

Lecture Notes in Networks and Systems 188

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# Integrated Computer Technologies in Mechanical Engineering - 2020

Synergetic Engineering

 Springer

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ISSN 2367-3370                      ISSN 2367-3389 (electronic)  
Lecture Notes in Networks and Systems  
ISBN 978-3-030-66716-0              ISBN 978-3-030-66717-7 (eBook)  
<https://doi.org/10.1007/978-3-030-66717-7>

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# Contents

## Artificial Intelligence and Smart Systems

<b>Synthesis Method of Robust Neural Network Models of Systems and Processes</b> .....	3
Nina Bakumenko, Viktoriia Strilets, Ievgen Meniailov, Serhii Chernysh, Mykhaylo Ugryumov, and Tamara Goncharova	
<b>A Fast Method for Visual Quality Prediction and Providing in Image Lossy Compression by SPIHT</b> .....	17
Fangfang Li, Sergey Krivenko, and Vladimir Lukin	
<b>A Fast and Efficient Method for Time Delay Estimation for the Wideband Signals in Non-gaussian Environment</b> .....	30
Viacheslav Oliinyk, Vladimir Lukin, and Igor Djurovic	
<b>On the Applications of the Special Class of Atomic Functions: Practical Aspects and Perspectives</b> .....	42
Viktor Makarichev, Vladimir Lukin, and Iryna Brysina	
<b>Cloud IoT Platform for Creating Intelligent Industrial Automation Systems</b> .....	55
Oleksandr Prokhorov, Yuri Pronchakov, and Valeriy Prokhorov	
<b>Improving Vehicle Safety Through the Use of Arduino Controller-Based Automotive Voice Informants</b> .....	68
Nataliia Kobrina, Andrey Makoveckiy, and Dmitriy Makarenko	
<b>Oil Products Moisture Measurement Using Adaptive Capacitive Instrument Measuring Transducers</b> .....	81
Oleksandr Zabolotnyi, Vitalii Zabolotnyi, and Nikolay Koshevoy	
<b>Sorption-Capacitive Gas Humidity Sensor of Increased Sensitivity</b> . . . .	92
Oleksandr Zabolotnyi and Maksym Sukhobrus	



<b>Photoelectric Measurement and Control Methods of Angular Displacement of the Aircraft Control Surfaces</b> .....	102
Nikolay Koshevoy, Oleg Burliev, Oleksandr Zabolotnyi, Olena Kostenko, Irina Koshevaya, and Oleksii Potylchak	
<b>Method for Designing Low-Orbit Clusters of Small Satellites Under Stochastic Disturbances</b> .....	112
Olena Tachinina, Oleksandr Lysenko, Iryna Alekseeva, and Valeriy Novikov	
<b>Big Data and Data Science</b>	
<b>Technology of Integrated Application of Classical Decision Making Criteria for Risk-Uncertainty Assessment of Group Systems of Preferences of Air Traffic Controllers on Error's Dangers</b> .....	125
Oleksii Reva, Andrii Nevyntsyn, Sergii Borsuk, and Valerii Shulgin	
<b>Smartphone for Smart Physics Learning</b> .....	135
Oksana Luchsheva, Ihor Turkin, Ihor Klymenko, and Vitaliy Narozhnyy	
<b>Classification of Diabetes Disease Using Logistic Regression Method</b> ...	147
Andrew Hrimov, Ievgen Menailov, Dmytro Chumachenko, Kseniia Bazilevych, and Tetyana Chumachenko	
<b>Conceptual Model of Information Security</b> .....	158
Vladimir Pevnev, Mikhail Tsuranov, Heorhii Zemlianko, and Olena Amelina	
<b>Serverless and Containerization Models and Methods in Challenger Banks Software</b> .....	169
Yuliia Kuznetsova, Artem Kolomytsev, Maksym Somochkin, and Oleksandr Vdovitchenko	
<b>A Graphical Environment for Algorithms Training</b> .....	186
Sergiy Markovych, Andrey Chukhray, Vladislav Lukashov, Olena Havrylenko, and Olena Novytska	
<b>Cyberterrorism Attacks on Critical Infrastructure and Aviation: Criminal and Legal Policy of Countering</b> .....	206
Mykola Nechyporuk, Volodymyr Pavlikov, Nataliia Filipenko, Hanna Spitsyna, and Ihor Shynkarenko	
<b>Information Technology in Creation of Rocket Space Systems</b>	
<b>Effect of Parameters of Adhesive Application by Intaglio Printing on Honeycomb Core Bonding Strength</b> .....	221
Andrii Kondratiev, Sergiy Melnikov, Tetyana Nabokina, and Anton Tsaritsynskyi	

