

Evaluation of Reformer Tubes Degradation after Long Term Operation

By

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13656

Dissertation submitted in partial fulfilment of  
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CERTIFICATION OF APPROVAL

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A project dissertation submitted to the

Mechanical Engineering Programme

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(MECHANICAL)

Approved by,

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(DR. MASDI BIN MUHAMMAD)

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TRONOH, PERAK

May 2014

## CERTIFICATION OF ORIGINALITY

This is to certify that I am responsible for the work submitted in this project, that the original work is my own except as specified in the references and acknowledgements, and that the original work contained herein have not been undertaken or done by unspecified sources or persons.

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(NURUL AIMI BINTI SAARI)

## **ABSTRACT**

Since the estimation of remnant life by deterministic methods is expensive and time consuming, in this study the remnant life is evaluated using structural reliability analysis and distribution analysis. The remnant life of the reformer tubes was studied by using the creep lifetime model and Monte Carlo Simulation, based on available data provided through non-destructive in site tests which is Laser-Optic Tube Inspection System (LOTIS) and the MANTIS technology consists of combined Eddy Current (ET) and Creep Stain measurement methodologies. The criterion which was used to evaluate the remnant life of the tubes is the service life, wall thickness measurements and minimum wall thickness. Then, the probabilistic variables related to parametric mentioned is gathered and modelled using the probabilistic distribution functions and their adoptable distribution functions were distinguished through simulation develop in Microsoft Excel spreadsheet.

## **ACKNOWLEDGEMENT**

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## **ABBREVIATIONS AND NOMENCLATURES**

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Abbreviations and Nomenclature	Full Meaning
ET	Eddy current
LOTIS	Laser-Optic Tube Inspection System
GLOSS	Generalized Local Stress Strain
LDA	Life Data Analysis
API	American Petroleum Institute
TTF	Time to failure
K-S	Kolmogrov-Smirnov test
Grade HK (25 Cr, 20 Ni, and 0.4 C)	Chromium-Nickel-Iron Alloy
Grade HP (26 Cr, 35 Ni, and 0.4 C)	Nickel-Chromium-Iron Alloy

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# CHAPTER 1

## INTRODUCTION

### 1.1. Background

In petrochemical industry, reformer furnaces are widely used and are subjected to extreme operation conditions. The tubes carries a mixture of hydrocarbon and steam at 980 kPa to 3500 kPa and is heated at the temperature of 500°C or above with the presence of a catalyst. The reaction is to produce a hydrogen gas at a temperature ranging from 850-900°C. According to American Petroleum Institute (API) Recommended Practice 5301, reformer tubes are designed to achieve a nominal life of 100,000 h (11.4 years) [1]. Nevertheless, depending on the operation conditions and the tubes material, the service life could be in the range from 30,000 to 150,000h. In order to meet the severe operating conditions of the tubes, generally the reformer tube is fabricated using centrifugally cast creep-resistant high carbon austenitic steel of ASTM A297 Grade HK (25 Cr, 20 Ni, and 0.4 C) or Grade HP (26 Cr, 35 Ni, and 0.4 C). Besides that, heat resistant alloys with a composition derived from HP grade can also be used in some cases for other high temperature.

It was found that primarily, the damage mechanism that leads to the tube failures under long term service is creep. In the early stage of service, the material may subject to carbon precipitations that cause embrittlement and reduction in strength or others. However, further degradation of the material under high temperature may lead to creep activities [2] [3] [4]. Similarly, I. Le May, T. L. da Silveirab and C.H. Viannac the authors for journal on Criteria for the Evaluation of Damage and Remaining Life in Reformer Furnace Tubes also points creep as the primarily damage mechanism for reformer furnace tube [4].

## **1.2.Problem Statement**

Catalytic tubes are important parts of reformer units at ammonia, methanol, hydrogen and gas process plants. They are the most expensive parts of reformer equipment. A steam reforming process converts hydrocarbons into mixture of hydrogen, carbon monoxide and dioxide. Chemical reactions proceed at a temperature range of 800-900°C and under pressure of 3-4 MPa. These severe working conditions cause a structural damage of tubes. Therefore, effective analysis on degradation indicator and remnant life of the tubes should be determine for future maintenance strategies before unexpected failure of the reformer tubes can cost unplanned downtime of the plant process and asset management.

## **1.3.Objectives**

The objective of this study is to evaluate reformer tubes degradation after long term operation in twofold: (a) to evaluate the degradation of the tubes with respect to time of service and (b) to estimate the remnant life of the reformer tubes system for a given operating condition.

## **1.4.Scope Of Study**

This study will utilize quantitative data collection tools from non-destructive in site tests which is Laser-Optic Tube Inspection System (LOTIS) and the MANTIS technology consists of combined Eddy Current (ET) that will evaluate the degradation mechanism through degradation analysis and Monte Carlo Simulation using macro in Microsoft Excel for the reformer tubes system remaining life. The limitations of this study would be that this study is the simulation of the life prediction through algorithms which can only partially indicates the asset health states.

## CHAPTER 2

### LITERATURE REVIEW

#### Degradation

In Reliability and risk: a Bayesian perspective, Singpurwalla stated that degradation is the accumulation of plastic damage throughout the service life which eventually led to failure wherein damage is regarded as aging of material. Through literature review, aging which relates to a unit is view in a state space whereas the probabilities of failure are greater than in a prior position [2]. With regards to the statement, degradation cannot be observed and assess directly therefore degradation model is established to relates the observable degradation indicators with the mathematical model on the degradation phenomenon. There are 3 types of degradation model that are commonly used, which are threshold crossing models, hazard rate process and state space models. Threshold crossing models is representing by degradation process in an indicator versus the time when it crosses a failure threshold. Secondly, degradation model modelled by failure time which built upon a hazard rate process. The third type, relates the relationship between the degradation process with degradation indicators by using a state and an observation equation.

#### Degradation mechanism

In degradation mechanism field of study, there are many mechanism that happens due to exposure to high temperature condition. Referring to API571 the relevant degradation mechanism that could relates to the severe operating condition imposed on the reformer catalytic tubes are Thermal shock, Creep and Stress rupture, Oxidation, Carburization and Hydrogen Embrittlement [1]. Creep affects all metals and alloys that operate at high temperatures and experiencing slow and continuous deformation under load which is below the yield stress. This time dependent deformation is a function of temperature, load and material. Generally creep deformation can be found in process with high temperature operating conditions above the creep range such as hydrogen reforming furnace tubes, hot-wall catalytic reforming reactors and furnace tube. In the presence of oxygen in the

surrounding air at high temperature, oxidation can take place when the oxygen reacts with the alloys and carbon steel to form metal oxide. Depending on composition and temperature, all iron based materials and nickel base alloys can be suspected of oxidation to varying degree. However, depending on the chromium content of the material, high chromium levels create a more protective oxide scale. Piping, equipment and combustion equipment that operate at high temperature exceeding 1000°F (538°C) will expose to oxidation. Carburization happens when a material is in contact with a carburizing environment or carbonaceous material at temperature that is high enough for diffusion of carbon into metal which around 1000°F (538°C). Materials that can be affected by this degradation mechanism are carbon steel, cast stainless steel, low alloy steels, nickel base alloys and HK/HP alloys. This degradation mechanism can result in loss of ambient temperature mechanical properties and loss of high temperature creep ductility. Penetration of hydrogen into carbon steel, low alloy steels and high strength nickel base alloys can result in a loss of ductility of high strength steels.

### **Remaining life assessment for reformer tubes**

There are several Nondestructive Examination that have been introduced to detect degradation mechanism in reformer tube especially due to creep damage such as Eddy Current, profilometry, and thermography. Seeing that the creep initiates at the grain scale, it cannot be evaluate straight forwardly. In Verification of Inspection Method Used to Predict Premature Failure of Primary Reformer Tubes, by Mahlangu, there were more than 300 tubes were inspected using Eddy current (ET) to estimate creep damage which provides results on the outer and inner diameter of the tube wall [3]. Mahlangu then further examined the tubes through metallographic approaches to further verify the findings before coming up with the nature and extent of the damage.

Other than that, analytical approaches have also been developed in assessing the reformer tubes life which as the procedure described in API Std 530 Calculation of Heater Tube Thickness in Petroleum Refineries [1], models and algorithm [5], robust method using Generalized Local Stress Strain (GLOSS) [6] or computational method [7].

Nowadays, probabilistic estimation of the remnant life of reformer tubes is one of the approaches that have been extensively used in this area by the engineers and researchers. Monte Carlo simulation is one of the applications which have been used excessively in engineering applications for its ability to model a complex system using less complicated approach where it involves non complex mathematical analysis and the input algorithms that are easy to understand. Monte Carlo simulation works by analysing and evaluating the logical model of the system repeatedly using different values of the distributed parameter for each run. This approach can be used in modelling a system reliability and availability using suitable computer program. Before running Monte Carlo simulation random variables that follow an arbitrary statistical distribution need to be generated, which for each input a distribution is assigned to represents the current state of the system. Reliability statistical distribution can be divided into point processes, discrete functions (Poisson distribution and Binomial Distribution) and continuous functions (Lognormal, Exponential, Gamma, Weibull, Extreme value and Normal or Gaussian distribution) as well as two additional important statistical distribution which is uniform distribution and triangular distribution which typically are not used to model failures but frequently used in engineering approximations and basic random number generations in Monte Carlo approach. Discrete function may describe situation concerned two-state discrete system such as either an equipment is in operational or a failed state whereas continuous functions is used to expressed continuous variables situation such as time or distance travelled. On the contrary, statistics of point functions is used for repairable systems, when there is more than one failure to occur in a continuous period. Generally, the choice of method will depend upon the available type of data and problem type. [8]

## CHAPTER 3

### METHODOLOGY

This study will utilize quantitative data collection tools that will evaluate the degradation mechanism for the reformer tubes after long term operation. This research methodology requires compilation of relevant data from journals, articles and specified documents in order to analyse and arrive at a more depth understanding of the degradation mechanism involved in reformer tube before a degradation model can be develop for different types of reformer tubes material and operating condition as the study basis. From this randomness degradation mechanism, further evaluation on the degradation of the tubes with respect to time of service and to estimation of the remnant life of the tubes for a given operating condition can be analyse according to the degradation model.

