

CECO Effox-Flextor



DAMPERS & EXPANSION JOINTS

**FOR FLUE GAS AND PROCESS AIR
HANDLING SYSTEMS**





4 CAPABILITIES



8 DAMPERS



16 EXPANSION JOINTS



20 MARKETS & SERVICES



21 CECO ENVIRONMENTAL



22 PROJECTS



INTRODUCTION

CECO Effox-Flextor the international leader in the design and manufacture of dampers and expansion joints for use in flue gas and process air handling systems. Our team includes a skilled staff of engineers, designers, fabricators, and field service personnel to ensure the highest quality engineered-to-order product.

WHY WORK WITH CECO EFFOX-FLEXTOR?

Quality Products

- Dampers and Expansion Joints
- Complementary product lines
- Engineered-to-Order products
- High value for the total cost
- Supplier of products for full system integration

Extensive Capacity

- 100,000 Sq Ft. (9,300 Sq. m) captive shop in the USA
- 200,000 Sq. Ft. (18,600 Sq. m) CECO captive shop in China
- Experienced global fabrication partners

User Friendly

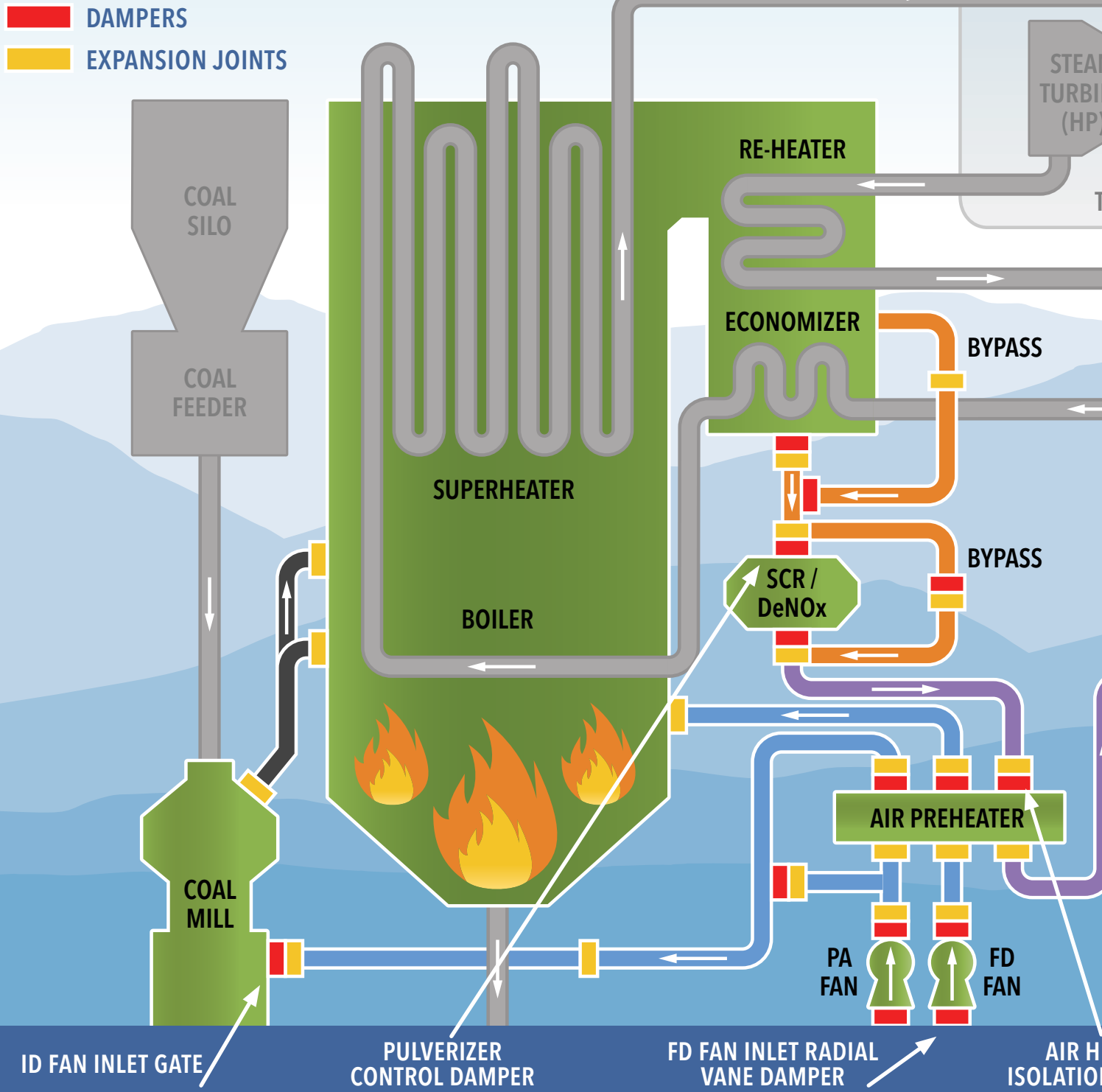
- On time deliveries
- Practical installation and maintenance manuals
- Global start-up technicians
- Spare parts and service support