<b>Analysis of Laminated Composites Subjected to Impact</b> .....	234
Sergey Ugrimov, Natalia Smetankina, Oleg Kravchenko, and Vladimir Yareshchenko	
<b>A Method of Rapid Measurement of Vessels Volume with Complex Shape by Critical Nozzles</b> .....	247
Sergiy Plankovskyy, Olga Shypul, Sergiy Zaklinskyy, Yevgen Tsegelnyk, and Volodymyr Kombarov	
<b>Optimal Design of the Cyclically Symmetrical Structure Under Static Load</b> .....	256
Serhii Misura, Natalia Smetankina, and Ievgeniia Misiura	
<b>Dynamic Response of Laminate Composite Shells with Complex Shape Under Low-Velocity Impact</b> .....	267
Natalia Smetankina, Alyona Merkulova, Dmytro Merkulov, and Oleksii Postnyi	
<b>Improving the Noise Immunity of the Measuring and Computing Coherent-Optical Vibrodiagnostic Complex</b> .....	277
Mykhaylo Tkach, Yuri Zolotoy, Yuri Halynkin, Arkadii Proskurin, Irina Zhuk, Volodymyr Kluchnyk, and Igor Bobylev	
<b>Determination of the Acoustic Strength of Solar Battery Panel for Space Applications</b> .....	290
Maksym Nesterenko and Andrii Kondratiev	
<b>Investigation of Condensing Heating Surfaces with Reduced Corrosion of Boilers with Water-Fuel Emulsion Combustion</b> .....	300
Victoria Kornienko, Roman Radchenko, Lukash Bohdal, Leon Kukielka, and Stanisław Legutko	
<b>One-Dimensional Axisymmetric Model of the Stress State of the Adhesive Joint</b> .....	310
Kostiantyn Barakhov, Daria Dvoretzka, and Oleksandr Poliakov	
<b>Improving of Energy Efficiency of Cruise Ships by Applying of Thermochemical Recuperation</b> .....	320
Oleksandr Cherednichenko, Mykhaylo Tkach, and Vira Mitienkova	
<b>Review of Methods for Obtaining Hardening Coatings</b> .....	332
Sergiy Plankovskyy, Viktoriia Breus, Vitalii Voronko, Oleksandr Karatanov, and Olha Chubukina	
<b>Stressed State of an Infinite Plate with a Circular Opening and a Concentric Cover Plate</b> .....	344
Sergey Kurennov and Natalia Smetankina	
<b>Kelvin-Voigt Model of Dynamic Stress in the Conveyors' Belt</b> .....	355
Oleh Pihnastyi and Georgii Kozhevnikov	

<b>Effective Conveyor Belt Control Based on the Time-Of-Use Tariffs . . . .</b>	<b>366</b>
Oleh Pihnastyi and Georgii Kozhevnikov	
<b>Methods for Producing Nanostructures and Performance of Zirconium Alloys . . . . .</b>	<b>377</b>
Gennadiy Kostyuk, Iryna Kantemyr, and Hanna Snitsar	
<b>Stress State of Two Glued Coaxial Tubes Under Nonuniform Axial Load . . . . .</b>	<b>389</b>
Sergey Kurennov, Kostiantyn Barakhov, Daria Dvoretzka, and Oleksandr Poliakov	
<b>Information Technology in Design and Manufacturing of Engines</b>	
<b>The Validation of the Bird-Impactor Model for Mathematical Modelling of Damage Processes in Turbofan Engine Parts . . . . .</b>	<b>403</b>
Dmitry Ivchenko and Natalia Smetankina	
<b>Estimation of Strength of the Combustion Chamber of the ICE Piston with a TBC Layer . . . . .</b>	<b>415</b>
Andriy Marchenko, Vyacheslav Pylyov, and Oleh Linkov	
<b>Numerical and Experimental Research of Radial-Axial Pump-Turbine Models with Splitters in Turbine Mode . . . . .</b>	<b>427</b>
Andrii Rusanov, Oleg Khorev, Yevgen Agibalov, Yurii Bykov, and Pavlo Korotaiev	
<b>Increasing Accuracy of the Gas Temperatures Pattern Calculation for GTE Combustor Using CFD . . . . .</b>	<b>440</b>
Serhii Yevsieiev, Dmytro Kozel, and Igor Kravchenko	
<b>Identification of Computational Models of the Dynamics of Gas Turbine Unit Rotors with Magnetic Bearings by Incomplete Data for Design Automation . . . . .</b>	<b>451</b>
Gennadii Martynenko and Volodymyr Martynenko	
<b>Numerical Estimation of the Residual Life-Time of the Elements of the Centrifugal Pump of the Energy Station Due to Corrosion Wear . . . . .</b>	<b>464</b>
Oleksiy Larin, Kseniia Potopalska, Evgen Grinchenko, and Andrii Kelin	
<b>The Design of Elements of Systems with Gas-Turbine Engines Based on Information Technology . . . . .</b>	<b>475</b>
Lyudmyla Rozova and Gennadii Martynenko	
<b>Analysis of Ship Main Engine Intake Air Cooling by Ejector Turbocompressor Chillers on Equatorial Voyages . . . . .</b>	<b>487</b>
Andrii Radchenko, Andrii Andreev, Dmytro Konovalov, Zhang Qiang, and Luo Zewei	



