

CORR VELOX

**Ultra Resolution ER RS-485 Transmitter
(Model MS2801E)
Operator's Manual**



Metal Samples

A Division of Alabama Specialty Products, Inc.

152 Metal Samples Rd., Munford, AL 36268 Phone: (256) 358-4202 Fax: (256) 358-4515

E-mail: msc@alspi.com Internet: www.metalsamples.com

Table of Contents

I. Introduction	1
A. General Description.....	1
B. Principles of Operation	1
C. Technical Specifications.....	3
II. Installation and Operation.....	4
A. Receiving the MS2801E transmitter.....	4
B. Installation	4
1. Physical Mounting and Probe Connection.....	4
a. Direct-Probe Mounting.....	4
b. Remote Mounting	5
2. Power and Data Connections	6
a. Making Connections	6
b. Grounding.....	7
c. Safe Area Installation	7
d. Hazardous Area Installation	7
3. Setup and Operation	9
a. Probe Settings.....	9
b. RS-485 Communication Settings	10
i. Baud Rate and Default Communication Parameters.....	11
ii. Device Address	11
iii. Communication Protocols	11
iv. Termination Resistor	11
v. Data Registers	12
c. Calibration and Testing	12
i. Calibration	12
ii. Testing output zero and span	12
iii. Testing the MS2801E transmitter with the Meter Prover	13
d. Interpreting Data	14
i. Metal Loss	14
ii. Calculating Corrosion Rate	15
e. Commissioning	16
C. Maintenance.....	16
D. Troubleshooting	17
III. Service and Warranty Information	18
A. Warranty	18
B. Obtaining Service and Returning the Instrument for Repair	18
C. Instrument Repair Form	19
Appendix A - Revision History	20
Appendix B - Control Drawing (Hazardous Area Wiring Diagram)	21

I. Introduction

A. General Description

The model MS2801E **CORR VELOX** transmitter is an ultra-high resolution instrument designed to measure and transmit corrosion (metal loss) data from an Electrical Resistance (ER) probe to a plant control system or other recording device. The **CORR VELOX** transmitter utilizes RS-485 communication which allows multiple units to be daisy-chained, simplifying installation and reducing associated costs. The use of the RS-485 protocol also allows the transmitter to be placed great distances from the control system or recorder while maintaining good noise rejection. Practical distances can be up to 4000 feet. Additionally, the **CORR VELOX** transmitter offers user-selectable RTU or ASCII communication protocols making it highly versatile.

The **CORR VELOX** transmitter is compatible with all types of Metal Samples ER probes, as well as any standard ER probe from other manufacturers. Unlike competitors' products, the **CORR VELOX** transmitter does not require factory modification to accommodate different probe types. The probe type can be easily changed at any time using the on-board probe selection switches (see page 9.)

The **CORR VELOX** transmitter is available as direct-mount or remote-mount. The direct-mount version is mounted directly to the ER probe. This option offers the simplest installation and minimizes noise problems. The remote-mount option allows the **CORR VELOX** transmitter to be mounted independently from (but in close proximity to) the ER probe. It is then connected to the probe via a short probe cable. (See pages 5 and 6 for mounting diagrams and specifications.)

B. Principles of Operation

The **CORR VELOX** transmitter operates on the Electrical Resistance (ER) technique and is used in conjunction with an ER probe. The ER probe utilizes a resistive sensing element manufactured from the material of interest (or a close approximation) which is exposed to a corroding environment. This is called the Exposed or Corroding Element. The resistance of the Exposed Element is directly related to its thickness, so as the element corrodes the resulting loss of metal causes a proportional increase in the element's resistance. The probe also contains an internal Reference Element which is used to compensate for the influences of temperature on the Exposed Element.

The **CORR VELOX** transmitter is designed to work with any standard ER probe, but it is recommended that Cylindrical and Large Flush type probes be used to ensure optimum performance. Their physical design places the Reference Element in closer proximity to the Exposed Element compared to other probe types, providing more effective temperature compensation and thus reducing the effects of thermal noise.

