SIEMENS

SAMA DIAGRAMS FOR BOILER CONTROLS

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APPLICATION DATA

PURPOSE

Functional control diagrams for the power industry are often referred to as SAMA diagrams. They are based on symbols and diagramming conventions developed by the Scientific Apparatus Makers Association (SAMA). They are used to describe and document control strategies and systems designed for both industrial and utility boiler applications. Although similar in concept to ISA diagrams, there are significant differences between the two methods of diagramming control systems.

SAMA Standard PMC 22.1-1981 *Functional Diagramming of Instrument and Control Systems* is no longer supported by SAMA or any other standardization committee. It is anticipated, however, that the symbols and conventions contained in this standard will continue to be used for the foreseeable future. The purpose of this document is to describe the basic symbols and a few of the many variations of these symbols that have evolved over the years.

These SAMA diagrams are used in the Siemens Moore series of boiler control application notes. Therefore, a general understanding of the diagrams is helpful to effectively use the applications notes.

HIGHLIGHTS

SAMA diagrams represent the language of choice throughout the power and pulp & paper industries for instrumentation and control systems. This document shows and explains the following types of symbols, including variations and examples of their application.

- Enclosure symbols
- Signal continuation symbols
- Signal processing symbols

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SYMBOLS

Figure 1 shows a simple flow control loop using both ISA and SAMA diagrams. Only the symbol for the flow transmitter (FT) is identical in both cases. The ISA diagram shows a very symbolic representation of the flow indicating controller (FIC). The SAMA diagram provides a more detailed block diagram of the proportional plus integral (PI) controller with setpoint and manual adjustments and auto/manual transfer switch. The SAMA and ISA versions also use different symbols to represent the flow control valve (FCV).

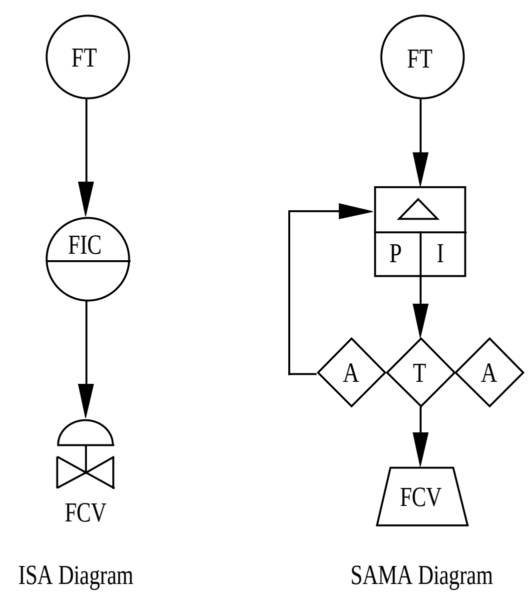
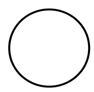
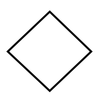
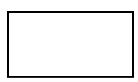
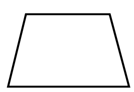
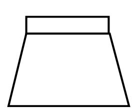
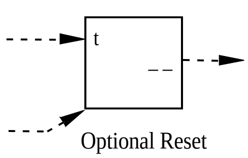


FIGURE 1 ISA vs. SAMA Functional Diagrams

A SAMA diagram uses various types of enclosure symbols as shown in Table 1 to represent the various elements or functions of the control system. The enclosure symbols are tied together by the continuation symbols shown in Table 2. Table 3 shows the many signal processing symbols used to describe the functions within each enclosure.

The use of most of these symbols will be fairly obvious after reading a few SAMA diagrams. It is important to realize, however, that very few designers adhere strictly to the SAMA standard, and it is not uncommon to see slight variations in the symbols shown here.

TABLE 1 Enclosure Symbols

FUNCTION	ENCLOSURE SYMBOL
Measuring or Readout	
Manual Signal Processing	
Automatic Signal Processing	
Final Controlling	
Final Controlling with Positioner	
Time Delay or Pulse Duration	

