

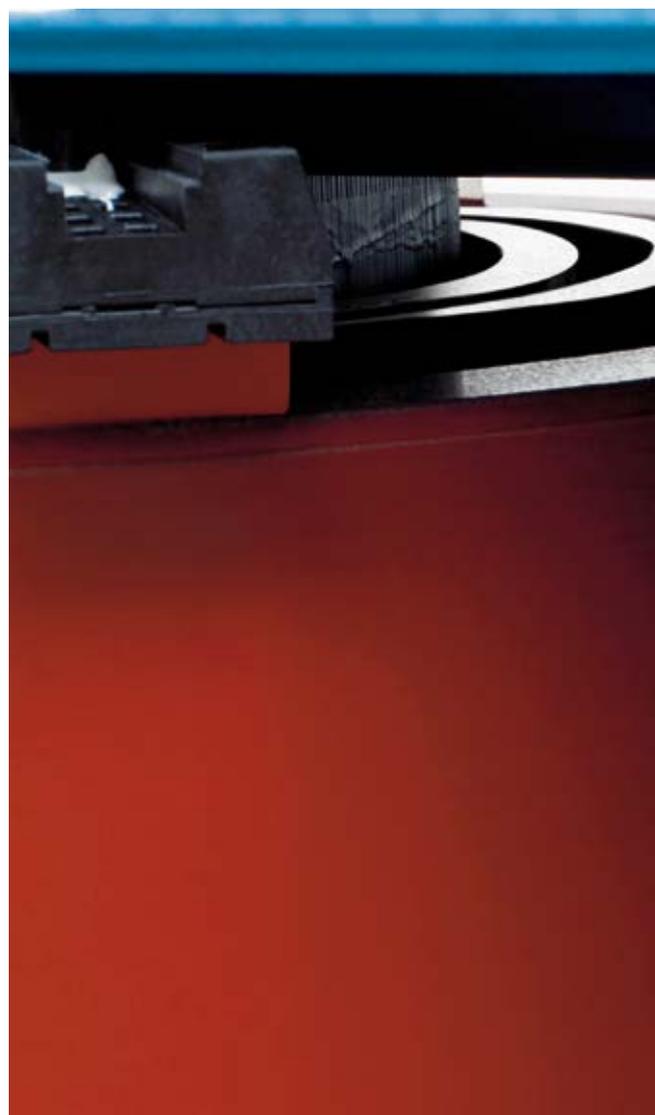
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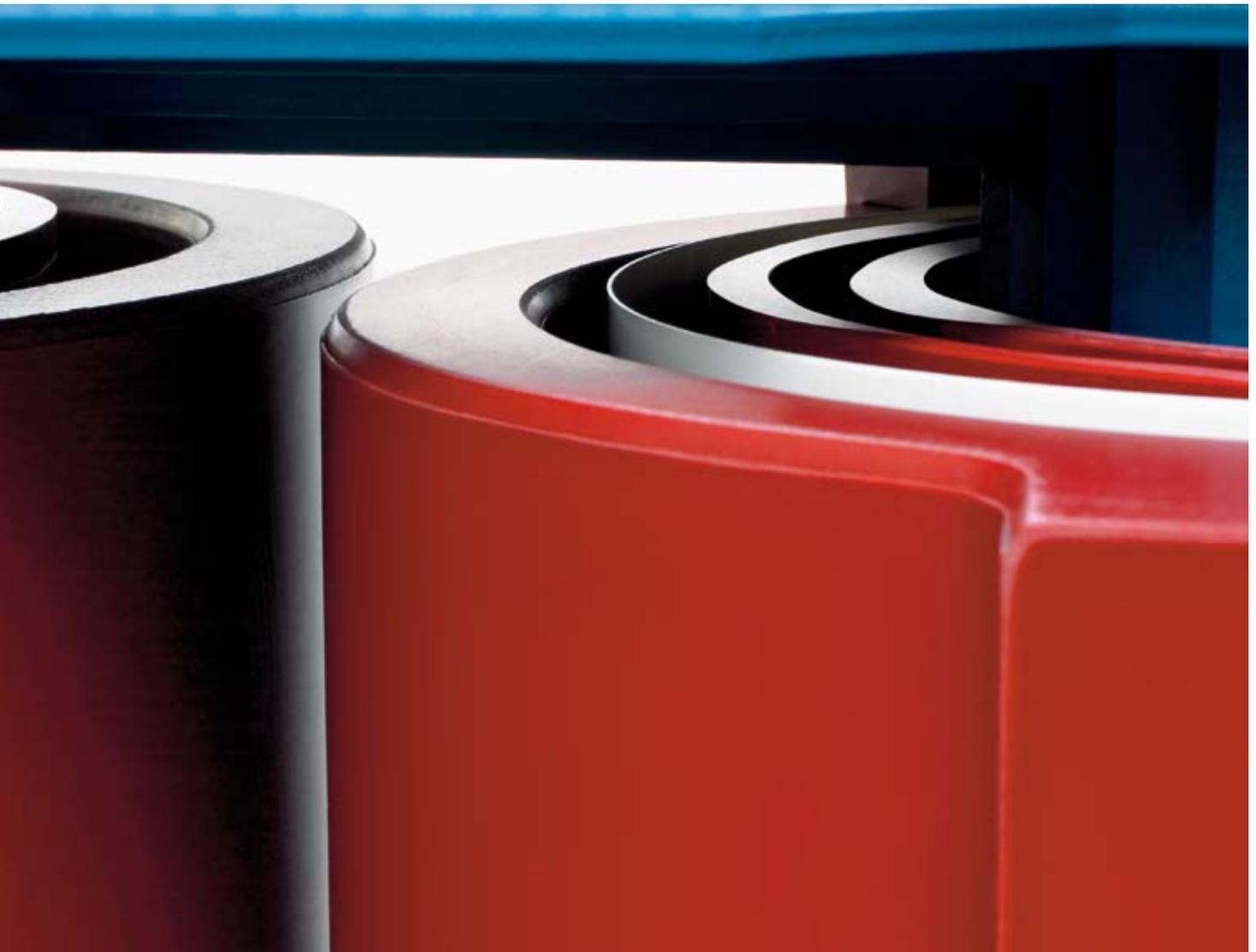
# GEAFOL Cast-Resin Transformers