<b>Efficient Ship Engine Cyclic Air Cooling by Turboexpander Chiller for Tropical Climatic Conditions</b> . . . . .	498
Mykola Radchenko, Dariusz Mikielewicz, Andrii Andreev, Serhiy Vanyeyev, and Oleg Savenkov	
<b>Modelling of Condenser Circuit of the Geothermal Heat Pump</b> . . . . .	508
Svitlana Matus, Bohdan Sydorchuk, and Oleksandr Naumchuk	
<b>Numerical Simulation of an Aerothermopressor with Incomplete Evaporation for Intercooling of the Gas Turbine Engine</b> . . . . .	519
Halina Kobalava, Dmytro Konovalov, Roman Radchenko, Serhiy Forduy, and Vitaliy Maksymov	
<b>Improving the Ecological and Energy Efficiency of Internal Combustion Engines by Ejector Chiller Using Recirculation Gas Heat</b> . . . . .	531
Roman Radchenko, Maxim Pyrysunko, Victoria Kornienko, Ionut-Cristian Scurtu, and Radosław Patyk	
<b>Integrated Computer Technologies in Aerospace Engineering</b>	
<b>Analysis of Operation of Ambient Air Conditioning Systems with Refrigeration Machines of Different Types</b> . . . . .	545
Eugeniy Trushliakov, Mykola Radchenko, Bohdan Portnoi, Veniamin Tkachenko, and Artem Hrych	
<b>Computer Simulation of Abnormal Glow Discharge in an Inverse Magnetron Sputtering System with Axial Plasma Flows</b> . . . . .	556
Denis Sliusar, Oleksii Isakov, Volodymyr Kolesnyk, Oleg Chugai, Leonid Litovchenko, and Mikola Stepanushkin	
<b>A Data-Driven Approach to the Prediction of Spheroidal Graphite Cast Iron Yield Surface Probability Characteristics</b> . . . . .	565
Mariya Shapovalova and Oleksii Vodka	
<b>Amplification of Heat Transfer by Shock Waves for Thermal Energy Method</b> . . . . .	577
Sergiy Plankovskyy, Olga Shypul, Yevgen Tsegelnyk, Alexander Pankratov, and Tatiana Romanova	
<b>Transport Aircrafts Rear Cargo Door Ramp with Sealed Floor Main Parameters and Components Description and Determination</b> . . . . .	588
Dmytro Konyshchev, Andriy Humennyi, Oleksandr Grebenikov, Anton Chumak, and Liliya Buival	

<b>Investigation into the Forming Process of Wing Panel Oblique Bending by Means of Rib Rolling</b> .....	598
Valeriy Sikulskiy, Stanislav Sikulskiy, and Vadym Garin	
<b>Numerical Analysis of Stress-Strain State of Fuel Tanks of Launch Vehicles in 3D Formulation</b> .....	609
Pavlo Gontarovskiy, Natalia Smetankina, Nataliia Garmash, and Iryna Melezhyk	
<b>Active-Passive Radar Systems Using Radiation of HF Band Broadcasting Stations for Airborne Objects Detection</b> .....	620
Vladyslav Lutsenko, Irina Lutsenko, Ihor Popov, Aleksandr Soboliak, Nguyen Xuan Anh, and Mikhail Babakov	
<b>3D-Modeling of the Dynamics of Real Processes of Different Nature</b> ...	633
Valeriy Mygal, Ihor Klymenko, and Galyna Mygal	
<b>Stochastic Optimization Algorithms for Data Processing in Experimental Self-heating Process</b> .....	644
Yuliia Viazovychenko and Oleksiy Larin	
<b>Project Management and Business Informatics</b>	
<b>Comparison of Metaheuristic Search Methods for the Task of Choosing a Rational Set of Measures to Risks' Respond</b> .....	657
Olha Pohudina, Anastasiia Morikova, Bohdan Haidabrus, Sergey Kiyko, and Evgeniy Druzhinin	
<b>Project Management in Universities Under the Global Pandemic: A Focus on Finance</b> .....	667
Olena Zhykhor, Valeriy Ryzhnikov, Olena Iafinovych, Nataliia Pohribna, and Nataliia Miedviedkova	
<b>Human Resource Management Tools in a Multiproject Environment</b> .....	680
Nataliia Dotsenko, Dmytro Chumachenko, Igor Chumachenko, Yuliia Husieva, Dmytro Lysenko, Iryna Kadykova, and Nataliia Kosenko	
<b>An Approach for Creating Learning Content from Knowledge Management System</b> .....	692
Volodymyr Sokol, Mariia Bilova, and Artem Kharin	
<b>The Cascading Subsystem of Key Performance Indicators in the Enterprise Performance Management System</b> .....	704
Valentina Moskalenko and Nataliia Fonta	






