


# ***ATC - CES IS AT YOUR SERVICE***



Applied Thermal Coatings

# **ATC-CES**

Combustion Engineering Solutions

Our Vision

*We strive to support the commercial success of our clients by providing superior technical services and problem-solving capabilities covering all materials-related issues in as timely and cost-effective manner as possible.*

Over 300 years  
experience in the  
industry

Office : 423-267-0647

ATC-TN.com

The graphic features a central cluster of hexagons. The top-left hexagon shows an industrial facility with two tall smokestacks. The top-right hexagon shows two men in a white lab coat and a grey shirt looking at a large blueprint. The bottom-left hexagon shows an office interior with desks and computers. The bottom-right hexagon shows a large industrial component being heated or processed in a furnace. The bottom-most hexagon shows a red fire extinguisher and other safety equipment.

***ATC – A Multi-Faceted Technology Company  
Chattanooga, TN, USA***

# ATC PROJECT MANAGEMENT

Small minority owned business offering a broad range of engineering services

Patented surface coatings and heat treating services

Industry experts in metallurgy, failure analysis, and advanced materials

Metallurgical lab testing and research (Grade 91 material development with ORNL)

Combustion Engineering Solutions, experts in Boiler and HRSG design, retrofit, and material supply

Project Management

# Who is ATC-Combustion Engineering Solutions (CES)?

ATC-CES is a diversified technology company that provides a range of services for US industries

ATC's Coatings Division offers a variety of coatings solutions for difficult wear and corrosion problems.

ATC's Heat Treatment Division offers heat treatment services covering a range of materials, specializing in advanced engineering alloys, like Grade 91, that require very precise control of temperature.

ATC's Combustion Engineering Solutions Division, which includes its full-service metallurgical laboratory, provides basic and advanced engineering assistance for all materials and welding related issues, along with mechanical/structural design, analysis, and material supply for the boiler/HRSG industry.

# ATC's Coating Division

- **Diffusion**

- Chromizing
- Aluminizing
- Boronizing
- Siliconizing

- **Thermal Spray**

- Electric-Arc
- Combustion/Powder

- **Plasma Transfer Arc**

- Wear Resistance
- Corrosion Resistance





# ATC's Heat Treatment Division

- **Heat-Treatment Services**

- Annealing/Normalizing
- Tempering
- Quench and Temper
- Stress Relief
- Post Weld Heat Treatment
- Solution Annealing
- Precipitation Hardening



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# ATC's Heat Treatment Division

## Flame Hardening Service



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# ATC's Combustion Engineering Solutions Division

