# Addressing Failures in Molten Salt Thermal Energy Storage Tank for Central Receiver Concentrating Solar Power Plants

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# Central receiver CPS Plants

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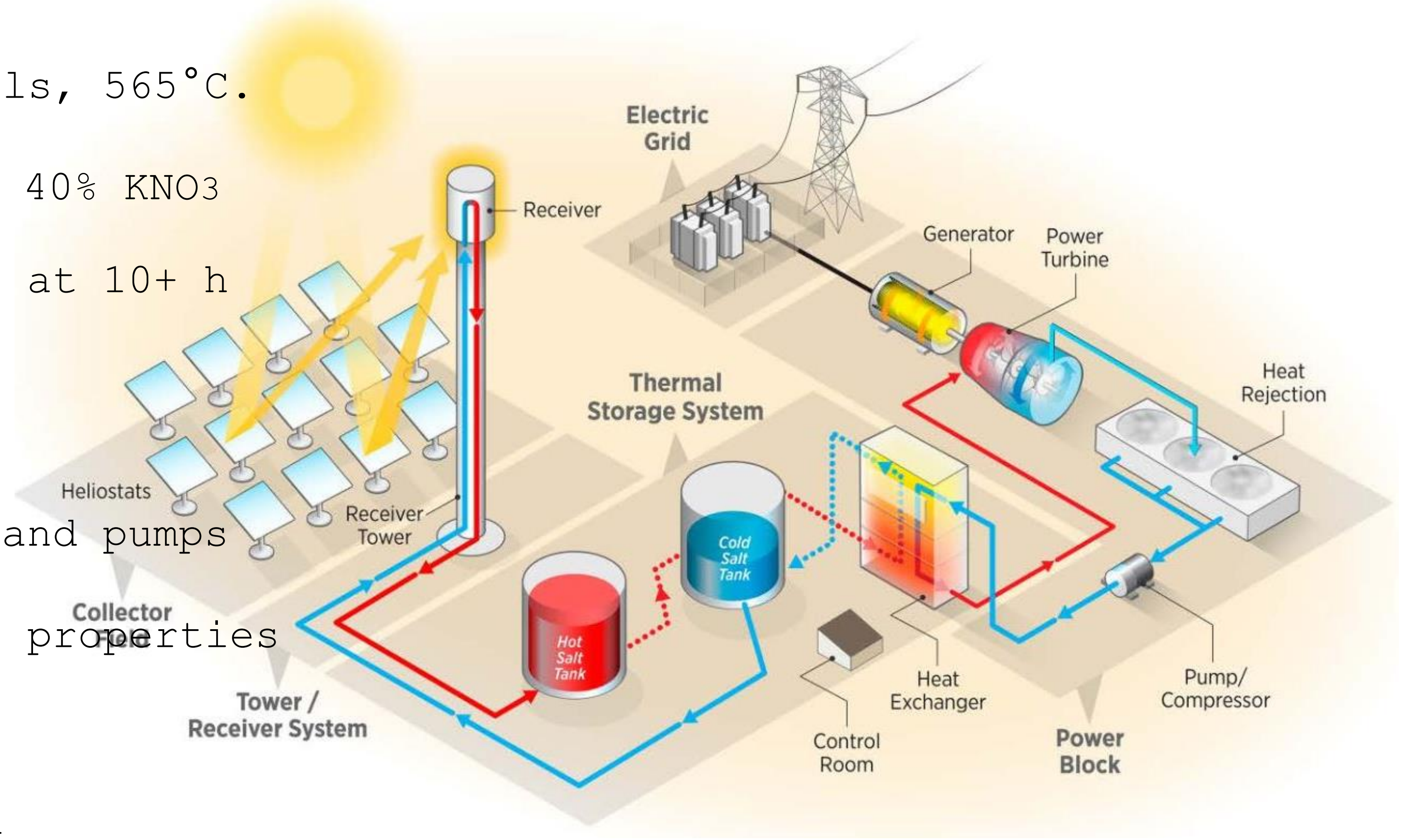
## Molten Salt Thermal Energy Storage

- Hot tank: 347H stainless steels, 565°C.
- Salt composition: 60% $NaNO_3$ – 40% $KNO_3$
- Commercial GWh energy storage at 10+ h duration
- Low capex
- Existing industry for valves and pumps
- Well-understood heat transfer properties
- Increase in capacity factors
- Levelized cost of Electricity
- Lower intermittent operation for the

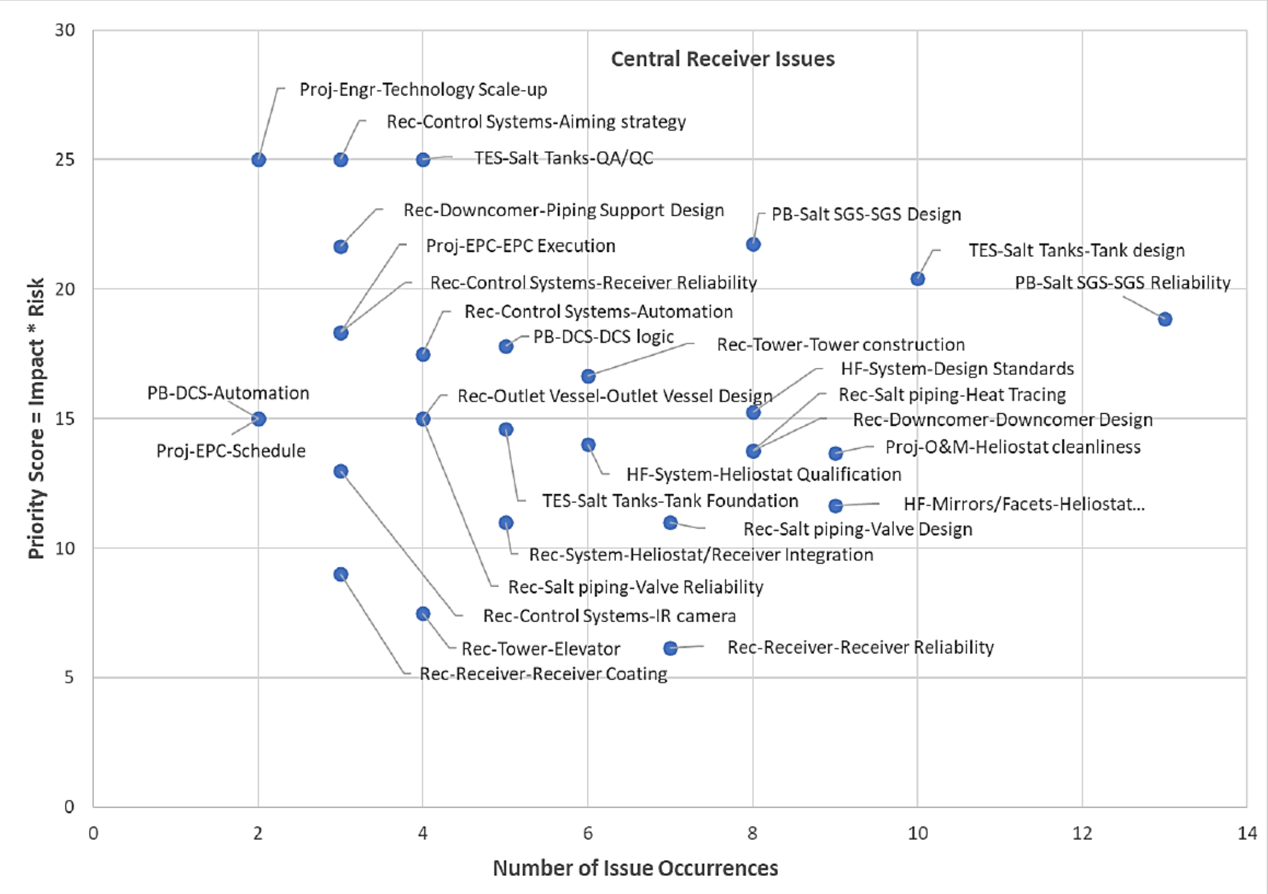



[Gen2 CSP Plant. Central Receiver, two-tank molten salt thermal energy storage, steam-Rankine power generation cycle]

# Problem Definition / Motivation

**Several Failures have occurred in molten salt tanks in commercial CSP Plants around the world**

[Crescent Dunes CSP Plant, Tonopah, NV]




[Mehos et al. 2020. Concentrating Solar Power Best Practices Study. NREL/TP-5500-75763]

In general, in-service hot tanks in the CSP industry have been generally designed based on American Petroleum Institute's (API) 650 and ASME BPVC Section II standards.