<b>On Using Information and Communication Technologies in Process of Mathematical Specialties Education</b> . . . . .	716
Nina Padalko, Halyna Padalko, and Anatoliy Padalko	
<b>Social and Legal Aspects of the Transition to Industry 4.0</b> . . . . .	726
Svitlana Gutsu, Maryna Mkrtychyan, and Anastasiia Strielkina	
<b>Author Index</b> . . . . .	739

# **Artificial Intelligence and Smart Systems**



# Numerical Estimation of the Residual Life-Time of the Elements of the Centrifugal Pump of the Energy Station Due to Corrosion Wear

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**Abstract.** This paper considers the issue of numeral estimating the residual strength of a centrifugal pump operating in excess of the design life in the line of pumps of the power station. Using modern technologies of computer and mathematical modeling the calculations of pump body for define its stress-strain state taking into account the change of geometry of body details had been carried out. The three-dimensional CE models are made, which take into account the actual geometry of the pump parts and the predict of its possible change for the period of extended time work. Estimation of static strength was performed for the main operating mode of the pump (under normal operating conditions). Taking into account the predicted values of the percentage of thinning of the wall of the pump, the statistical deformed state of the structure had been investigated. On the basis of statistical data, the parameter of damage and the probability of failure-free operation of the structure had been determined.

**Keywords:** Life-time · Corrosion wear · Reliability · Power equipment · Numeral calculation

## 1 Introduction

At the heart of Ukraine's energy efficiency and energy security are important issues related to energy components transportation. The use of modern technologies of computer and mathematical modeling makes it possible to effectively assess the residual resource and predict the period of no-failure operation of the power supply elements. Important elements of the system that play a significant role in meeting the needs of the end consumer are the accompanying power machines, in particular centrifugal pumps [1–5]. The pumps that are used at stations in Ukraine have already



worked out their design resource, but as practice shows, they can still be exploited. But for their safe use, it is necessary to assess their life-time [1, 2], taking into account the thinning of the walls of the case as a result of long-term operation. In operation, these structures are subject to significant cyclic overloads, as well as experiencing the action of an aggressive environment, influence of aggressive temperature extremes [6], which for some time of operation leads to accumulation of damage [7–11], and as a result to system failures [8, 12, 14]. Untimely detection can cause accidents, environmental disasters, cause significant consumer damage, as well as be a threat to human life [12]. Preventing these events through timely maintenance and repair is an extremely important task.

This paper considers the issue of estimating the residual strength of a centrifugal pump operating in excess of the design life in the line of pumps of the Nuclear station. The results of theoretical researches of its stress-strain state taking into account the change of geometry of case details which was observed after the end of design term of operation are resulted. Estimation of static strength was performed for the main operating mode of the pump (under normal operating conditions).

The study was conducted in the framework of numerical computer modeling based on the finite element method using modern software. Estimated three-dimensional CE models have been developed, which take into account the actual geometry of the pump parts and the predict of its possible change for the period of the extended life-time. The change in the geometry of the structure is taken into account on the basis of extrapolation of the data of the thickness of the walls of the body of pump, obtained in the process of long service life.

## 2 Defining Parameters of Deformed State

The pump under consideration has exhausted its design resource. Expert assessment of the operating organization of its technical condition shows that there is a thinning of the walls of the body in comparison with the design values. When analyzing the rate of erosion and corrosion wear, it was found that during the operation of the wall thickness of the housing, cover and tubulures, they will thin linearly over time evenly throughout the housing by 1% per 100 h of operation.

Operating experience shows that the average operating time for the pump is 20 h/year. Based on expert estimates of the rate of thinning of the walls and the assessment of the average operating time of the pump per year, the thinning of the walls of the body parts is predicted.

Strength calculations were performed using three-dimensional CE modeling technology. For adequate deformed state assessment, fragments of 1 m long pipes with elastically suspended ends were added to each pipe.

Linear elements of hexagonal and tetrahedral shapes were used for CE sampling (Fig. 1). The pipelines have a less dense mesh than the body parts, because their stress state is not the object of study – they are modeled only to transfer adequate boundary conditions to the pump tubulures. In fact, these elements are needed to level the possible edge effects near the pump. To assess the quality of the constructed model, a series of calculations with mesh of different densities was performed. The wall thicknesses of the body parts are set in accordance with the predicted data on thinning.

The parts of the pump are divided so that the main structural elements have at least two elements in thickness, everywhere the ratio of the sides of the CE is maintained so that the mesh does not have degenerate elements. CE mesh, which is used for calculations, is presented in Fig. 1.

