate LED indication for power, load & alarm for each circuit shall be provided on front panel
14. Controller shall be Chromalox ITC-XX1 for single loop application or ITC-XX2 for dual loop applications.

4.3.2 Single Point Control

For single or dual loop applications, a UL listed micro-processor based temperature control, monitoring and power distribution system shall be used. The controller shall accept (2) 100 ohm platinum RTD sensor inputs per circuit. The system shall be compatible with self-regulating and MI cables and shall have the following features.

1. NEMA 4X Polyphenylene Sulphide Plastic Material* enclosure
2. Supply voltage: 120-277 Vac single phase.
3. Field power connection terminal block to accept (1) RTD sensor input per circuit.
4. Control must operate in -40-104°F (-40-40°C) environments.
5. Solid state relay rated 30A at 104°F (40°C) output.
6. Solid state alarm output with high temp, low temp, RTD failure alarms.
7. Selectable Soft start control mode to reduce nuisance tripping due to self-regulating cable in-rush current.
8. LED display
9. Separate LED indication for power, load & alarm for each circuit shall be provided on front panel
10. Controller shall be Chromalox DTS-HAZ for single loop applications.

4.4 Thermostats and Contactors

1. Freeze protection systems shall operate using self-regulating control, the RTAS thermostat in ordinary areas, the RTAS-EP in Division 2 hazardous areas, or the B121 thermostat in Division 1 hazardous areas.
2. Process temperature maintenance system shall operate using the RTBC thermostat in ordinary areas, the RTBC-EP in Division 2 hazardous areas or the E121 thermostat in Division 1 hazardous areas.
3. Chromalox contactor type CONT shall be used where the heat tracing circuit current exceeds the thermostat switch rating. Contactor enclosure type NEMA 1, 4, or 7 shall be used according to enclosure location.

5.0 Engineering

The vendor shall be given a line list from which to design and estimate a complete heat-tracing system. The bid package shall also include area layout and orthographic drawings.

The vendor shall provide a detailed design utilizing standard heat-tracing design software, such as Chromatrace. At minimum, the design must provide the following:

1. Circuit identification number.
2. Maintain temperature.

3. Line size and insulation.
4. Heat loss for pipe, valves, and supports.
5. Amount and type of heating cable required.
6. Spiral requirements.
7. Heating cable service voltage.
8. Heating cable power output at the maintain temperature.
9. Uncontrolled pipe temperature at maximum ambient.

6.0 Installation

1. The system shall be installed per manufacturers engineering details, isometric drawings, line lists and other pertinent data.
 2. The installing contractor shall have a minimum of 5 years experience installing industrial electric heat trace systems as demonstrated by a manufacturer approved experience list
 3. Installation techniques shall be governed by the manufactures installation instructions, and the NEC202-2013 Installing and Maintaining Industrial Heat Trace Systems document. In event of conflict the order or precedence is manufacturers design details, manufactures installation instructions and then the NEC202-2013 document.
 4. The Installation contractor shall maintain licensed, trained and qualified personnel on site through out the installation process.
 5. Installation schedule shall be defined and agreed to by all parties prior to contractor mobilization
 6. Installer shall provide weekly updates on job completion status including both physical install details and financial reporting.
 7. Installer shall conform to all site safety requirements and provide site safety documentation as required.
 8. Installer shall keep records of all heating cable installed on site per job requirements – at a minimum circuit number corresponding with heat trace isometric drawing with model number, batch number, reel number and actual footage installed shall be documented on provided heat trace isometrics. Actual location of power connection, end seals and splice/tee boxes shall be indicated on isometric drawings as well. This documentation is required prior to final payment for install services.
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7.0 System Commissioning

System commissioning shall be performed by manufacturer or approved manufacturer's representative.

System commissioning testing and documentation shall conform to manufacturers standard procedures and at a minimum confirm –

1. Correct cable model number installed on each circuit per circuit isometric drawings
2. Circuit electrical data conforms to heat trace isometric data including Circuit current
Circuit insulation resistance
Circuit voltage
3. Location and coordinates of power connection kits, end seals, splice/tee kits for each circuit

Documentation of commissioning activities and test results shall be provided per contract requirements, manufacturer's instructions, and NEC202-2013 document.

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