In developing the degradation model the studies from literature on the random variables of service life are listed and characteristic curve will be plot for each reformer tube. The characteristic curve will illustrate the relation of the wall thickness of the tube against time and the minimum thickness that have been specified. From the findings, each of the tube condition will be recorded and illustrate in order to observe the extent of degradation condition for different positions along the tube. Finally, this study will attempt probabilistic approached to modelling on estimating remnant life of the reformer tubes. Using the available data and random variables of service life, the remnant life of the reformer tube will be determined. The summarization on this study methodology is as presented in *figure1*.

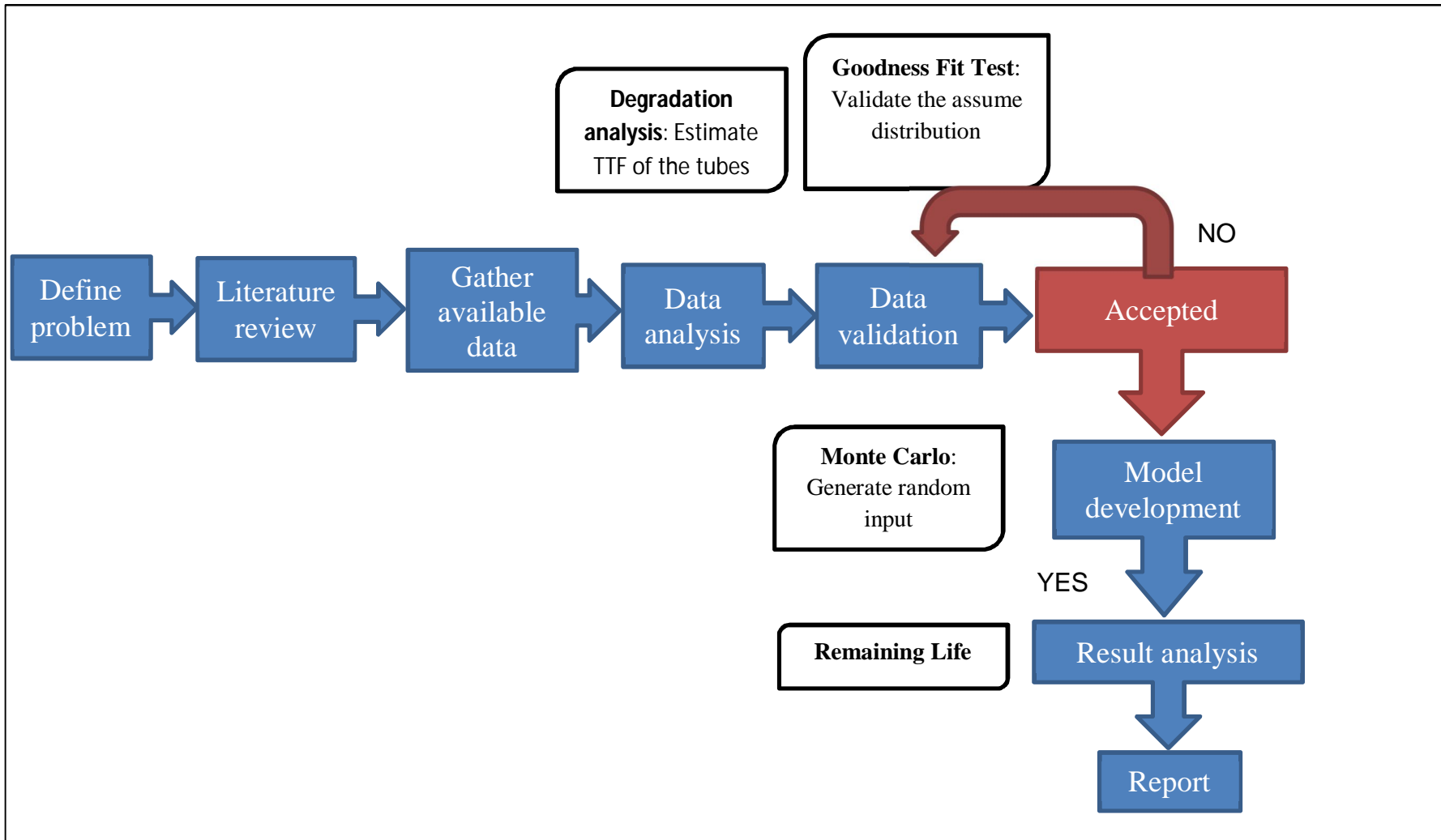


Figure 1 Methodology flow chart



## **1. Gather available data**

Generally premature creep failures in reformer tubes are associated with significant tube wall thinning, e.g. 30% or more. This thinning phenomenon primarily results from excess oxidation due to high temperature exposure, however for certain cases, foreign species in the fluid may cause increased rates of fire-side corrosion at design temperatures. For this study the available data given are the tubes failure threshold at 4.03 inch minimum inner diameter of the reformer tubes as well as general information on the reformer and tubing. From the given data, the remnant life of the tubes system is to be calculated. This study used the relation between minimum wall thickness permitted, rate of wall thinning, life fraction range and the service life of a tube to calculate the remaining life of reformer tubes system.

## **2. Data Analysis**

Components testing approach requires long term procedure and under normal operating condition failure may occur after long time, therefore degradation analysis is used to allows the data to be extrapolate at the point of failure based on degradations measured over time. At the point of failure the failure times is identified, and life data analysis can be conducted to analyse the demonstrate failures. *Figure 2* below demonstrates the form of degradation analysis.

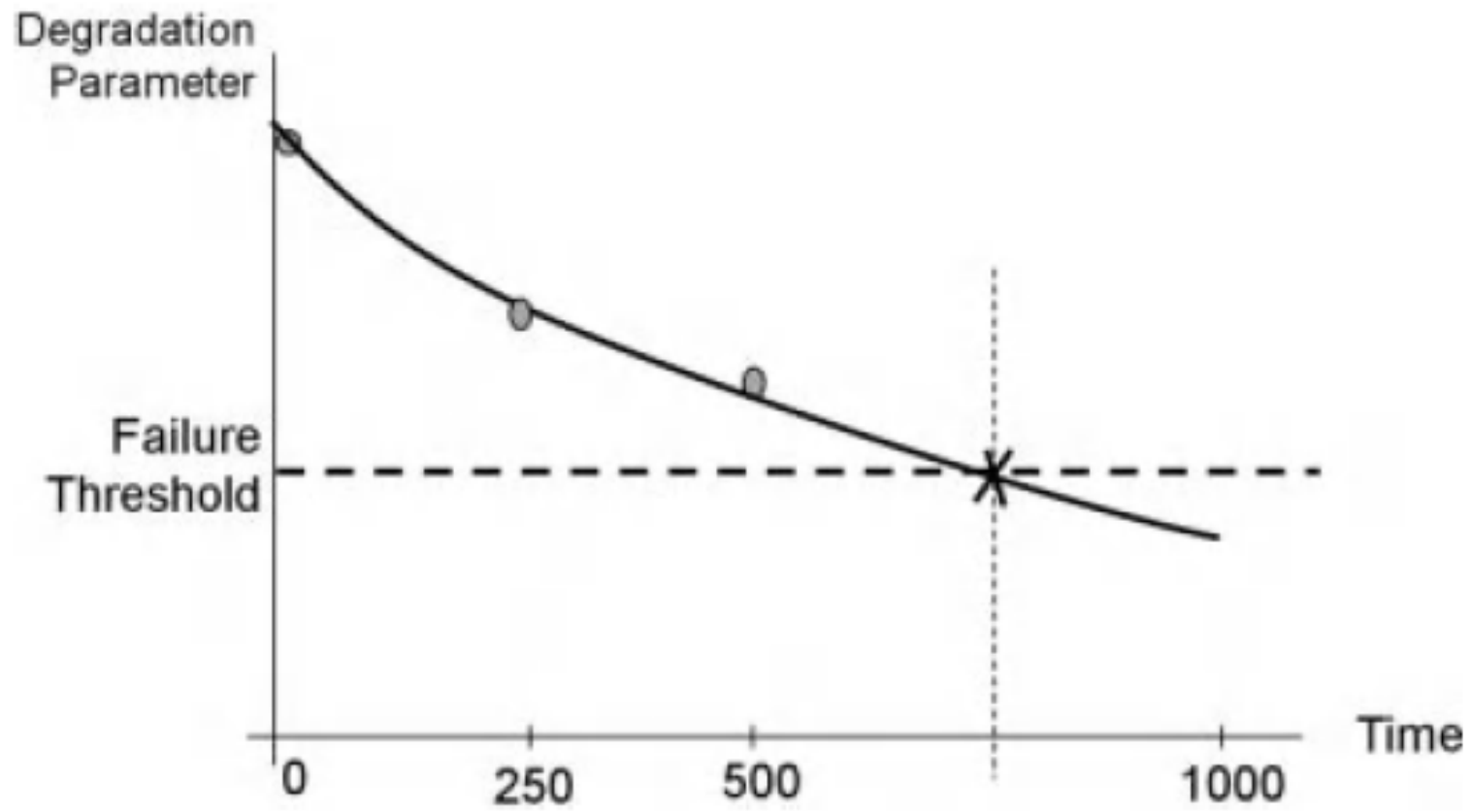


Figure 2 Degradation analysis diagram

### 3. Data Validation

It is vital to recognize the type of distribution functions of the variables which are concerned within the system, hence goodness-of-fit test which is Kolmogorov-Smirnov test is use to analyse the results statistics. First, the ranked failure data will be tabulate and the values of  $|x_i - E_i|$  will be calculated where  $x_i$  is the  $i_{th}$  cumulative rank value and  $E_i$  the expected cumulative rank value for the assumed distribution. Next, the highest single value is determined and lastly this value will be compare with the appropriate K-S value (Appendix 1).