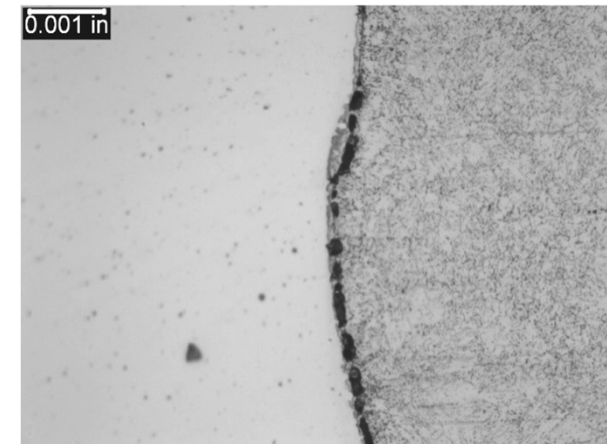
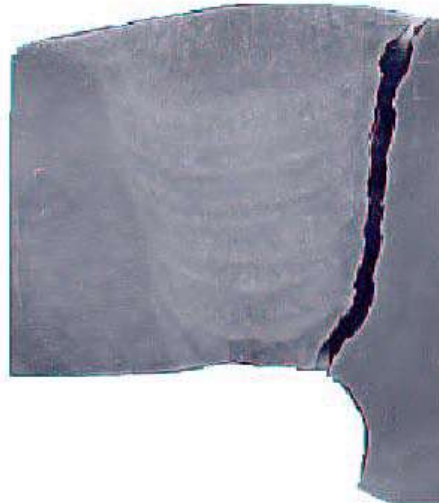
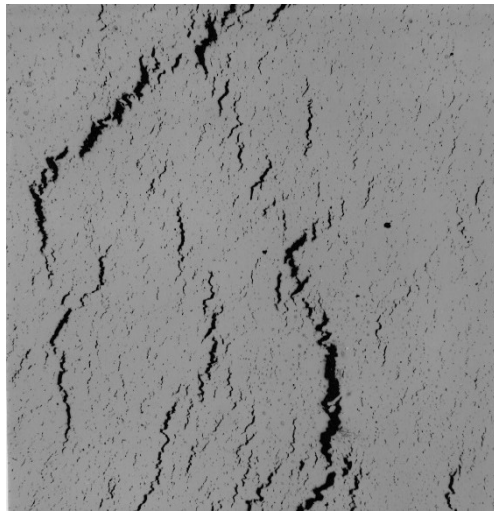
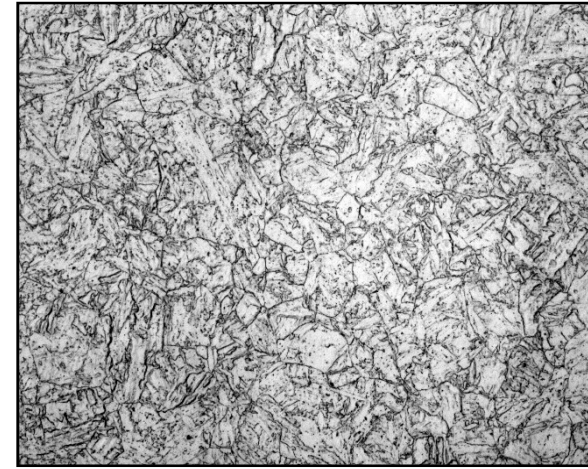
- **Materials Qualification**
  - Chemical Analysis
  - Mechanical Testing
    - Tensile Testing
    - Charpy V-Notch Testing
  - Weld Qualification Testing
    - Bend Testing
    - Metallography/Hardness Testing
  - Macrostructural and Microstructural Analysis



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# ATC's Combustion Engineering Solutions Division

- **Assistance with Materials-Related Issues**
  - Extensive experience with “difficult” materials, such as CSEF steels (e.g., Grade 91), advanced austenitics (e.g., TP310HCbN) and nickel-base alloys
  - **Guidance on:**
    - Material selection
    - Quality oversight throughout processing
    - Control of heat treatment
    - Condition assessment
    - Fitness For Service Evaluations

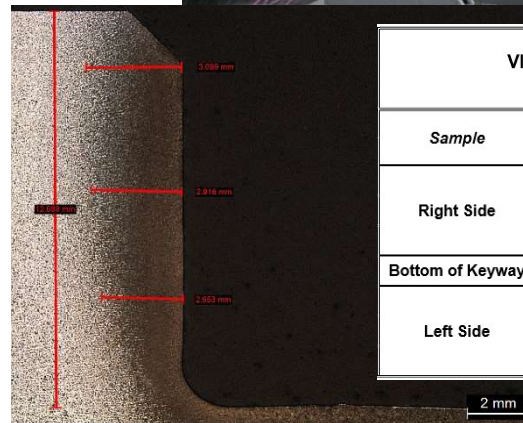
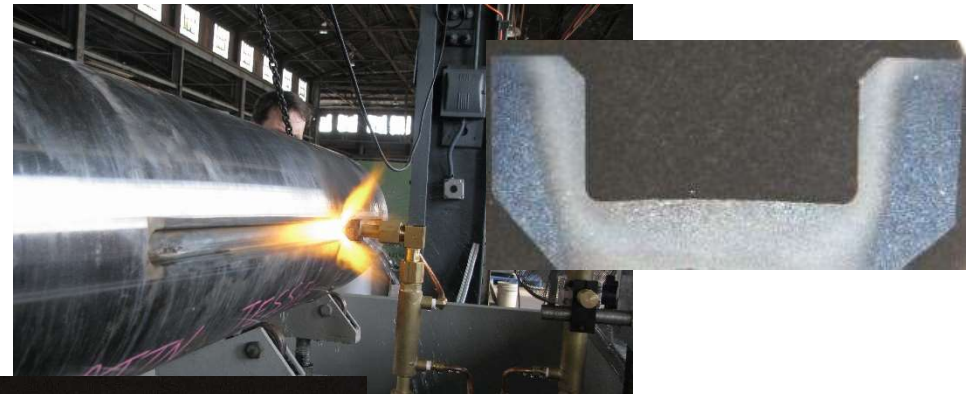


