



Marine Engine Market Segment

Over the recent years regulators have imposed more stringent regulations on the emissions of marine engines for example low sulphur emissions as defined in MARPOL. New engines are now designed to comply with the Tier II NOx regulations and Energy Efficiency Design Index (EEDI) guidelines.

These regulations together with the constant requirement to reduce operation costs have resulted in the design of more fuel efficient ship engines. The new generation of ship engines have longer piston strokes and operate at a lower temperature that is below the dew point and at higher pressure compared to previous generations of ship engines.

Previously, sulphur in the engine was in a gas form as SOx. Now, because of the lower temperature the H2S can react with water, that condense on the liner of the cylinder walls, to form sulphuric acid, resulting in corrosion on the liner surface.

This process is called cold corrosion and it creates excessive wear of the liner material. How serious is cold corrosion for my engine? Cold corrosion is at its most serious in the latest engine designs but also impacts earlier engine designs modified for part-load or low-load operation (known as 'slow steaming', where vessels may operate as low as 10% load). Many ship operators have switched over to slow steaming in recent years to save fuel costs and as a consequence the engine management and oil condition monitoring becomes increasingly important for ship operators.

The key parameters that have a direct influence on the cold corrosion potential are the cylinder temperature, the base number of the cylinder oil, the load factor, lubricator feed rate, sulphur content of the fuel that is used. All these parameters are influenced by each other and it is important to identify the optimum working point of the engine where all the parameters are balanced and stable.

The IR Sphinx spectrometer range is a very useful tool to ensure that the engine operates efficiently. This can



be achieved by analysing the cylinder oil at a suitable position, i.e. the underside of the piston to extract relevant oil parameters such as Total Base Number, water content, oxidation level etc.

The spectrometer can either be configured as an inline marine oil analyser or a portable ATR unit can be used to carry out frequent spot-checks of the cylinder oils. In both cases the marine oil analyser will provide an accurate picture of the stats of the oil and the information obtained can be used to fine tune the engine to achieve the lowest possible operating costs.

The marine oil analyser does not require any consumables and does not require the use of any wet chemical substances. The results will be available within minutes and can be used as a real time feedback for the ship engineers.

With the data being available in digital format it can be presented to an operator in form of a traffic light system or engineers can study the data in detail to gain a further understanding of how the fuel type (i.e. using high sulphur fuel), the lube oil feed rate or the total base number of the cylinder oil influences the lifetime of the cylinder.

Applications notes for these parameters can be found on our website:

TBN, Water, Soot, Oxidation



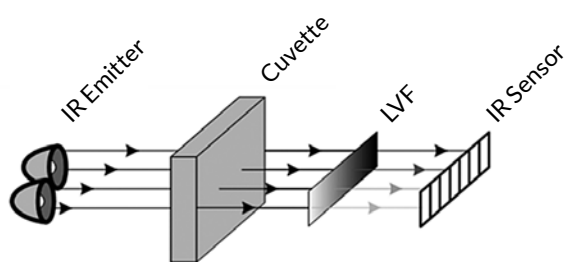
Mid-infrared spectroscopy

Mid infrared spectroscopy (Mid IR) is a powerful technique for measuring the concentration of organic molecules. Mid-IR spectroscopy covers the absorption of light by a sample in the range from 2000 nm to 12000 nm. In this wavelength range the absorption of light at a specific wavelength can be linked unequivocally to a certain molecular structures that subsequently identifies the molecule.

In the Mid-IR wavelength region each molecule absorbs light at a molecule characteristic wavelength and the amount of light absorbed is a measure of the concentration of the particular molecule in a sample.

As different molecules absorb light at different characteristic wavelength in the Mid-IR wavelength region the measurement of a mid-infrared absorption spectrum from 5500 nm to 11000 nm can be used to identify the existence and the concentration of a multitude of different molecules in a sample.

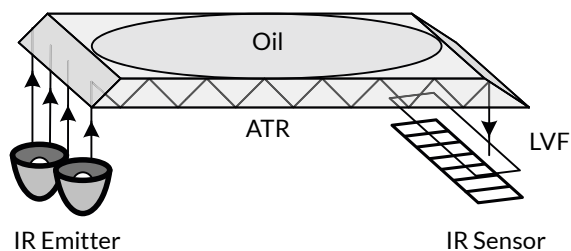
Mid-infrared spectroscopy is either carried out in transmission mode or in ATR mode where ATR stands for Attenuated Total Reflection.