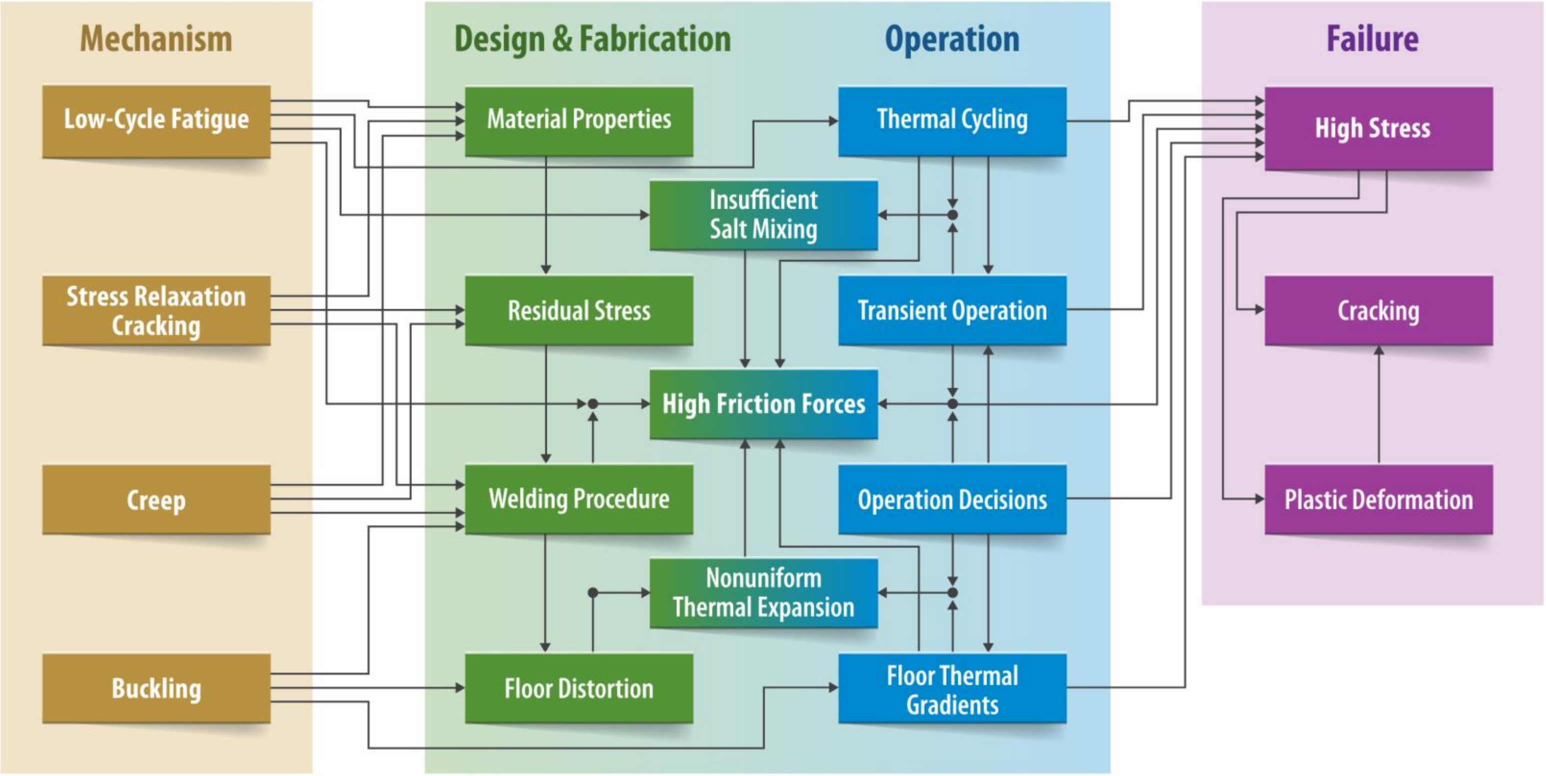
**API 650** → Guidelines about dimensions and fabrication for oil storage tanks up to 260°C.

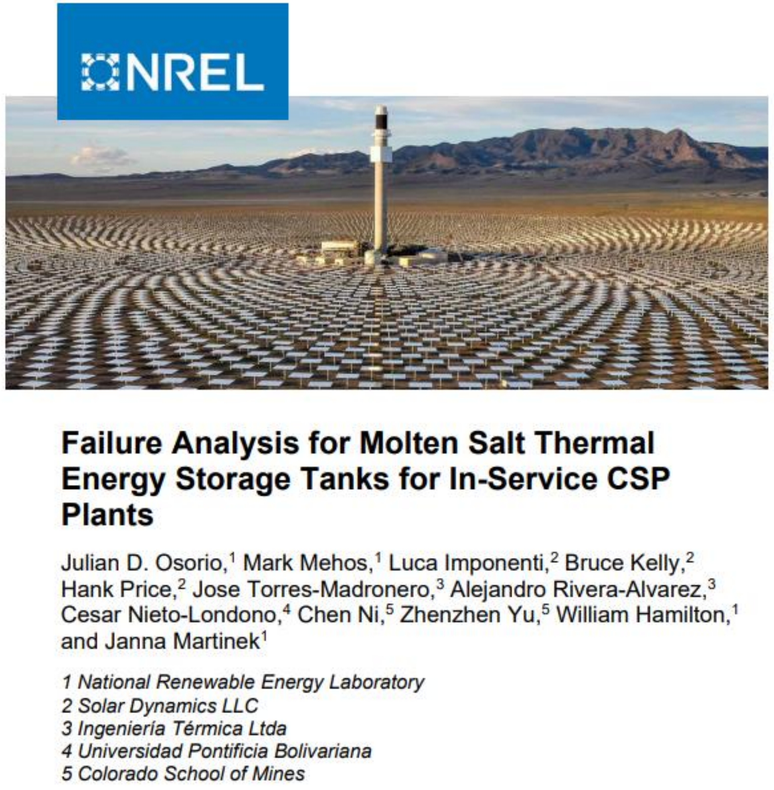
**ASME BPVC Section II** → Allowable stress values for various materials at a range of temperatures and conditions

***API 650 and ASME BPVC Section II seem to be limited for hot tanks design where high temperatures, thermal cycling, and transient conditions are expected!***

# Problem Definition / Motivation

Project 38475 – "Failure Analysis of Molten salt Thermal energy storage tanks for in-service CSP plant"