### 4. Model development: Monte Carlo Simulations

Figure 3 show the Monte Carlo simulation procedure which after identifying the best system data distribution, random inputs is entered into simple mathematical equation in order to generate random outputs in the forms of probability distribution which the sample is simulated into actual population using the best describe distribution of the sample state vice versa it can simulate sample numbers randomly for any probability distribution for given cumulative distribution function which is called inverse statistical function shown in figure 4.

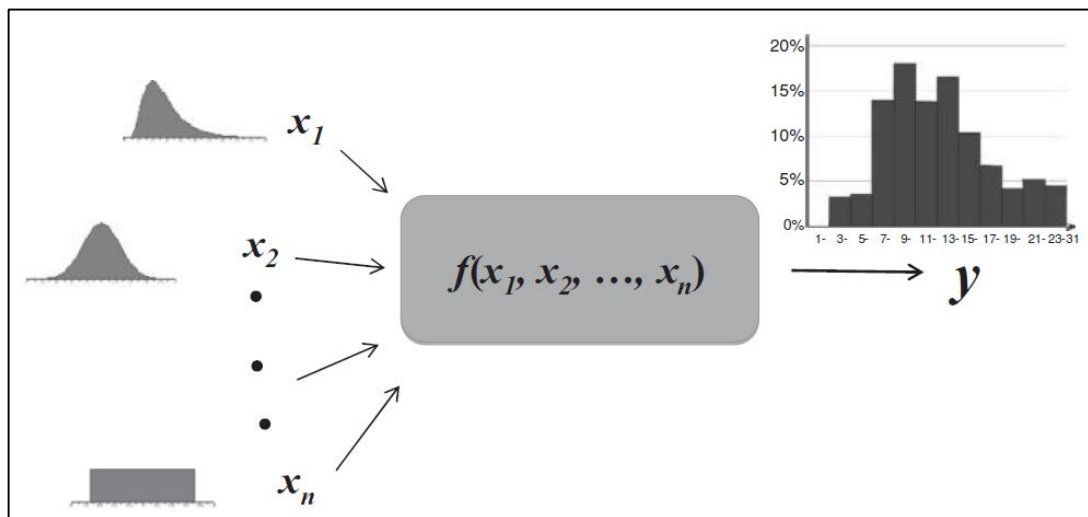


Figure 3 Monte Carlo simulation procedure

Distribution	cdf	Excel Function
Uniform	$F(x) = \begin{cases} \frac{x-a}{b-a} & a \leq x \leq b \\ 0 & \text{otherwise} \end{cases}$	=(b-a)*RAND()
Triangular (Symmetrical)	$F(x) = \begin{cases} 2 \left( \frac{x-a}{b-a} \right)^2 & \text{for } a \leq x \leq \frac{a+b}{2} \\ 1 - 2 \left( \frac{b-x}{b-a} \right)^2 & \text{for } \frac{a+b}{2} \leq x \leq b \end{cases}$	=a+(b-a)*(RAND()+RAND())/2
Normal	$F(x) = \Phi \left( \frac{x-\mu}{\sigma} \right)$	=NORMINV(RAND(), $\mu$ , $\sigma$ )
Lognormal	$F(x) = \Phi \left( \frac{\ln x - \mu}{\sigma} \right)$	=LOGINV(RAND(), $\mu$ , $\sigma$ )
Weibull (2 Parameter)	$F(x) = 1 - e^{-\left(\frac{x}{\eta}\right)^\beta}$	=( $\eta$ *LN(RAND()))^(1/ $\beta$ )
Weibull (3 Parameter)	$F(x) = 1 - e^{-\left(\frac{x-\gamma}{\eta}\right)^\beta}$	=( $\eta$ *LN(RAND()))^(1/ $\beta$ )+ $\gamma$
Extreme Value (Minimum)	$F(x) = 1 - \exp \left\{ -\exp \left[ \frac{1}{\sigma}(x - \mu) \right] \right\}$	= $\mu + \sigma * \text{LN}(\text{LN}(1/\text{RAND}()))$
Extreme Value (Maximum)	$F(x) = \exp \left\{ -\exp \left[ -\frac{1}{\sigma}(x - \mu) \right] \right\}$	= $\mu - \sigma * \text{LN}(\text{LN}(1/\text{RAND}()))$

Figure 4 Statistical distributions sampling using Microsoft Excel

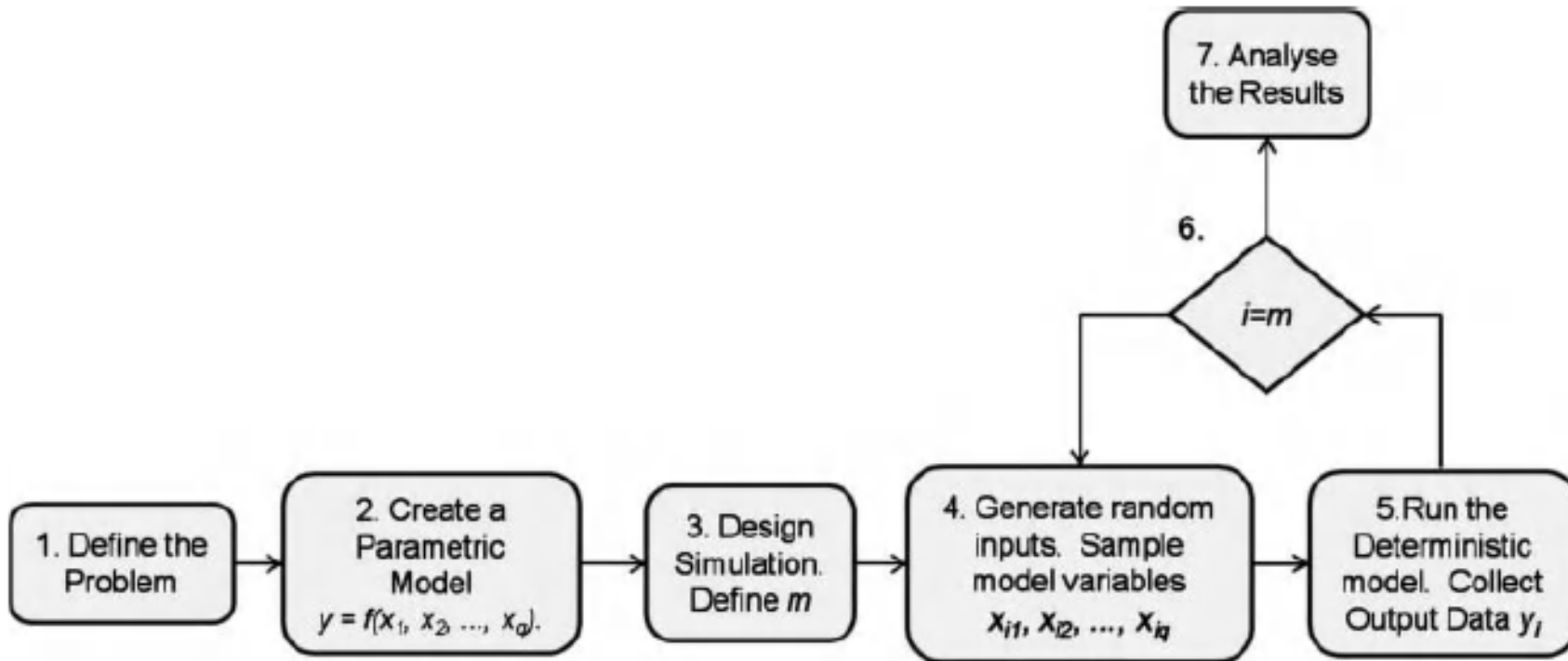


Figure 5 Monte Carlo simulation process

## 5. Define the system and create a parametric model [9]

Assuming the tubes are homogenous, life data analysis can be performed using results from degradation analysis as the relations of service life, wall thickness measurements and minimum wall thickness permits estimations of time to failure for the tubes. The parametric model of the evaluation would be time to failure of the tubes which the limit state function is represented by a set of random variables described by the distribution type and other parameters such as mean and standard deviation.

Ellis et al. stated that the life fraction range is established to correlate with damage classification model by Cane et al. which proposed relation between numbers of fraction of cavitated boundaries with life fraction consumed using heat specific constant for a constrained-cavity-growth model. [10] Through metallographic observations, Wedel-Neuber damage rating class is proved to be possible in relating the expended life fraction of material to the creep cavitation evolution and quantitatively examined through stochastic approach. The results of mean value and standard error of damage rating obtained from the stochastic analysis is summarized as in *table 1* [11]

**Table 1 Dispersion in Wedel-Neubauer Classification of Damage Ratings**

DAMAGE RATING	EXPENDED LIFE FRACTION (t/t <sub>r</sub> )
	mean value ± standard error
1 - UNDAMAGED	0.074 ± 0.035
A - ISOLATED CAVITIES	0.237 ± 0.032
B - ORIENTED CAVITIES	0.408 ± 0.029
C - MICROCRACKS	0.630 ± 0.046
D - MACROCRACKS	0.861 ± 0.037

By having the corresponding damage rating, the remaining life can be calculated using the equation shown below:

$$T_{rem} = T_t \left( \frac{T_r}{T_t} - 1 \right)$$

$$T_{rem} = T_r - T_t \text{ (Eq1)}$$

Creep level at Oriented Cavities level life fraction of  $T_t$  time of service over

$T_r$  rupture life is defined as Eq2:

$$0.408 = \frac{T_t}{T_r} \text{ (Eq2)}$$

By substituting Eq2 into Eq1:

$$T_{rem} = T_r - 0.408T_r \text{ (Eq3)}$$

Eq3 is the system model for Monte Carlo which  $T_{rem}$  is the remaining life

$$0.408 = \frac{T_r - T_{ttf}}{T_r} \text{ (Eq4)}$$

Eq4 is defined as the parametric model which the time to failure of the tubes,  $T_{ttf}$  will generated random output of normally distributed  $T_{ttf}$  with  $T_r$  rupture life

Tubes that experience life fraction that is equal or more than 0.408 is consider failed, whereas for the whole tubes system to be considered fail it is assumed to be at 10% of tubes fail.