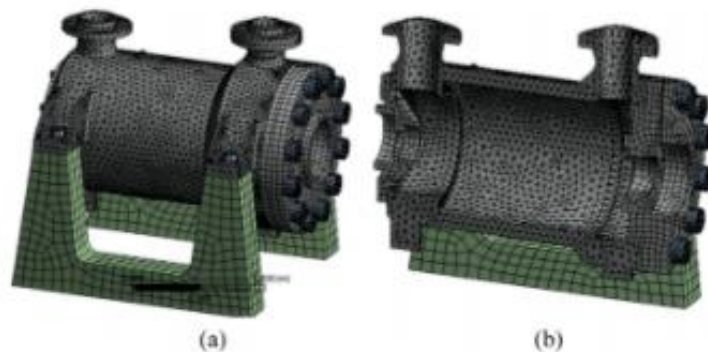


Fig. 1. CE mesh of the pump body (a) (horizontal sectional view (b)).

To select the size and number of elements for the CE model, test calculations were performed up to a permissible error of 5% for equivalent stresses.

Physical and mechanical characteristics of materials 12X18H10T, 40X, according to RNNE G 7-002-86 were used for calculations. The following boundary conditions were used:

- rigid sealing on the bearing surfaces of the pump legs;
- limiting the possibility of radial compression on the inner circles of the pressure and inlet covers;
- the base of the pressure and inlet flange in the axial direction had an elastic support, which simulates the effect of discarded pipes.
- volumetric force – the force of gravity;
- convective heat exchange water – steel was set on the inner surfaces (heat transfer coefficient,  $27900 \text{ W/m}^2 \text{ }^\circ\text{C}$ );
- on the outer surfaces was set convective heat transfer steel – wind (heat transfer coefficient,  $5 \text{ W/m}^2 \text{ }^\circ\text{C}$ );
- the ambient temperature was taken as  $22 \text{ }^\circ\text{C}$ .

In calculations was taken into account the presence of pre-tightening of threaded connections (Fig. 2). The values of the axial forces for the studs of the inlet cover and the pressure head were 100 kN and 35 kN, respectively.

Thus, at the first stage the problem of determination of the prestressing condition caused by tightening of hairpins was solved. In Fig. 3 shows the distribution of the intensity of stresses (equivalent stresses according to the Mises test), which are formed in the pump under this load mode.

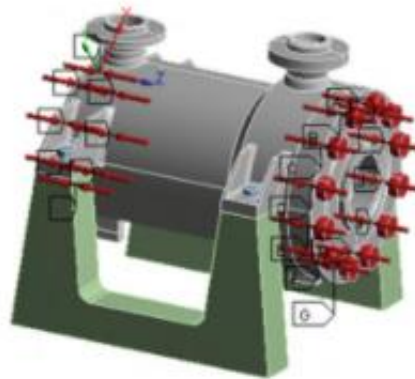


Fig. 2. Modeling of conditions of tightening of threaded connections.

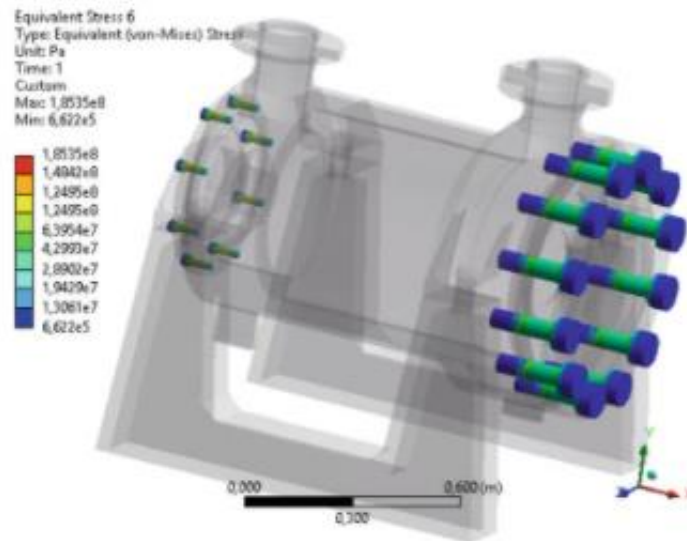


Fig. 3. Pre-stressed state of the studs caused by their mounting tightening.

According to RNNE G 7-002-86 (p. 3.4), the rated stress allowed for the elements of equipment and pipelines loaded with internal pressure, take the minimum of the following values:

$$\sigma = \min\{R_m/2.6; R_{0.2}/1.5\}, \tag{1}$$

where  $R_m$  is the tensile strength;  $R_{0.2}$  is the yield point.



For bolted connections

$$[\sigma]_{br} = R_{0,2} / 1,5, \quad (2)$$

Analyzing the previous stress state of the studs, tightening led to the presence of compressive stresses in the studs of a significant level (the level of maximum stresses is formed under the nut and at the entrance of the stud into the body and is 185 MPa, which is less than the allowable value of 295 MPa).