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# ATC's Combustion Engineering Solutions Division

- **Component Qualification**
  - NDE
  - Hardness Testing
  - Microstructure Examination
  - Charpy V-Notch Testing



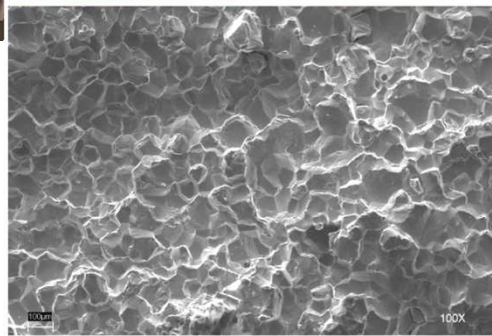
VICKERS HARDNESS VALUES-HV (HRC)* (500 grams Test Load)			
Sample	Location	Values	
		1 (at surface)	2 (~0.5 mm from surface)
Right Side	Top Corner	486 (48)	444 (45)
	Middle	486 (48)	468 (47)
	Bottom	466 (47)	455 (46)
Bottom of Keyway	Center	468 (46)	441 (44)
Left Side	Top Corner	493 (49)	458 (46)
	Middle	497 (49)	460 (46)
	Bottom	472 (47)	465 (46)

17H110 - Sample L281798-01 - Keyway Evaluation

Keyways	Flame Hadening Parameters						Keyway Width (in)					
	Nozzle end to Keyway (in)	Travel Speed (in/min.)	Fuel Flow (SCFH)	Oxygen Flow (SCFH)	Water Flow (GPM)	Tube Length (in)	Pre HT			Post HT		
							Mouse Hole ---> Critical			Mouse Hole ---> Critical		
							1	2	3	1	2	3
1	0.160	4.00	50	100	9.00	53.75	1.018	1.018	1.018	1.003	1.004	1.005
2	0.154	3.50	50	100	9.00	53.75	1.019	1.020	1.020	1.003	1.006	1.006
3	0.154	3.06	50	100	8.75	53.75	1.018	1.017	1.018	1.003	1.002	0.986
4	0.16	3.75	50	100	8.75	53.75	1.019	1.020	1.020	1.007	1.007	1.011

# ATC's Combustion Engineering Solutions Division

- **Failure Analysis and Root Cause Investigation**
  - Damage Mechanism Determination
  - Verification of Specification Compliance
  - Root Cause Analysis
  - Litigation support



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# ATC's Combustion Engineering Solutions Division

- **Field Inspection Support**
  - Standard NDE
  - Metallographic Replication
  - Hardness Testing