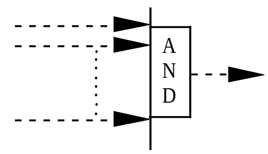
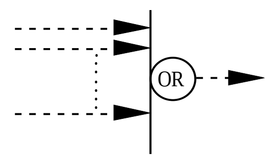
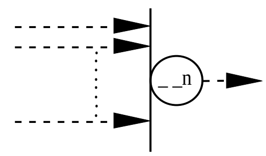
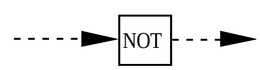
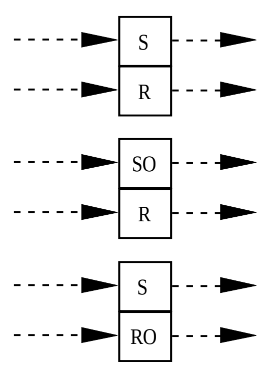
FUNCTION	ENCLOSURE SYMBOL
Logical AND	
Logical OR	
Qualified Logical OR	
Logical NOT	
Maintained Memory	

TABLE 2 Processed Signal Continuation Symbols

SIGNAL	SYMBOL
Continuously Variable Signal	────────►
Incremental Change Signal or Rate of Change of a Continuously Variable Signal	●────────►
On-Off Signal *	- - - - - - - - - - - -►

* *The on-off signal symbol may be a solid line if on a separate digital logic diagram or if on an inset detail on a funtional diagram.*

TABLE 3 Signal Processing Symbols

FUNCTION	SIGNAL PROCESSING SYMBOL
Summing	Σ or +
Averaging	Σ / n
Difference	△ or −
Proportional	K or P
Integral	∫ or |
Derivative	d/dt or D
Multiplying	x
Dividing	÷
Root Extraction	$\sqrt[n]{\ }$
Exponential	x^n
Non-Linear Function	f(x)
Tri-State Signal (Raise, Hold, Lower)	↕
Integrate or Totalize	Q
High Selecting	>
Low Selecting	<
High Limiting	≯
Low Limiting	≮
Reverse Proportional	-K or -P
Velocity Limiting	v ≯
Bias	±
Time Function	f(t)
Variable Signal Generator	A
Transfer	T
Signal Monitor	H/, H/L, /L

FUNCTION		SIGNAL PROCESSING SYMBOL
Logical Signal Generator		B
Logical AND		AND
Logical OR		OR
Qualified Logical OR	> n	GTn
	< n	LTn
n = an integer	= n	EQn
Logical NOT		NOT
Set Memory		S, SO
Reset Memory		R, RO
Pulse Duration		PD
Pulse Duration of the Lesser Time		LT
Time Delay on Initiation		DI or GT
Time Delay on Termination		DT
Input/ Output Signal Converter	Analog	A
	Digital	D
	Voltage	E
	Frequency	F
	Hydraulic	H
Examples: D/A I/P	Current	I
	Electromagnetic or Sonic	O
	Pneumatic	P
	Resistance	R

VARIATIONS
PID Controller

The fundamental function of most control loops is the PID controller. PID stands for the Proportional plus Integral plus Derivative control algorithm. Figure 2 shows four variations of the symbol used to describe this algorithm in SAMA diagrams.

The PID controller generally has two inputs representing the process variable (PV) to be controlled and the setpoint (SP) value at which it is desired to maintain the PV. The controller calculates the difference (△), or control error, between these two signals and generates an output to drive the PV to SP. Depending on the number of control modes specified, the controller output is proportional (P) to the magnitude of the error, the integral (I) of the error, the derivative (D) of the error, or various combinations of these three functions.

Figures 2A shows the classic SAMA symbol for a PID controller using the standard mathematical symbols for these functions. The rectangular enclosures indicate that these signals and functions are processed automatically. Figure 2B simply substitutes P, I, and D for the standard mathematical symbols. Figure 2C simplifies the drawing of the symbol by combining the P, I, and D functions within a single rectangle.

Figure 2D shows the actual structure of the standard Siemens Moore implementation of the PID algorithm. In this form, the derivative mode is a function of a change in process variable instead of a change in control error. This avoids a derivative "kick" on changes in setpoint. In most cases, however, it is not necessary to make this distinction when drawing a SAMA diagram.

