Characteristics and Applications of Hitachi H-25 Gas Turbine

Osamu Arai
Shinji Use
Shunichi Hirose
Shinichi Nagai
Mitsuo Teranishi
Kenji Kamino

OVERVIEW: More than 100 orders have been placed for Hitachi H-25 gas turbines from both Japan and various other countries, because of their exceptionally high reliability and efficiency in their class. In addition, they can be used for a wide range of applications, from power and general industrial use to utilization in oil and gas fields. The H-25 is characterized as being heavy-duty, highly reliable, and applicable to cogeneration and combined cycle operations, resulting in higher operational efficiency of the entire system, for which it is highly acclaimed. In one recent application where the worksite was located far from the power supply system, several H-25 gas turbines were used to form an island operation system that was not linked to the main power system. In another application, an H-25 gas turbine was used as a power supply for driving a motor instead of the mechanical drive system usually based on a small gas turbine. Such applications have been adopted due to the high reliability of the H-25 gas turbine. Hitachi, Ltd. has continued to enhance its H-25 gas turbine as a type of power supply equipment, and thus has contributed to the fields in which it has been used.

INTRODUCTION

THE H-25 gas turbine is an open, simple-cycle, single shaft gas turbine of the 30-MW class.

The H-25 gas turbine offers the following characteristics:
(1) It is heavy-duty, highly reliable, and ideally suited for continuous operation.
(2) The system start-up time when used in a simple gas turbine cycle is between 15 and 20 min from ignition to reaching the rated load, and thus shorter than that in conventional steam power generation. It is therefore applicable for DSS (daily start-up and shutdown) and peak applications.
(3) Based on modern turbine cooling and compressor technologies, the H-25 achieves the highest level of thermal efficiencies in the heavy-duty 30-MW class. It is also one of the models that has achieved the highest level of efficiency as a cogeneration system combined

![Fig. 1—H-25 Gas Turbine and General Overview of Sakhalin II Project in Russia.](image1.jpg)
Hitachi delivered four H-25 gas turbine generation equipment units to the Sakhalin Energy Investment Co., Ltd., for use in a land-side plant that processes gas and oil extracted from the seabed off the eastern shore of Sakhalin Island in Russia.
with an HRSG (heat recovery steam generator) and a combined cycle equipped with a steam turbine.

(4) The use of a horizontally split casing and a multi-can combustor ensures its high maintainability, and enables the on-site replacement of hot gas path parts.

(5) The adoption of various combustor technologies makes the system adaptable for use of light oil, LNG (natural gas), LPG (liquefied petroleum gas), and other fuels. Moreover, the application of a wet/dry low-NO<sub>x</sub> combustor enables low-NO<sub>x</sub> environmental measures to be taken.

For fuel diversification technology, Hitachi is actively committed to using off-gas, COG (coke oven gas), coal gas, dimethyl ether, and other special fuels. The rest of this report describes H-25 gas turbine’s history, specifications, and examples of its applications (see Fig. 1).

**HISTORY OF H-25 GAS TURBINE**

In 1988, the first H-25 unit was completed and delivered to the Tokuyama Oil Refinery of Idemitsu Kosan Co., Ltd.

Then in 1990, Hitachi delivered the first H-15 unit — a scaled down model — to the Research Union for Integrated Coal Gasification Combined Cycle, and thus expanded its scope of applications.

For about a decade after delivery of its first unit, the H-25 has been mainly used for cogeneration applications in domestic petrochemical companies. Based on its proven capabilities and track record during that period, Hitachi delivered the first unit for overseas use to South Korea in 2000. Since then, many more units have been delivered to various parts of the world (see Fig. 2).

The 20th anniversary of the first H-25 unit ever being delivered will happen this year (2008). Given its widely recognized high performance and reliability, the unit has received more than 100 cumulative orders, with more than 70 units now in commercial operation.

Moreover, the total operation time of these turbines largely exceeds 1.4 million hours. As illustrated in Fig. 2, the product continues to run steadily worldwide.

**PERFORMANCE AND EQUIPMENT COMPOSITION OF H-25 GAS TURBINE**

**Performance of H-25 Gas Turbine**

Fig. 3 (a) shows the performance of the H-25 and H-15 under ISO (International Organization for Standardization) conditions. The H-25 achieves an output of 31 MW and a gross thermal efficiency of 34.8% LHV (lower heating value) when fired with natural gas.