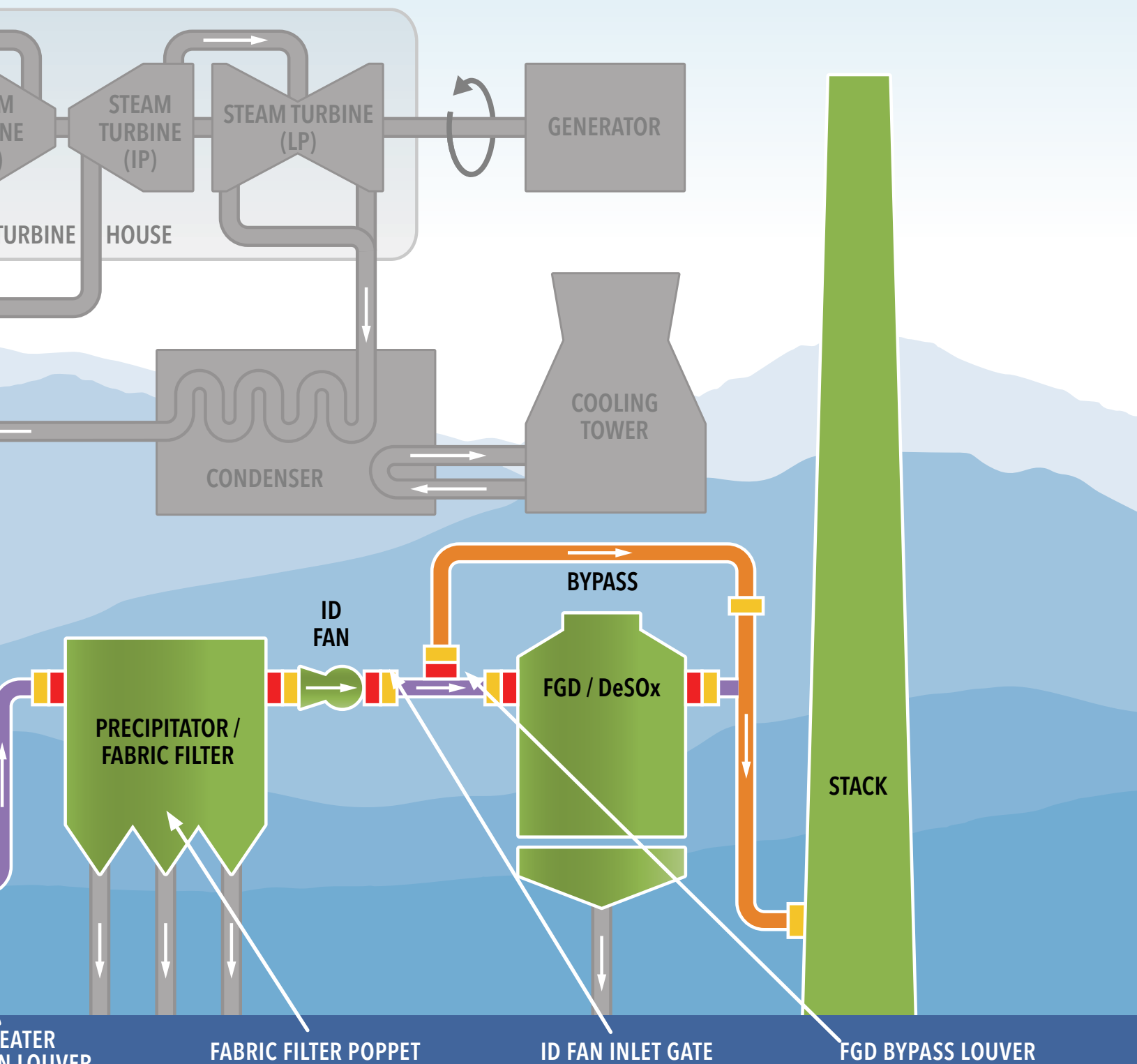
Experienced Professionals

- Specialized industry expertise
- Reliable products
- High customer satisfaction ratings
- Knowledgeable Regional Sales Representatives