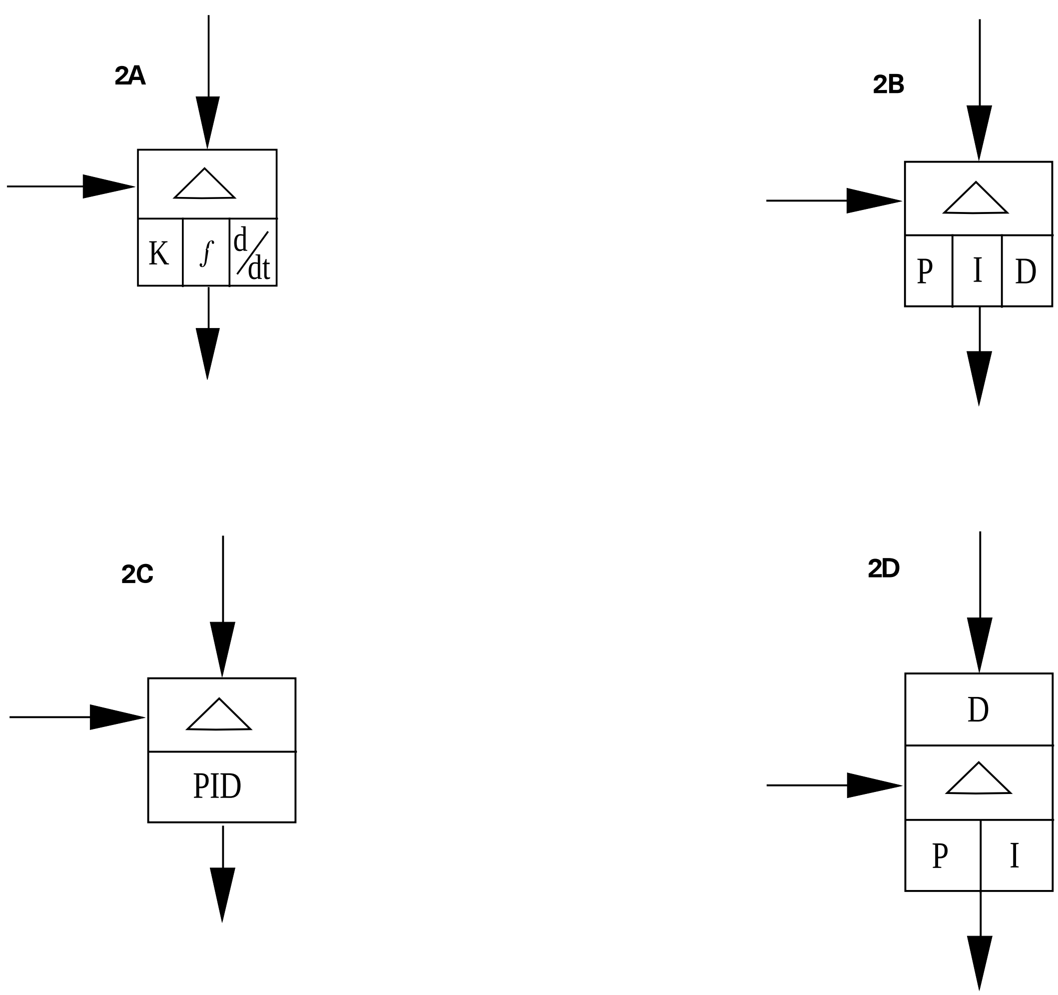


FIGURE 2 PID Controller Symbol Variations

Single Loop Control

The fundamental single loop control diagram includes a process measurement, a PID controller with adjustable setpoint and auto/manual transfer, and a final control element such as a control valve or drive mechanism. Figure 3 shows three variations of the collection of symbols used to describe single loop control on SAMA diagrams.

Figure 3A shows the classic SAMA diagram for single loop control using a PI controller. The three diamonds ganged together represent the adjustable setpoint (left A), the adjustable manual output (right A), and the auto/manual transfer switch (T). The diamond shaped enclosures indicate that these are all manual functions performed by an operator. The location of these functions on the diagram is probably symbolic of the equipment designs in use when the standard was originally developed. These adjustments were typically provided by separate components mounted within a control station.

Figure 3B simply relocates the setpoint adjustment directly on the symbol for the PI controller. It also shows the FCV equipped with a valve positioner. It should be noted, however, that many diagrams omit the positioner symbol for simplicity, and the drawing should not be construed as the final authority regarding the presence or absence of a valve positioner.

Figure 3C shows another variation of the classic arrangement of the three diamonds. Also note the non-linear function symbol [f(x)] instead of the FCV. This may be used to represent an inherently non-linear valve characteristic (e.g. equal percentage), or it may represent the use of a positioner that includes a characterizer function (even though the positioner symbol is not shown). Also be aware that some SAMA diagrams routinely show the f(x) symbol on all final control elements without regard for the actual characteristics of the valve or positioner.

Equipment Detail

SAMA diagrams are used to describe the functional elements of a control strategy. The symbols are generic and are not specific to the control hardware manufactured by any particular vendor. There are instances, however, when it may be necessary to show equipment details to fully document the control strategy. Figure 4 shows two variations of the single loop control diagram showing equipment details. In general, this level of detail should be avoided since it obscures the basic control strategy and makes the diagram less generic.