This performance is remarkable for a heavy-duty gas turbine of the 30-MW class. When combined with a steam turbine, the system offers the highest level of combined cycle efficiency — a gross thermal efficiency of 50% LHV or more.

**Equipment Composition of H-25 Gas Turbine**

Fig. 3 (b) shows the equipment composition and performance of the H-25 gas turbine. The turbine can be roughly divided into 17 axial flow compressors, 10 cannular combustors, and three stage turbines.

The bearings have a forced lubricating system. The journal bearings are No. 1 on the turbine side and No. 2 on the compressor side, while the thrust bearings are on the compressor side. These are tilting pad bearings.

The casing is horizontally split for both the compressor and turbine sides, while the support is designed to absorb thermal elongation.

In terms of exhaust, a side exhaust was previously the mainstream. However, in recent years, the axial
The H-25 turbine consists of three impulse stages. As illustrated in Fig. 5 (a), the first stage bucket is designed as a multi-pass cooling bucket, with staggered ribs developed by Hitachi to increase the cooling efficiency.

The turbine buckets are made of nickel-base alloys that have extremely high temperature strengths. The first stage turbine bucket has a TBC (thermal barrier coating), as illustrated in Fig. 5 (b), to cool the metal surfaces of the bucket.

The combination of impingement cooling, film cooling, and pin fin cooling are applied for the first stage flow exhaust has also been used to increase efficiency. The axial flow type is designed so that the front shaft of the compressor is connected to a reduction gear equipped with an accessory gear. The start-up motor is then connected to the generator. The lubricating oil tank is either installed separately as an off-base skid or arranged compactly, also functioning as the basis for the reduction gear as shown in Fig. 3 (b).

**COMPRESSOR**

**Compressor Application Technology**

The axial compressor for the H-25 gas turbine has 17 stages and a pressure ratio of 15. The compressor is equipped with an IGV (inlet guide vane) at the inlet, and its hydraulic drive allows it to control the airflow.

The front stages of the compressor entail a high Mach number. A supercritical arc blade, multiple circular arc blade, and double circular arc blade are applied to control any loss, as shown in Fig. 4. The rotor and stator blades are made of 12Cr-Nb steel and 12Cr steel, and given a corrosion-proof coating.

The system is designed so that 6-stage and 13-stage air extractions are used to discharge air to prevent from a rotating stall during start-up. In particular, the 6-stage air extraction is used to seal the bearings and cool the exhaust frame, while the 13-stage air extraction cools the second and third stage turbine nozzles.

**TURBINE**

**Turbine Application Technology**

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COMBUSTOR Application Technology

The H-25 is equipped with 10 cannular combustors connected by cross fire tubes. This structure makes the system highly maintainable.

Possible fuel options are the combustion of gas or oil, a dual fuel of gas and oil, or a dual combustion of gas and gas.

Among the possible methods of reducing NOₓ,
emissions are a water injection (wet) method and a steam injection method. The dry method can use a low-NO\textsubscript{x} combustor developed by Hitachi, illustrated in Figs. 6 (a) and (b), that achieves 25 ppm (dry) or less in 15% oxygen during a base load operation with natural gas.

The types of fuel used in the H-25 and H-15 include natural gas, off-gas, coal gas, kerosene, light distillate oil, A-heavy oil and cracked kerosene.

Hitachi developed the cluster burner illustrated in Fig. 6 (c) that burns dimethyl ether, and evaluated its feasible combustion performance by conducting a full load test. This combustion system allows for faster premixing in a shorter distance than conventional premixing burners, making it applicable for high-burning velocity fuels and capable of reducing NO\textsubscript{x} emissions.

**EXAMPLES OF H-25 GAS TURBINE APPLICATIONS**

**Application for Power Utilities**

The following is an example of the application of these turbines for power utilities. An H-25 was put into operation in 2007 in the NYKCE project in Hungary that was undertaken by E.ON Hungaria, Ltd. The turbine used for this project was Hitachi’s fifth unit delivered to Europe.

As shown in the system diagram in Fig. 7, the project is a multi-shaft, combined cycle plant consisting of an H-25 gas turbine, a heat recovery steam generator with supplementary burner, and a steam turbine.

The net combined output was between 29.5–49.5 MW. This plant uses the H-25 gas turbine exhaust gas energy to provide hot water for the district heating, and 26-bar high pressure and 7.5-bar low pressure steam for the industrial customers. Therefore this plant is a highly efficient cogeneration system whose cogeneration efficiency is 89.3% LHV.