Because they are designed to corrode, ER probes are sacrificial in nature. Each ER probe will have a finite life that is based on the element thickness. ER probes are available in a number of geometries and thicknesses designed to suit a wide variety of applications. Table 1 lists the common ER element options available from Metal Samples and the effective life of each.






Element Type		Compatibility	Thickness	Probe Life (Span)
	Tubular Loop	Compatible	4	2
			8	4
	Wire Loop	Compatible	40	10
			80	20
	Flush (Small)	Compatible	4	2
			8	4
			20	10
	Cylindrical	Preferred	10	5
			20	10
			50	25
	Flush (Large)	Preferred	5	2.5
			10	5
			20	10
			40	20

Table 1. Standard ER Probe Elements

The **CORR VELOX** transmitter measures an ER probe utilizing a high-resolution, 20-bit measurement. This allows the unit to detect much smaller amounts of metal loss, thus responding faster to corrosion events and upsets. At 20-bit resolution the **CORR VELOX** transmitter can measure metal loss amounts as small as 0.0001% of the probe life. For highly sensitive probes such as the 5-mil large flush shown above, that results in a detection limit of less than one angstrom.

Metal loss readings taken by the **CORR VELOX** transmitter are output as a digital RS-485 signal which can be fed into a plant control system or other recording devices. The Metal Loss is represented by a 20-bit digital value between 0 and 1,048,575, where:

0 = 0 mils (0% Metal Loss)

1,048,575 = Probe Life* in mils (or 100% Metal Loss)

**The Probe Life (or Span) of the probe being used (see table 1 above.)*

The Metal Loss data can be used to calculate the corrosion rate between any periods of interest. This is covered in more detail on pages 13 and 14. More information on ER probes, their theory, selection, and use can be found on our web site at <http://www.alspi.com/erintro.htm>.

C. Technical Specifications

Model MS2801E CORR *VELOX* High Resolution ER RS-485 Modbus Transmitter

Physical Data

Instrument Weight:	3.70 lb. (1.68 Kg) Total
Weight w/ Accessories:	5.76 lb. (2.61 Kg)
Instrument Dimensions:	8.0"H x 4.0"W x 3.45"D (20.32cm H x 12.24cm W x 8.76"D)
Operating Temperature:	-40° to 158°F (-40° to 70°C)
Storage Temperature:	-40° to 176°F (-40° to 80°C)
Enclosure Material:	Cast Aluminum (Copper-Free)
Mounting Specifications:	Direct probe mount or Remote mount (Up to a 2.5" (6.35cm) Dia. pole)

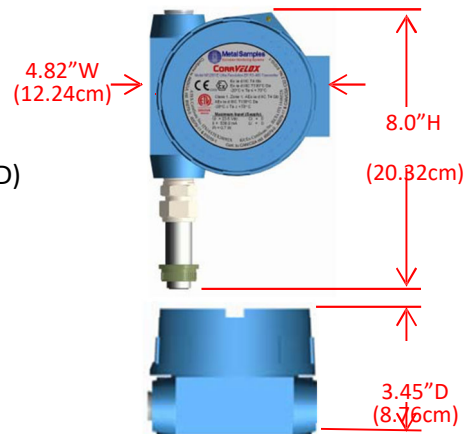


Figure 1. Overall Dimensions

Performance Data

Measurement Type:	ER measurement
Range:	0-100% of probe life
Resolution:	0.0001% of Probe Life (20-bit)
Cycle Time:	75 Seconds

Electrical Data

Power Requirements:	10 to 30 VDC
Maximum Probe Cable Distance:	30 ft (9.1 m)
Output Specifications:	RS-485 Modbus, RTU or ASCII Protocol (Switch Selectable) 2400 / 4800 / 9600 / 19.2K Selectable Baud 32 Maximum Units (Addresses 1 to 32)

Hazardous Location Certifications – Transmitter

Europe and Worldwide (ATEX and IECEx)	Ex db [ia Ga] IIC T6....T4 Gb Ex tb [ia Ga] IIIC T 75 ° C Gb - 40°C ≤ Ta ≤ + 70°C ATEX Certificate No: ITS18ATEX203437X IECEx Certificate No: IECEx ETL 18.0020X
--	--

X - see Special Conditions (page 7)