Operating Instructions

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GEAFOL digital, with detailed video modules on installation, commissioning, and maintenance in the digital operating instructions. Simply scan the QR code on the left and install it as an app or go directly online using the QR code on the right.

# Scope

These operating instructions are applicable to all GEA FOL® cast-resin transformers of three-phase and single-phase design, including special versions such as rectifier and star-point transformers.

# Application

GEA FOL cast-resin transformers are particularly suitable for applications where fire or ground-water regulations would involve additional expense if liquid-immersed transformers were used, e.g., in ships, offshore and wind power plants, department stores, subways, sports stadiums and meeting halls, pumping stations, and water catchment areas. They are also being used more frequently in industrial applications for load-center substations and supply feeder stations because, with cast-resin transformers, there are no structural costs for oil catch pits and fire protection. This also greatly facilitates relocation of the transformers should it be necessary.



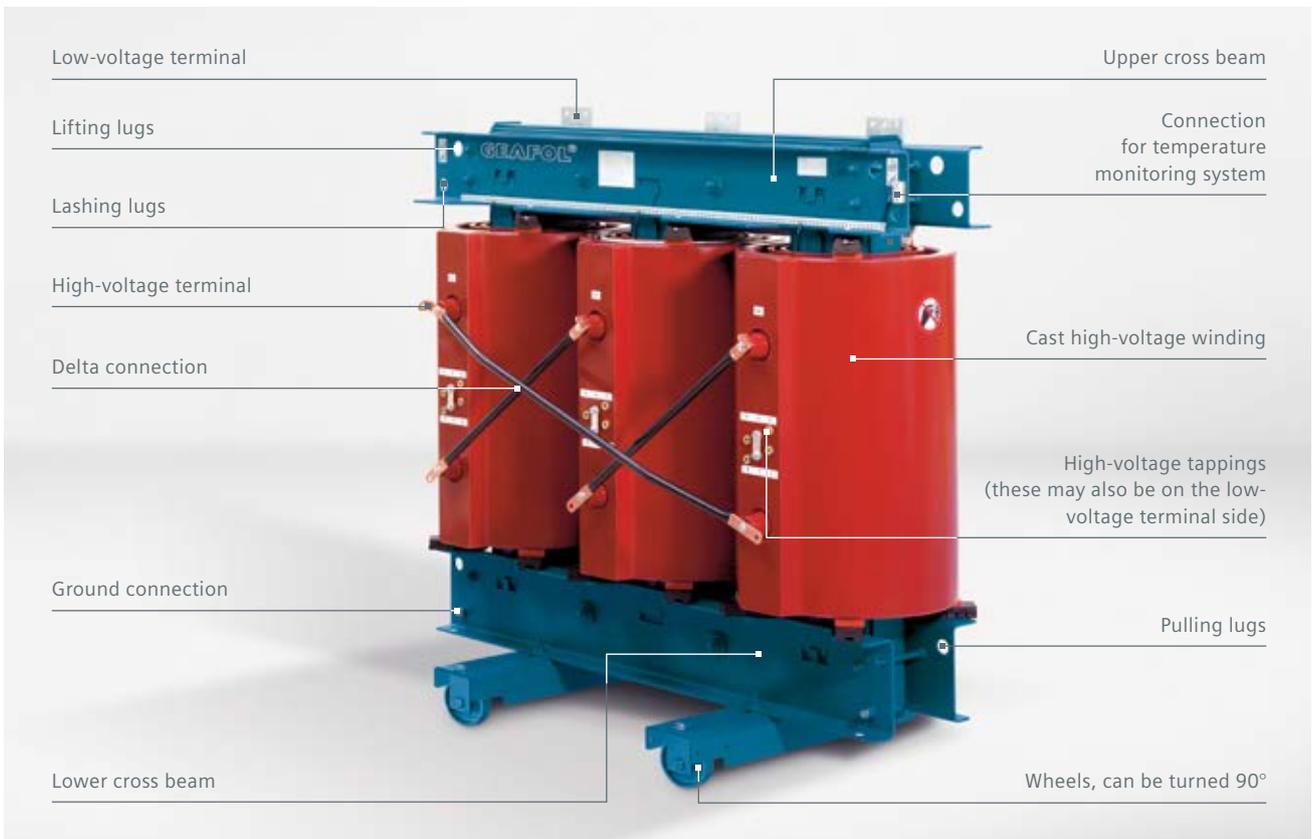


Fig. 1: 630 kVA GEA FOL cast-resin transformer  $10 \pm 2 \times 2.5\%/0.4$  kV high-voltage connection side



A new design for your success – the reliable, space-saving GEA FOL Basic

# Description



## Core

Only grain-oriented, cold-rolled plates insulated on both sides are used for the iron core.

The leg and yoke cross-sections are staggered by different lamination widths. The outer legs have miter joints and the middle leg a pointed miter joint at the yoke junction.

## Windings

The high-voltage coils are made of aluminum strips and high-quality insulating films. Each phase winding is formed from several separate coils connected in series which are encapsulated in resin under a vacuum. The winding ends and tappings are routed to threaded bushes and are encapsulated with the remainder of the winding. The low-voltage coils are made of aluminum strips and resin impregnated insulating film (prepreg).

## Insulation

The insulation structure is dimensioned on the basis of the impulse voltage distribution. It ensures freedom from partial discharge up to twice the rated voltage, as well as thermal and mechanical strength.