To protect the inlet filter of the gas turbine against icing, the plant uses hot air from the ventilation outlet of the gas turbine enclosure.

Low-NO\textsubscript{x} combustors are used to achieve 25 ppm (dry) or less in 15% oxygen during base load operations.

**Application 1 for Petrochemical Company (Example-1)**

The following information is a summary of the information from the Betara Project of PetroChina International Jabung Ltd. in Indonesia as our example for turbine use in a petrochemical projects (see Fig. 8).

This project is being undertaken in the jungles of Sumatra Island in the Republic of Indonesia, and therefore, is far away from the main Indonesian power system (50 Hz). Based on the evaluation of high reliability of H-25 gas turbine, three sets are used as the power supply at the project site and run in the “island operations.” To scale down the pumps and equipment and reduce the total system costs, the plant...
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is designed to operate at a frequency of 60 Hz. This site incorporates three 5,800-kW compressors, two 4,800-kW compressors, one 2,990-kW compressor, and many other compressors. In conventional practice, the normal method has been to provide mechanical drive gas turbines for the drive compressors. However, gas turbines require the periodic replacement of spare parts, such as the hot gas path parts. When the compressors are being driven by a lot of mechanical drive gas turbines, a large number of spare parts are required. However, serious consideration was given to an easy operation and layout, less maintenance, reducing the cost for keeping spare parts, the cost-cutting effects of facilities, and other advantages, and the entire system was then made more operable by concentrating the power supply on the H-25 and replacing all the compressors with motor-driven models.

Application 2 for Petrochemical Company (Example-2)

Fig. 9 shows a cross-sectional view of the H-25 layout plan inside the building for Sakhalin II, as shown on the first page of this article. This project is an example of our turbines application in a cold environment where the ambient temperature is –48°C. The indoor equipment is comprised of a total of four
H-25 gas turbines including the waste heat recovery units. To increase the operability, two of the four units consist of gas-fuel, dry low-NOₓ combustors; the other two consist of dual gas/oil fuel, dry low-NOₓ combustors.

CONCLUSIONS

We have discussed the characteristics and typical applications of the H-25 gas turbine. Since the Third Conference of Parties to the United Nations Framework Convention on Climate Change (COP3) in 1997, various efforts have been made to reduce greenhouse gas emissions. Power plants based on fossil fuels are projected to find higher need for highly efficient gas turbine combined cycles, cogeneration systems, and similar systems. The need for cogeneration systems based on such a medium-capacity gas turbine as the H-25, in addition to the conventional, large gas turbine power plants, is increasing. Hitachi intends to continue working towards developing even higher levels of performance and reliability in its H-25 gas turbine.

REFERENCES


ABOUT THE AUTHORS

Osamu Arai
Joined Hitachi, Ltd. in 1982, and now works at the Turbine Plant Design Department, Hitachi Works, the Power Systems. He is currently engaged in designing gas turbines. Mr. Arai is the Registered Professional Engineer (Oregon USA) and a member of the Gas Turbine Society of Japan.

Shinji Use
Joined Hitachi, Ltd. in 1979, and now works at the Turbine Plant Design Department, Hitachi Works, the Power Systems. He is currently engaged in designing building gas turbines. Mr. Use is a member of the Gas Turbine Society of Japan.

Shunichi Hirose
Joined Hitachi, Ltd. in 1970, and now works at the Thermal Technology Headquarters, the Thermal Power Systems Division, the Power Systems. He is currently engaged in supervising overseas thermal plants. Mr. Hirose is a member of The Institute of Electrical Engineers of Japan.

Shinichi Nagai
Joined Hitachi, Ltd. in 1980, and now works at the Turbine Plant Design Department, Hitachi Works, the Power Systems. He is currently engaged in supervising gas turbine design.

Mitsuo Teranishi
Joined Hitachi, Ltd. in 1979, and now works at the Overseas Thermal Power Business Development Department, the Thermal Power Systems Development and Management Division, the Power Systems. He is currently engaged in gas turbine marketing. Mr. Teranishi is a member of the Gas Turbine Society of Japan.

Kenji Kamino
Joined Hitachi, Ltd. in 1980, and now works at the Nuclear & Thermal Power Department, the International Operations Division, the Marketing Group, the Power Systems. He is currently engaged in Iberia & Latin America / H-25 Gas Turbine Project.