A high level of stresses in the places of concentration was formed on the covers of the pump (Fig. 3), and the obtained equivalent stress (72 MPa) are less than the nominal allowable stresses (131 MPa). To estimate the residual resource, the results of deformed state calculation at NCE pressure were used (Fig. 4)

Thus, the values of equivalent Mises stresses (88 MPa in the housing, 83 MPa in the pressure cap) are used as the minimum cycle stresses.

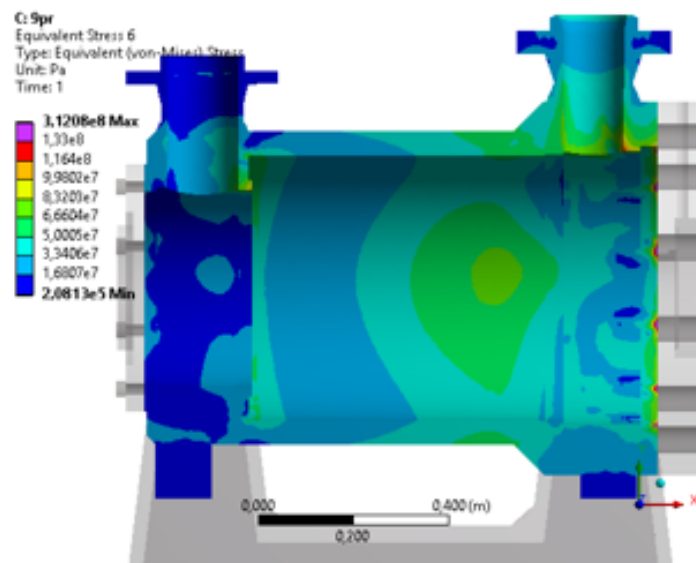


Fig. 4. Distribution of equivalent stresses according to Mises on the pump housing

At the welds, the cyclic strength was checked separately, taking into account the decrease in their strength by increasing the equivalent stress amplitudes by dividing them by the coefficient of decrease in the strength of the weld. This coefficient for austenitic grade steel in manual welding followed by visual inspection corresponds to 0.8 (the most conservative estimate) in accordance with the recommendation in the RNNE. Thus, together with the weld on the paw, the minimum cycle stresses are  $143 / 0.8 = 178$  MPa, and the maximum -  $155 / 0.8 = 193$  MPa.

From the data on the operation of the centrifugal pump at the power plant it is known that after the design period the walls of the housing were thinned by 10% due to erosion and corrosion wear. In subsequent calculations, the predicted value of the percentage of thinning of the hull wall was considered to be a random variable that changes over time.

Thinning of the pump wall is proposed to be taken into account in time in the form of a power function, which connects the operating time and the percentage of thinning  $h(t)$ :

$$h(t) = \hat{h} + k(t - \hat{t})^\alpha, \quad (3)$$

where  $t_0$  is the design life is 30 years,  $\alpha$  and  $k$  are indicators of thinning kinetics. The process of wall thinning due to corrosion-erosion wear is random, which can be taken into account if the indicators of the equation of its growth kinetics (3):  $\alpha$  and  $k$  are considered random variables.

The parameter  $k$  is able to change significantly, even under more or less the same external factors. The parameter  $\alpha$  in many studies is considered to be a constant deterministic value equal to 0.73. From the statistical data it is also known that the distribution of values with sufficient accuracy can be considered subject to the log-normal distribution law:

$$f(h, t) = \frac{1}{h(t)S(t)\sqrt{2\pi}} \exp\left[-\frac{(-\ln h - \mu(t))^2}{S^2(t)}\right], \quad (4)$$

where  $S(t)$  and  $\mu(t)$  are the parameters of the law, which depend on the value of the percentage of thinning in the current operation time and are determined from the coefficient of variation and mathematical expectation of the percentage of thinning as follows:

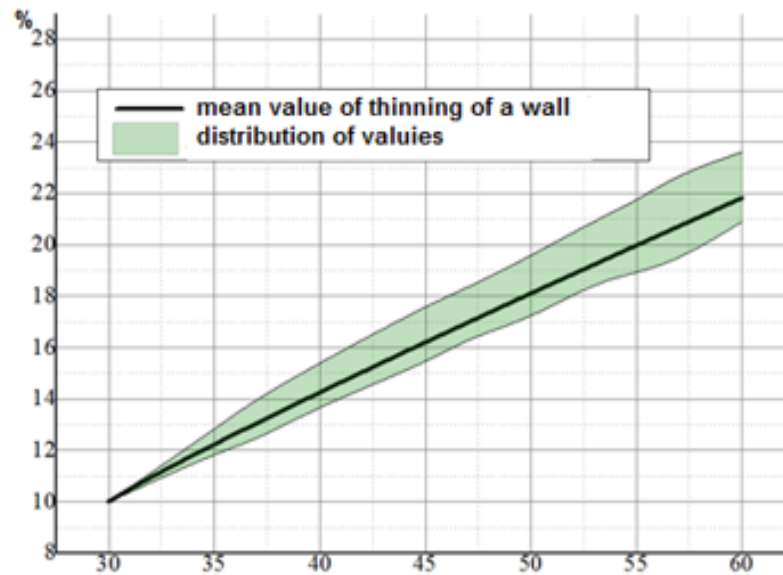
$$\mu(t) = \ln\left(\frac{m(t)}{\sqrt{1 + \frac{v(t)}{m^2(t)}}}\right), \quad S^2(t) = \ln\left(1 + \frac{v(t)}{m^2(t)}\right), \quad (5)$$

$$m(t) = \langle \hat{h} + k(t - \hat{t})^\alpha \rangle = \hat{h} + \langle k \rangle (t - \hat{t})^\alpha, \quad (6)$$

$$\text{Var}_h(t) = \langle (\hat{h} + k(t - \hat{t})^\alpha)^2 \rangle = \text{Var}(k)(t - \hat{t})^{2\alpha}, \quad (7)$$

$$v(t) = \frac{\sqrt{\text{Var}_h(t)}}{m(t)} = \frac{\sqrt{\text{Var}_k(t)}}{\langle k \rangle} = \text{const}, \quad (8)$$

where  $\langle \dots \rangle$  is the averaging operator,  $m(t)$  is the mean value,  $\text{Var}()$  is the variance,  $v(t)$  is the coefficient of variation. Which depends on time. In Fig. 4 schematically shows the development over time of the mean of corrosion damage  $m(t)$  and the possible scatter of its values over time (Table 1 and Fig. 5).



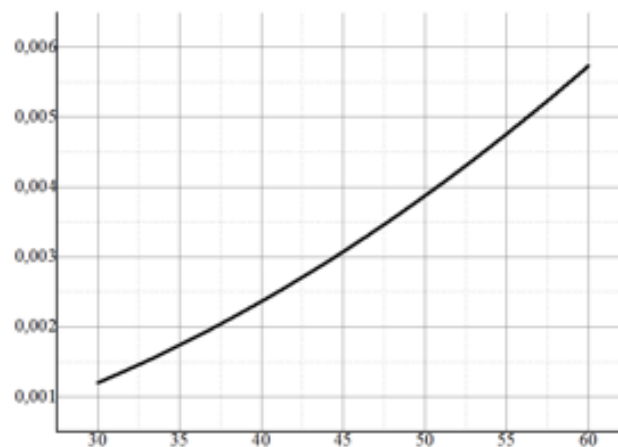
**Fig. 5.** Distribution of values of percent of thinning of a wall of the case of the pump depending on time of operation

**Table 1.** Probabilistic characteristics of the thinning.

Parameter	Characteristics of the growth rate of corrosion thinning
Coefficient of variation	0,075
Average value, mm	0,853

Displayed equations are centered and set on a separate line.

The change of plastic deformations depending on the service life and thinning of the pump housing is shown in Fig. 6



**Fig. 6.** Plastic deformations in the pump housing depending on design time of operation



$$\varepsilon(h, t) = K_1 h(t)^2 + K_2 h(t) + K_3 \text{ for } 30 \leq t \leq 60. \quad (9)$$

The level of plastic deformation is shown that in structure could accumulated fatigue die to cyclic load and it for defending safe life-time of pump it should taken into account.

### 3 Estimation of Pump Body Life-Time

Accordingly, to the probable values of the percentage of thinning of the wall was investigated statistical deformed state of the structure, on the basis of which the parameter of damage was determined. For this purpose, the step law of kinetics of damage accumulation is used within the framework of the Rabotnov-Kachanov concept of effective stresses. Taking into account the processes of accumulation of high- or low-cycle fatigue, the damage parameter is determined for each of the predicted cases in accordance with expression 10.

$$D = \begin{cases} 1 - [1 - (n + N_D)\delta_D(2s + 1)]^{1/2s + 1}, & dp > 0, \\ 1 - [1 - (n + N_D)\delta_M(m + 1)]^{1/m + 1}, & dp = 0, \end{cases} \quad (10)$$

where  $D$  is the damage parameter,  $n$  is the current value of the cycle,  $N_D$  is the value of the cycle at which the accumulation of damage begins,  $\delta_D$  is a variable that depends on the deformed state parameters of the structure when accumulating low-cycle fatigue,  $\delta_M$  is a variable that depends on the deformed state parameters with the accumulation of multicycle fatigue,  $s, m$  are the parameters of the material, which are determined from the Wehler curve,  $dp$  is the value of plastic deformations [13]. From the data on the operation of centrifugal pumps at the power plant it is known that the number of cycles per year is 1000. Taking into account the developed mathematical model, the parameter of damage to the thinned wall was obtained when predicting further operation for 15 years (Fig. 7).