**Table 2 System threshold**

Condition for tube to fail	$0.408 = \frac{T_r - T_{ttf}}{T_r}$
Threshold of the system to fail	10% of the tubes fail

## 6. Design the simulation

Define how many simulation runs,  $m$  should be used which  $m$  is affected by the complexity of the model and the sought accuracy of results.

$$m = \frac{Z_{\alpha/2} \times \sigma / \mu}{Er(\mu) / \mu}$$

where,

$Er(\mu)$ =standard error of the mean

$\alpha=1-C$ , where  $C$  is the confidence level

$Z_{\alpha/2}$ =the standard normal statistic

$\sigma$  =standard deviation of the output

## 7. Generate a set of random inputs

In generating a set of random inputs through basic formula as many time as the quantity of simulations required for the model, Monte Carlo simulation can be run using basic spread sheet program. In this study, macro excel functions was used to generate the random inputs. *Figure 4* shows the statistical distributions sampling functions using Microsoft Excel®. Input parameters will be tested will different type of probability distribution in order to identify the parameters distribution. In this case, the time to failure of the tubes will be statistically distributed using normal distribution trend.

## 8. Run the deterministic system model with the set of random input

## 9. Evaluate the model and the results is recorded

## 10. Analyse the results



## CHAPTER 4

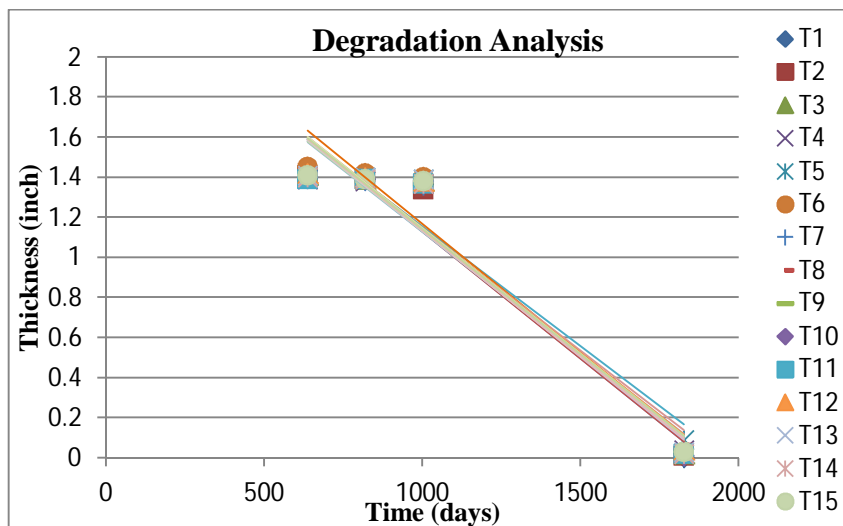
### RESULTS AND DISCUSSION

Using degradation analysis, the relations of service life, wall thickness measurements and minimum wall thickness permitted was plotted to calculate the estimations of time to failure for the tubes.

The data of the wall thickness and service life is presented in *table 3*. Degradation analysis of the tubes is presented in *figure 6* by plotting thickness of the tubes versus the time of service. In order to determine the time to failure of each data set, trend line was used to get the best line fit of the data set with highest R-square valued. After the type of trend line has been decided, the equation of the line was identified and the time to failure for each data set was obtained by extrapolate the line when thickness, y-axis is at zero. The obtained trend line for linear equation, R-square value and time to failure of the data set were tabulated in *table 4*.

**Table 3 Wall thickness data over time of use**

Time (days)	L1	L2	L3	L4	L5	L6	L7	L8	L9	L10	L11	L12	L13	L14	L15
638	1.4	1.41	1.41	1.39	1.4	1.45	1.39	1.39	1.39	1.4	1.39	1.42	1.41	1.4	1.41
820	1.39	1.39	1.39	1.38	1.4	1.42	1.38	1.39	1.38	1.39	1.39	1.4	1.4	1.39	1.39
1004	1.37	1.34	1.38	1.37	1.39	1.4	1.36	1.38	1.37	1.38	1.37	1.38	1.39	1.37	1.38
1826	0	0.01	0.02	0.04	0.09	0.03	0.03	0.06	0.03	0.01	0.02	0.04	0.03	0.02	0.03



**Figure 6 Degradation Analysis: Linear regression model between the wall thickness and time**

**Table 4 The data set trend line equation, R-square value and time to failure**

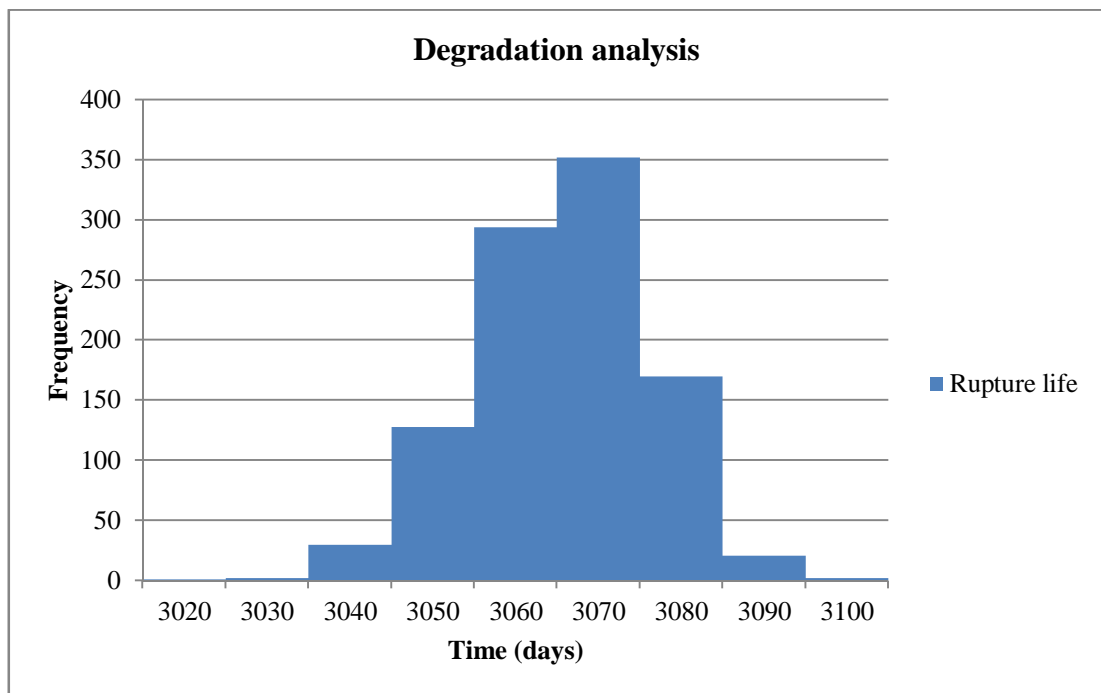
i	Equation of linear model	R Square
1	$y = -0.0013x + 2.383$	0.9252
2	$y = -0.0013x + 2.3911$	0.9283
3	$y = -0.0013x + 2.3953$	0.9283
4	$y = -0.0013x + 2.3964$	0.94
5	$y = -0.0013x + 2.4018$	0.9252
6	$y = -0.0013x + 2.402$	0.9314
7	$y = -0.0013x + 2.4026$	0.9283
8	$y = -0.0013x + 2.4045$	0.9252
9	$y = -0.0013x + 2.4057$	0.9282
10	$y = -0.0013x + 2.452$	0.9341
11	$y = -0.0012x + 2.3526$	0.9222
12	$y = -0.0012x + 2.3572$	0.9221
13	$y = -0.0012x + 2.3626$	0.9253
14	$y = -0.0012x + 2.3665$	0.9285
15	$y = -0.0012x + 2.3699$	0.9253

From the obtain time to failure value, goodness fit test, Kolmogrov-Smirnov test was conducted in order to obtain the type of distribution for the time to failure of the system. Assuming that the data was normally distributed the critical value of the data was calculated with mean of 1888.578 days and standard deviation of 59.40842 days. The highest critical value obtained is 0.303947 which is smaller compared with K-S table value for 15 number of sample at 10% significance level which is 0.40962. Hence, the early assumption, that the data is normally distributed is accepted. The goodness fit test calculation was summarized in as in *table 5* below.