In transmission mode (see picture above) the light from a broadband emitter is directed through a cuvette (which contains the sample) onto a grating. The grating splits out the light into more discrete wavelength (similar to a rainbow) and the light then falls onto an infrared sensor (line array) where each pixel corresponds to a specific wavelength. A mid-infrared absorption spectrum is recorded by first recording the signal levels of each of the pixels of the line array without a sample being present in the cuvette. This is called a background measurement. Subsequently the measurement is repeated but with a sample being

present in the cuvette. This is called the sample measurement. The difference between the background measurement and the sample measurement originates from the light that is absorbed by the sample and it is called the absorption spectrum of the sample.

The working principle of the ATR mode is shown below. Light from a broadband emitter is coupled into an ATR crystal. The geometry of the crystal is designed in such a way that the light bounces through the ATR crystal (total internal reflection) and is coupled out on the other side where the light is again split up into discrete wavelengths by a grating and detected by an infrared line array.



If now a sample is placed on top of the ATR crystal the refractive index of that sample is different to that of air resulting that the light penetrates which each bounds a certain distance into the sample before it is reflected back into the ATR crystal (evanescent waves). Which each bounce certain wavelength of the light are absorbed by the sample sitting on top of the ATR crystal.

An absorption spectrum of a sample in ATR mode is obtained in the same way as in transmission mode. First a measurement is taken without a sample being present on the ATR crystal (background measurement). Subsequently a sample is placed onto the ATR crystal and the sample measurement is taken. The difference is again called the absorption spectrum of the sample.

In principle both transmission mode and ATR mode provide exactly the same absorption spectrum of the sample and it depends on the exact application which measurement mode is best suited.



Oil conditioning monitoring based on Mid-IR spectroscopy

Many different substances can be used to lubricate a surface. Oil and grease are the most common. Grease is composed of oil and a thickening agent to obtain its consistency, while the oil is what actually lubricates. Oils can be synthetic, vegetable or mineral-based as well as a combination of these. The application determines which oil, commonly referred to as the base oil, should be used. In extreme conditions, synthetic oils can be beneficial. Where the environment is of concern, vegetable base oils may be utilized.

Lubricants containing oil have additives that enhance, add or suppress properties within the base oil. The amount of additives depends on the type of oil and the application for which it will be used. Typical additives are anti-foam additives, anti-wear additives and anti-oxidants. The only problem with additives is that they can be depleted, and in order to restore them back to sufficient levels, generally the oil volume must be replaced.

As such a replacement of the lubricants can be very expensive (either directly due to the high costs of the lubricant or indirectly due to downtime of the engine and lost earnings) it is desirable to have a cost effective oil conditioning monitoring sensor that provides accurate and reliable information about the condition of the oil.

Mid-IR spectroscopy is well suited to oil condition analysis. During the aging of the oil, different decomposition and conversion processes occur at the molecular level resulting in changes in the absorption spectrum. As these aging processes introduce changes in the absorption spectra at many different characteristic wavelengths one IR spectrum of an oil sample can provide accurate and conclusive information about the status of the oil and about it can help to identify the root cause of the aging mechanism as the characteristic wavelength, where the change in absorption is observed, is linked to one specific and uniquely identifiable molecular structure.

The oil aging or degradation process can be attributed to three key aging mechanisms:

- oil degradation
- additive depletion
- contamination

Base oil degradation is predominantly driven by an oxidation processes. It can be viewed as the chemical breakdown of the base oil molecules with oxygen as a reagent. The principle source of oxygen is air. There are a number of parameter that accelerate the oxidation process such as high temperature, wear particles, water and other contaminants. The breakdown of the base oil involves a number of chemical reactions that produce acid compounds which undergo further reactions to form polymeric compounds resulting in varnish, sludge and other deposits. Typical oil condition parameters related to base oil degradation are: Oxidation, Total Acid Number (TAN), Total Base Number (TBN), nitration and sulphation.