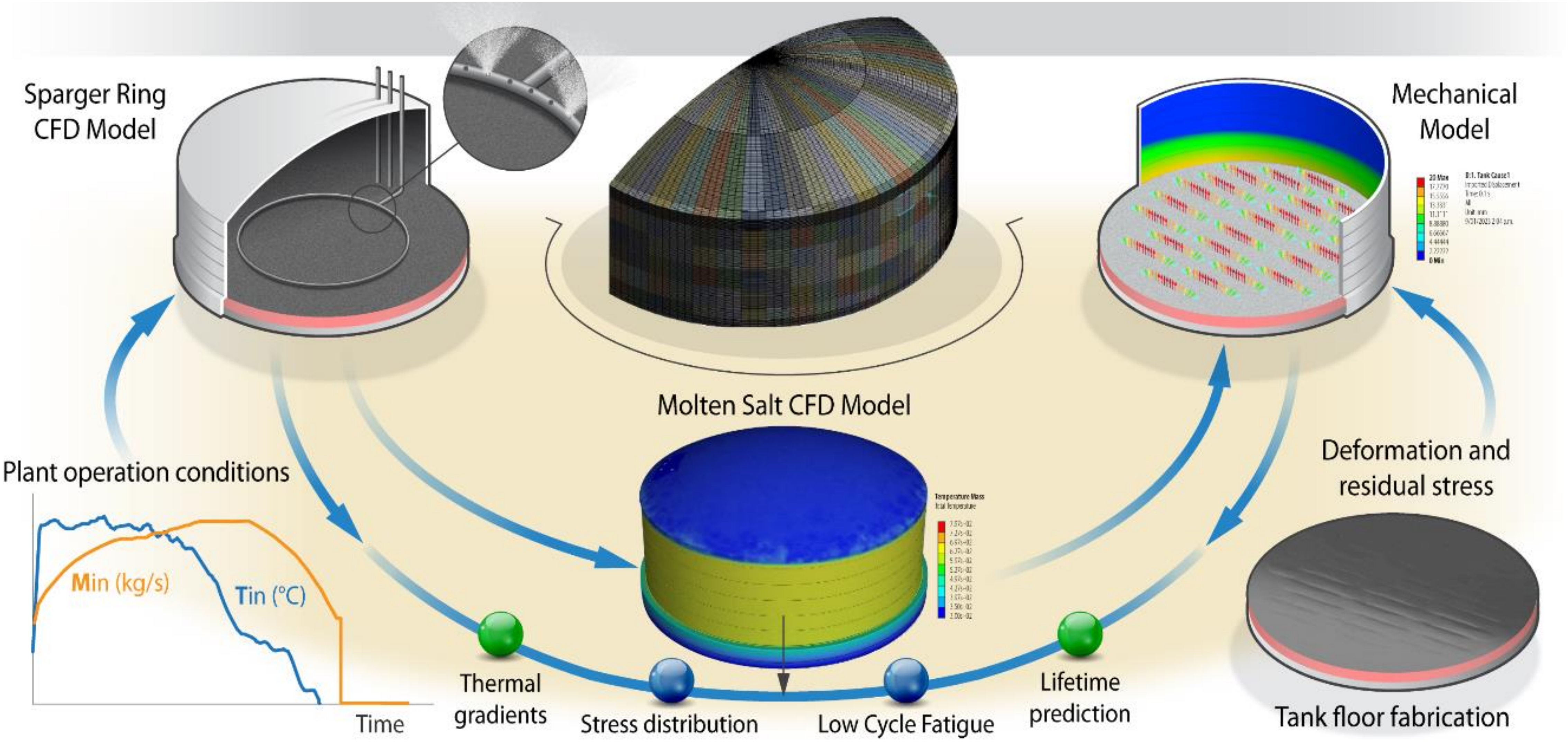



nrel.gov/docs/fy24osti/89036.pdf

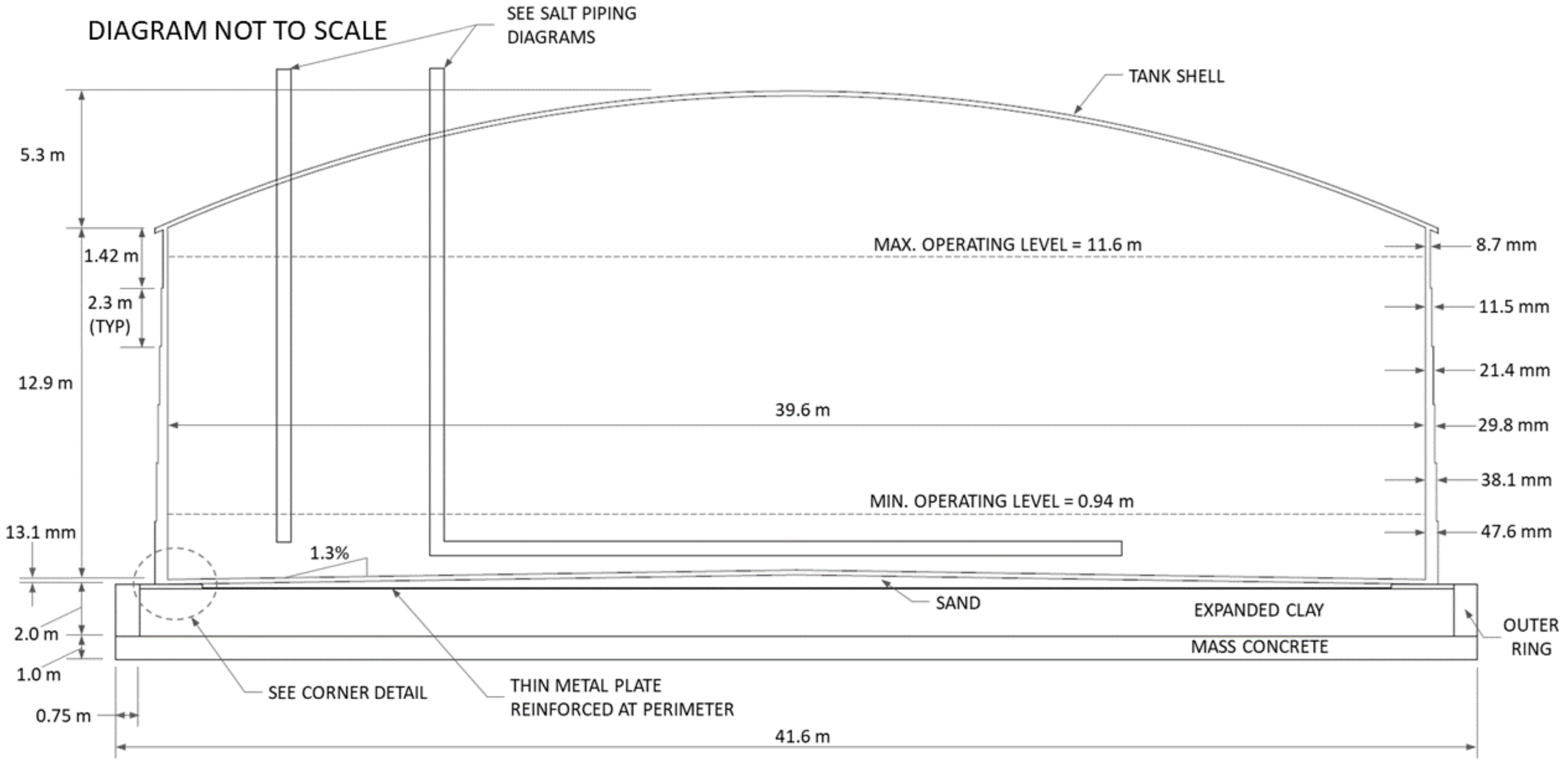
Most tank **failures** have **occurred in the tank floor** and are mainly associated with **improper design** and **fabrication procedures** of the floor, leading to **high residual stresses** after welding fabrication, **high stress** during operation, stress relaxation cracking (SRC), buckling, and creep

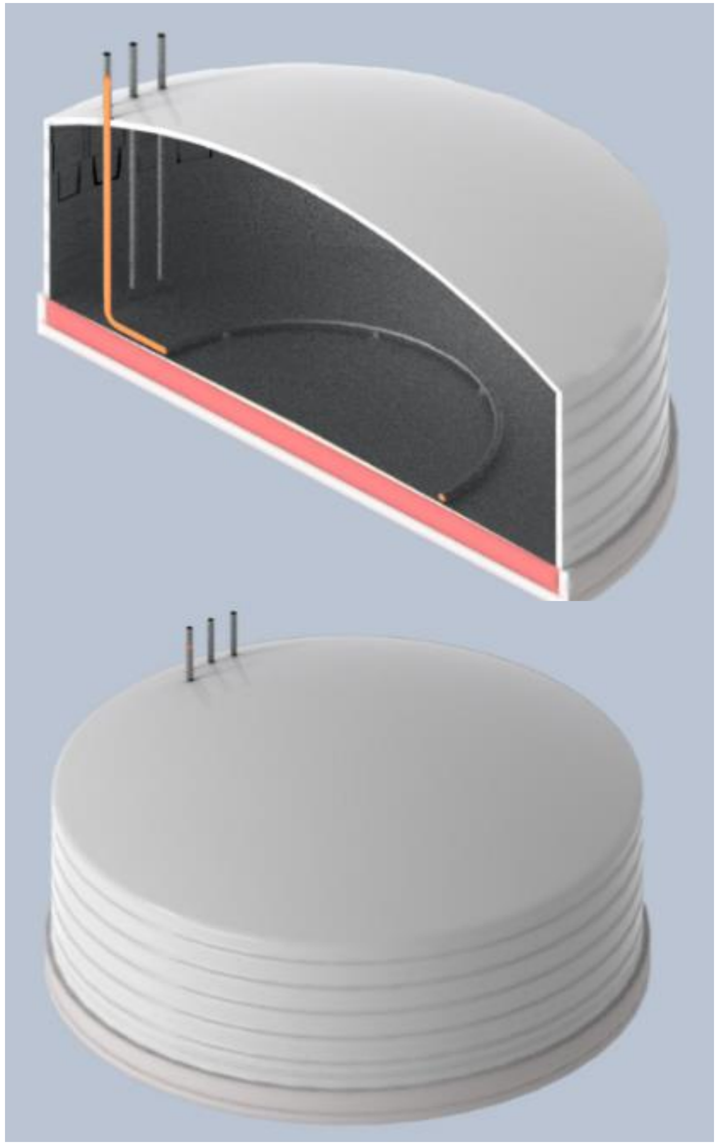
# Molten Salt Hot Tank Modeling




The hot tank model has been validated. It incorporates computational fluid dynamics (CFD) models for the sparger ring and molten salt and a mechanical model for the tank shell and floor.

# Representative Tank Design



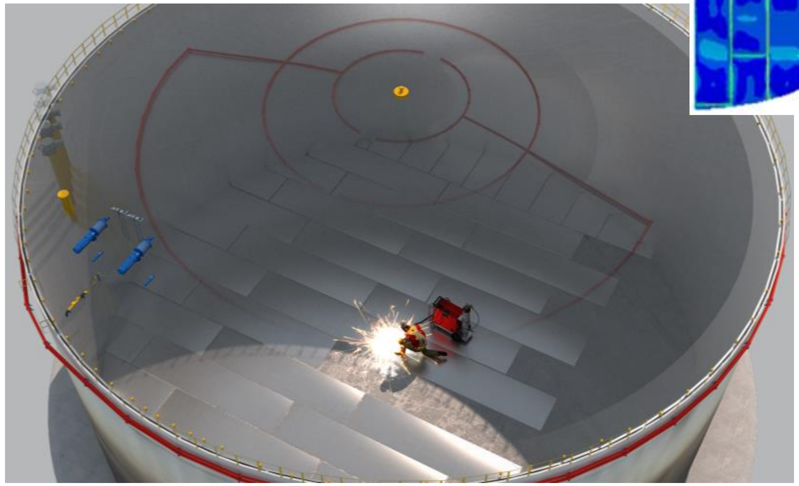
Dimensions are representative several existing hot tank designs