## Supports

A clamping arrangement designed specifically for the characteristics of the strip windings and flexible bracing of the coils ensure both high short-circuit strength and a very low noise level.

With GEA FOL Basic, the coils do not need to be clamped.

# Installing

## Unloading, transporting, unpacking, inspecting, cleaning, and storing

GEAFOL transformers may be unloaded and transported only by means of four individual cords attached to the lifting lugs provided on the upper constructional cross beam (see Fig. 1, page 5). The information about pulling at an angle provided on the labels at the lifting lugs must be observed (see Fig. 2, below). If a transformer is moved on its wheels, the points of action are the pulling lugs provided in the lower cross beams (see Fig. 1, page 5) or on the truck.

**Do not push or pull on the high-voltage windings or their connecting tubes.**

GEAFOL cast-resin transformers may be transported only by forklift truck if the transporting party ensures that

- the transformer is adequately secured against the risk of tipping and/or falling and
- damage to the iron core between the cross beams and any attached accessories such as fans or make-proof earthing switches is reliably prevented.



If signs prohibiting transport by forklift are attached near the bottom of the transformer, transport of the transformer by forklift is absolutely prohibited!

GEAFOL transformers should be unloaded and unpacked in a sheltered area and inspected immediately for transportation damage. Any damage visible on delivery must be noted in the transport papers and confirmed by the deliverer. The sender must be informed immediately so that a suitable claims settlement procedure can be initiated, if necessary with the participation of the transport insurance company.

If necessary, the transformer must be cleaned before commissioning (see recommendations for cleaning and checking GEAFOL cast-resin transformers on page 14).

**If the transformer is not commissioned straight away, it must be stored in a sheltered area that is dry and protected from sunlight. The area's temperature must not drop below  $-25^{\circ}\text{C}$  (unless otherwise agreed).**

The transformer must be packed in a protective film when being transported on-site or being stored temporarily. This effectively prevents the ingress of dust and foreign matter. In order to prevent condensation from forming, an adequate quantity of desiccant agent (such as silica gel) must be enclosed in the packaging.