Hazardous Location Certifications – Enclosure

Case Specifications:	Explosion Proof (FM, CSA, CENELEC, UL) IP 66, NEMA 4X, 7BCD, 9EFG
----------------------	--

Included Accessories (Direct-Mount Model)

Meter Prover, Operations Manual

Included Accessories (Remote-Mount Model)

Meter Prover, Operations Manual, Probe Cable, Mounting Hardware Kit

II. Installation and Operation

A. Receiving the MS2801E CORR *VELOX* Transmitter

Check the **CORR *VELOX*** Transmitter for any shipping damage when it is first received. When the unit is unpacked, verify that the following items are included:

- Transmitter
- Meter Prover
- User's Manual
- Probe Cable (for remote-mount only)
- Mounting Hardware (for remote-mount only)

In the event of shipping damage, quantity shortage, or missing items, it is recommended that the event is documented immediately and that digital photographs are taken. Any shortages or missing items should be reported to Metal Samples immediately. In the event of shipping damage, a claim should be opened with the responsible carrier.

B. Installation

CAUTION: *Using this product in any way other than that specified within this manual may impair the intrinsic safety protection.*

Installation of the **CORR *VELOX*** transmitter involves the following steps:

1. Physical Mounting
2. Electrical Connection
3. Setup and Programming

1. Physical Mounting and Probe Connection

When selecting a location to mount the **CORR *VELOX*** transmitter it is important to consider the surrounding environment. To ensure proper operation:

- Do not mount the transmitter in a location that exceeds its operating temperature.
- Avoid mounting the transmitter near sources of strong electrical noise.
- Ensure that there is sufficient clearance for installation and to open the transmitter cover afterwards.

a. Direct-Probe Mounting

The **CORR *VELOX*** transmitter is designed for direct-probe mounting which eliminates the need for additional hardware and transmitter-to-probe cabling. This greatly simplifies installation, reduces costs, and minimizes electrical noise that can be coupled onto probe cabling from nearby electrical equipment.

Before mounting the **CORR *VELOX*** transmitter, first ensure that the probe is installed properly and securely. During installation it is important that you do not apply excessive force on the probe or seals, as doing so could break the seal and result in system leakage.

To mount the **CORR *VELOX*** transmitter:

1. Align the keyways of the transmitter and probe connectors.
2. Insert the transmitter connector plug fully into the probe connector receptacle.
3. Secure the transmitter to the top of the probe by tightening the coupling nut.

NOTE: Hand-tight is sufficient. Do not over-tighten the coupling nut.

NOTE: Never force the connectors to mate. If there is resistance, stop and check for bent pins on the probe and for foreign material in the female sockets of the transmitter connector. Gently straighten any bent pins and clear any foreign material that may be found.

