Identification and evaluation of reliability factors of main oil pumps

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Abstract. Preventative maintenance systems today are not always able to achieve projected levels of the main pumps use because of the presence of random technical, technological and statistical errors. It is necessary to identify the mean time between failures, reducing factors in situations where exploitative parameters are within the normal limits. It is offered to use statistical indexes and standard parameters for the analysis. Factor analysis defines a moderate negative correlation between the vibration velocity of the fixed pumps' parts and the mean time between failures. Also, a weak positive correlation between vibration velocity and other parameters has been determined. The results can be used to improve preventive maintenance systems, as well as to choose the most reliable structural performance.

1. Introduction
At present, preventative maintenance systems are used in exploitation of the main pumps, with which it is possible to make a timely diagnosis of the equipment, and thus predict and minimize equipment failures. However, when evaluating the reliability parameters, it is often difficult to consider all the factors that influence the occurring failures. Despite the fact that the equipment operating time is determined by standards, failures still occur due to the technological, exploitation and other errors admission [1, 2]. Such errors, seeming minor, lead to the changes of parameters that have a direct impact on the reliability of the all technical systems and as a result reduce its resource [3].

The exploitative parameters of the pumps in the standard range are not always the norm in terms of equipment work resources. In other words, the time between failures can greatly decrease even in cases where the operational parameters do not exceed the standards’ specified limits [4, 5]. In these cases, it becomes difficult to predict equipment failures by the operating time and the current state due to reduced possibility of detecting early failures because exploitative parameters do not exceed the norm in accordance with the technological regulations and standards for a given type of equipment [6, 7]. It is therefore necessary to identify the factors of reliability which directly affect the actual operating time of the main oil pumps [8]. It will help to estimate the technical risks in situations where exploitative parameters are not out of the specified limits.

2. Main pumps and its parameters
Main pumps are basic equipment that is used for the transport of separator oil by pipelines after its extraction from wells, preparation and water release. Ensuring the smooth operation of pumps requires...
a high level of reliability that is not only set in the production, but also depends on the operating conditions [9, 10]. Standard GOST 12124-87 - "Centrifugal pumps for oil trunk pipelines" covers centrifugal pumps for supply of oil and oil products (including natural gas liquids) in pipeline systems. The standard requires 23 types, for which the following parameters are set up: pressure, flow (main indicator of productivity), limiting pressure, net positive suction head (NPSH), efficiency, frequency of rotation and mass. Thus, the choice of the equipment brand from presented types is possible and it is based not only on frequency of rotation, mass and productivity parameters, but also on their combinations that are most convenient for the particular technological objects.

Standard GOST 32601-2013 "Centrifugal pumps for petroleum, petrochemical and natural gas industries. General specifications" implies an additional requirement according to which vibration velocity of fixed pump elements should be between 2.8 to 7.6 mm/sec and the operating time of the pumps should be at least 40,000 hours. However, taking into consideration factors of errors origin in production, installation, commissioning and exploitation, the operating time indicator is practically 1.5-2 times less. That leads to increased costs for capital unscheduled repairs of equipment. To achieve setup in the standard rates of operating time, it is necessary to identify those factors that have a direct impact on the reliability. So, having a technique to detect and prevent possible failures, for example such as a preventative maintenance system, it will help to minimize technical risks.

3. Indexes of main pumps reliability

Reliability indexes quantitatively characterize the extent of certain object properties that determine reliability of any technical system [11]. The basis for all further identified reliability parameters will be system infallibility because in our research we consider indexes during operation. Infallibility of the technical system, according to the theory of reliability, is an object ability to continuously maintain usable state for some time or operating time [12, 13].

The main indicator of reliability is a time between failures, which is calculated and set up in manufacturing in accordance with the standards. Nevertheless, the real operating time values can significantly differ in mean occurrence of random errors, which is not possible to identify at certain stages of technical system cycle’s life [14].

4. Factor analysis of reliability indexes

To evaluate the factors that lead to a decrease in reliability indexes, we have collected data on the operating time before the first main pumps failure of all types and calculated mean time between failures (MTBF) for each of them. The choice of different pumps’ types is caused by the fact that certain exploitative parameters can be repeated for different types in the presence of differences in other parameters. Also, in accordance with the standards we have collected data on the mean values of vibration pumps velocity during their operating time and, thereafter, obtained the mean values for the different types of the main pumps. Thus, with the data on the operating time, vibration velocity and exploitative parameters that are set up in the standards, for which the manufacturing process regulations are found, we have obtained data sampling to assess all the factors of the operating time as the main indicator of exploitative reliability.

Evaluating all the parameters that might be suitable for reliability analysis, it is necessary to note that we have excluded those parameters, whose values are calculated from other known parameters. That fact can be explained by their impact on the operating time, which will be based on the parameters of their components. As a result, for implementation of the factorial analysis we have used the data presented in table 1.

Correlation analysis is used as a method of factor analysis in order to find out how the factors affect the operating time. Analysis was performed in a software package Statistica. Such program package provides powerful and easy-to-use tools for statistical and graphical analysis, predicting, data mining, creating one’s own custom applications, integration, collaboration and web-based access [15].