CAPABILITIES





CAPABILITIES



DAMPERS

With over 35 years of experience, **CECO Effox-Flextor** offers time tested robust dampers to achieve a 20+ year low maintenance design life. Constructed with carbon steel, stainless steel, alloy, and/or corrosion resistant materials our dampers are capable of withstanding temperatures up to 1800°F (982°C) and the most chemically punishing environments. Our engineering and design team is involved with every project to ensure the structural and dynamic integrity of our products.

Standard design considerations:

- 300% safety factor on drive sizing
- Maximum of 60% of yield stress on all components
- Modeling to minimize pressure drop, frame deflection and blade deflection
- High quality components and trademarked material selection to minimize maintenance

EXPANSION JOINTS

CECO Effox-Flextor is the recognized leader in providing non-metallic expansion joints to the utility and industrial markets around the world. With custom engineered designs for each application, **CECO Effox-Flextor** has provided reliable flexible solutions for service from -40°F to 2100°F (-40°C to 1149°C). Our **EFLEX™** expansion joints reflect the highest engineering standards and professional workmanship in the power generation and heavy industrial market. The **CECO Effox-Flextor** team provides customer service and technical support from project inception to completion.

- Over 100 years of combined experience in the Expansion Joint Industry
- DuPont Certified Supplier of
- VITON® Fluoroelastomer Expansion Joints
- Long time contributing member of the FSA (over 25 years)



QUALITY AND CERTIFICATES

All **CECO Effox-Flextor** fabrication is performed according to strict Quality Control procedures.

Our quality standards include:

- 3AISC (American Institute of Steel Construction)
- AWS (American Welding Society)
- CWB (Canadian Welding Bureau)
- ISO 9001:2008

We are also members of the following trade associations:

- ASME (American Society of Mechanical Engineers)
- FSA (Fluid Sealing Association)

CECO Effox-Flextor offers in-house, non-destructive testing using approved and certified testing methodology. Our in-house quality control staff includes full-time certified welding inspectors (CWI).

GUILLOTINE/SLIDE GATE DAMPERS

CECO Effox-Flextor manufactures heavy-duty low-leak slide gate and zero-leak slide gate dampers to provide isolation for flue gas and air systems. Slide gates, also referred to as guillotine dampers, are required to isolate systems for maintenance or for bypass purposes.

CECO Effox-Flextor has supplied slide gate dampers in the largest ducting systems in the industry. We have supplied gates with duct openings of 25 feet (7.6 m) wide and 35 feet (10.7 m) tall. Our zero leak guillotine dampers are pressure and temperature tested to verify leakage at system design conditions. Our guillotine dampers can be found in some of the most demanding environments such as high dust loading zones in cement plants, highly corrosive environments in coal fired power plants and high temperature and high velocity gas turbine systems.



Zero-Leak design

- Allows for complete isolation of the flue duct
- Seal air fan provides 200% safety factor with
- a minimum of +3 inches w.g. (7.5 mbar) above system pressure

Low-Leak design

- For use in negative pressure systems or where small flue gas pass through may be tolerated
- Blade guides and angle seats provide an economical alternative for low leak applications

Optional designs and features include:

- Drive system:
 - Chain and sprocket system with
 - proprietary **CECO Effox-Flextor** sprocket design
 - Rack and Pinion
 - Linear drive system
- Electric, pneumatic, hydraulic, or manual actuation
- Bottom chamber with clean out ports allows blade to cut through particulate obstructions in the duct
- Mullion seals coupled with re-entry seals provide complete removal of blade from the gas stream
- Metallic leaf seal and retainer design achieves tight shutoff and ease of maintenance

**SEAL AIR SYSTEMS ARE DESIGNED WITH
200% SAFETY FACTOR TO ENSURE ZERO
FLUE-GAS LEAKAGE WHEN REQUIRED**

**ALL DAMPERS ARE FULLY
ASSEMBLED, CYCLED, AND TESTED
IN THE SHOP PRIOR TO SHIPMENT**

LOUVER DAMPERS

Designed for flow control or isolation, **CECO Effox-Flextor** offers several styles of louver dampers to meet your application and system specifications.