Figure 4A shows one of the single loop variations with the addition of three separate indicators for monitoring and manipulating the loop. The indicators are shown as circular enclosure symbols with the ISA indicator symbol (I). They display the three key variables of the control loop (process, setpoint, and valve). The operator needs to see these three variables to determine the state of the control loop. In addition, the operator must be able to see the value of the setpoint and valve loading to adjust these variables in auto and manual modes, respectively. Since it is standard practice to provide these readouts on every control loop, it is generally not necessary to show them explicitly on the SAMA diagram.

Figure 4B shows additional automatic signal processing functions to describe equipment details. The transfer blocks on the setpoint signal and controller output are used to describe setpoint and controller tracking. The rectangular transfer symbols switch automatically based on the state of the discrete input signal represented by the dotted line. This discrete signal indicates the position of

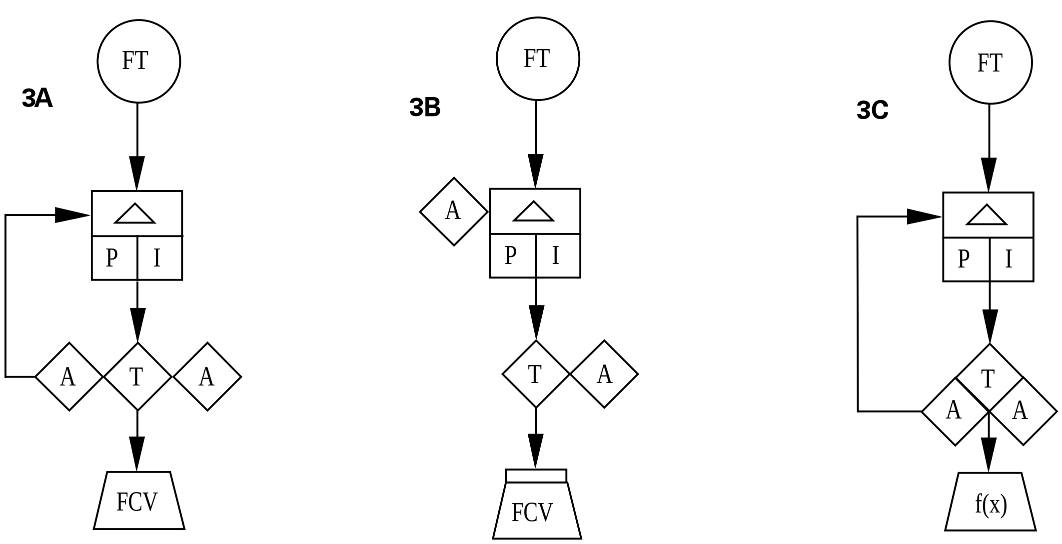


FIGURE 3 Single Loop Control Variations

the manually operated auto/manual transfer switch. In the manual mode, the setpoint tracks the process variable, and the controller tracks the manually adjusted valve loading signal. This prepares the controller for bumpless transfer back to auto, and aligns the setpoint with the present value of the PV. Another equipment detail shows reset feedback from the valve signal to drive the integral action of the PI controller. These are control hardware implementation details that are not usually necessary to convey the overall control strategy. They should be shown only as necessary in the judgment of the designer or end user.

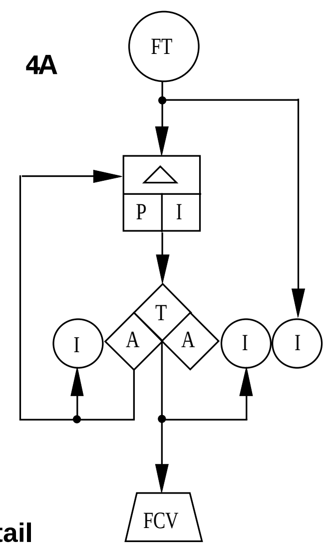
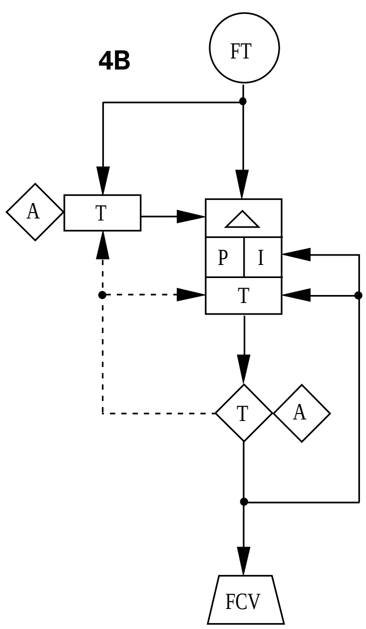


FIGURE 4
Equipment Detail Variations



EXAMPLES

Three-Element Drum Level Control

A common application in boiler control is three-element drum level control. Boiler drum level is a critical variable in the safe operation of a boiler. Low drum level risks uncovering the boiler tubes and exposing them to heat stress and damage. High drum level risks water carryover into the steam header and exposing steam turbines to corrosion and damage. The level control problem is complicated by inverse response transients known as shrink and swell.