**Table 5 Goodness fit test**

i	Equation of linear model	R Square	TTF (days)	X	E	Abs( X-E)
1	$y = -0.0013x + 2.383$	0.9252	1833.077	0.045455	0.175094	0.129639
2	$y = -0.0013x + 2.3911$	0.9283	1839.308	0.11039	0.203455	0.093065
3	$y = -0.0013x + 2.3953$	0.9283	1842.538	0.175325	0.219181	0.043856
4	$y = -0.0013x + 2.3964$	0.94	1843.385	0.24026	0.223412	0.016848
5	$y = -0.0013x + 2.4018$	0.9252	1847.538	0.305195	0.244846	0.060349
6	$y = -0.0013x + 2.402$	0.9314	1847.692	0.37013	0.24566	0.12447
7	$y = -0.0013x + 2.4026$	0.9283	1848.154	0.435065	0.248113	0.186952
8	$y = -0.0013x + 2.4045$	0.9252	1849.615	0.5	0.255964	0.244036
9	$y = -0.0013x + 2.4057$	0.9282	1850.538	0.564935	0.260988	0.303947
10	$y = -0.0013x + 2.452$	0.9341	1886.154	0.62987	0.483727	0.146143
11	$y = -0.0012x + 2.3526$	0.9222	1960.5	0.694805	0.886983	0.192178
12	$y = -0.0012x + 2.3572$	0.9221	1964.333	0.75974	0.898875	0.139134
13	$y = -0.0012x + 2.3626$	0.9253	1968.833	0.824675	0.911638	0.086963
14	$y = -0.0012x + 2.3665$	0.9285	1972.083	0.88961	0.920081	0.030471
15	$y = -0.0012x + 2.3699$	0.9253	1974.917	0.954545	0.926931	0.027614

Referring to the obtained distribution, random inputs of the time to failure was generated using  $\text{NORMINV}(\text{RAND}(), \mu, \sigma)$  function in excel for the 288 tubes. Using the parametric model constructed the relations of the time to failure and rupture life was simulated in order to calculate the remaining life of the system. For the simulation, the parametric model was run for 1000 iterations. The rupture life of the tubes is presented in the forms of cumulative failure probability, therefore by deciding the threshold failure of the tubes for the system to fail the remaining life can be obtained. To determine the threshold of failure, operational circumstances must be considered from various points of view. The remaining system life prediction for this study is assumed to be 10% of failure probability. The results of the simulation are presented in *figure 7*.



**Figure 7 Rupture life of the system for 1000 simulations**

The average rupture system life prediction for 10% failure of tubes and the remaining life of the system is estimated as shown in *table 6* below.

**Table 6 Average remaining life prediction with 10% tubes failure for 1000 times**

<b>Time to rupture, <math>T_r</math>, days</b>	<b>Time to rupture, <math>T_{rem}</math>, days (years)</b>
<b>3066</b>	1814.865 (5)

To ensure the accuracy of the calculated value, the simulation was run for 20 times, the resulted remaining life for each run is tabulated in *table 7* below.

**Table 7 Calculated remaining life prediction with 20 runs for 1000 iteration**

Run	Time to rupture, $T_r$ , days	Remaining life, $T_{rem}$ , days (years)
1	3066.52	1815.37984
2	3066.53	1815.38576
3	3066.56	1815.40352
4	3066.55	1815.3976
5	3066.56	1815.40352
6	3066.55	1815.3976
7	3066.56	1815.40352
8	3066.55	1815.3976
9	3066.55	1815.3976
10	3066.57	1815.40944
11	3066.54	1815.39168
12	3066.55	1815.3976
13	3066.55	1815.3976
14	3066.54	1815.39168
15	3066.55	1815.3976
16	3066.55	1815.3976
17	3066.54	1815.39168
18	3066.52	1815.37984
19	3066.55	1815.3976
20	3066.53	1815.38576

From the resulted 20 runs of the simulation, the value shows insignificant different in the values of the calculated remaining life. Therefore, the average life taken is applicable. It is to be noted that, the preciseness of the estimation depends on the precision of distinguishing the probabilistic functions. Besides that, rate of wall thinning also contributes on the remaining life estimation. Monte Carlo simulation approach enables life assessment with considering typical variations in reformer tubes pressure and skin temperatures, in addition with time. Moreover, using this approach individual circumstance associated within plant can be adopted.

## **CHAPTER 5**

### **CONCLUSION AND RECOMMENDATION**

In preceding development, it has been proved that a practicable approach to perform residual life predictions can be achieved in absence of complete knowledge on the operational history of a component subjected to creep conditions. The non-destructive test and degradation analysis using simple wall thickness displacement measurements provide information to be elaborated for more realistic prediction of residual life.

From the literature review there have been many models, algorithms and techniques discussed, hence in the future it would be recommended to conduct a study on how to effectively use all the available data to estimates the remnant life of the reformer tubes and to design a multi failure modes in a model.

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# APPENDICES

## APPENDIX 1

### Kolmogorov–Smirnov Tables

Critical values,  $d_{\alpha;n}^*$ , of the maximum absolute difference between sample  $F_n(x)$  and population  $F(x)$  cumulative distribution.

Number of trials, $n$	Level of significance, $\alpha$			
	0.10	0.05	0.02	0.01
1	0.95000	0.97500	0.99000	0.99500
2	0.77639	0.84189	0.90000	0.92929
3	0.63604	0.70760	0.78456	0.82900
4	0.56522	0.62394	0.68887	0.73424
5	0.50945	0.56328	0.62718	0.66853
6	0.46799	0.51926	0.57741	0.61661
7	0.43607	0.48342	0.53844	0.57581
8	0.40962	0.45427	0.50654	0.54179
9	0.38746	0.43001	0.47960	0.51332
10	0.36866	0.40925	0.45662	0.48893
11	0.35242	0.39122	0.43670	0.46770
12	0.33815	0.37543	0.41918	0.44905
13	0.32549	0.36143	0.40362	0.43247
14	0.31417	0.34890	0.38970	0.41762
15	0.30397	0.33760	0.37713	0.40420
16	0.29472	0.32733	0.36571	0.39201
17	0.28627	0.31796	0.35528	0.38086
18	0.27851	0.30936	0.34569	0.37062
19	0.27136	0.30143	0.33685	0.36117
20	0.26473	0.29408	0.32866	0.35241
21	0.25858	0.28724	0.32104	0.34427
22	0.25283	0.28087	0.31394	0.33666
23	0.24746	0.27490	0.30728	0.32954
24	0.24242	0.26931	0.30104	0.32286
25	0.23768	0.26404	0.29516	0.31657
26	0.23320	0.25907	0.28962	0.31064
27	0.22898	0.25438	0.28438	0.30502
28	0.22497	0.24993	0.27942	0.29971
29	0.22117	0.24571	0.27471	0.29466
30	0.21756	0.24170	0.27023	0.28987
31	0.21412	0.23788	0.26596	0.28530
32	0.21085	0.23424	0.26189	0.28094
33	0.20771	0.23076	0.25801	0.27677
34	0.20472	0.22743	0.25429	0.27279
35	0.20185	0.22425	0.26073	0.26897
36	0.19910	0.22119	0.24732	0.26532
37	0.19646	0.21826	0.24404	0.26180
38	0.19392	0.21544	0.24089	0.25843
39	0.19148	0.21273	0.23786	0.25518
40 <sup>b</sup>	0.18913	0.21012	0.23494	0.25205

<sup>a</sup>Values of  $d_{\alpha;n}^*$  such that  $P(\max |F^n(x) - F(x)| \leq d^*) = \alpha$ .

<sup>b</sup> $N > 40 \Rightarrow \frac{1.22}{\sqrt{10n}}, \frac{1.36}{\sqrt{20n}}, \frac{1.51}{\sqrt{30n}}$  and  $\frac{1.63}{\sqrt{40n}}$  for the four levels of significance.

APPENDIX 2

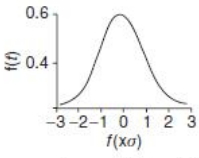
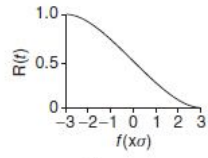
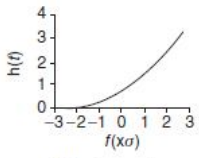
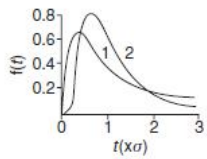
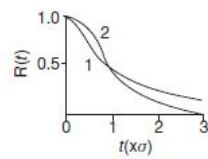
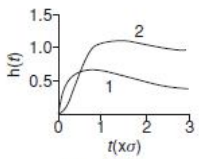
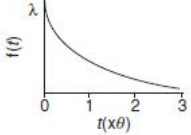
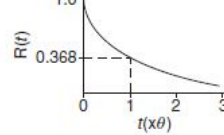
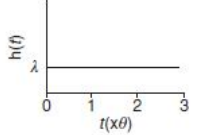
$\chi^2(\alpha, \nu)$  Distribution Values