Our louver dampers are offered with a parallel blade or opposed blade design. Parallel louvers are primarily used for system isolation. **CECO Effox-Flextor** parallel blade louvers are used around the world in applications for bypass capability and tight shut off for the process & utility industries.

The **CECO Effox-Flextor** opposed blade louver offers the ability to accurately modulate and control flow over a design range. The opposed blade design helps to create a more uniform flow across the damper.

Louver design features:

- Bolted dual airfoil design to minimize deflection and warping of blades
- Electric, pneumatic, hydraulic, or manual actuation
- Outboard bearings to prevent flue gas exposure and allow for ambient cooling. Bearings are permanently sealed and lubricated to eliminate maintenance
- Bolted packing assembly at damper shafts for ease of maintenance
- Blade to blade, top & bottom, and jamb seals are available to minimize leakage to less than 1% of flow volume

Zero-Leak design

Along with our standard dual bolted airfoil design, **CECO Effox-Flextor** offers two damper models with a zero -leakage design.

Double louvers

- Two banks of blades. The area between the banks of blades is pressurized with seal air to achieve zero leakage
- Options for in-sync actuation or independent actuation of banks of blades when control is needed
- “Belt and Suspenders” approach



Tandem louvers

- One bank of blades with open space in-between blade assemblies. When in the closed position the open space between the blades is pressurized to achieve zero leakage
- Offers a lower cost alternative and smaller footprint to the double louver



**BOLTED DUAL AIRFOIL
LOUVER BLADE DESIGN**



**300% SAFETY FACTOR ON DRIVE SIZING
FOR LONG TERM RELIABILITY**

DIVERTER DAMPERS

CECO Effox-Flextor has extensive experience in the design and supply of toggle and pivot style diverter dampers for HRSG, waste heat recovery, gas turbine, and other systems that require diversion of the gas stream. We have designed and installed diverter dampers in systems ranging from small engine units to the largest turbines in the world such as the GE Frame 7 FA & 9 FA.

Additionally, **CECO Effox-Flextor** can supply a variety of diverter arrangements including louvers, butterfly/wafers and guillotines. Leakage options range from low leak to zero leak, and man safe with the use of a blanking plate. We can engineer the best arrangement for your leakage, pressure drop, operational needs, and safety requirements.

CECO Effox-Flextor can pair any of our diverter designs with stacks, silencers, expansion joints, structural supports, and/or ladders and platforms to supply a turn-key diverter solution custom designed for your application.

Our louver style diverter offers cost-effective fine-tuned flow control where higher pressure drop is acceptable.

STACK ISOLATION DAMPERS

CECO Effox-Flextor offers a wide range of options for stack dampers. Whether the installation is for large diameter or rectangular stacks our blade configurations are designed to meet the needs for your application.

- Linkage and counterweight arrangements assist in preventing pressure from building in system
- Integrated gutter design redirects precipitation to the outside of the stack in the closed position



**PIVOT AND TOGGLE STYLE DIVERTER DAMPERS
OFFER METALLIC LEAF SEALS ON THE BLADE
FOR TIGHT SHUTOFF AND RELIABILITY**

**DIVERTER DAMPERS TESTED IN
THE AS INSTALLED POSITION**

BUTTERFLY/WAFER DAMPERS

CECO Effox-Flextor has installed butterfly dampers from 12 inches (304 mm) in diameter to greater than 120 inches (3048 mm) in diameter. Our butterfly dampers can be found in some of the harshest environments where abrasion, corrosion and dust loading are prevalent.

- Seal options include tadpole seal, bar stop, or elastomeric seals
- Electric, pneumatic, or hydraulic actuation.
- Can be used for modulation or open/close applications
- Internal refractory/ceramic wool linings available for high temperature applications

Butterfly dampers are not as precise as louver dampers for flow control but can be used for modulation when precision is not critical. For more precise flow control applications, opposed multi-blade circular louver dampers should be used.

HIGH-PERFORMANCE METAL SEAT WAFER

CECO Effox-Flextor manufactures high performance metal seat dampers for elevated temperature applications in thermal oxidizers and dirty abrasive environments such as pulverizer outlet dampers. Utilizing a sectioned adjustable metal seal and machined blade seating surface these dampers provide tight shutoff for critical applications.

Design features

- Proven ¼% leakage at 24 inches w.g. (60 mbar) and 450°F (232°C)
- Designed for reliable frequent operation such as cycling every 3 minutes, 365 days/year
- 200,000+ cycle life, tested.