Thus, the correlation matrix of parameters is presented in table 2 as a result of such analysis.
Table 1. Parameters data for different main pump.

| Types     | MTBF, h | Productivity, cbm/h | Pressure, m | Frequency, rpm | NPSH, m | Middle vibration velocity, mm/sec. |
|-----------|---------|----------------------|-------------|----------------|---------|-----------------------------------|
| NM 125-550| 18256   | 125                  | 550         | 3000           | 4       | 5.62                              |
| NM 180-500| 26251   | 180                  | 500         | 3000           | 4       | 2.98                              |
| NM 250-475| 33594   | 250                  | 475         | 3000           | 4       | 2.83                              |
| NM 360-460| 11445   | 360                  | 460         | 3000           | 4.5     | 7.24                              |
| NM 500-300| 27892   | 500                  | 300         | 3000           | 4.5     | 4.33                              |
| NM 710-280| 15957   | 710                  | 280         | 3000           | 6       | 6.01                              |
| NM 1250-260| 32584  | 1250                 | 260         | 3000           | 18      | 3.56                              |
| NM 2500-230| 16845  | 2500                 | 230         | 3000           | 32      | 3.86                              |
| NM 3600-230| 25114  | 3600                 | 230         | 3000           | 35      | 4.12                              |
| NM 7000-210| 21891  | 7000                 | 210         | 3000           | 52      | 3.84                              |
| NM 10000-210| 14125 | 10000                | 210         | 3000           | 65      | 6.41                              |
| NPV 150-60 | 16032  | 150                  | 60          | 3000           | 3       | 7.15                              |
| NPV 300-60 | 13252  | 300                  | 60          | 3000           | 4       | 6.36                              |
| NPV 600-60 | 17052  | 600                  | 60          | 1500           | 4       | 4.11                              |
| NPV 1250-60| 11151  | 1250                 | 60          | 1500           | 2.2     | 3.52                              |
| NPV 2500-80| 19913  | 2500                 | 80          | 1500           | 3.2     | 4.16                              |
| NPV 3600-90| 20021  | 3600                 | 90          | 1500           | 4.8     | 3.87                              |
| NPV 5000-120| 12576 | 5000                 | 120         | 1500           | 5       | 4.51                              |
| NOU 50-350 | 18127  | 50                   | 350         | 3000           | 3       | 5.12                              |
| NM 200-800 | 15602  | 200                  | 800         | 3000           | 4       | 4.32                              |
| NM 500-800 | 13685  | 500                  | 800         | 3000           | 4.5     | 6.54                              |
| NM 1250-400| 24251  | 1250                 | 400         | 6000           | 60      | 6.24                              |
| NM 2500-710| 18514  | 2500                 | 710         | 8200           | 160     | 7.51                              |

Table 2. Correlation table.

| Variable                      | MTBF, h | Productivity, cbm/h | Pressure, m | Frequency, rpm | NPSH, m | Middle vibration velocity, mm/sec. |
|-------------------------------|---------|----------------------|-------------|----------------|---------|-----------------------------------|
| MTBF, h                       | 18256   | 125                  | 550         | 3000           | 4       | 5.62                              |
| Productivity, cbm/h           | 17052   | 600                  | 60          | 1500           | 4       | 4.11                              |
| Pressure, m                   | 15602   | 200                  | 800         | 3000           | 4       | 4.32                              |
| Frequency, rpm                | 13685   | 500                  | 800         | 3000           | 4.5     | 6.54                              |
| NPSH, m                       | 24251   | 1250                 | 400         | 6000           | 60      | 6.24                              |
| Middle vibration velocity, mm/sec. | 18514  | 2500                 | 710         | 8200           | 160     | 7.51                              |

For visual presentation, a graph was drawn between the time of work and the most significant factor – vibration velocity (figure 1).
According to the correlation matrix and the graph, it is obvious that the MTBF is the moderate negative expressed dependence of the mean vibration. The correlation matrix shows that the middle vibration velocity has a weak positive correlation with such factors as the NPSH and rotation frequency.

5. Results discussion
As a result of the factor analysis, we have revealed the dependence between the middle vibration velocity, during the operating time, of the fixed parts of the main pumps and MTBF of each pump type. The resulting dependence can be interpreted as a moderate expressed. This gives us a reason to consider that the resource of the main pumps can significantly change even within a normal range of the vibration velocity values that are set up by standards. Despite the fact that the same extent expressed dependences between operating time and other factors have not been identified, it is possible to estimate that the parameters such as NPSH and rotation frequency of working pumps part are weak correlated with the mean value of the vibration velocity. This fact allows one to conclude about the forming factors of vibration velocity that are the presentation of reliability parameters. From this we can report that the embodiments of the main pumps with similar parameters may be factors of reliability.

There are qualitative parameters of main pumps which are the embodiment’s variants. Thus, changes in rotation frequency will lead to lack of productivity changes. One method to implement such parameter combination is the facing of pump impellers [10]. According to this method you can change the vibration velocity of the pumps without affecting their productivity that will ensure higher levels of reliability.

6. Conclusion
The article reports about the factors affecting reliability of the main pumps. We have found the dependence between the vibration velocity of fixed parts of the pumps and MTBF. In this way, we have identified the vibration velocity dependences from the operating parameters that can be selected on the assumption of the necessary reliability indexes and embodiments.

Analysis of factors has shown the parameters that do not exceed the normal limits, can significantly reduce the reliability of the technical system. The results of this study make it possible to select the most appropriate embodiment solutions that will have the lowest negative impact on the reliability indexes.
In addition, the results may be used in order to predict the pumps conditions in the analysis of technical risks [16]. Based on the assessment of relationships between factors, it is possible to improve the system of preventative maintenance and avoid a number of failures.

7. Acknowledgments
The study has been undertaken as part of the research into the subject MK-1574.2017.8 “Designing the expert system of the analysis and control of reliability, risks and emergencies in support of the operation of petroleum refinery equipment” funded by the Grant Advisory Board for the President of the Russian Federation in a bid to provide governmental support for young Russian scientists.

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