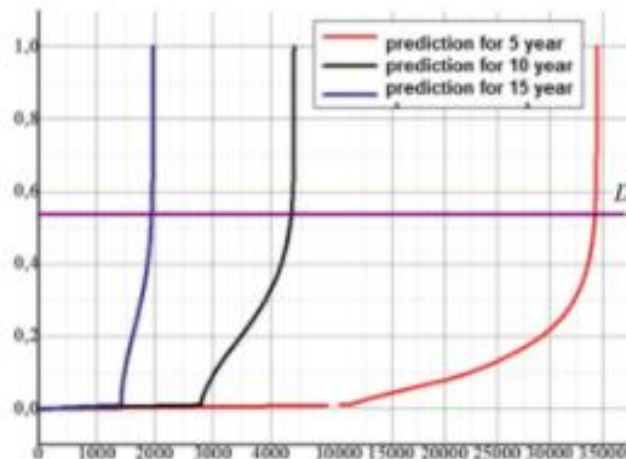


Fig. 7. Mean value of the damage parameter when predicting 5, 10 and 15 works over the design period.

From the analysis of the received data it is defined that at the predict at thinning of a wall in 5 years of operation the number of cycles to failure is equal 30,000 cycles that is equivalent to service life in 30 years, at the predict at thinning of a wall in 10 years of operation the number of cycles to failure is equal – 4200, which is equivalent to 4 years, and the predict for thinning of the wall after 15 years of operation, the number of cycles to failure is equal to 1000 cycles (1 year of operation). That is, operation of the pump after this level of corrosion and erosion wear is dangerous, and this object should be removed from operation.

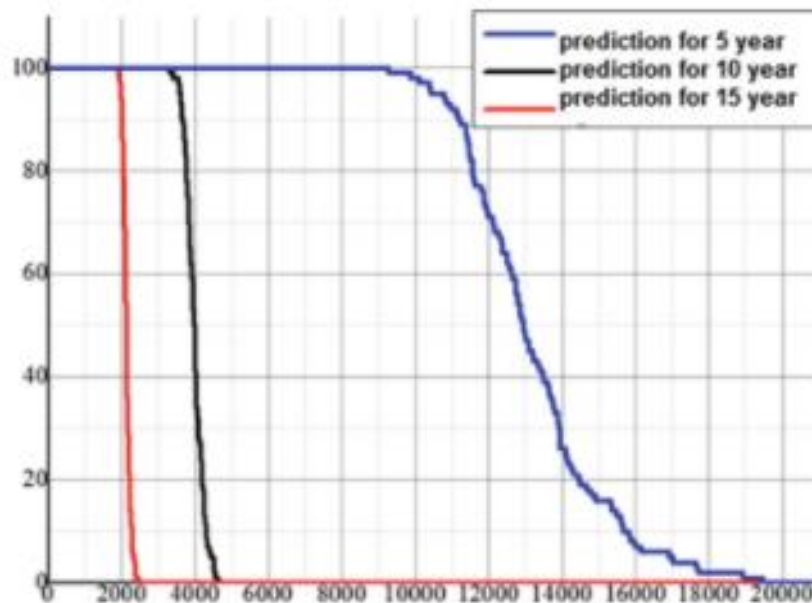
Thus, the probabilistic characteristics of the accumulation of fatigue damage during operation were obtained. These results can be used to estimate the probabilistic characteristics of the time to failure as a random variable.

Using the obtained statistical data of the damage parameter, the probability of trouble-free operation in predicting the extended service life for 5, 10 and 15 years was determined. For that was used the next equation

$$P(t) = \Pr[D \in (0, D_c)], \quad (11)$$

where  $P(t)$  is probability of non-failure operation.

Using the numerical procedure, the probability of failure-free operation was determined as the probability that the parameter  $D$  is equal to the value of  $D_c$  (0.5 for the pump material). The results of the calculations are shown in Fig. 8.



**Fig. 8.** Probability of non-failure operation of the pump body with a predict of 5, 10 and 15 works over the design period.

## 4 Conclusion

In this work the analysis of the residual life-time of the centrifugal pump which has fulfilled the design resource is carried out. Numerical calculations had been performed to determine the parameters of the deformed state, taking into account the thinning of the wall of the pump housing. Based on these studies, the parameter of damage during the accumulation of fatigue in the material of the pump had been obtained. The probabilistic characteristics for the design had been determined, which allow to predict the failure time at the corresponding thinning of the wall of the pump housing. Therefore, it can be concluded that with further operation of the centrifugal pump, after 15 years of operation, its efficiency will be reduced by 15 times, and its further use will be dangerous.

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