# Tank Floor Fabrication Modeling

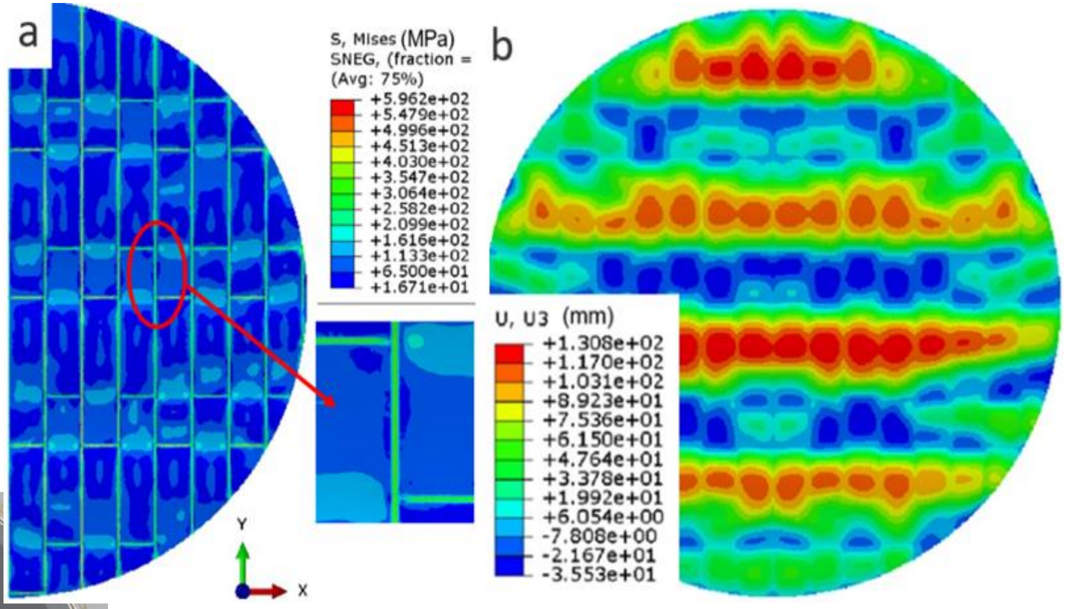
The tank floor is the most critical component due to the large loads and friction forces between floor and foundation during cycle operation.

High stresses have a negative impact on the tank lifetime.

Under current fabrication procedures and implementation practices followed by industry, the floor fabrication and tank commissioning usually result in plastic deformations and high residual stresses

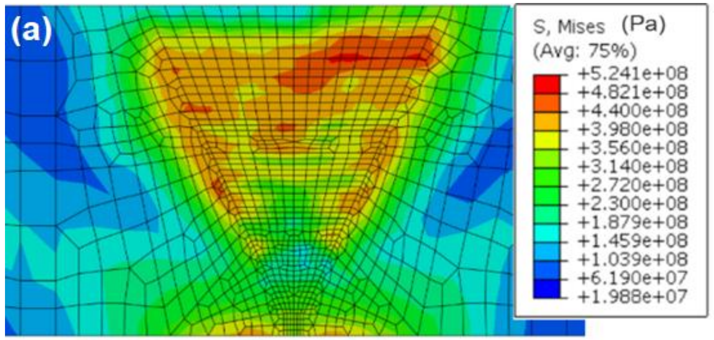


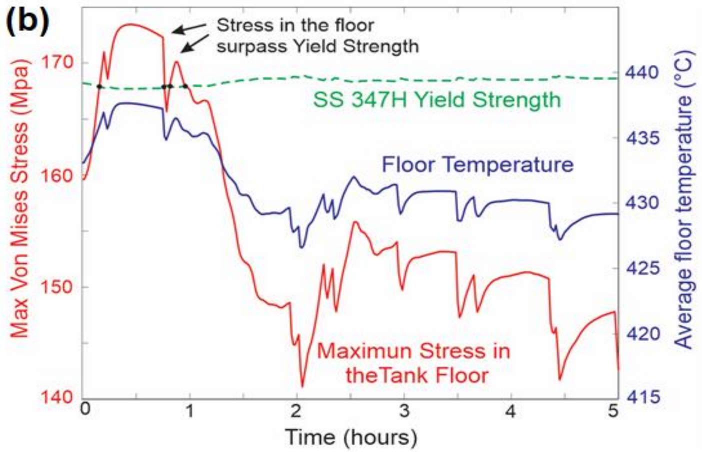
The floor is typically fabricated from several thin rectangular plates that are welded together.




a) Von Mises stress (half floor),
b) floor plastic deformation

Under current floor design, fabrication, and operation **our model predicts a lifetime lower than 3 years!**



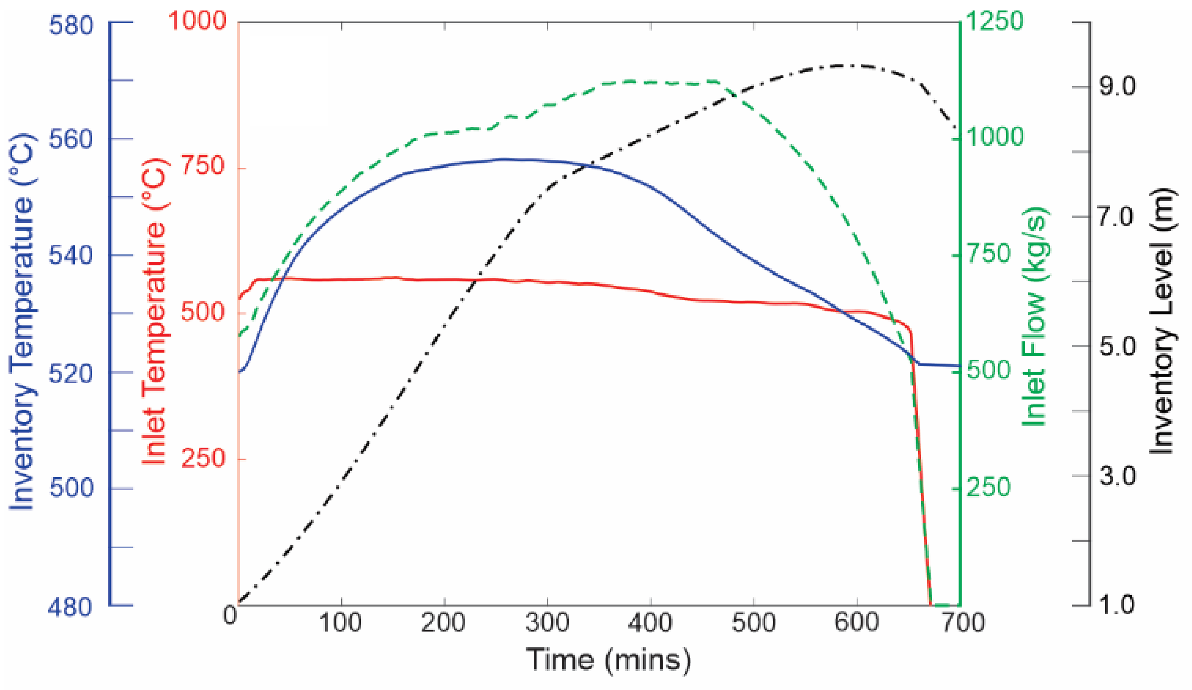




(a) Residual stresses in the floor after fabrication;
(b) Maximum stress in the floor during operation.

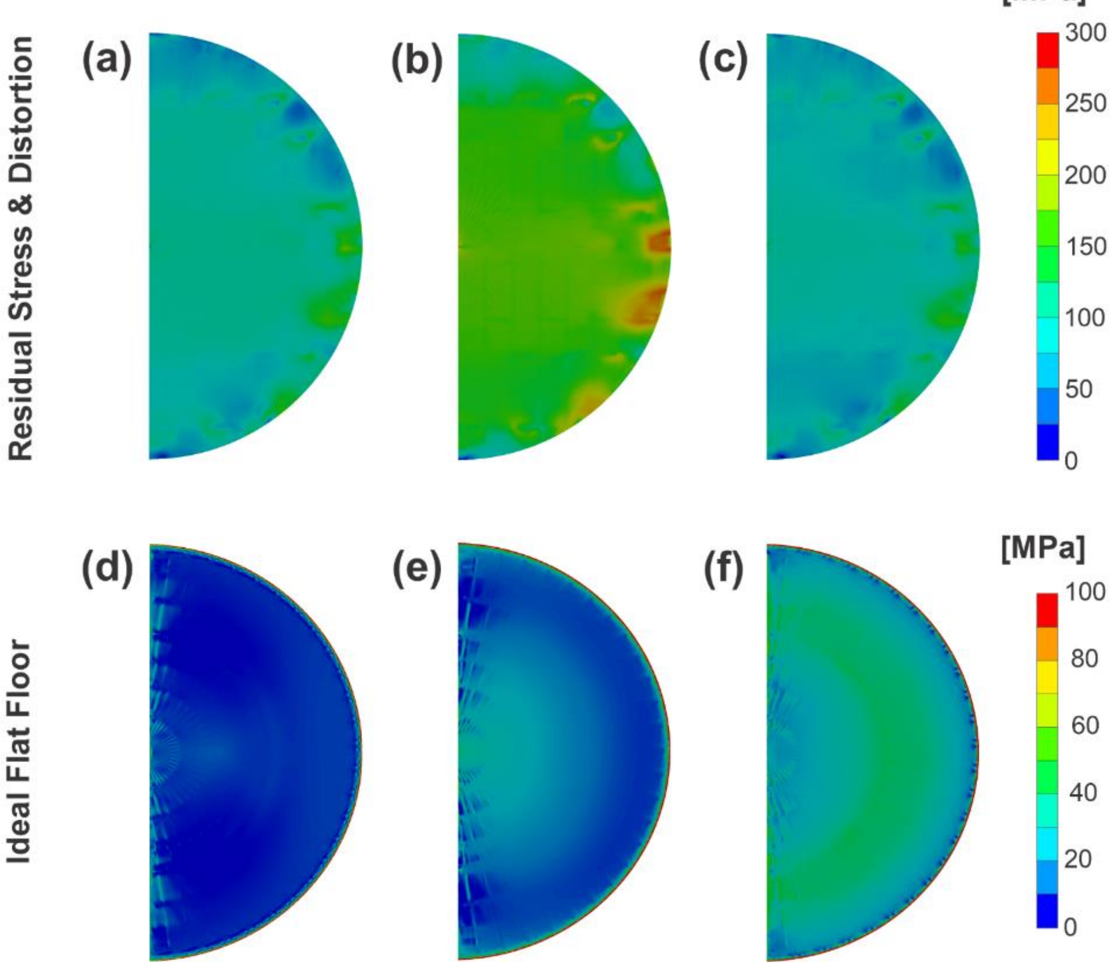
**Failures in current plants have occurred in less than 3 years of operation!!**

