



SUGGESTED HEATING PROCEDURES FOR XERTECH CASTABLES

The following schedule is suggested for Xertech Specialties low cement castables. The controlled release of moisture in the monolithic is required to prevent possible build-up of steam pressure and potential steam spalling.

1. After the initial cure (minimum 24 hours), raise the temperature to 300° F at a rate of 50° F per hour.
2. Hold at 300° F for one hour per inch of lining thickness (6 hours minimum).
3. Raise the temperature to 450° F at a rate of 50° F per hour.
4. Hold at 450° F for one hour per inch of lining thickness (6 hours minimum).
5. Raise the temperature to 600° F at a rate of 25° F per hour.
6. Hold at 600° F for one hour per inch of lining thickness (6 hours minimum).
7. Raise the temperature to 1000° F at a rate of 50° F per hour.
8. Hold at 1000° F for one hour per inch of lining thickness (6 hours minimum).
9. Cool or raise to operating temperature at a rate of 100° F per hour.

Notes:

1. The use of “XR” fibers does not guarantee a rapid heat-up schedule.
2. Temperatures should be monitored at the refractory surface not the furnace atmosphere.
3. If pressure steaming is observed at any time during the schedule, the temperature should be held constant until the steaming subsides.
4. Good airflow across the hot face is required to help remove moisture. Weep holes through the metal shell are recommended.

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