Degrees of freedom $\nu$	$\alpha$ (risk factor) = 1 - Confidence							
	0.995	0.990	0.975	0.95	0.90	0.80	0.70	0.60
1	0.004393	0.01157	0.03982	0.07393	0.158	0.0642	0.148	0.275
2	0.0100	0.0201	0.0506	0.103	0.211	0.446	0.713	1.02
3	0.0717	0.115	0.216	0.352	0.584	1.00	1.42	1.87
4	0.207	0.297	0.484	0.711	1.06	1.65	2.19	2.75
5	0.412	0.554	0.831	1.15	1.61	2.34	3.00	3.66
6	0.676	0.872	1.24	1.64	2.20	3.07	3.83	4.57
7	0.989	1.24	1.69	2.17	2.83	3.82	4.67	5.49
8	1.34	1.65	2.18	2.73	3.49	4.59	5.53	6.42
9	1.73	2.09	2.70	3.33	4.17	5.38	6.39	7.36
10	2.16	2.56	3.25	3.94	4.87	6.18	7.27	8.30
11	2.60	3.05	3.82	4.57	5.58	6.99	8.15	9.24
12	3.07	3.57	4.40	5.23	6.30	7.81	9.03	10.2
13	3.57	4.11	5.01	5.89	7.04	8.63	9.93	11.1
14	4.07	4.66	5.63	6.57	7.79	9.47	10.8	12.1
15	4.60	5.23	6.26	7.26	8.55	10.3	11.7	13.0
16	5.14	5.81	6.91	7.96	9.31	11.2	12.6	14.0
17	5.70	6.41	7.56	8.67	10.1	12.0	13.5	14.9
18	6.26	7.01	8.23	9.39	10.9	12.9	14.4	15.9
19	6.84	7.63	8.91	10.1	11.7	13.7	15.4	16.9
20	7.43	8.26	9.59	10.9	12.4	14.6	16.3	17.8
21	8.03	8.90	10.3	11.6	13.2	15.4	17.2	18.8
22	8.64	9.54	11.0	12.3	14.0	16.3	18.1	19.7
23	9.26	10.2	11.7	13.1	14.8	17.2	19.0	20.7
24	9.89	10.9	12.4	13.8	15.7	18.1	19.9	21.7
25	10.5	11.5	13.1	14.6	16.5	18.9	20.9	22.6
26	11.2	12.2	13.8	15.4	17.3	19.8	21.8	23.6
27	11.8	12.9	14.6	16.2	18.1	20.7	22.7	24.5
28	12.5	13.6	15.3	16.9	18.9	21.6	23.6	25.5
29	13.1	14.3	16.0	17.7	19.8	22.5	24.6	26.5
30	13.8	15.0	16.8	18.5	20.6	23.4	25.5	27.4
35	17.2	18.5	20.6	22.5	24.8	27.8	30.2	32.3
40	20.7	22.2	24.4	26.5	29.1	32.3	34.9	37.1
45	24.3	25.9	28.4	30.6	33.4	36.9	39.6	42.0
50	28.0	29.7	32.4	34.8	37.7	41.4	44.3	46.9
75	47.2	49.5	52.9	56.1	59.8	64.5	68.1	71.3
100	67.3	70.1	74.2	77.9	82.4	87.9	92.1	95.8

0.50	0.40	0.30	0.20	0.10	0.05	0.025	0.010	0.005	$\nu$
0.455	0.708	1.07	1.64	2.71	3.84	5.02	6.63	7.88	1
1.39	1.83	2.41	3.22	4.61	5.99	7.38	9.21	10.6	2
2.37	2.95	3.67	4.64	6.25	7.81	9.35	11.3	12.8	3
3.36	4.04	4.88	5.99	7.78	9.49	11.1	13.3	14.9	4
4.35	5.13	6.06	7.29	9.24	11.1	12.8	15.1	16.7	5
5.35	6.21	7.23	8.56	10.6	12.6	14.4	16.8	18.5	6
6.35	7.28	8.38	9.80	12.0	14.1	16.0	18.5	20.3	7
7.34	8.35	9.52	11.0	13.4	15.5	17.5	20.1	22.0	8
8.34	9.41	10.7	12.2	14.7	16.9	19.0	21.7	23.6	9
9.34	10.5	11.8	13.4	16.0	18.3	20.5	23.2	25.2	10
10.3	11.5	12.9	14.6	17.3	19.7	21.9	24.7	26.8	11
11.3	12.6	14.0	15.8	18.5	21.0	23.3	26.2	28.3	12
12.3	13.6	15.1	17.0	19.8	22.4	24.7	27.7	29.8	13
13.3	14.7	16.2	18.2	21.1	23.7	26.1	29.1	31.3	14
14.3	15.7	17.3	19.3	22.3	25.0	27.5	30.6	32.8	15
15.3	16.8	18.4	20.5	23.5	26.3	28.8	32.0	34.3	16
16.3	17.8	19.5	21.6	24.8	27.6	30.2	33.4	35.7	17
17.3	18.9	20.6	22.8	26.0	28.9	31.5	34.8	37.2	18
18.3	19.9	21.7	23.9	27.2	30.1	32.9	36.2	38.6	19
19.3	21.0	22.8	25.0	28.4	31.4	34.2	37.6	40.0	20
20.3	22.0	23.9	26.2	29.6	32.7	35.5	38.9	41.4	21
21.3	23.0	24.9	27.3	30.8	33.9	36.8	40.3	42.8	22
22.3	24.1	26.0	28.4	32.0	35.2	38.1	41.6	44.2	23
23.3	25.1	27.1	29.6	33.2	36.4	39.4	43.0	45.6	24
24.3	26.1	28.2	30.7	34.4	37.7	40.6	44.3	46.9	25
25.3	27.2	29.2	31.8	35.6	38.9	41.9	45.6	48.3	26
26.3	28.2	30.3	32.9	36.7	40.1	43.2	47.0	49.6	27
27.3	29.2	31.4	34.0	37.9	41.3	44.5	48.3	51.0	28
28.3	30.3	32.5	35.1	39.1	42.6	45.7	49.6	52.3	29
29.3	31.3	33.5	36.3	40.3	43.8	47.0	50.9	53.7	30
34.3	36.5	38.9	41.8	46.1	49.8	53.2	57.3	60.3	35
39.3	41.6	44.2	47.3	51.8	55.8	59.3	63.7	66.8	40
44.3	46.8	49.5	52.7	57.5	61.7	65.4	70.0	73.2	45
49.3	51.9	54.7	58.2	63.2	67.5	71.4	76.2	79.5	50
74.3	77.5	80.9	85.1	91.1	96.2	100.8	106.4	110.3	75
99.3	102.9	106.9	111.7	118.5	124.3	129.6	135.6	140.2	100

## APPENDIX 3

### Summary of Continuous Statistical Distributions

Type of distribution	Parameters	Probability density function, $f(t)$	Reliability function, $R(t) = 1 - F(t)$	Hazard function (instantaneous failure rate). $h(t) = \frac{f(t)}{R(t)}$
Normal	Mean, $\mu$ Standard deviation, $\sigma$	 $f(t) = \frac{1}{\sigma(2\pi)^{1/2}} \exp\left[-\frac{(t-\mu)^2}{2\sigma^2}\right]$	 $R(t) = \int_t^{\infty} f(t) dt$	 $h(t) = \frac{f(t)}{R(t)} \text{ (general expression)}$
Lognormal	Mean, $\mu$ Standard deviation, $\sigma$	 $f(t) = \frac{1}{\sigma t(2\pi)^{1/2}} \exp\left[-\frac{(\ln t - \mu)^2}{2\sigma^2}\right]$	 $R(t) = \int_t^{\infty} f(t) dt$	 $h(t) = \frac{f(t)}{R(t)} \text{ (general expression)}$
Exponential	Failure rate, $\lambda$ MTBF (=SD), $\theta$ $\theta = \lambda^{-1}$	 $f(t) = \lambda \exp(-\lambda t)$	 $R(t) = \exp(-\lambda t)$	 $h(t) = \lambda = \theta^{-1}$

## APPENDIX 4

### Simulation

Days	3000	3010	3020	3030	3040	3050	3060	3070	3080	3090	3100
Percentage fail	0	0	0	0	0	0	0	0	0	0	0
At 10% threshold	0	0	0	0	0	0	0	0	0	0	0
# of tubes fail	11	12	13	16	19	24	25	26	32	35	40
RL											
TTF	3000	3010	3020	3030	3040	3050	3060	3070	3080	3090	3100
1	1937.337337	0	0	0	0	0	0	0	0	0	0
2	1827.630234	0	0	0	0	0	0	0	0	1	1
3	1896.492805	0	0	0	0	0	0	0	0	0	0
4	1902.235478	0	0	0	0	0	0	0	0	0	0
5	2007.741802	0	0	0	0	0	0	0	0	0	0
6	1940.723476	0	0	0	0	0	0	0	0	0	0
7	1908.319752	0	0	0	0	0	0	0	0	0	0
8	1897.900861	0	0	0	0	0	0	0	0	0	0
9	1921.158199	0	0	0	0	0	0	0	0	0	0
10	1863.53298	0	0	0	0	0	0	0	0	0	0
11	1867.466106	0	0	0	0	0	0	0	0	0	0
12	1972.420731	0	0	0	0	0	0	0	0	0	0
13	1887.577175	0	0	0	0	0	0	0	0	0	0
14	1925.108204	0	0	0	0	0	0	0	0	0	0
15	1805.314859	0	0	0	0	1	1	1	1	1	1
16	1887.805862	0	0	0	0	0	0	0	0	0	0
17	1936.164459	0	0	0	0	0	0	0	0	0	0
18	2032.503408	0	0	0	0	0	0	0	0	0	0
19	1823.228672	0	0	0	0	0	0	0	1	1	1
20	1863.908251	0	0	0	0	0	0	0	0	0	0
21	1794.229061	0	0	0	1	1	1	1	1	1	1
22	1876.166713	0	0	0	0	0	0	0	0	0	0
23	1843.273302	0	0	0	0	0	0	0	0	0	0
24	1947.139175	0	0	0	0	0	0	0	0	0	0
25	1975.821477	0	0	0	0	0	0	0	0	0	0
26	1949.881663	0	0	0	0	0	0	0	0	0	0
27	1868.028614	0	0	0	0	0	0	0	0	0	0
28	1830.706224	0	0	0	0	0	0	0	0	0	1
29	1898.199602	0	0	0	0	0	0	0	0	0	0
30	1858.309257	0	0	0	0	0	0	0	0	0	0
31	1856.673565	0	0	0	0	0	0	0	0	0	0
32	1894.648788	0	0	0	0	0	0	0	0	0	0
33	1776.065278	0	1	1	1	1	1	1	1	1	1
34	1952.988368	0	0	0	0	0	0	0	0	0	0
35	1764.717022	1	1	1	1	1	1	1	1	1	1
36	1941.485437	0	0	0	0	0	0	0	0	0	0
37	1959.738653	0	0	0	0	0	0	0	0	0	0
38	1926.476452	0	0	0	0	0	0	0	0	0	0
39	1872.255825	0	0	0	0	0	0	0	0	0	0
40	1865.648707	0	0	0	0	0	0	0	0	0	0
41	1915.601286	0	0	0	0	0	0	0	0	0	0
42	1929.965773	0	0	0	0	0	0	0	0	0	0
43	1931.924859	0	0	0	0	0	0	0	0	0	0
44	1899.060659	0	0	0	0	0	0	0	0	0	0
45	1900.834771	0	0	0	0	0	0	0	0	0	0
46	1964.131925	0	0	0	0	0	0	0	0	0	0
47	1902.166218	0	0	0	0	0	0	0	0	0	0
48	1821.981325	0	0	0	0	0	0	0	1	1	1
49	1896.887205	0	0	0	0	0	0	0	0	0	0
50	1880.81786	0	0	0	0	0	0	0	0	0	0
51	1904.435587	0	0	0	0	0	0	0	0	0	0
52	1863.69416	0	0	0	0	0	0	0	0	0	0
53	1830.326588	0	0	0	0	0	0	0	0	0	1
54	1920.440945	0	0	0	0	0	0	0	0	0	0
55	1891.523478	0	0	0	0	0	0	0	0	0	0
56	1974.980547	0	0	0	0	0	0	0	0	0	0
57	1765.345584	1	1	1	1	1	1	1	1	1	1
58	1852.72938	0	0	0	0	0	0	0	0	0	0
59	1823.87812	0	0	0	0	0	0	0	0	1	1
60	1924.773798	0	0	0	0	0	0	0	0	0	0
61	2000.439605	0	0	0	0	0	0	0	0	0	0
62	1840.441512	0	0	0	0	0	0	0	0	0	0
63	1842.357806	0	0	0	0	0	0	0	0	0	0
64	1879.264461	0	0	0	0	0	0	0	0	0	0
65	1792.96986	0	0	0	1	1	1	1	1	1	1
66	1994.033918	0	0	0	0	0	0	0	0	0	0
67	1941.52152	0	0	0	0	0	0	0	0	0	0
68	1770.677411	1	1	1	1	1	1	1	1	1	1
69	1867.723943	0	0	0	0	0	0	0	0	0	0
70	1942.249462	0	0	0	0	0	0	0	0	0	0