# Stress Distribution in the Tank Floor

Comparison in stress in the tank floor. (a-c) Residual stress & distortion considered. (d-f) Flat floor



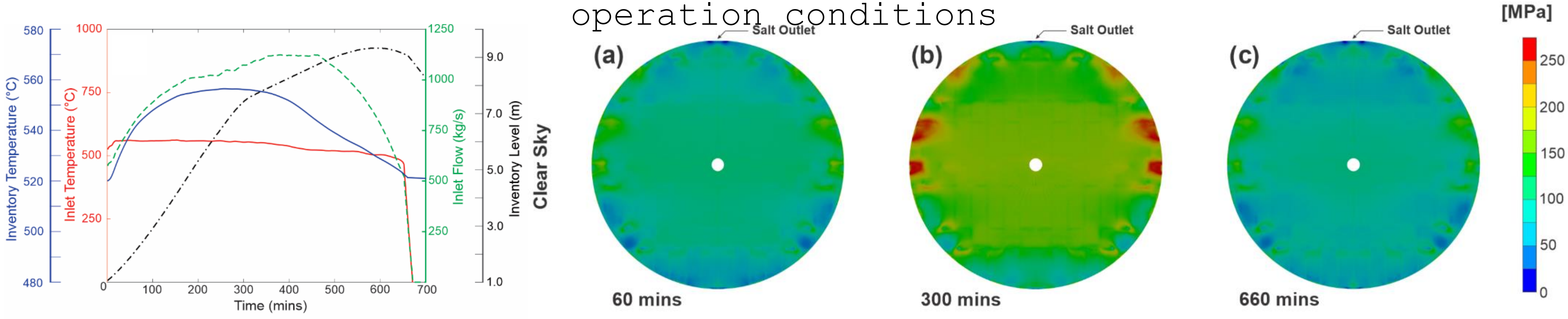

Boundary conditions: Inlet salt mass flow rate and inlet molten salt temperature. Molten salt inventory level and temperature.

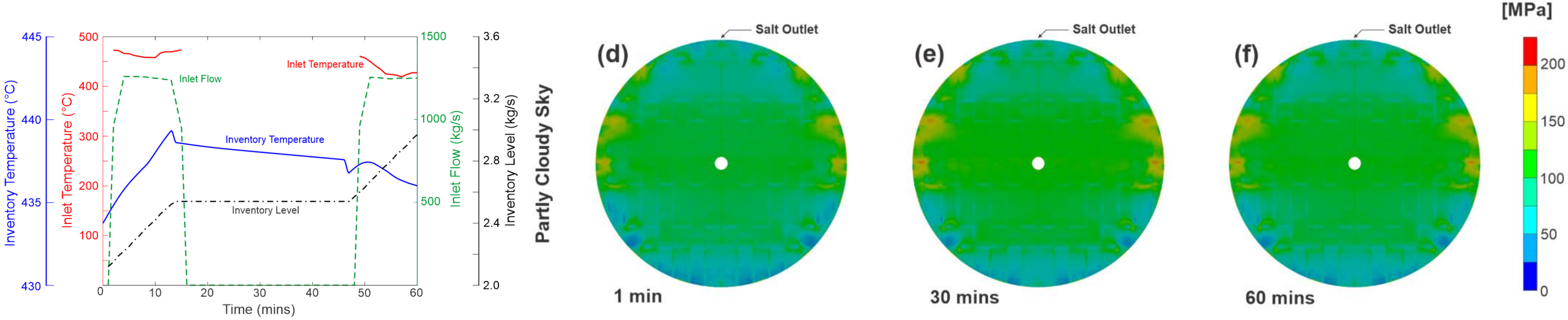



Friction coefficient = 0.5

# Stress Distribution in the Tank Floor

Von Mises Stress contours. (a-c) Clear sky and (d-f) Partly cloudy sky operation conditions

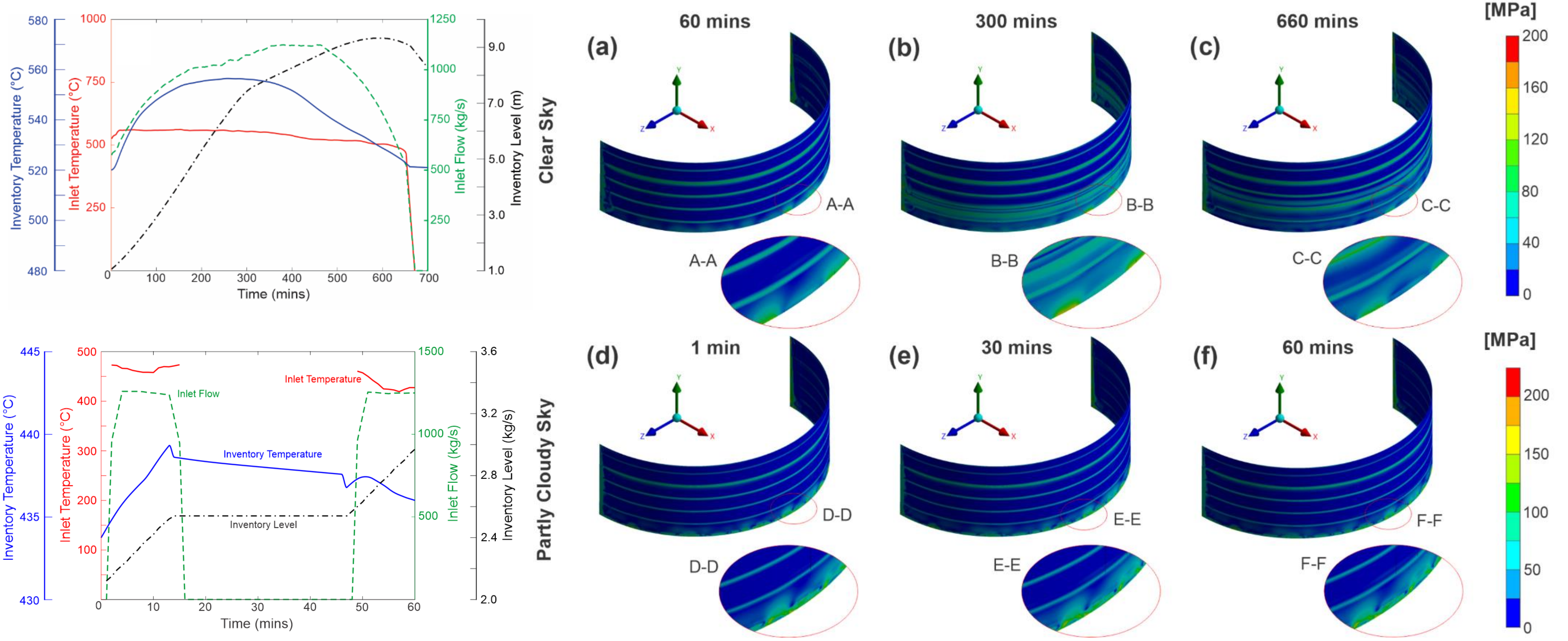



Friction coefficient = 0.5

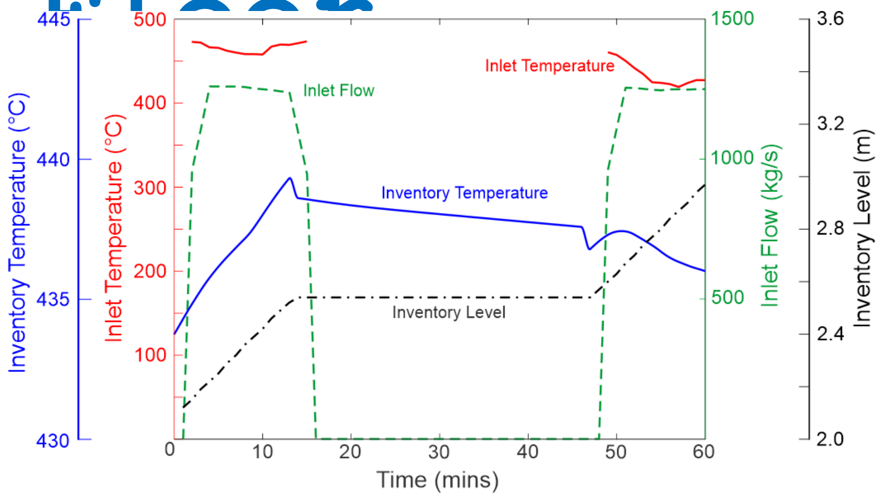
# Stress Distribution in the Ta
# Shell

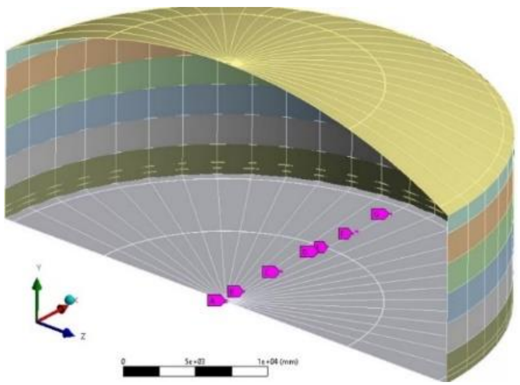
Von Mises Stress contours. (a-c) Clear sky and (d-f) Partly cloudy sky