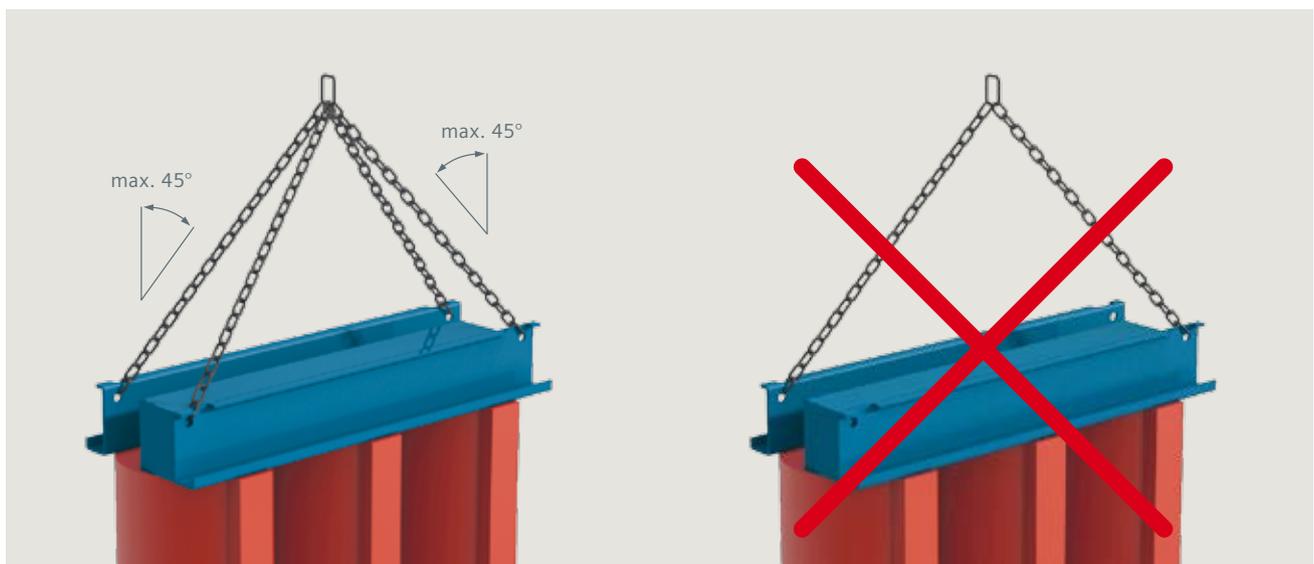


Fig. 2: Lifting the transformer

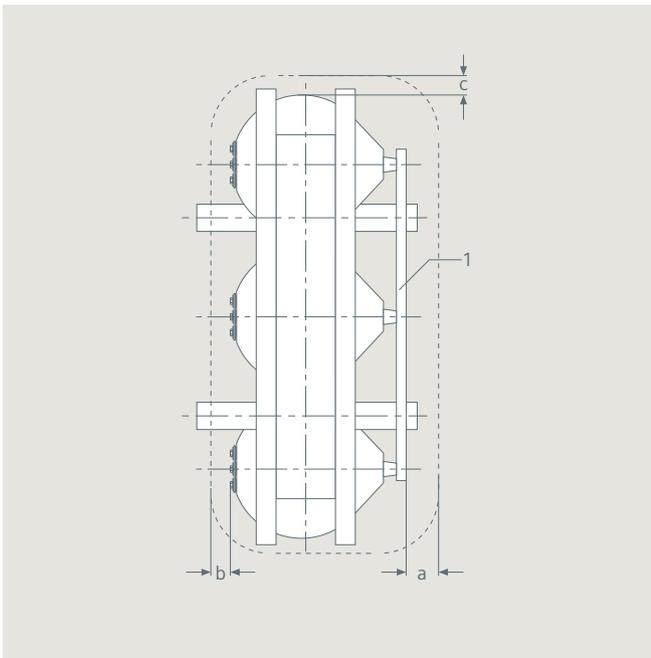


Fig. 3: Minimum clearances around GEAFOLE cast-resin transformers with switching strip (1)