181	1992.459368	0	0	0	0	0	0	0	0	0	0	0	0
182	1860.419597	0	0	0	0	0	0	0	0	0	0	0	0
183	1896.997424	0	0	0	0	0	0	0	0	0	0	0	0
184	1861.957903	0	0	0	0	0	0	0	0	0	0	0	0
185	1892.63837	0	0	0	0	0	0	0	0	0	0	0	0
186	1870.464143	0	0	0	0	0	0	0	0	0	0	0	0
187	1844.981621	0	0	0	0	0	0	0	0	0	0	0	0
188	1887.308955	0	0	0	0	0	0	0	0	0	0	0	0
189	1914.138212	0	0	0	0	0	0	0	0	0	0	0	0
190	1863.092118	0	0	0	0	0	0	0	0	0	0	0	0
191	1857.233741	0	0	0	0	0	0	0	0	0	0	0	0
192	1878.097109	0	0	0	0	0	0	0	0	0	0	0	0
193	1800.902983	0	0	0	0	0	1	1	1	1	1	1	1
194	1799.387678	0	0	0	0	1	1	1	1	1	1	1	1
195	1857.269446	0	0	0	0	0	0	0	0	0	0	0	0
196	1979.445368	0	0	0	0	0	0	0	0	0	0	0	0
197	1861.537744	0	0	0	0	0	0	0	0	0	0	0	0
198	1934.998137	0	0	0	0	0	0	0	0	0	0	0	0
199	1710.079398	1	1	1	1	1	1	1	1	1	1	1	1
200	1887.210472	0	0	0	0	0	0	0	0	0	0	0	0
201	1937.051677	0	0	0	0	0	0	0	0	0	0	0	0
202	1927.257978	0	0	0	0	0	0	0	0	0	0	0	0
203	1857.587671	0	0	0	0	0	0	0	0	0	0	0	0
204	1838.956312	0	0	0	0	0	0	0	0	0	0	0	0
205	1839.259347	0	0	0	0	0	0	0	0	0	0	0	0
206	1855.020023	0	0	0	0	0	0	0	0	0	0	0	0
207	1969.072386	0	0	0	0	0	0	0	0	0	0	0	0
208	1881.389033	0	0	0	0	0	0	0	0	0	0	0	0
209	1841.56013	0	0	0	0	0	0	0	0	0	0	0	0
210	1898.295726	0	0	0	0	0	0	0	0	0	0	0	0
211	1726.693632	1	1	1	1	1	1	1	1	1	1	1	1
212	2005.870768	0	0	0	0	0	0	0	0	0	0	0	0
213	1895.079436	0	0	0	0	0	0	0	0	0	0	0	0
214	2011.780214	0	0	0	0	0	0	0	0	0	0	0	0
215	1976.397082	0	0	0	0	0	0	0	0	0	0	0	0
216	1872.853986	0	0	0	0	0	0	0	0	0	0	0	0
217	1899.919735	0	0	0	0	0	0	0	0	0	0	0	0
218	1924.720689	0	0	0	0	0	0	0	0	0	0	0	0
219	1861.804418	0	0	0	0	0	0	0	0	0	0	0	0
220	1821.251564	0	0	0	0	0	0	0	0	1	1	1	1
221	1954.930745	0	0	0	0	0	0	0	0	0	0	0	0
222	1863.63574	0	0	0	0	0	0	0	0	0	0	0	0
223	1900.70563	0	0	0	0	0	0	0	0	0	0	0	0
224	2000.978141	0	0	0	0	0	0	0	0	0	0	0	0
225	1890.8856	0	0	0	0	0	0	0	0	0	0	0	0
226	1941.101087	0	0	0	0	0	0	0	0	0	0	0	0
227	1908.631432	0	0	0	0	0	0	0	0	0	0	0	0
228	1911.055758	0	0	0	0	0	0	0	0	0	0	0	0
229	1864.11891	0	0	0	0	0	0	0	0	0	0	0	0
230	1870.584463	0	0	0	0	0	0	0	0	0	0	0	0
231	1908.045676	0	0	0	0	0	0	0	0	0	0	0	0
232	1914.975581	0	0	0	0	0	0	0	0	0	0	0	0
233	1941.8126	0	0	0	0	0	0	0	0	0	0	0	0
234	1856.93067	0	0	0	0	0	0	0	0	0	0	0	0
235	1890.706136	0	0	0	0	0	0	0	0	0	0	0	0
236	1817.084111	0	0	0	0	0	0	0	1	1	1	1	1
237	1916.187151	0	0	0	0	0	0	0	0	0	0	0	0
238	1878.985144	0	0	0	0	0	0	0	0	0	0	0	0
239	2015.587872	0	0	0	0	0	0	0	0	0	0	0	0
240	1907.230419	0	0	0	0	0	0	0	0	0	0	0	0
241	1822.787379	0	0	0	0	0	0	0	0	1	1	1	1
242	1933.160479	0	0	0	0	0	0	0	0	0	0	0	0
243	1874.691897	0	0	0	0	0	0	0	0	0	0	0	0
244	1866.376192	0	0	0	0	0	0	0	0	0	0	0	0
245	1953.563179	0	0	0	0	0	0	0	0	0	0	0	0
246	1933.654327	0	0	0	0	0	0	0	0	0	0	0	0
247	1955.153634	0	0	0	0	0	0	0	0	0	0	0	0
248	1982.427377	0	0	0	0	0	0	0	0	0	0	0	0
249	1928.7553	0	0	0	0	0	0	0	0	0	0	0	0
250	1825.633863	0	0	0	0	0	0	0	0	0	0	1	1
251	1731.012843	1	1	1	1	1	1	1	1	1	1	1	1
252	1831.204105	0	0	0	0	0	0	0	0	0	0	0	1
253	1790.849938	0	0	0	1	1	1	1	1	1	1	1	1
254	1903.348068	0	0	0	0	0	0	0	0	0	0	0	0
255	1909.825742	0	0	0	0	0	0	0	0	0	0	0	0
256	1935.441948	0	0	0	0	0	0	0	0	0	0	0	0
257	1847.096769	0	0	0	0	0	0	0	0	0	0	0	0
258	1956.105883	0	0	0	0	0	0	0	0	0	0	0	0
259	1866.558811	0	0	0	0	0	0	0	0	0	0	0	0
260	1928.727245	0	0	0	0	0	0	0	0	0	0	0	0
261	1923.300582	0	0	0	0	0	0	0	0	0	0	0	0
262	1875.688873	0	0	0	0	0	0	0	0	0	0	0	0
263	1850.514102	0	0	0	0	0	0	0	0	0	0	0	0
264	1839.809507	0	0	0	0	0	0	0	0	0	0	0	0
265	1952.866219	0	0	0	0	0	0	0	0	0	0	0	0
266	1971.662174	0	0	0	0	0	0	0	0	0	0	0	0
267	1890.776073	0	0	0	0	0	0	0	0	0	0	0	0
268	1799.431124	0	0	0	0	1	1	1	1	1	1	1	1
269	1903.0993	0	0	0	0	0	0	0	0	0	0	0	0
270	1850.80664	0	0	0	0	0	0	0	0	0	0	0	0
271	1818.243276	0	0	0	0	0	0	0	0	1	1	1	1
272	1875.968466	0	0	0	0	0	0	0	0	0	0	0	0
273	1882.986507	0	0	0	0	0	0	0	0	0	0	0	0
274	1939.315456	0	0	0	0	0	0	0	0	0	0	0	0
275	1934.012716	0	0	0	0	0	0	0	0	0	0	0	0
276	1807.459317	0	0	0	0	0	0	1	1	1	1	1	1
277	1886.916443	0	0	0	0	0	0	0	0	0	0	0	0
278	1914.277898	0	0	0	0	0	0	0	0	0	0	0	0
279	1950.289958	0	0	0	0	0	0	0	0	0	0	0	0
280	1856.75146	0	0	0	0	0	0	0	0	0	0	0	0
281	1974.327914	0	0	0	0	0	0	0	0	0	0	0	0
282	1819.774589	0	0	0	0	0	0	0	0	1	1	1	1
283	1890.968976	0	0	0	0	0	0	0	0	0	0	0	0
284	1918.511054	0	0	0	0	0	0	0	0	0	0	0	0
285	1916.85956	0	0	0	0	0	0	0	0	0	0	0	0
286	1940.493404	0	0	0	0	0	0	0	0	0	0	0	0
287	1878.312119	0	0	0	0	0	0	0	0	0	0	0	0
288	1918.7069	0	0	0	0	0	0	0	0	0	0	0	0