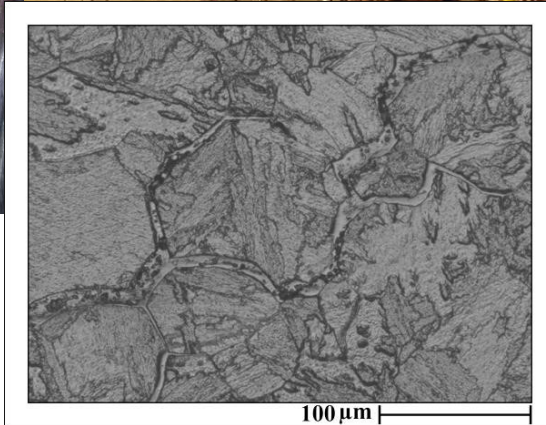
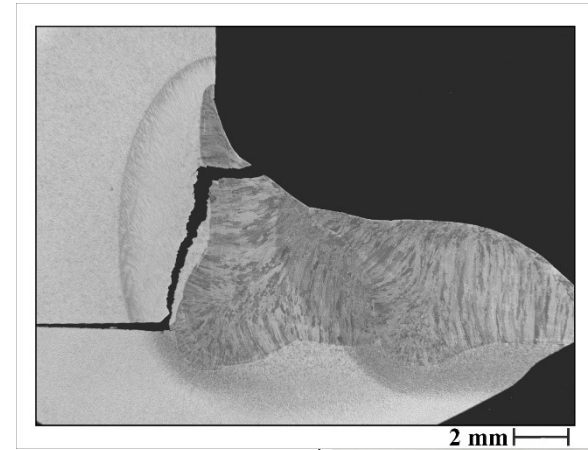
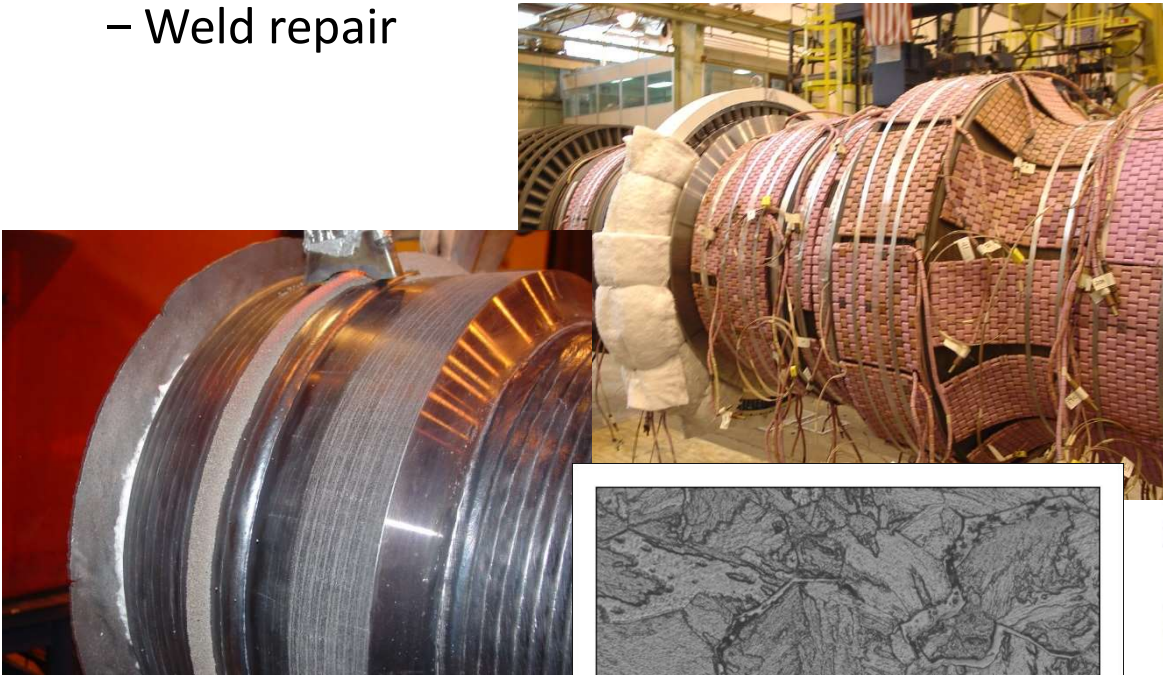




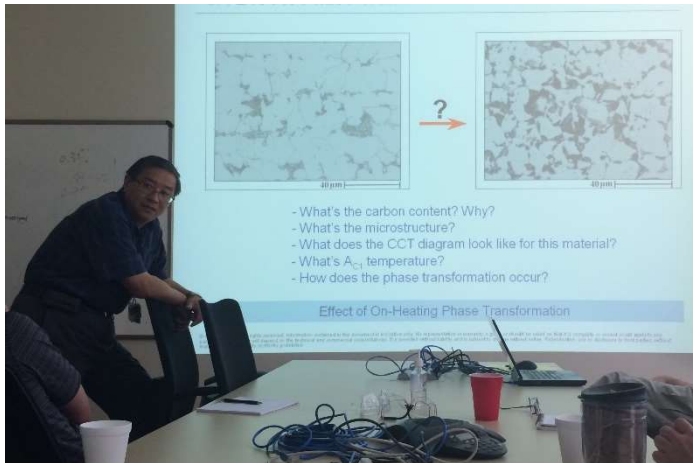
# ATC's Combustion Engineering Solutions Division

- **Welding Engineering and Technology**

- Welding metallurgy
- Weld Procedure Development
- Weld Qualification Testing
- Weld cracking behavior
- Weld repair