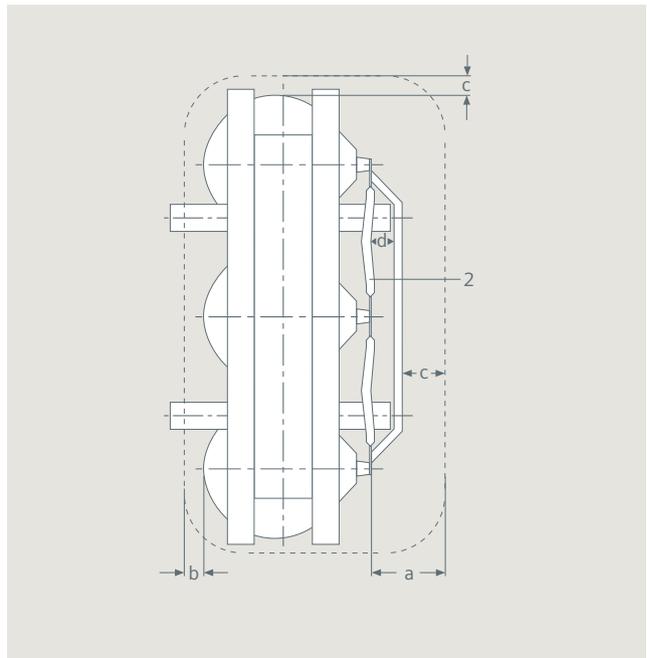


Fig. 4: Minimum clearances around GEAFOLE cast-resin transformers with connecting tubes (2)

### Setting up

GEAFOLE cast-resin transformers should be installed only in a sheltered area or cell that is dry and protected from sunlight, where the degree of protection assured is at least IP 23. If appropriately coated with special paint and if an outdoor housing is used, they are also suitable for installation outdoors. GEAFOLE cast-resin transformers need an adequate supply of fresh air to dissipate the heat loss. Approx. 200 m<sup>3</sup> of fresh air per hour and for each kW of heat loss is the recommended value; further information can be found in the GEAFOLE planning notes.

Also make sure that the clearances from the surface of the cast-resin coils to the walls, busbars, grounded parts, etc. satisfy the applicable installation and safety regulations (see Figs. 3 and 4).

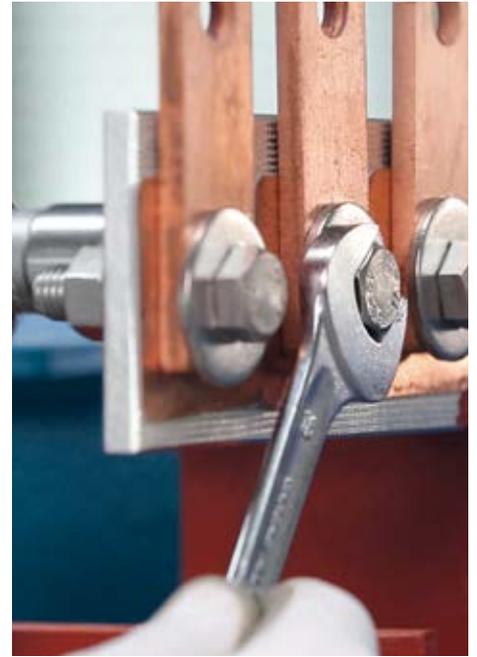
Cast-resin transformers are **not safe to touch**. The power must be shut off before work is carried out on the transformers. Applicable regulations must be observed.

Maximum voltage for equipment $U_m$ <sup>1)</sup> (rms value)	Rated lightning impulse withstand voltage $U_L$ <sup>1)</sup>		Minimum clearances			
	List 1 [kV]	List 2 [kV]	a [mm]	b [mm]	c [mm]	d [mm]
12	–	75	120	*	50	40
24	95	–	160	*	80	50
24	–	125	220	*	100	70
36	145	–	270	*	120	90
36	–	170	320	*	160	110

<sup>1)</sup> See IEC 60071

\* If there are high-voltage tappings on this side, the value in column a applies to the clearance b; otherwise, the value in column c applies.

Table 1



Transformers are designed in accordance with the applicable standards for the following cooling air values:

- 40 °C maximum
- 30 °C monthly average of the hottest month
- 20 °C annual average

If operated normally, the transformer should attain its expected service life consumption. In particular, the average annual temperature and the load crucially influence the service life consumption.

GEAFOL cast-resin transformers for installation at altitudes over 1,000 m above mean sea level are identified on the rating plate with the maximum permissible installation altitude. When transformers are installed accordingly, the minimum clearances listed in Table 1 (see page 8) must be increased by 1% for each 100 m above the altitude of 1,000 m.

### **Housings**

When using housings, note that all bolted connections must be firmly tightened during installation, thus avoiding damage to the transformer, e.g., as a result of nuts falling out.

### **Minimum clearances**

Adequate clearance must always be ensured around the transformer to enable connections to be made and also to keep to the necessary electrical clearances. The minimum clearances to prevent flashover are shown in Table 1 (see page 8) in conjunction with the sketch in Fig. 3 or 4 (see page 8).