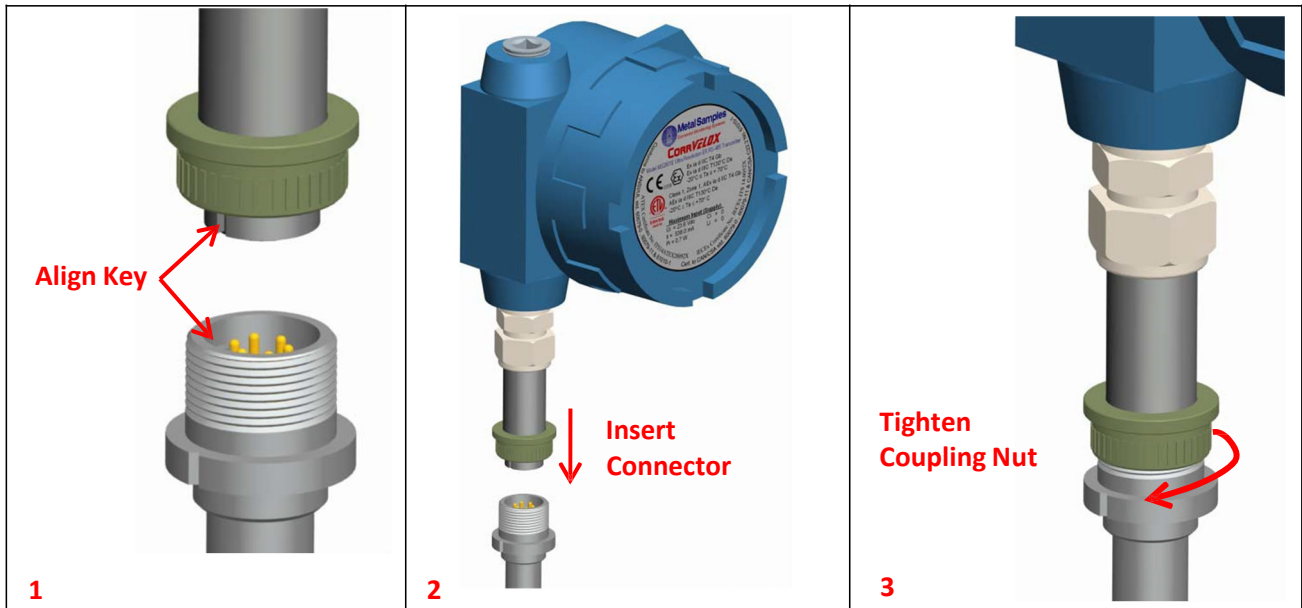


Figure 2. Direct Mount Installation

b. Remote Mounting

When it is not practical to direct-probe mount the **CORR VELLOX** transmitter, the unit can be remote mounted instead. In this case the instrument is mounted to a separate mounting pole using the optional Remote Mounting Hardware Kit. The transmitter is then connected to the ER probe via the probe extension cable.

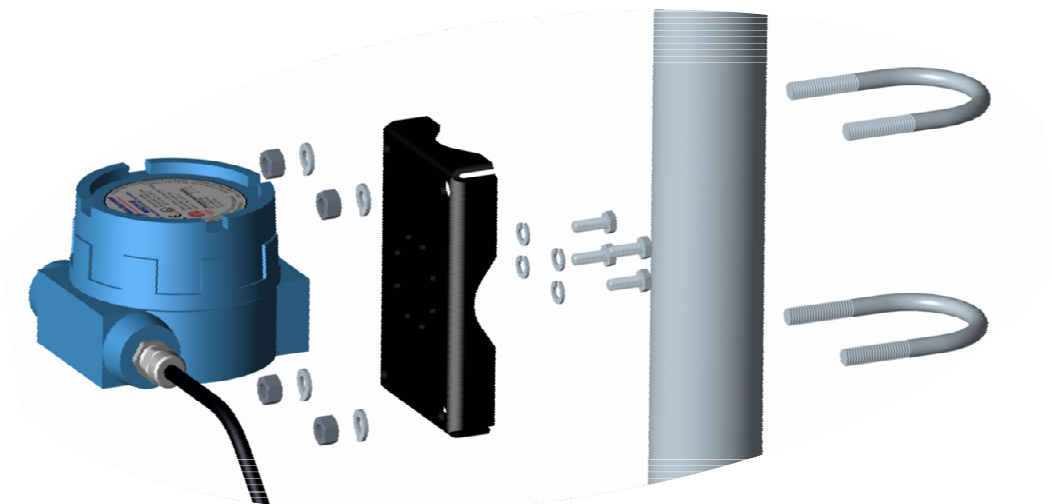


Figure 3. Remote Mount Installation

2. Power and Data Connections

a. Making Connections

The RS-485 field wiring enters the transmitter through the 1/2" female NPT conduit port shown in Figure 4 below.

CAUTION: When used in a hazardous area, the conduit or cable connections must be made in such a way that all hazardous area requirements are met.

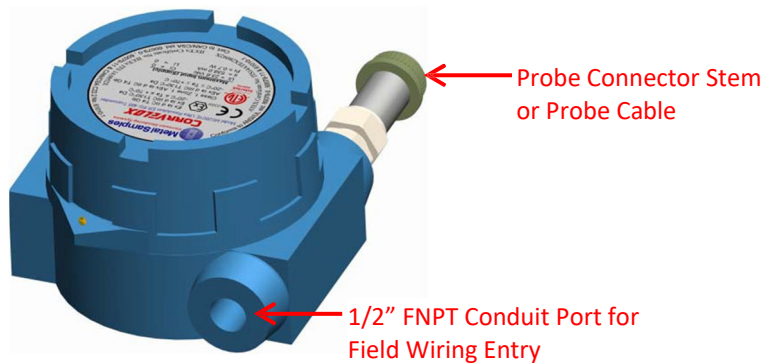


Figure 4. RS-485 Connector

Electrical connections are made to the main PCB via the terminal blocks J2 and J9 as shown in Figure 6.