Days Iteration	3000	3010	3020	3030	3040	3050	3060	3070	3080	3090	3100	At 10% threshold
1	0	0	0	0	0	0	1	1	1	1	1	3050
2	0	0	0	0	0	0	0	1	1	1	1	3070
3	0	0	0	0	0	0	0	1	1	1	1	3070
4	0	0	0	0	0	0	0	1	1	1	1	3060
5	0	0	0	0	0	0	0	1	1	1	1	3070
6	0	0	0	0	0	0	1	1	1	1	1	3050
7	0	0	0	0	1	1	1	1	1	1	1	3040
8	0	0	0	0	0	0	1	1	1	1	1	3060
9	0	0	0	0	1	1	1	1	1	1	1	3040
10	0	0	0	0	0	0	0	0	0	1	1	3090
11	0	0	0	0	0	0	0	1	1	1	1	3060
12	0	0	0	0	0	0	1	1	1	1	1	3050
13	0	0	0	0	0	0	1	1	1	1	1	3050
14	0	0	0	0	0	0	0	1	1	1	1	3060
15	0	0	0	0	0	0	0	0	1	1	1	3080
16	0	0	0	0	0	0	0	1	1	1	1	3060
17	0	0	0	0	0	0	0	1	1	1	1	3060
18	0	0	0	0	0	0	0	1	1	1	1	3070
19	0	0	0	0	0	0	0	0	1	1	1	3070
20	0	0	0	0	0	0	0	1	1	1	1	3060
21	0	0	0	0	0	0	0	0	1	1	1	3070
22	0	0	0	0	0	0	0	0	1	1	1	3080
23	0	0	0	0	0	0	0	0	1	1	1	3070
24	0	0	0	0	0	0	0	1	1	1	1	3060
25	0	0	0	0	1	1	1	1	1	1	1	3040
26	0	0	0	0	0	0	0	0	0	1	1	3090
27	0	0	0	0	0	0	0	1	1	1	1	3060
28	0	0	0	0	0	0	0	0	1	1	1	3070
29	0	0	0	0	0	0	0	1	1	1	1	3060
30	0	0	0	0	0	0	0	0	1	1	1	3070
31	0	0	0	0	0	0	0	1	1	1	1	3070
32	0	0	0	0	0	0	0	0	0	1	1	3090
33	0	0	0	0	0	0	0	1	1	1	1	3060
34	0	0	0	0	0	0	0	1	1	1	1	3060
35	0	0	0	0	0	0	0	1	1	1	1	3060
36	0	0	0	0	0	0	0	1	1	1	1	3060
37	0	0	0	0	0	0	0	0	0	1	1	3080
38	0	0	0	0	0	0	0	1	1	1	1	3060
39	0	0	0	0	0	0	0	0	1	1	1	3070
40	0	0	0	0	0	0	0	1	1	1	1	3060
41	0	0	0	0	0	0	0	0	1	1	1	3070
42	0	0	0	0	0	1	1	1	1	1	1	3040
43	0	0	0	0	0	0	0	1	1	1	1	3060
44	0	0	0	0	0	0	0	0	0	1	1	3080
45	0	0	0	0	0	0	0	1	1	1	1	3060
46	0	0	0	0	0	0	0	1	1	1	1	3060
47	0	0	0	0	0	0	0	0	1	1	1	3070
48	0	0	0	0	0	0	1	1	1	1	1	3050
49	0	0	0	0	0	0	0	0	0	1	1	3080
50	0	0	0	0	0	0	0	1	1	1	1	3060
51	0	0	0	0	0	0	1	1	1	1	1	3050
52	0	0	0	0	0	0	0	1	1	1	1	3060
53	0	0	0	0	0	0	0	0	1	1	1	3070
54	0	0	0	0	0	0	0	0	0	1	1	3080
55	0	0	0	0	0	0	0	1	1	1	1	3060
56	0	0	0	0	0	0	0	0	1	1	1	3070
57	0	0	0	0	0	0	1	1	1	1	1	3050
58	0	0	0	0	0	0	1	1	1	1	1	3050
59	0	0	0	0	0	0	1	1	1	1	1	3050
60	0	0	0	0	0	0	0	1	1	1	1	3060
61	0	0	0	0	0	0	0	0	0	1	1	3080
62	0	0	0	0	0	0	0	1	1	1	1	3060
63	0	0	0	0	0	0	0	0	1	1	1	3070
64	0	0	0	0	0	0	0	0	1	1	1	3080
65	0	0	0	0	0	0	0	1	1	1	1	3060
66	0	0	0	0	0	0	0	0	1	1	1	3070
67	0	0	0	0	0	0	0	0	1	1	1	3070
68	0	0	0	0	0	0	0	1	1	1	1	3060
69	0	0	0	0	0	0	0	0	1	1	1	3070
70	0	0	0	0	0	0	0	1	1	1	1	3060
71	0	0	0	0	0	0	0	1	1	1	1	3060
72	0	0	0	0	0	0	0	0	1	1	1	3070
73	0	0	0	0	0	0	0	1	1	1	1	3060
74	0	0	0	0	0	0	0	1	1	1	1	3060
75	0	0	0	0	0	0	0	1	1	1	1	3060
76	0	0	0	0	0	0	0	0	0	1	1	3090
77	0	0	0	0	0	0	0	1	1	1	1	3060
78	0	0	0	0	0	0	0	1	1	1	1	3060
79	0	0	0	0	0	0	0	1	1	1	1	3060
80	0	0	0	0	0	0	0	0	1	1	1	3070
81	0	0	0	0	0	0	0	1	1	1	1	3060
82	0	0	0	0	0	0	1	1	1	1	1	3050
83	0	0	0	0	0	0	0	1	1	1	1	3060
84	0	0	0	0	0	0	0	0	0	1	1	3080
85	0	0	0	0	0	0	0	0	1	1	1	3080
86	0	0	0	0	0	0	0	1	1	1	1	3060
87	0	0	0	0	0	0	0	0	0	1	1	3080
88	0	0	0	0	0	0	0	0	1	1	1	3070
89	0	0	0	0	0	0	0	0	1	1	1	3070
90	0	0	0	0	0	0	1	1	1	1	1	3050
91	0	0	0	0	0	0	0	0	1	1	1	3070
92	0	0	0	0	0	1	1	1	1	1	1	3040



93	0	0	0	0	0	0	0	1	1	1	1	3070
94	0	0	0	0	0	0	0	1	1	1	1	3060
95	0	0	0	0	0	0	0	1	1	1	1	3060
96	0	0	0	0	0	0	0	1	1	1	1	3060
97	0	0	0	0	0	0	0	0	1	1	1	3070
98	0	0	0	0	0	0	0	0	1	1	1	3070
99	0	0	0	0	0	0	0	1	1	1	1	3060
100	0	0	0	0	0	0	0	1	1	1	1	3060
101	0	0	0	0	0	0	1	1	1	1	1	3050
102	0	0	0	0	0	0	0	0	1	1	1	3070
103	0	0	0	0	0	0	0	1	1	1	1	3060
104	0	0	0	0	0	0	0	0	0	1	1	3080
105	0	0	0	0	0	0	0	0	1	1	1	3070
106	0	0	0	0	0	0	0	0	1	1	1	3070
107	0	0	0	0	0	0	1	1	1	1	1	3050
108	0	0	0	0	0	0	0	0	1	1	1	3070
109	0	0	0	0	0	0	1	1	1	1	1	3060
110	0	0	0	0	0	0	1	1	1	1	1	3050
111	0	0	0	0	0	0	0	1	1	1	1	3070
112	0	0	0	0	0	0	0	0	1	1	1	3070
113	0	0	0	0	0	0	0	0	1	1	1	3070
114	0	0	0	0	0	0	0	0	1	1	1	3080
115	0	0	0	0	0	0	0	1	1	1	1	3060
116	0	0	0	0	0	0	0	0	1	1	1	3070
117	0	0	0	0	0	0	0	1	1	1	1	3060
118	0	0	0	0	0	0	0	0	1	1	1	3070
119	0	0	0	0	0	0	0	1	1	1	1	3060
120	0	0	0	0	0	0	0	1	1	1	1	3060
121	0	0	0	0	0	0	0	1	1	1	1	3060
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697	0	0	0	0	0	0	0	0	0	1	1	3080
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700	0	0	0	0	0	0	0	1	1	1	1	3060
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702	0	0	0	0	0	1	1	1	1	1	1	3040
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997	0	0	0	0	0	0	0	0	0	1	1	1	3080
998	0	0	0	0	0	1	1	1	1	1	1	1	3050
999	0	0	0	0	0	0	0	0	1	1	1	1	3070
1000	0	0	0	0	0	0	0	0	0	1	1	1	3080