# Connecting

On the high-voltage side, the transformer is connected to the surfaces of the connecting tubes or the terminals provided on the switching strip (delta connection), or to the cast-on post insulators of the high-voltage pottings (Y connection). When connecting by means of cables, make sure that they feature adequate strain relief and are routed so that the voltage clearances are maintained in line with relevant regulations. The minimum clearances for cable connections shown in Table 1 (see page 8) and Fig. 5 must be observed.

On the low-voltage side, the transformer is connected to the aluminum bars provided for this purpose (in special cases, to copper bars). The following guidelines must be observed when connecting conductor bars via expansion straps.

## Surface preparation

Before making any bolted or terminal connections, it is necessary to remove the thin, invisible layer of oxide, which is a poor conductor of electricity, from the aluminum surface.

For this purpose, the contact surfaces must be polished bare metal. Every time a point of contact is opened, the aluminum contact surface must be subjected to the whole preparation process again before it is bolted back together.

If the transformer is installed indoors in a room where condensation is frequently to be expected or where corrosive gases are present, an aluminum sheet copper-plated on one side (known by the trade name "Cupal", for example,) must be inserted between Cu-Al contact points so that the aluminum side is in contact with the aluminum bar and the copper side is in contact with the copper terminal. All edges of this sheet must protrude some millimeters so as to ensure that any corrosion occurring in the transition area remains outside the contact zone. Corrosion can be largely avoided by applying a protective coating to the cut edges of this "Cupal" sheet. Tin-plated terminals can be combined with bare copper, aluminum or silver-plated surfaces.

## Fastenings

Corrosion-proof parts must be used for bolted connections. Bolts belonging to strength class 8.8 or 10.9 should be used. In order to transmit the bolting force to the largest possible contact surface, stiffened washers should be inserted under the bolt head and the nut. Spring elements are also necessary to accommodate heat-generated tension resiliently, so as to compensate for plastic deformation and to thus maintain the required minimum contact pressure at all times. Both conditions are met by conical spring washers per DIN 6796, which are used particularly for conductor bar threaded fastenings.

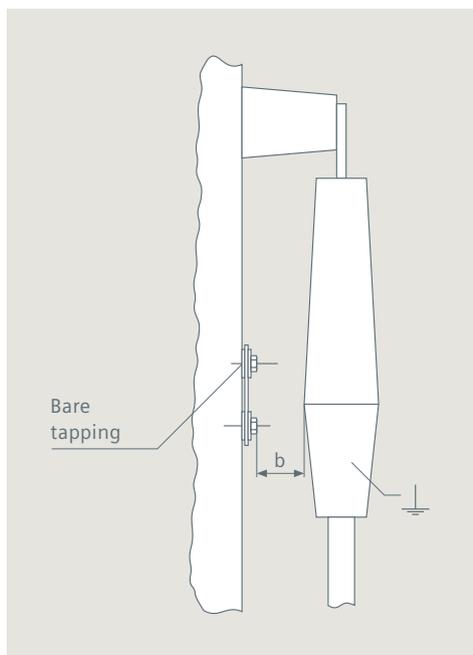


Fig. 5: Minimum clearance for cable connection; see Table 1

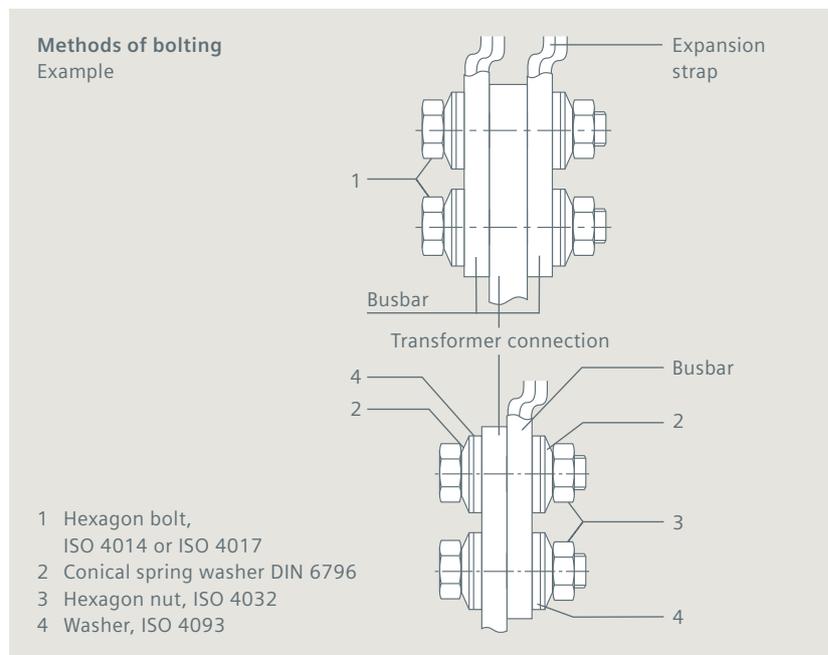


Fig. 6: Transformer connection with busbar

### Contact pressure

The bolts should be tightened with a torque wrench. This ensures that the bolt connections are made with adequate contact pressure.