POPPET DAMPERS

Poppet Dampers are ideal for applications that require quick cycling time and tight shutoff. Poppet dampers are used for isolation capabilities for fabric filter applications and incineration systems. They are engineered to control the reverse gas flow, outlet flow, and bypass flow of gases, in turn enhancing filtration.

Poppet dampers are designed so that all the components can be maintained after the damper has been installed. This allows for easy and low-cost maintenance and inspections

- Constructed in single and double blade arrangements, double blade arrangements are used when zero leakage is required.
- Poppet seats are manufactured with thick gauge back-up bars and welded thin gauge metal seals to maximize strength while minimizing leakage

RADIAL VANE DAMPERS

Radial vane dampers are used primarily on the inlet of centrifugal fans to direct flow and assist in pre-spinning the flow into the wheel. Radial Vanes are commonly referred to as Variable Inlet Vanes (VIV). The use of a radial vane damper enhances the performance of the fan by:

- Introducing swirl into the inlet of the fan in the direction of rotation
- Changing the fan curve as the damper moves
- Eliminating low-volume stalling of the fan



EXPANSION JOINTS

EFLEX™ FLUOROFLEX FLEXIBLE
ELEMENTS DELIVER SUPERIOR
CHEMICAL AND THERMAL RESISTANCE

THREE BOLT BACKUP BAR CORNERS
WITH 6" (150 MM) RADIUS REDUCE
STRESS AND PROVIDE PROPER SEALING

NON-METALLIC EXPANSION JOINTS

CECO Effox-Flextor is the world leader in the design and supply of non-metallic expansion joints. We offer designs specifically engineered for every application and have supplied expansion joints in Boilers, Incinerators, Fans, Environmental Control Equipment such as SCR's, FGD and Fabric Filters. Our expansion joints can be found in Fossil Fired Power Plants, Refineries, Cement Plants, Steel Mills, Pulp & Paper Plants, and Gas Turbine Applications throughout the world.

The design parameters which influence the performance of any expansion joint and which must be defined for proper design analysis include:

- Movements
- Design/Operating Temperature
- Design/Operating Pressure
- Flue Gas Composition
- Adjacent Ductwork Configuration & Metallurgy

Our **EFLEX™** non-metallic expansion joints incorporate the latest advancements in engineering and materials such as:

Elastomeric

Elastomeric expansion joints are used in flue ducts operating at or below 400°F (204°C) and provide vibration and acoustic dampening when connected to large fans. Material selection is based on maximum duct temperatures and flue gas composition.

- Ethylene Propylene (EPDM) has very good chemical resistance and is rated for 300°F (149°C)
- Fluoroelastomers (FKM) such as DuPont's Viton® were specifically engineered for the low temperature applications of fossil fired power plants and have excellent chemical and abrasion resistance and are rated for 400°F (204°C)
 - Meets FSA-DSJ-401-09 Specification for FKM Compound
 - Belt buildup per FSA-DSJ-402-09 recommendation

Fluoroplastic

Our **EFLEX™** Fluoroflex expansion joints can provide a flexible solution for applications operating at or below 600°F (316°C). These materials are designed for wet and/or corrosive services and provide outstanding resistance to chemicals and heat beyond that of elastomers. Fluoroflex belts are manufactured using a fluoropolymer (PTFE) coated fiberglass cloth with a secondary laminated corrosion barrier of cross-ply PTFE resulting in a superior chemical resistant product with ZERO porosity.

- Meets FSA-DSJ-403-07 guidelines

Composites

Composite expansion joints consist of layers of material bonded and sewn together along the outer edges starting with our Fluoroflex single layer belt as the outside cover and gas seal member. Each layer of a composite is designed to work in unison for the specific service conditions.



EXPANSION JOINTS

1 OUTSIDE LAYER/COVER

Our EFLEX™ Fluoroflex single layer belt beside with the highest temperature capability for a gas seal layer.

2 INSULATION LAYER

Needled fiberglass insulation thermally bonded to the EFLEX™ Fluoroflex substrate to protect from heat degradation. The bonding prevents separation and potential "Hot Spots".

3 TFE LAYER

Additional vapor barrier can be provided for applications which may cycle thru dew point

4 REINFORCING LAYERS

Vermiculite coated fiberglass fabric acts as an insulator and increases expansion joint strength and durability. Wire mesh layers may also be added for increased durability and abrasion resistance.

5 ADDITIONAL INSULATION LAYERS

The presence and thickness of this layer is determined by the system temperature to ensure that the heat transfer from the flue gas is reduced to a point less than the maximum temperature of the vapor barrier and cover.