NOTE: Do not connect cable shielding to the Transmitter. The shield must remain floating at the Transmitter.

The RS-485 protocol allows up to 32 transmitters to be daisy-chained which simplifies installation and reduces costs. Figure 5 shows an example of a typical arrangement. Full wiring details are shown on pages 21 and 22.

CAUTION: Be sure to observe the appropriate gas group rating listed on page 3 for stand-alone or multi-drop operation.

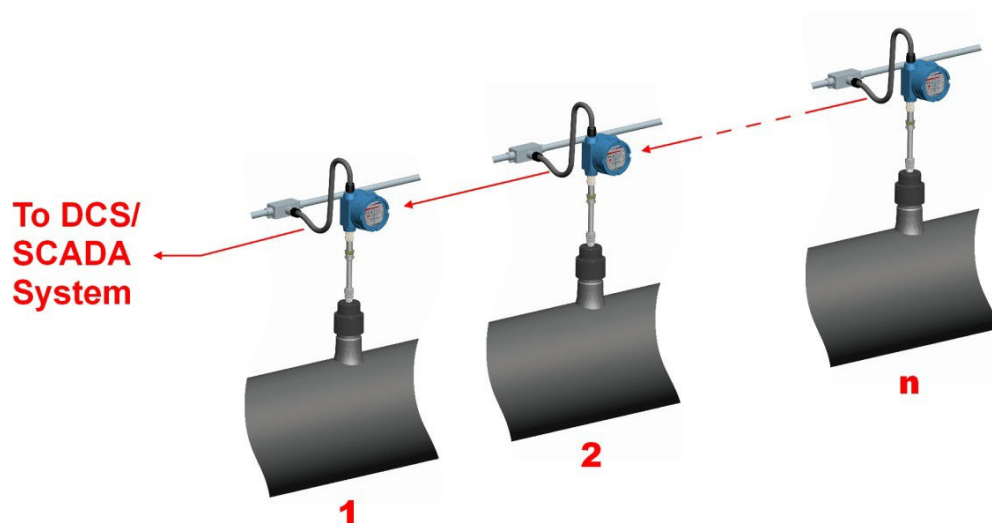


Figure 5. Typical daisy-chain arrangement, where 'n' is the number of the last transmitter.

The maximum permissible length of the field wiring between the **CORR VELOX** transmitter and the control system is determined by the control system supply voltage, the electrical resistance of the cable and the load of the control system input. If the Transmitter is to be installed in a safe area, refer to section c. *Safe Area Installation* for details. If the Transmitter is to be installed in a hazardous area, refer to section d. *Hazardous Area Installation*.

b. Grounding

The **CORR VELOX** transmitter enclosure is grounded internally through the wiring harness, but an additional, external grounding terminal is provided as well. The enclosure should be grounded properly using the external grounding terminal to ensure safe operation.

c. Safe Area Installation

The **CORR VELOX** transmitter is approved for use in hazardous areas, but can be used in non-hazardous areas as well. For basic safe area wiring information refer to the circuit diagram shown on page 21.