To eliminate any settling in the joints, it is advisable to retighten the bolts after a few hours. However, the torque then applied should not be greater than the torque applied during the first installation.

Bolt	Torque [Nm] dry
M6	10
M8	20
M10	45
M12	75
M16	140

Table 2: Tightening torque values for the phase connections and tappings

We recommend the tightening torque values listed in Table 2 for tightening the ungreased (dry) bolted joints. If the low-voltage connection is established with busbars, an expansion strap (flexible connection element) must be installed between the transformer and the busbars. This keeps mechanical stresses away from the transformer (see Fig. 8) and largely prevents transmission of structure-borne transformer noise. Detailed information on bolted busbar connections can be found in DIN 43673.

### Grounding

Make sure that the necessary ground connection is established on accessories installed subsequently on the transformer. Transformer housings must also be grounded in accordance with the known grounding specifications.

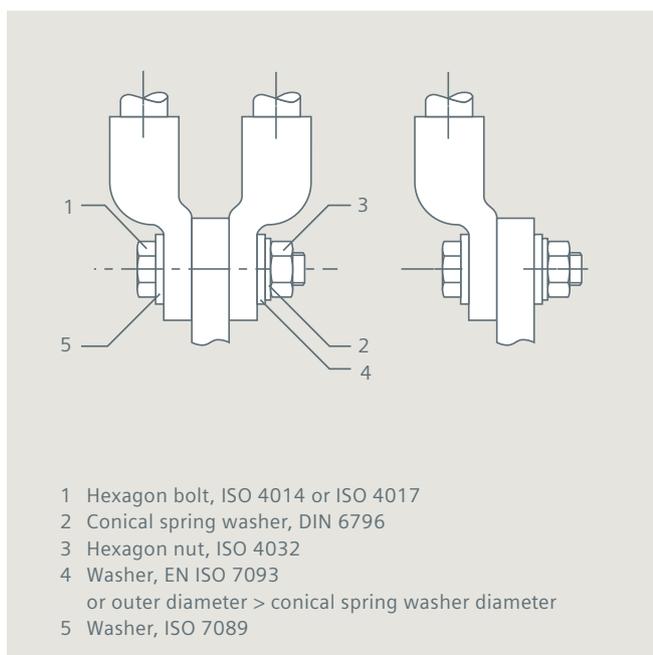


Fig. 7: Transformer connection with cable lug

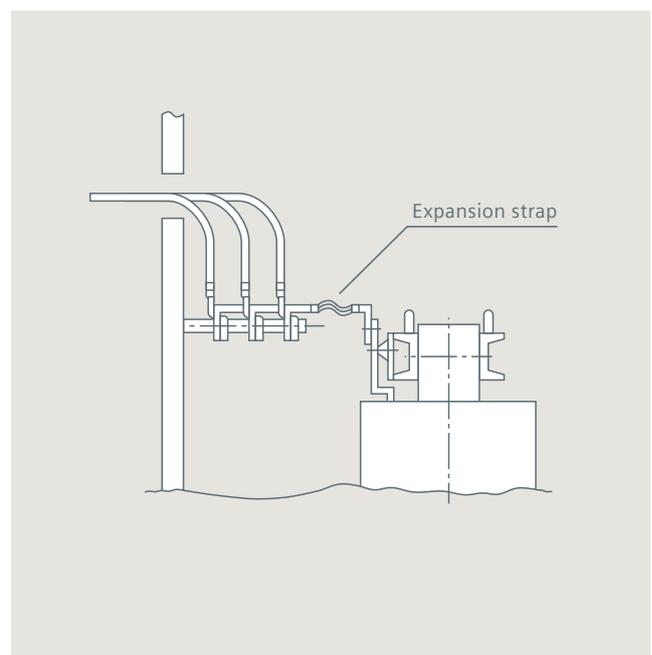


Fig. 8: GEAFOLE cast-resin transformers  
Low-voltage end connection with expansion strap

# Temperature monitoring

## General

The measuring sensors of the temperature monitoring system record the winding temperature. This acts as overload protection against excessive heat generation in the transformer winding. This protection does not prevent increased rate of service life consumption if the cooling air temperatures are not kept within specified limits (see list, page 8/9). The following versions or combinations can be installed:

## Description

The temperature monitoring system for GEA FOL cast-resin transformers consists of a PTC thermistor, DIN 44082-compliant temperature sensors or platinum resistance thermometers (PT100) in accordance with IEC 60751, and the associated evaluation devices. Positioning of the overload protection is identical for both systems. The evaluation devices must be designed for processing the signals from the particular system.