6 INSIDE LAYER/ENCASEMENT

Close weave material binds the belt together, acts as an insulator and adds strength for handling & service. **Note:** A metal flow liner is required to protect against abrasion.



Integrally Flanged U-Belt Design

- Belt is formed at right angles and incorporates flanges into the flexible element
- Best for single layer belts and services less than 700°F (371°C)
- Highly effective vibration and acoustical dampening with elastomers adjacent to Fans
- Good design for applications where condensation is an issue as internal cavity is reduced

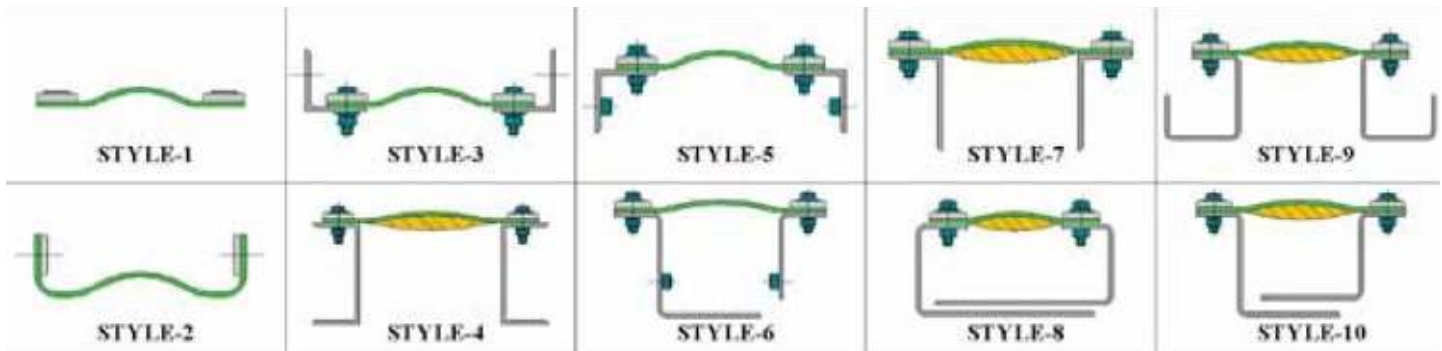
Flat Belt Design

- Mounted parallel to flow stream using adapter frames
- Multiple design configurations engineered for specific service conditions
- Best use for higher temperature applications

Design Configurations

EFLEX™ Non-metallic expansion joints can be provided in a myriad of profiles engineered for each location in your system. Every design has particular benefits and by incorporating additional accessories such as metal flow liners, cavity pillows and various frames styles can provide a flexible solution for any application

This chart represents only the basic expansion joint designs.
Contact **CECO Effox-Flexor** for the best solution to fit your needs.



DESIGN & ENGINEERING

CECO Effox-Flextor has a dynamic team of designers and engineers who thrive on the technical challenges of Engineered-to-order heavy duty industrial requirements. Our technical staff includes graduate and professional engineers highly experienced in the damper and expansion joint industries. Our staff has extensive global field experience.

PROJECT MANAGEMENT

Many of our key personnel have been with the company since the 1980's. Additional personnel have been added over the years who have damper and expansion joint experience. **CECO Effox-Flextor** is the only damper and expansion joint manufacturer that has maintained this degree of continuity within its organization.

We follow a strict project management methodology using project scheduling and tracking software designed for the challenges of the Engineered-to-order production environment.

INSTALLATION & START-UP

has experienced site personnel that offer high quality support of our equipment at your job site. We offer you the following services:

- Routine inspections/surveys
- Site supervision
- Calibration and testing
- Training for operations personnel
- Belt vulcanizing/heat splicing

MAINTENANCE

Our staff is available promptly to be on your job site for maintenance, inspections, and troubleshooting. Our technicians are also available to train your personnel on the use, inspection, and maintenance of our equipment in order to prolong the service life of our components in your system.

AFTERMARKET SERVICES

CECO Effox-Flextor offers a wide variety of aftermarket products and services including:

- Spare Parts
- Service
- Repair/retrofit of any brand damper
- Fabric Expansion Joint belt replacements



ENERGY TECHNOLOGIES

CECO Environmental, through its Aarding, CECO China, **CECO Effox-Flextor** and Zhongli Industrial Technology businesses, is the leading provider of custom engineered solutions which meet the most demanding needs of the power, petrochemical and heavy industries worldwide.