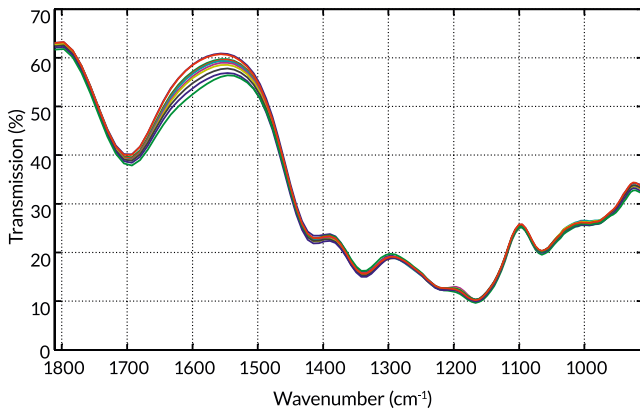
Additives are part of any modern lubricant solution. Additives are functional groups, usually with central ions such as zinc, molybdenum, magnesium etc. that are suspended into the base oil to enhance the overall performance of the lubricant. Typical additives are used to combat the main degradation mechanism of the base oil and they address areas such as anti-foam additives, anti-wear additives and anti-oxidants additives.

During the oil ageing process the concentration of additives within the lubricant decreases and once the additive concentrations have reached a lower threshold concentration the degradation of the lubricant becomes inevitable. Monitoring the concentration levels of the different additives is therefore very important to get a good understanding of the current condition of the oil.

Typical additives used to neutralise the key degradation mechanisms are molecules with central ions of

zinc, molybdenum, phosphorus, calcium, magnesium, barium or sodium. Again these molecules have uniquely identifiable characteristic absorption wavelength and by way of measuring the infrared absorption spectrum of an oil sample the respective concentrations of each of the additives can be determined.

Oil contamination is often caused by foreign substances such as water, glycol, diesel, petrol or foreign oils. Each of these substances have unique characteristic absorption wavelength and can therefore easily being identified. This is shown in the figure below for water contamination of a oil between 250–5000 ppm. A characteristic water absorption peak at 1644 cm^{-1} develops as the water concentration in oil increases.



Mid-IR spectroscopy is able to provide information (qualitatively and quantitatively) about the three different aging mechanism. By a detailed analysis of the mid-infrared absorption spectrum of an oil sample the oil condition can be characterised and specific degradation mechanism can be identified and analysed.

Oil Condition Sensors based on Mid-IR spectroscopy

The oil condition sensor of the IR Sphinx series detects the three major oil degradation mechanism simultaneously. The standard oil condition parameters, that are commonly obtained by laboratory based analysis, are calculated from the measured IR spectra.

The sensor is based on a spectral apparatus that is constructed with no moving parts, which makes it durable and virtually maintenance free. Meaningful oil condition parameters are calculated from the recorded spectra by a previously built oil-specific calibration (chemometric model).

The sensor also does not require any consumables or wet chemistry which significantly enhances the safety aspect and reduces long term operation costs.

One sensor can be configured to measure all parameters that are relevant to the oil condition monitoring and maintenance of marine engines.

In addition to portable systems for rapid on-site analysis, device models for use in the laboratory are available – as well as rugged field installations for

In addition to portable systems for rapid on-site analysis, device models for use in the laboratory are available – as well as rugged field installations for inline operation.



IR Sphinx ATR product portfolio and technical specification

Spectrometer

**IRSphinx
ATR Lab**



**IRSphinx
ATR Portable**



**IRSphinx
ATR Industrial**



Spectral range	2.5–5.0 μm 4000–2000 cm^{-1}		5.5–11.0 μm 1800–900 cm^{-1}		2.5–5.0 μm 4000–2000 cm^{-1}		5.5–11.0 μm 1800–900 cm^{-1}		2.5–5.0 μm 4000–2000 cm^{-1}		5.5–11.0 μm 1800–900 cm^{-1}	
ATR Crystal Material	ZnS	ZnSe	ZnS	ZnSe	ZnS	ZnSe	ZnS	ZnSe	ZnS	ZnSe	ZnS	ZnSe
ATR Frame Material	Stainless steel											
Spectrometer Housing Material	Anodized aluminium											
Number of Sample Reflections	9											
Dimensions (L x W x H)	165 x 74 x 35 mm											
Protection Class	IP64											
Battery	–				Lithium polymer (LiPo) 1300 mAh				–			
Power Requirement	5 Volt DC, 5 W				5 Volt DC, 5 W				5 Volt DC, 10 W			
Standalone Operation	–				–				yes			
Interface	USB, Ethernet				USB, Ethernet, Bluetooth				USB, Ethernet, CANopen			
Weight	~700 g				~710 g				~750 g			