## Version with PTC

At least two PTC thermistors are installed in each of the low-voltage windings to be monitored. They are provided for warning and triggering. A third system can be installed, also subsequently, e.g., for controlling fans. The PTCs of the particular functional stage are connected in series and are routed to a terminal strip (max. 2.5 mm<sup>2</sup>) on the upper pressed metal sheet.

## Version with PT100

At least one resistance thermometer (PT100) is installed in each low-voltage winding to be monitored. The warning, triggering, or fan control functions must be set on the evaluation device. The corresponding setting values can be found on the information plate attached to the transformer. By default the PT100s are routed in a three-conductor circuit to a terminal strip (max. 2.5 mm<sup>2</sup>) on the upper pressed metal sheet.

## Evaluation devices

For the function and connection of the evaluation devices, refer to the respective operating instructions. Information about the devices can be found at [www.ziehl.de](http://www.ziehl.de) and [www.tecsystem.it](http://www.tecsystem.it)

The setting values for the corresponding trigger device in the case of PT100 temperature monitoring can be found on the information plate affixed to the transformer.



# Commissioning



The transformer must have been cleaned and it must not contain any foreign matter (see also Installing, page 7).

- Check technical data on the rating plate attached to the transformer against the customer's requirements.
- Tighten all contact connections to the torque stated in Table 2 (see page 11).
- Adjust any connecting brackets on the high-voltage tapplings to the prevalent voltage.
- The correct tapping connection is given on the rating plate. All connecting brackets at the HV windings must be fixed at the same voltage tapping. Tightening torques of the bolts are specified in Table 2 (see page 11). Adjust the connecting brackets only in the de-energized state.

When large idling transformers are switched on, in isolated cases visible sparks may occur on the outside (particularly in the area of the core and the clamped parts), but these will soon subside. This effect occurs for reasons of physics and has no influence on operating safety; it is not a defect. Due to the low attenuation, it may take the switch-on currents of GEAFOL cast-resin transformers some time to decay. Refer to the test report for the exact values. This must be borne in mind when selecting fuses and/or relay times.

If protection settings are wrong, the transformer will be switched off during the power-on current surge. This will lead to high excess voltages in the transformer windings, where they may cause damage.

# Recommendations for cleaning and inspection



GEAFOL cast-resin transformers are practically maintenance-free. If they are operated in very dusty installations, e.g., in rolling mills, we recommend cleaning several times a year.

In parallel, generally once every year, the contact bolts, warning facilities, and functioning of any attached fans should be checked.

The transformer must be switched off on all sides before maintenance work is begun. All terminals must be short-circuited and grounded. The safety regulations must be observed.

## **Cleaning transformers**

Particular care must be paid to cleaning all horizontal surfaces and support blocks in the area between the low-voltage and high-voltage coils where, according to experience, dirt can accumulate very easily.

## **Cleaning method**

- Rub the soiled surfaces with a cloth soaked in a conventional tenside-based cleaning agent. Then wipe with a dry cloth.
- Use a vacuum cleaner to remove loose parts and dirt in the cooling ducts as far as they are accessible.

## **Checking the torque values of bolted connections**

The torque values of the transformers' ground terminals (and above all the bolted connections of all electrical terminals), the high-voltage tapplings, and the connections from one system to another in the case of double-tier transformers should be checked once every year. Use a torque wrench or a force-limiting wrench to check bolted connections against the values listed in Table 2 (see page 11).



### Faults

In case of faults that cannot be cleared by the customer itself, a service department of Siemens AG should be notified.

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### Checking warning facilities

The "Inspection" function for the evaluation devices can be carried out as specified in the operating instructions. Visual inspection of the terminal connections on the transformer is recommended.

### Checking attached fans

If possible, the functioning and running characteristics of attached fans should be checked once every year.

#### Please note:

**On delivery, the default setting of the monitoring system types T154 and NT935 includes a functional test for fans. If run in the factory default setting, every 96 hours the fans will undergo a short test lasting 5–10 minutes.**

### Protective housings

Protective housings can be cleaned in the same way as control cabinets. Ensure particularly that air inlet and outlet openings are clean of dust and dirt deposits.

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