# Metallurgical Consulting, Litigation Support, Training (Metallurgy, Welding Engineering, NDE, Heat Treatment), Engineering Project Management, Assistance with Codes and Standards



## **ATC's** Combustion Engineering Solutions **Division**

### Boiler and HRSG Design/Structural Group

- 300+: Combined Years of Boiler Service Engineering Practice
- Extensive Design Experience with Boiler/HRSG Equipment from Combustion Engineering/Alstom, ABB-CE Services, Foster-Wheeler, B&W
- 10: States in which Our Professional Engineers Are Licensed
- Located in Chattanooga, TN USA



# ATC's Combustion Engineering Solutions Division

## Analysis, Design, and Material Capabilities

- High Energy Piping
- Pressure Part Components (SH, RH, Econ, Harps, Headers)
- Structural Support and Platforms
- Boiler Framing (Buckstay)
- Duct, Toggle Sections, Expansion Joints
- Construction Engineering
- Drafting Services



# ATC's Combustion Engineering Solutions Division

ASME B31.1 Power Piping

ASME B31.3 Process Piping

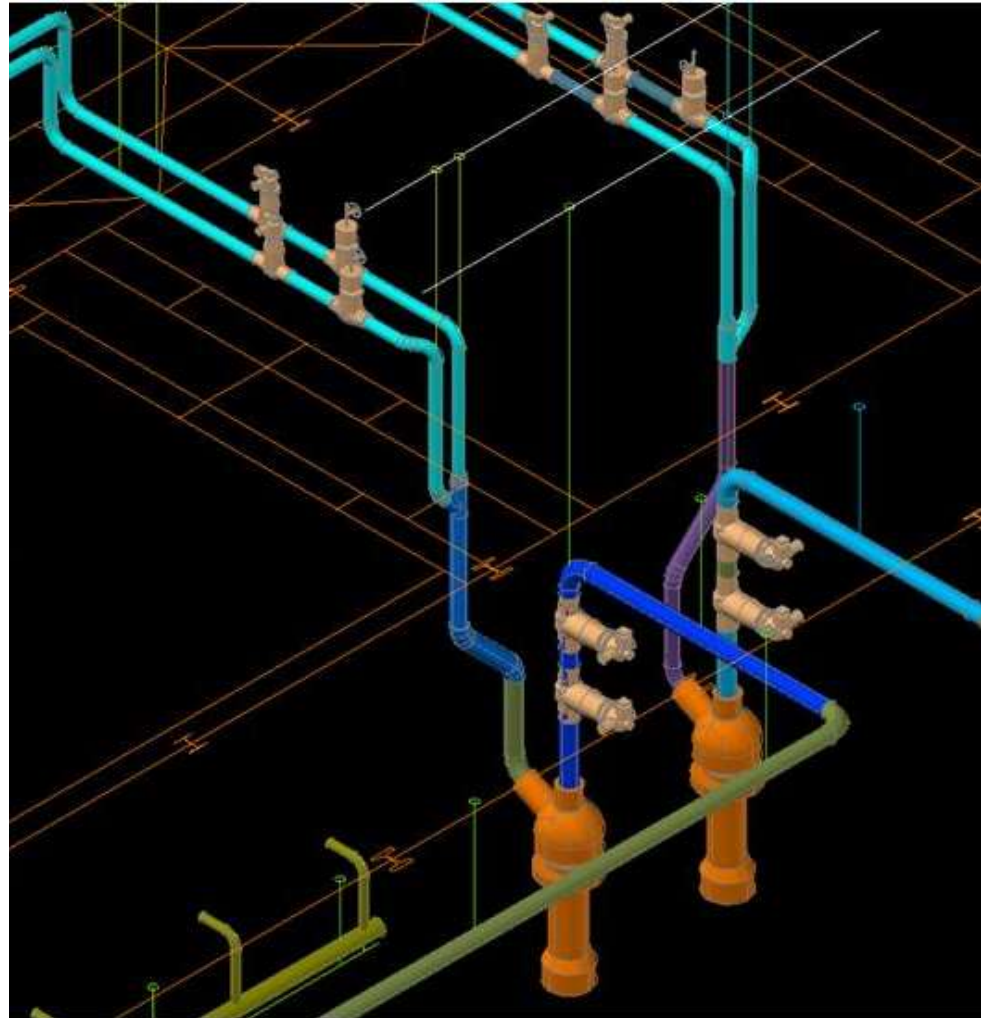
Condition Assessment

Pipe Support Repair

Drain Piping

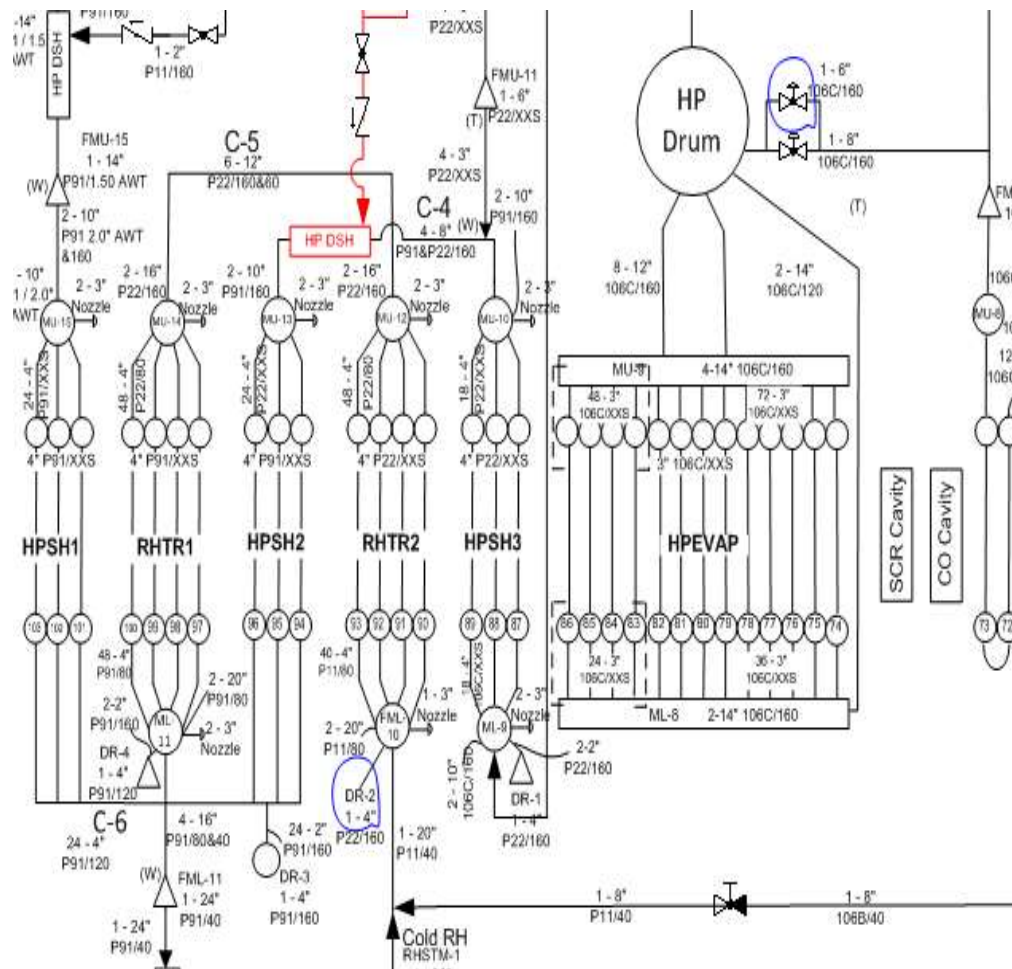
Pressure Relief Vent Piping

Soot Blower Piping



# ATC's Combustion Engineering Solutions Division

## Pressure Part Component Analysis & Design





# ATC's Combustion Engineering Solutions Division

## Structural Analysis, Design & Material

Main Boiler/HRSG  
Support Steel

Press Part Support  
Steel

Platform Steel

Boiler Building  
Wind/Seismic  
Resisting Structure

Duct Support Steel

Pipe Support Steel



# ATC's Combustion Engineering Solutions Division

## Boiler/HRSG Framing Analysis, Design & Material

- Buckstay Systems
- Lower Tube & Drum  
Supports
- Nose Arch Framing
- Lower Enclosure Framing
- Penthouse Enclosure  
Framing
- Casing Design
- Boiler/HRSG Guides