Our products and solutions include designing, engineering and manufacturing of exhaust systems, acoustical components, heavy duty dampers, and fabric expansion joints for use in gas turbine, fossil fuel combustion and other exhaust gas applications.

CECO ENVIRONMENTAL

CECO Environmental is a leading global industrial technology company focused on providing innovative solutions for the air pollution control, energy, and fluid handling/filtration industries. Through its well-known brands, CECO provides a wide spectrum of products and services that play a vital role in helping companies achieve production standards, meet increasing plant needs and comply with stringent air quality control regulations.

CECO also offers you an advantage that's unavailable anywhere else. We are a single source provider that utilizes the combined knowledge and expertise gained from years of working together, to develop integrated products and solutions for a broad and diverse customer base.

Our multi-disciplined engineering and project management staff have a thorough understanding of industry codes

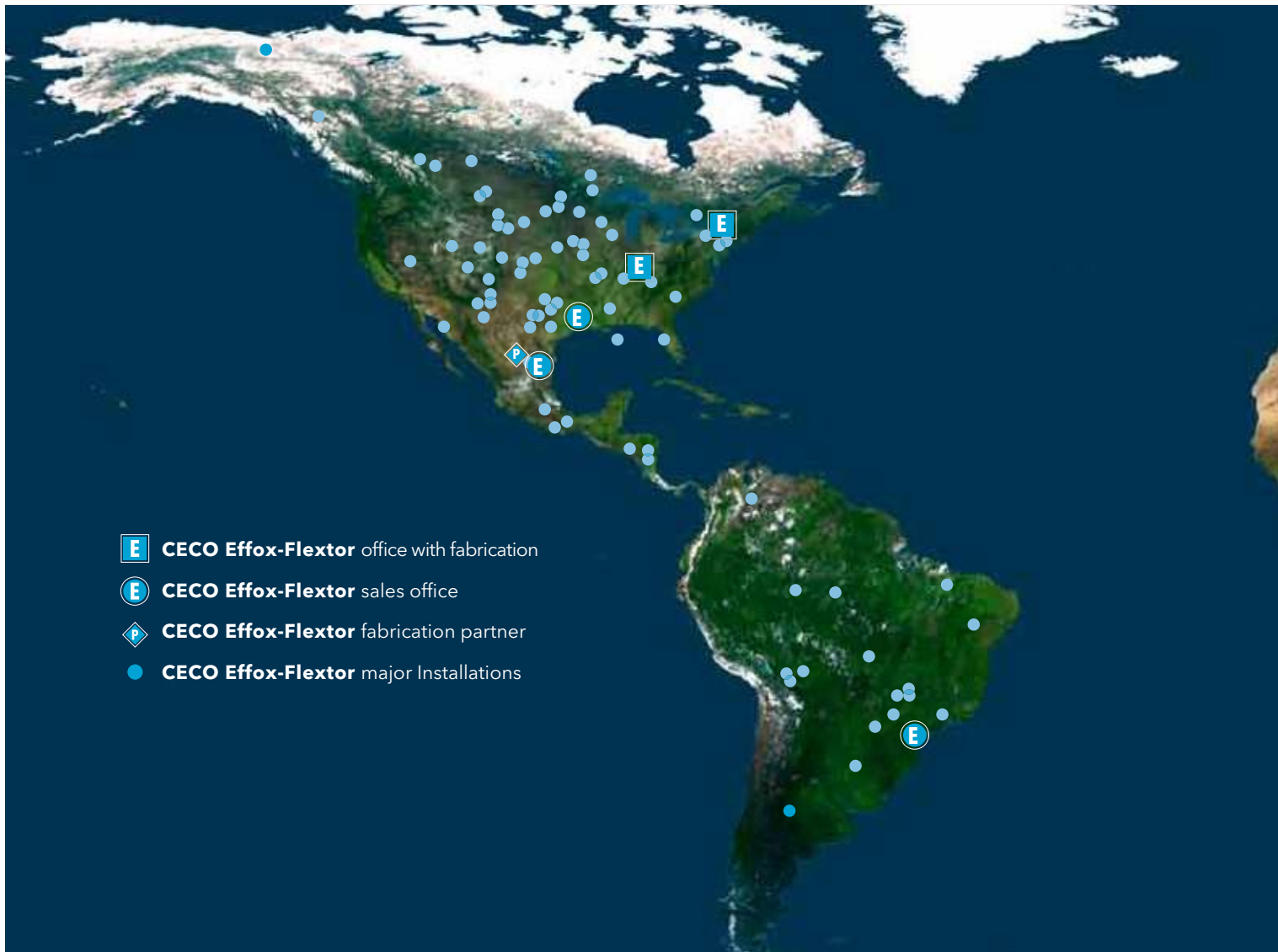
and standards as well as extensive technical capabilities. This makes CECO the ideal partner in developing new products or helping you choose the best solution to each and every application.