CAUTION: *When used in non-hazardous areas, equipment must be supplied with a pre-approved power supply unit or approved equipment which meets the entity parameters shown below.*

The pre-approved equipment must be certified to the electrical safety standards for equipment in ordinary locations (for example, EN/IEC/CSA UL 61010-1 or EN/IEC/CSA UL 60950-1). Failure to meet these requirements will void the intrinsic safety certification of the equipment and prohibit its future use in hazardous areas.

d. Hazardous Area Installation

CAUTION: *This section provides general guidelines for hazardous area wiring. However, regardless of anything stated here, the **CORR VELOX** transmitter must be installed in full compliance with the control drawing located on page 20 and all of the local area requirements.*

CAUTION: *When used in Hazardous areas, equipment must be supplied with a pre-approved power supply unit or approved equipment via a certified intrinsically safe barrier or a galvanically isolated barrier) with the following **entity parameters**.*

Input supply terminal (J1)

Um = 30.0V DC
Um = 6.0V RS485

Probe Connector (J3)

Uo = 5.115 Vdc
Io = 0.344 A
Po = 0.44 W
Co = 0.5 uF
Lo = 35 uH

Special Conditions

- 1. All Cable Glands, blanking elements and thread adapters used with the equipment shall be suitable certified Ex db parts, providing a degree of protection of IP66 and be suitable for use in ambient temperature range of -40Deg C. to 70 Deg.C .*
 - 2. No more than one Hazardous area reducer shall be used on any entry.*
-

CAUTION: *For hazardous area installations, the maximum inductance and capacitance of the field wiring between the connected equipment and the transmitter cannot exceed the entity parameters.*

CAUTION: *Non-Metallic Hazardous area label on the instrument may pose a potential electrostatic hazard. Following precautions may help to reduce risk during maintenance / handling the equipment. The static charge can be dissipated by following simple steps*

- a. Use dampened cloth to clean the label surface before handling it.*
 - b. Body can be grounded by using ground/anti-static wrist bands or by other means before handling.*
-

3. Setup and Operation

a. Probe Settings

The probe selection switches are located on the top left corner of the main board as illustrated in Figure 6 below. These switches are used to set the ER probe type. They also allow the instrument to be placed into several test modes which output fixed values, allowing verification of the output signal. Table 2 gives the switch settings for each probe type and the various test modes.