Figure 5 is a SAMA diagram of the cascade plus feedforward control strategy that is normally used to solve these control problems. The three transmitters, or variables, are the three elements referred to in the name of the control strategy. The feedwater flow setpoint is set automatically by the steam flow signal to keep the feedwater supply in balance with the steam demand; this is the feedforward component of the control strategy. The drum level controller trims the feedwater flow setpoint to compensate for errors in the flow measurements or any other unmeasured load disturbances (e.g. blowdown) that may effect the drum level; this is the cascade component of the control strategy. The summing function is used to combine these two components.

The square root functions on the flow transmitters linearize the relationship between flow and differential pressure in head-type flowmeters.

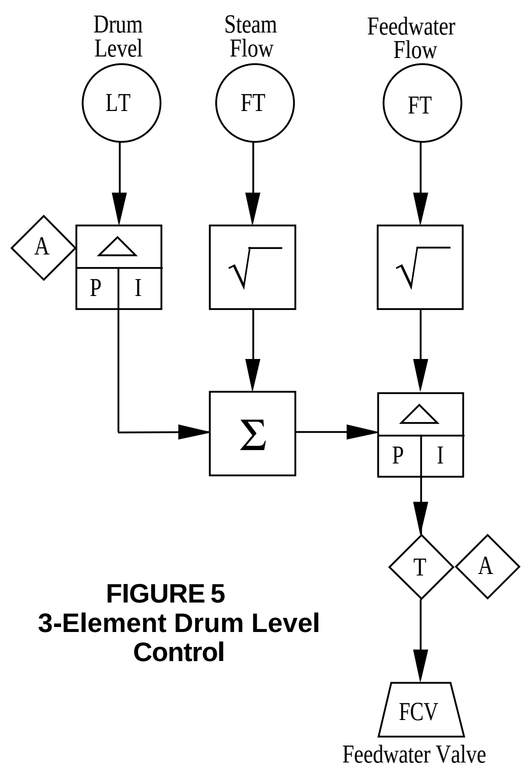


FIGURE 5
3-Element Drum Level Control

Logic Diagram

To avoid damage to equipment and injury to personnel, boiler control systems include safety systems for combustion control and burner management. These systems provide permissives and interlocks to ensure safe operating conditions and to shutdown or "trip" the unit if safe operating conditions are not maintained.

Figure 6 shows a typical logic diagram for a small portion of the safety system. This diagram shows the derivation of a boiler trip command signal and alarm indicators, based on high or low drum level, and power failures in the combustion control or burner management systems. For fail-safe operation, the drum level and power switches (LSH, LSL, JS) are ON for safe conditions and OFF for trip conditions. The NOT functions reverse the logic to accommodate this input convention.

The time delay functions on the drum level switch signals prevent nuisance trips due to brief violations of the level limits that may be caused by noise or transient behavior. As indicated in Table 1, these symbols require a time setting "t" and a two-letter designator for the function type (e.g. PD, DI, DT, etc.). DI stands for "Delay On Initiation"; in this example, the delay time is set for 20 seconds. The input signal must stay ON for at least 20 seconds before the output signal will turn ON.

One OR function provides a common alarm and trip signal for high or low drum level conditions. The other OR function provides a common boiler trip signal for a level trip, a CCS power failure, or a BMS power failure.

This example uses dotted lines to designate discrete logic signals. However, it is also acceptable to use solid lines when the logic diagram is separate from the continuous control diagram.

APPLICATIONS

SAMA diagrams are generally used to describe boiler control systems for the power industry. Although there is no reason they cannot be used to describe control systems in other industries, convention dictates that ISA diagrams are used in those industries. Therefore, the control engineer should be conversant in either method of diagramming control systems.