CECO is driven by an unwavering commitment to provide high quality solutions and products for our customers, a challenging and innovative workplace for our employees, and long-term sustainable growth for our shareholders.



PROJECTS

A FEW OF OUR MAJOR INSTALLATIONS



- E** CECO Effox-Flextor office with fabrication
- E** CECO Effox-Flextor sales office
- P** CECO Effox-Flextor fabrication partner
- CECO Effox-Flextor major Installations

NORTH AMERICA

Prudhoe Bay, Alaska
Refinery - Petroleum

Fort McMurray, Alberta, Canada
Refinery - Oil Sands

LaCygne, Kansas
Coal Fired Boiler - Fabric Filter

Belews Creek, North Carolina
Coal Fired Boiler - FGD

Oak Grove, Texas
Coal Fired Boiler

Chouteau, Oklahoma
Coal Fired Boiler - Fabric Filter

Council Bluffs, Iowa
Coal Fired Boiler - Fabric Filter & FGD

Cumberland City, Tennessee
Coal Fired Boiler - FGD

Castle Dale, Utah

Coal Fired Boiler - FGD

Dickerson, Maryland
Coal Fired Boiler - FGD

Cedar Rapids, Iowa
Grain Processing

Cliffside, North Carolina
Coal Fired Boiler - FGD

Oak Creek, Wisconsin
Coal Fired Boiler - FGD

Cameron Parish, Louisiana
Gas Turbine - LNG

LATIN & SOUTH AMERICA

Lazaro Cardenas, Mexico
Gas Turbine - Power Generation

Mazatlan, Mexico
Gas Turbine - Power Generation

Puerto Nare, Columbia

Gas Turbine - Power Generation

Timbues, Argentina
Gas Turbine - Power Generation

Iquique, Chile
Coal Fired Boiler - Fabric Filter

EUROPE+

Castejon, Spain
Gas Turbine - Power Generation

Modugno, Italy
Gas Turbine - Power Generation

Krakow, Poland
Coal Fired Boiler - FGD

Smedervo, Serbia
Steel Mill



MORE THAN 5,000 SATISFIED CUSTOMERS
50,000 INSTALLED DAMPERS **2,000 COAL**
POWER PROJECTS INSTALLED **400 HRSG**
PROJECTS INSTALLED **250,000 INSTALLED**
EXPANSION JOINTS **35 COUNTRIES SERVED**

AFRICA

Arzew, Algeria

Refinery - Petroleum

Bonny Island, Nigeria

Gas Turbine - Refinery

MIDDLE EAST

Jeddah, Saudi Arabia

Gas Turbine - Power Generation; Oil Fired Boiler, Seawater FGD & ESP

Yanbu, Saudi Arabia

Oil Fired Boiler

Ras Tanura, Saudi Arabia

Refinery - Fabric Filter

Riyadh, Saudi Arabia

Gas Turbine - Power Generation

Sohar Port, Oman

Gas Turbine - Refinery

ASIA

Jingyuan, China

Coal Fired Boiler

Thai Binh, Vietnam

Coal Fired Boiler - FGD

Ratchaburi, Thailand

Coal Fired Boiler - Wet FGD

Yeosu-si, Korea

Gas Turbine - Refinery

Dangjin, Korea

Coal Fired Boiler - Wet FGD

Samalkot, India

Gas Turbine - Power Generation

Jamshedpur, India

Steel Mill

Manjung, Malaysia

Coal Fired Boiler

Sual, Philippines

Coal Fired Boiler - Wet FGD

Taichung, Taiwan

Coal Fired Boiler - Wet FGD

East Java, Indonesia

Coal Fired Boiler - Wet FGD

Grasberg, Indonesia

Mining

AUSTRALIA & NEW ZEALAND

Wheatstone, Australia

Fired Heater - LNG

South West Queensland, Australia

Coal Fired Boiler

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CECO Effox-Flextor

CECO Effox-Flextor is the world leader in the design and manufacturing of heavy-duty utility and industrial dampers and expansion joints for use in solid fuel combustion and exhaust systems, with more than 50 years of industry experience.