IR Sphinx Transmission product portfolio and technical specification

Spectrometer

**IRSphinx
Transmission Lab**



**IRSphinx
Transmission Portable**



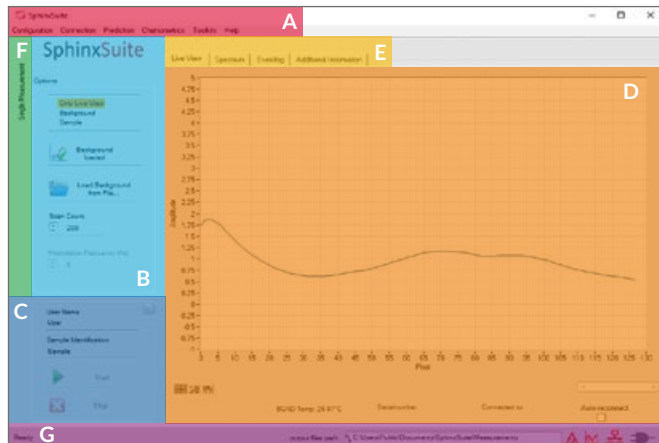
**IRSphinx
Transmission Industrial**

Spectral range	2.5–5.0 μm 4000–2000 cm^{-1}		5.5–11.0 μm 1800–900 cm^{-1}		2.5–5.0 μm 4000–2000 cm^{-1}		5.5–11.0 μm 1800–900 cm^{-1}		2.5–5.0 μm 4000–2000 cm^{-1}		5.5–11.0 μm 1800–900 cm^{-1}	
Cuvette	Aluminium				Aluminium				Stainless steel + fluid channels			
Spectrometer Housing Material	Anodized aluminium											
Dimensions (L x W x H)	85 x 99 x 97 mm				165 x 74 x 97 mm				85 x 99 x 97 mm			
Protection Class	IP44				IP64				IP44			
Battery	–				Lithium polymer (LiPo) 1300 mAh				–			
Power Requirement	12 Volt DC, 5 W				5 Volt DC, 5 W				12 Volt DC, 10 W			
Standalone operation	–				–				yes			
Thermal Stabilisation	–				–				yes			
Interface	USB, Ethernet				USB, Ethernet, Bluetooth				USB, Ethernet, CANopen			
Weight	~430 g				~720 g				~460 g			

Sphinx Suite-Software

All Spectrolytic's products come with a proprietary software called Sphinx Suite. The software is modular and can be customised as required. The software also has the option to interface directly with commonly used data processing software such as Unscrambler.

By default all spectrometers are delivered with the Basic software option. The Basic software module allows the customer to perform measurements, save data, export data etc.



A: Menu bar with configuration options

B: Measurement options and import/export configuration

C: Start & Stop measurement button

D: Graphic display

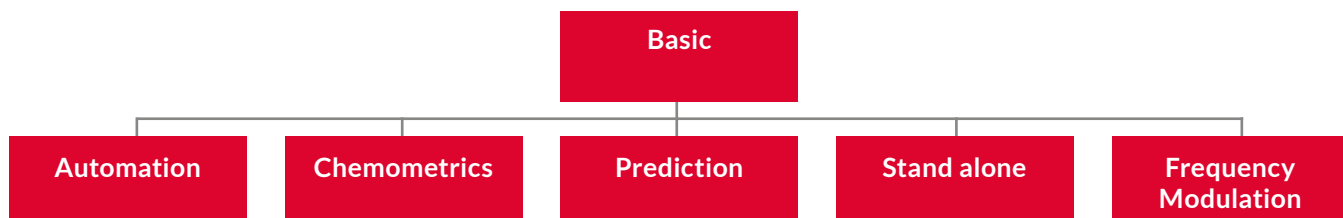
E: Data selection tabs

F: Measurement selection

G: Status bar with information about battery charge level, connection and folders

Sphinx Suite-Software Modules

The picture below depicts the available software modules that are available within Sphinx Suite.



Basic software Measuring and capturing spectral data, saving data, exporting data to Excel etc.

Automation module Definition of measurement routines, Continues execution of measurement routine, automatic data capture, automated reconnect after computer restart, trigger modus, control of extension interface

Chemometric module ANN model builder (classification), PLS1 model builder (quantification), SIX model builder (similarity index), band pass filter model builder, Definition of control parameters, saving of models, analysis of historic data

Prediction module Integration in Automation module, automatic evaluation of measured IR spectra, visualisation of control values, saving of the analytical results, generation of customised reports

Stand alone module OCOM interface (allows user to control spectrometer via external interface), transfer of automation sequences onto spectrometer, autonomous measurement by spectrometer without computer

Frequency Modulation module Optimisation of emitter modulation frequency between 5–20 Hz