# ATC's Combustion Engineering Solutions Division

## Duct Analysis & Design

Air Ducts

Gas Ducts

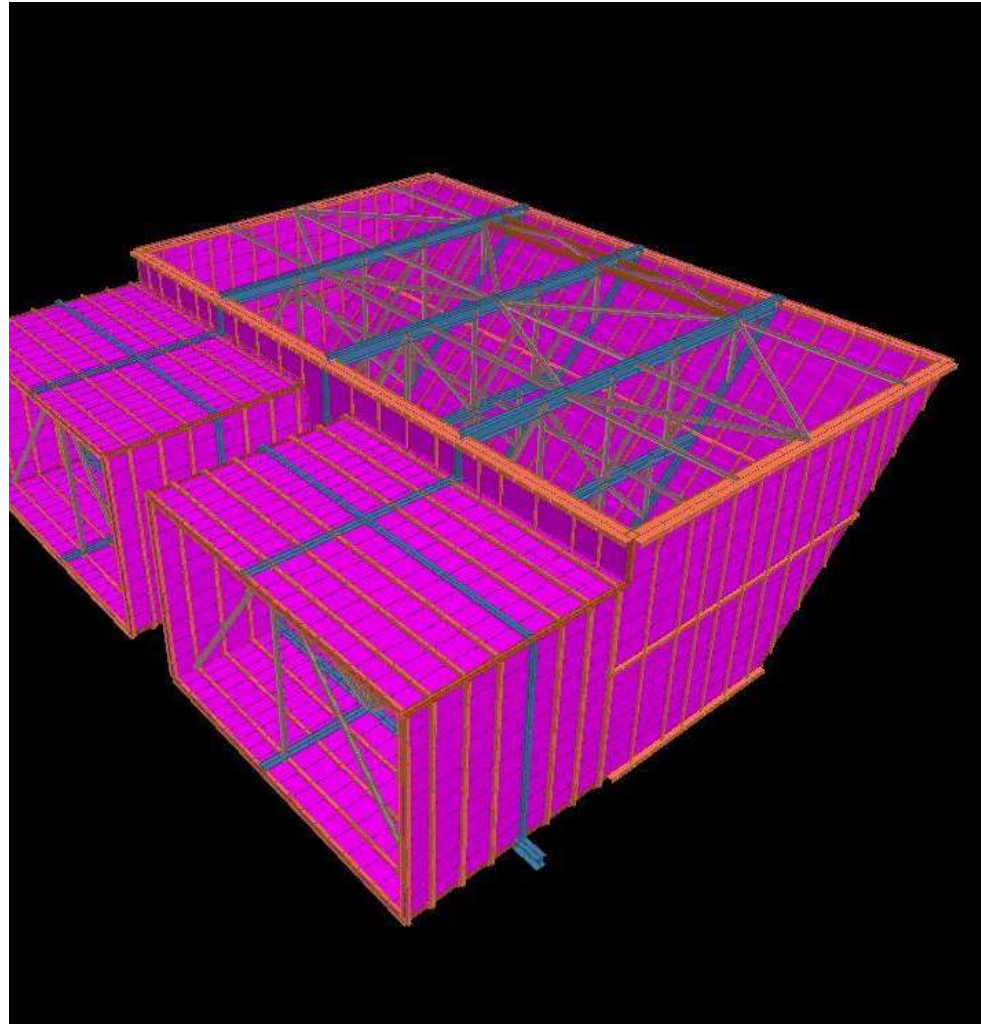
Toggle Sections

Expansion Joints

Hoppers

New Duct Routing

Fabric Joint Specifications





# ATC's Combustion Engineering Solutions Division

## Construction Engineering

Temporary Support  
Designs for Replacement:

- Waterwall Panels
- Lower Slope Panels
- Rear Arch Panels
- Headers
- Piping



# ATC's Combustion Engineering Solutions Division

## Drafting Services

Pipe Arrangements

Pressure Part Arrangements

Steel Arrangements

Duct Arrangements

New Boiler Equipment  
Layout

Construction Sequencing



Thank  
you!



*Team*