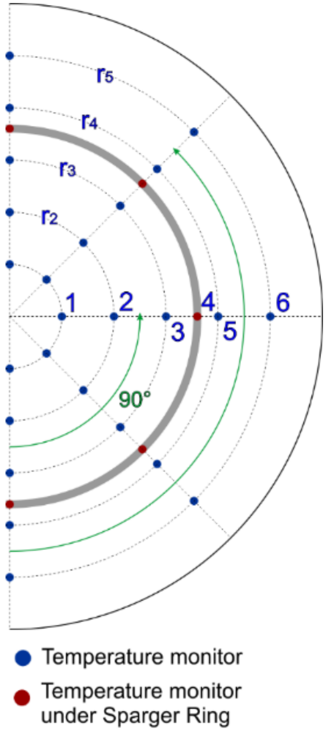



Friction coefficient = 0.5

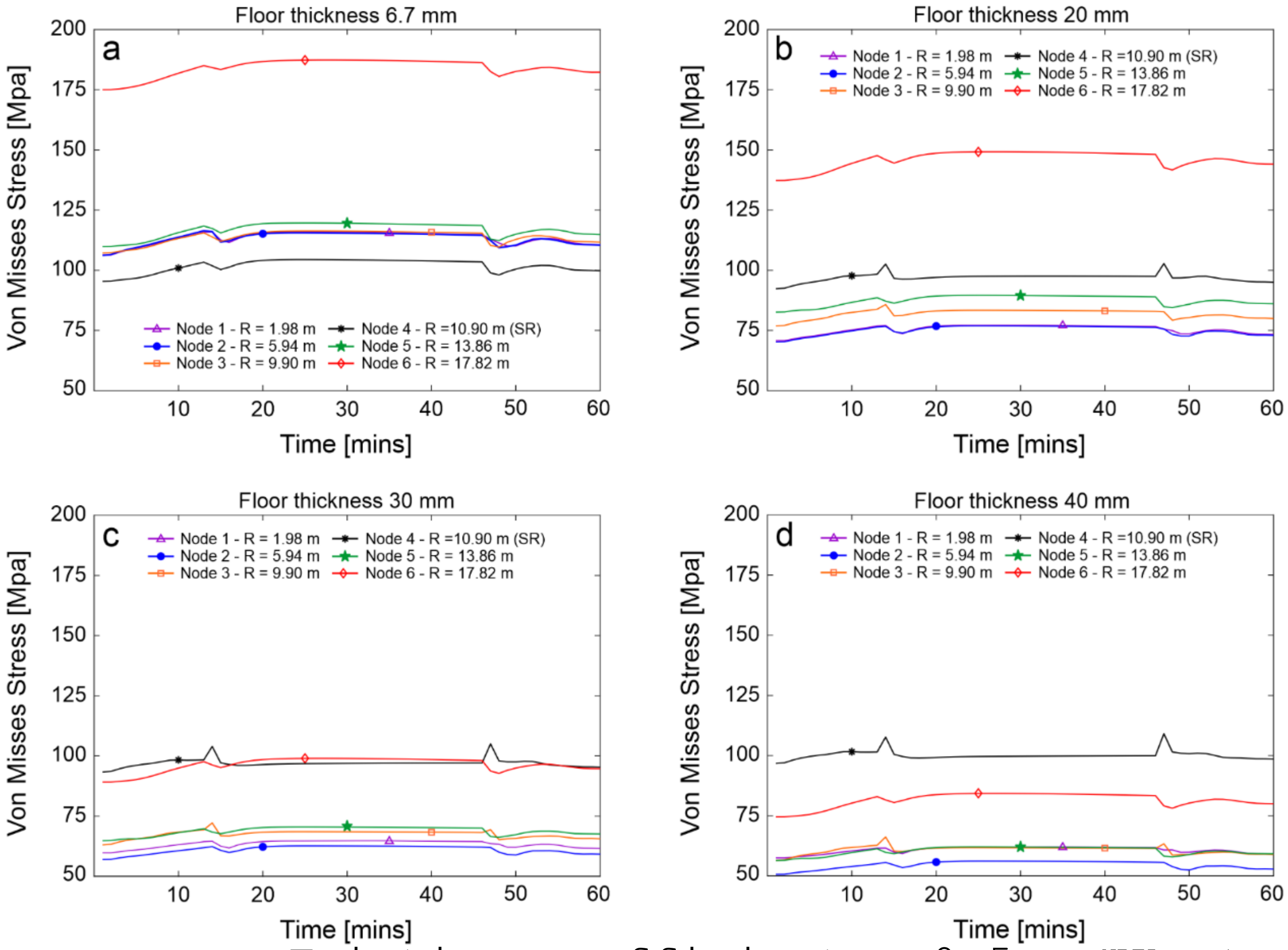
# Stress Distribution in the Tank Floor



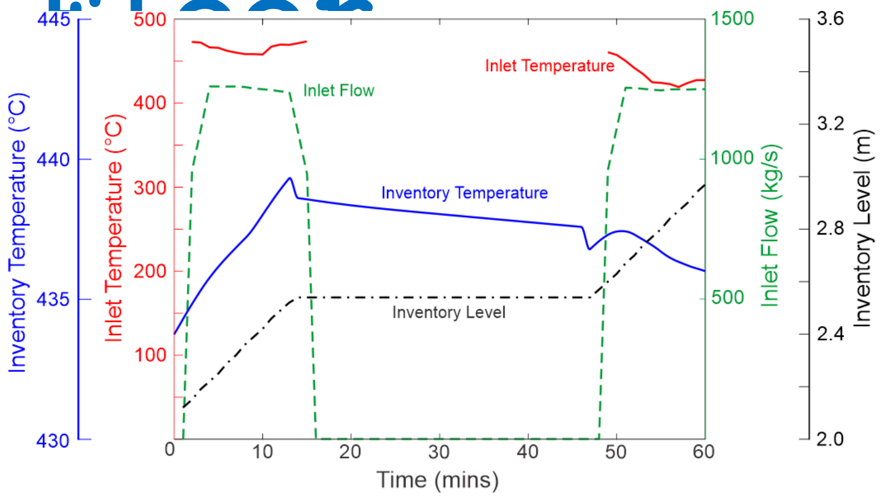


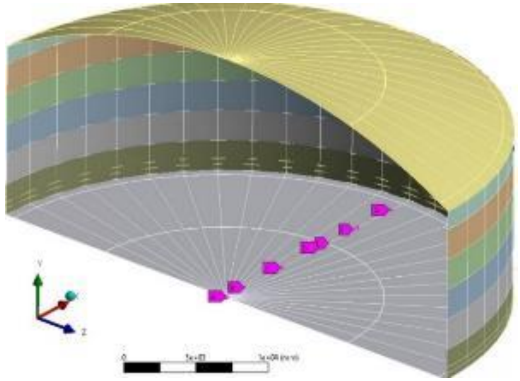

Stress evolution in the tank floor for different floor thicknesses

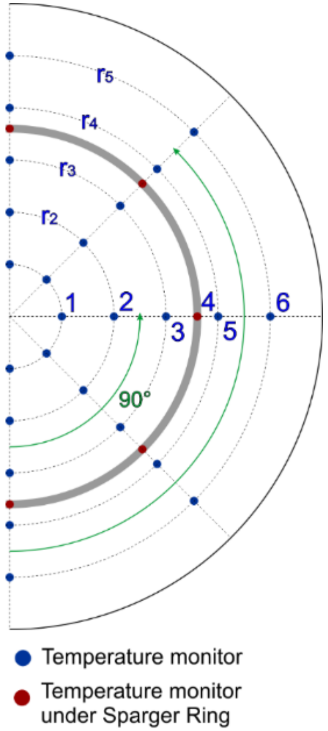



Friction coefficient = 0.5

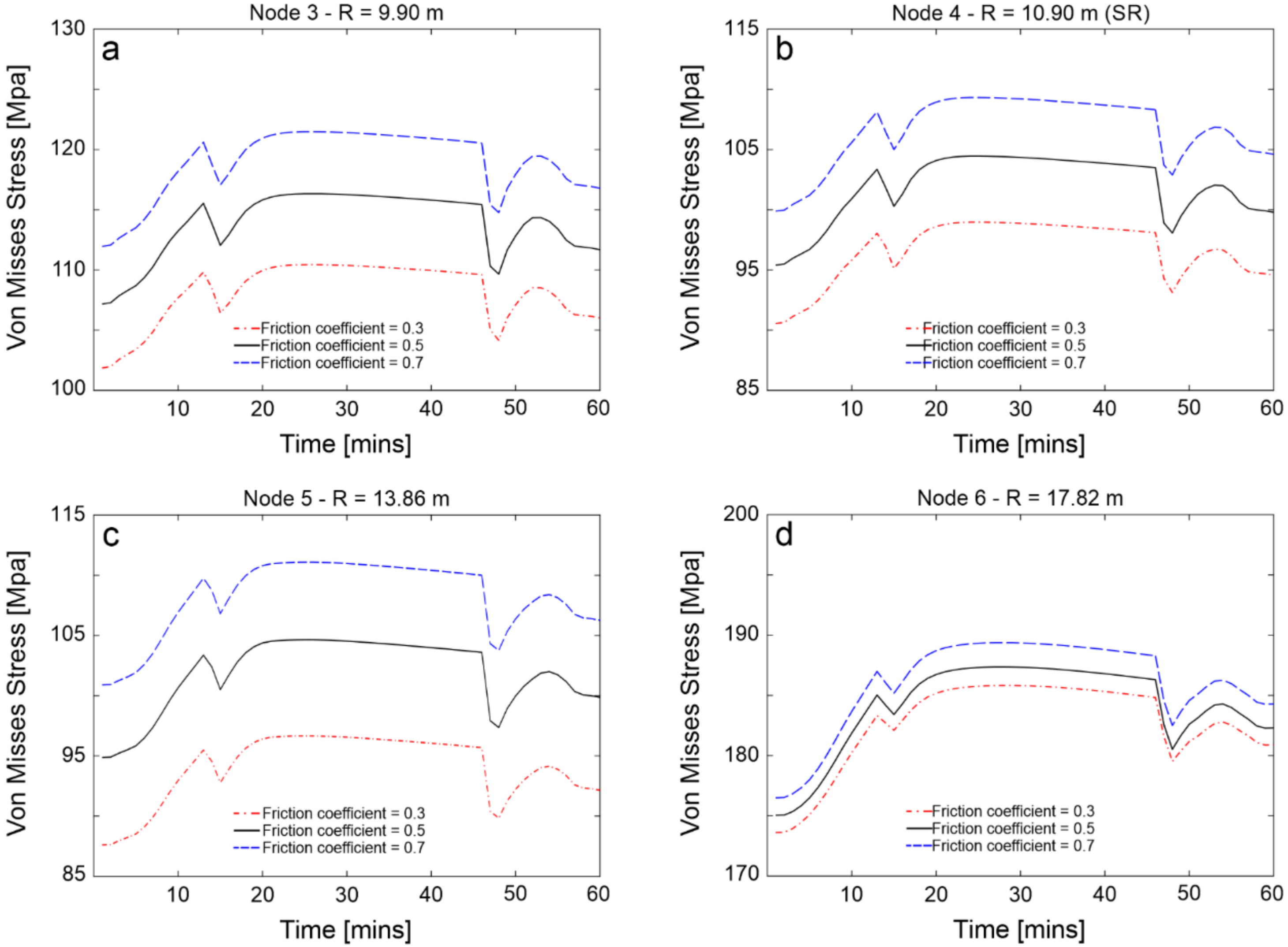
# Stress Distribution in the Tank Floor



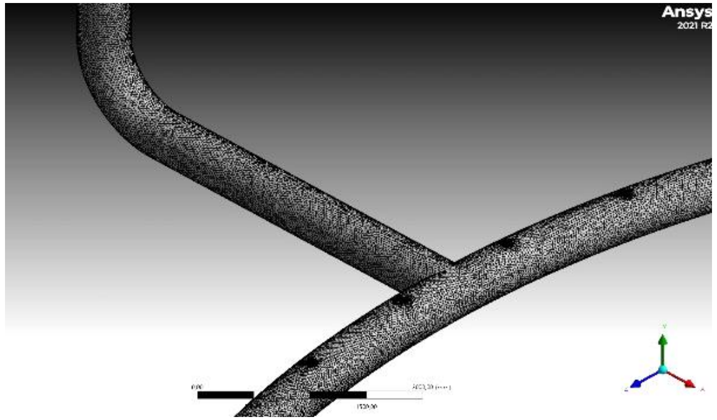


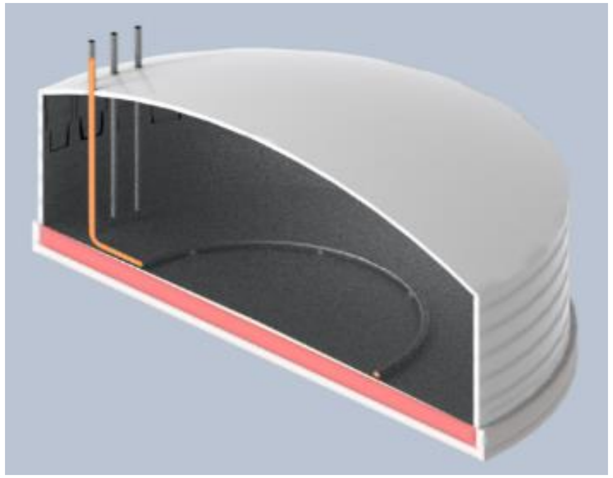

Stress evolution in the tank floor for different friction coefficients



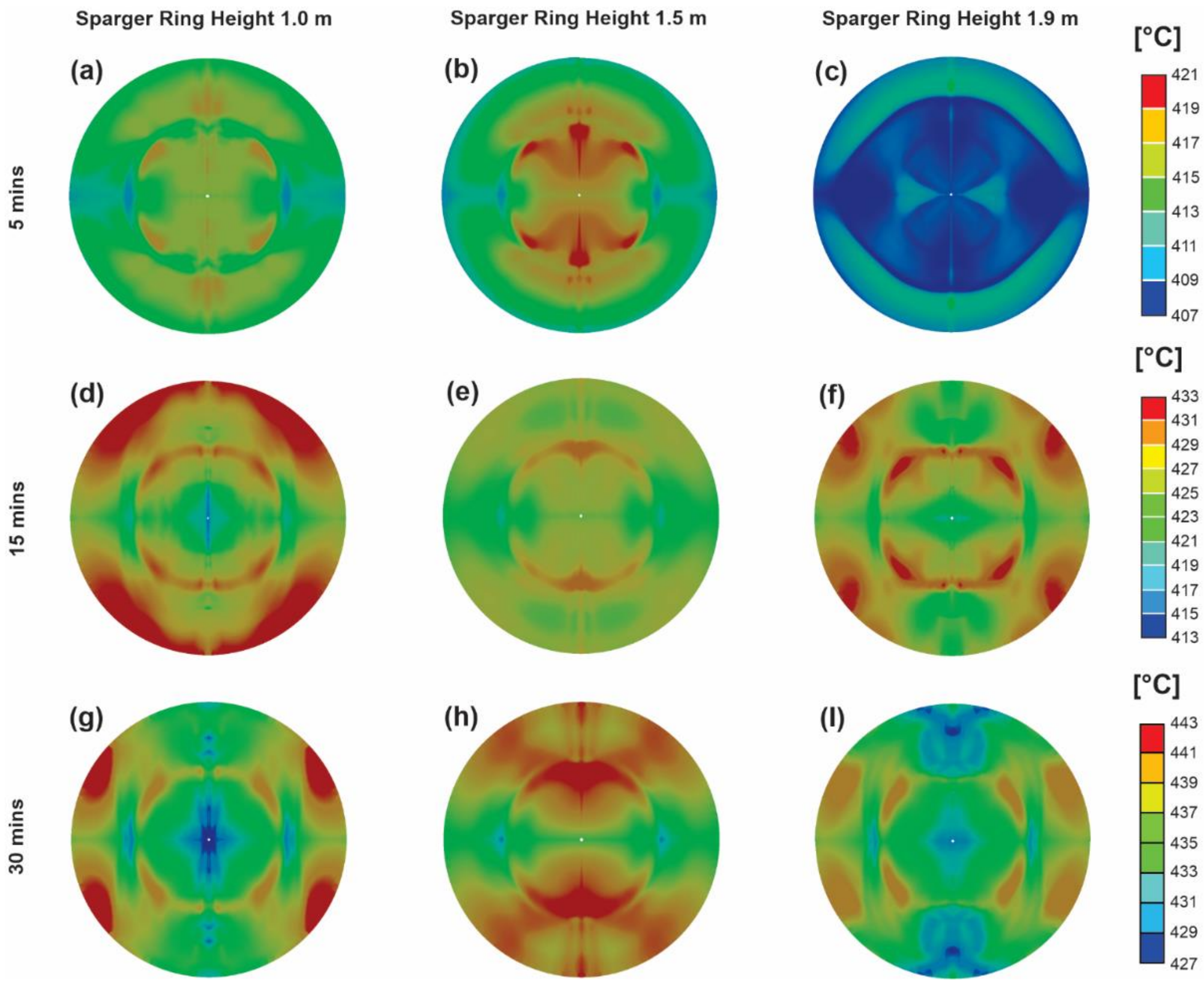

Floor thickness = 6.7 mm

# Sparger Ring Position



Large radial and circumferential temperature gradients in the floor