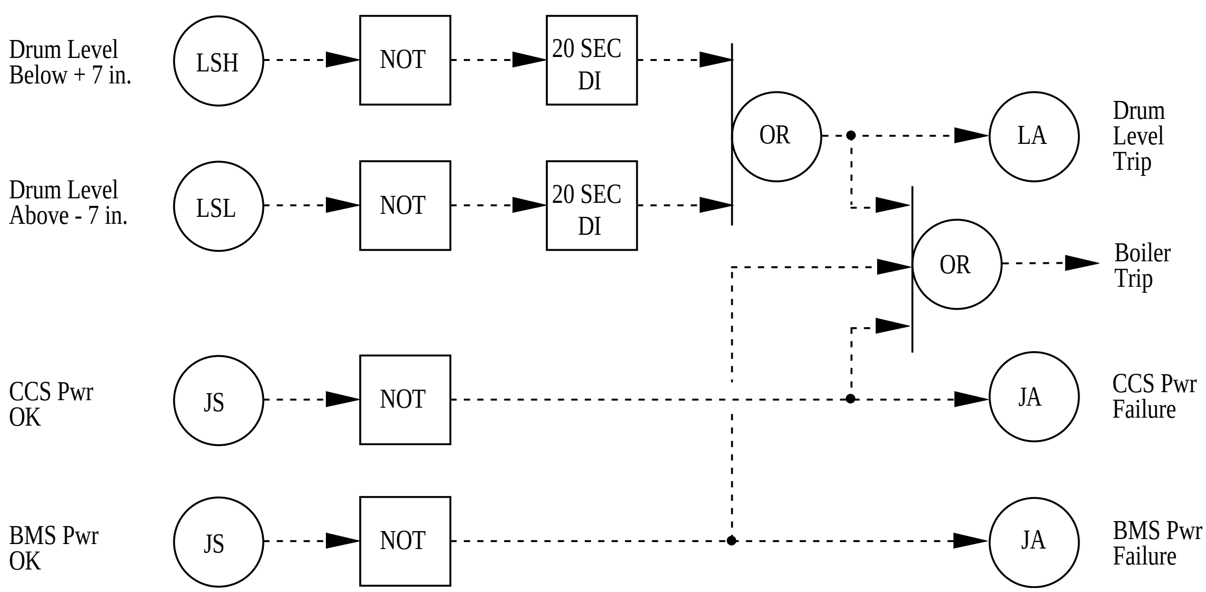


FIGURE 6 Typical Logic Diagram

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THE BENELUX

Wagenmakerstraat 3
2984 BD RIDDERKERK
Tel: +31 180 461111
Fax: +31 180 461132

CANADA

P.O. Box 370
Brampton, Ontario L6V 2L3
Tel: +1 905 457 9638
Fax: +1 905 457 4182

CHINA

Automation & Drives Group
10/F China Marine Tower
No. 1 Pudong Da Dao
Pudong New Area
Shanghai 100120
China
Tel: +86 21 5888 2000
Fax: +86 21 5879 0144

FRANCE

Logistique A&D
Tour Centre 5eme etage
39-47 Boulevard Ornano
93527 Saint Denis
Cedex 2, France
Tel: +33 1 49 22 93 18
Fax: +33 1 49 22 93 20

INDIA

34/35, MIDC Estate
"H" Block
Pimpri, Pune - 411 018
Tel: +91 20 7470171, +91 20 7470121
Fax: +91 20 7477049

ITALY

Via S. Aleramo 2
20063 Cernusco sul Naviglio (Milano)
Tel: +39 02 929054 1
Fax: +39 02 92905454

MEXICO

Tintoreto No. 32 - 302
Col. Nonoalco, Mixcoac
Mexico, D.F.
C.P. 03910
Tel: +52 5 611 9858; +52 5 615 1948;
+52 5 615 0262; or +52 5 615 0238
Fax: +52 5 611 4541

SINGAPORE

2 Kallang Sector
Singapore 349277
Tel: +65 740 7842
Fax: +65 740 7839

SOUTH AFRICA

Moore House
39 Monza Place
Kyalami Business Park
Midrand
Tel: +27 11 466 1673/9
Fax: +27 11 466 1618

UNITED KINGDOM

Copse Road
Lufton Industrial Estate
Yeovil, Somerset BA22 8RN
Tel: +44 1935 706262
Fax: +44 1935 706969

UNITED STATES

1201 Sumneytown Pike
Spring House, PA 19477-0900
Tel: +1 215 646 7400
Fax: +1 215 283 6358

Siemens Moore Process Automation, Inc.
1201 Sumneytown Pike
Spring House, PA 19477-0900

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