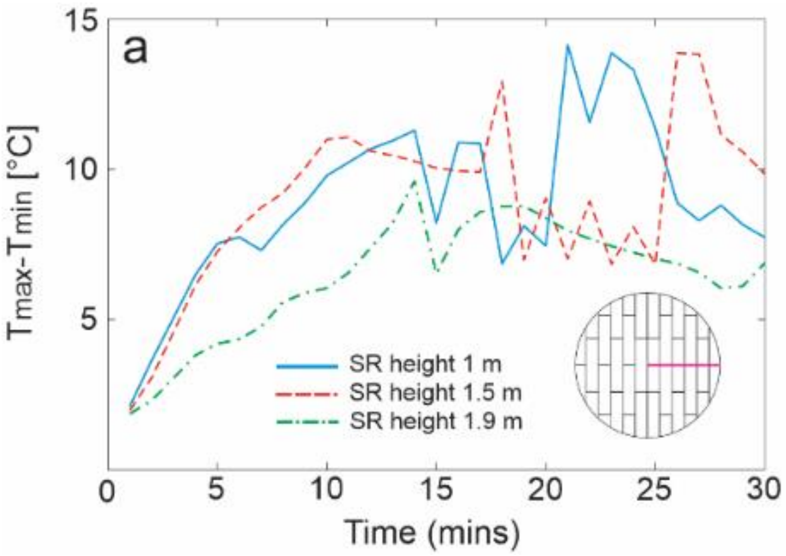


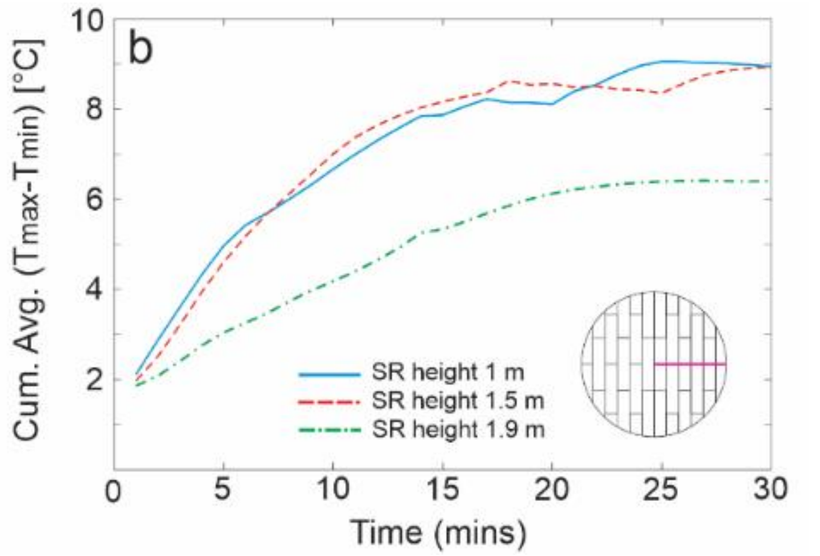

Inventory level = 2m, Tinv. = 400°C, Tin = 560°C, inflow = 1200 kg/s

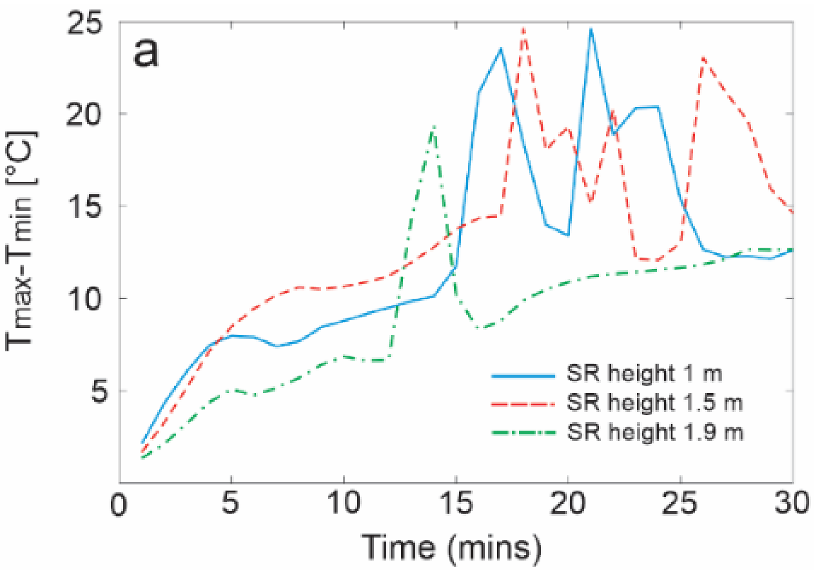
# Sparger Ring Position

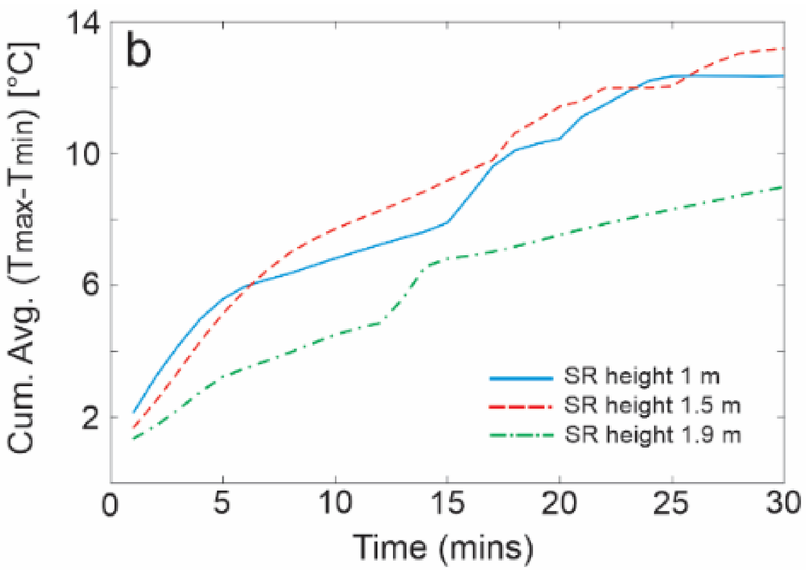
Tmax – Tmin radial line

A significant reduction in the temperature difference is observed for a sparger ring located at 1.90 m above the floor



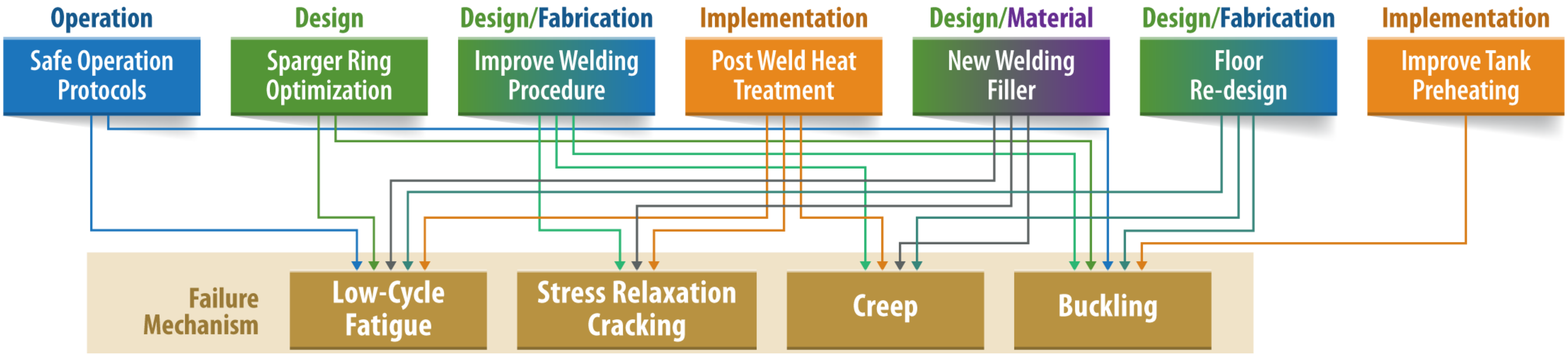




The Sparger Ring should be optimized to reduce temperature variations

Tmax – Tmin tank floor

# Final Remarks




- Failures in hot tanks can be attributed to multiple mechanisms, including low cycle fatigue, stress relaxation cracking, excessive deformation (buckling), and creep.
- Current failures in hot tanks are strongly influenced by their design, fabrication procedures, material characteristics, and challenging operating conditions.
  - The residual stresses and distortion of the tank floor after welding fabrication exert a strong impact on the stress levels developed during operation.

# Final Remarks

- Design changes such as floor thickness and sparger ring location (height) could be improved to reduce stresses.
- A definitive solution to tank failures requires addressing multiple issues during tank design, fabrication, implementation, and operation.

Take a picture to download the **final report**

https://www.nrel.gov/docs/fy24osti/89036.pdf


**Failure Analysis for Molten Salt Thermal Energy Storage Tanks for In-Service CSP Plants**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# Thank you

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