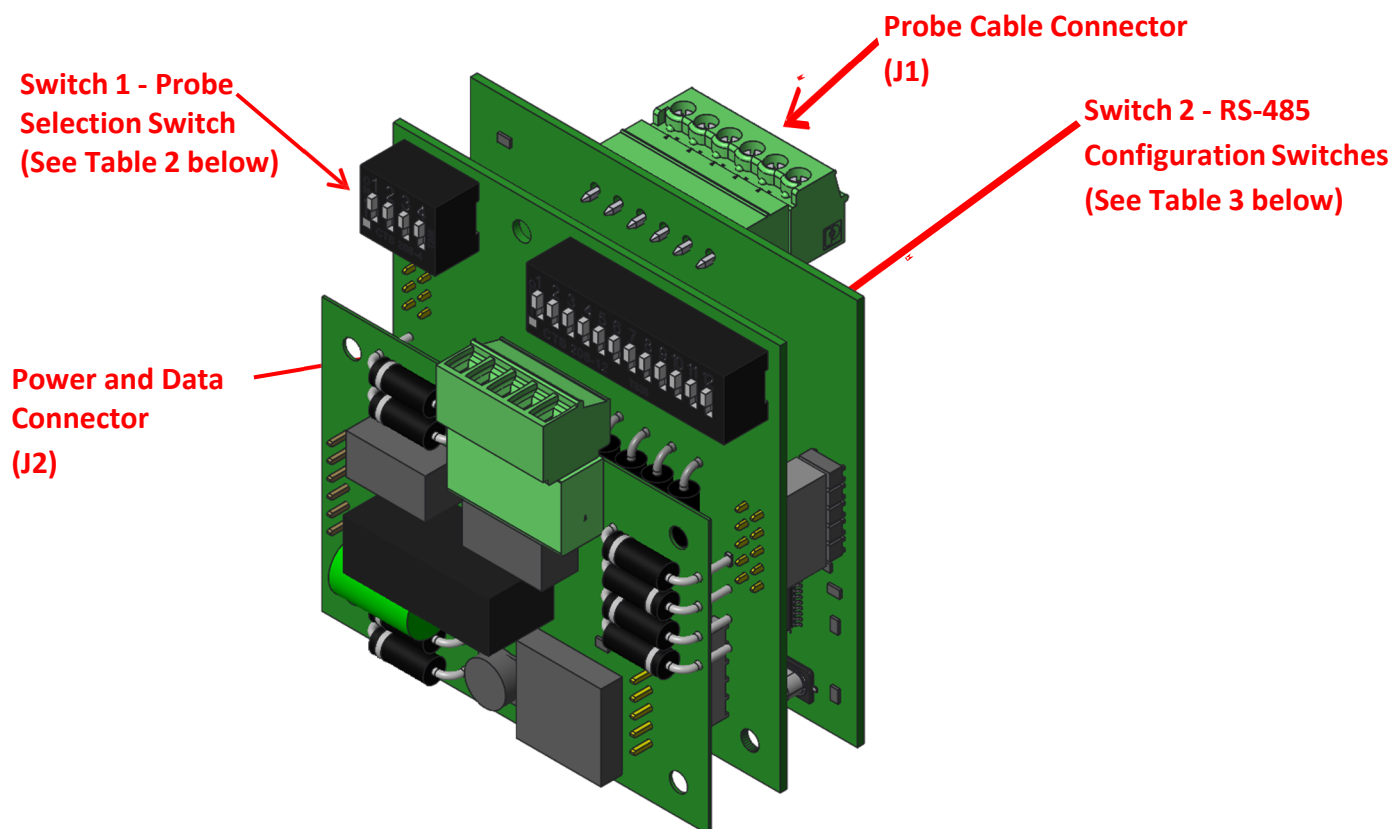


Figure 6. Connector and Switch Details

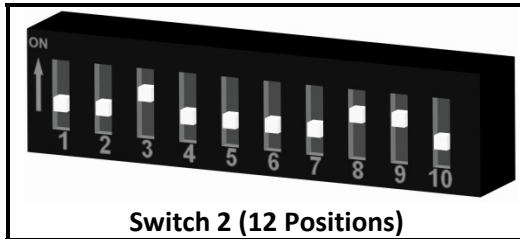
	Setting	Position			
		1	2	3	4
Operating Positions	Wire Loop	Off (↓)	On (↑)	On (↑)	Off (↓)
	Tube Loop/Flush	On (↑)	Off (↓)	On (↑)	Off (↓)
	Cylindrical*	Off (↓)	Off (↓)	On (↑)	Off (↓)
	HS Probes	Off (↓)	Off (↓)	Off (↓)	Off (↓)
Test Positions	Zero Output (0)	On (↑)	On (↑)	Off (↓)	Off (↓)
	Maximum Output (1,048,575)	Off (↓)	On (↑)	Off (↓)	Off (↓)
	Full Scale Sweep	On (↑)	Off (↓)	Off (↓)	Off (↓)
Maintenance Position	Service Registers	*	*	*	On (↑)

Table 2. Probe Switch Settings

*Cylindrical probe setting is illustrated.

b. RS-485 Communication Settings

The RS-485 configuration switches are located on the top right corner of the main board as illustrated in Figure 6. These are used to set the instrument address, baud rate, communication protocol, and to enable the termination resistor. Table 3 gives the switch settings for each of these parameters, and they are explained in more detail below.



Baud Rate	Position	
	1	2
2400	Off (↓)	Off (↓)
4800	Off (↓)	On (↑)
9600	On (↑)	Off (↓)
19200	On (↑)	On (↑)

Communication Protocol	Position	
	8	9
Modbus ASCII	On (↑)	Off (↓)
Modbus RTU	Off (↓)	Off (↓)
Serial ASCII	On / Off	On (↑)

Termination Resistor	Position 12
Active	On (↑)
Inactive	Off (↓)

Spare	Position 10 & 11
-------	------------------

Device Address	Position				
	3	4	5	6	7
1	Off (↓)	Off (↓)	Off (↓)	Off (↓)	Off (↓)
2	On (↑)	Off (↓)	Off (↓)	Off (↓)	Off (↓)
3	Off (↓)	On (↑)	Off (↓)	Off (↓)	Off (↓)
4	On (↑)	On (↑)	Off (↓)	Off (↓)	Off (↓)
5	Off (↓)	Off (↓)	On (↑)	Off (↓)	Off (↓)
6	On (↑)	Off (↓)	On (↑)	Off (↓)	Off (↓)
7	Off (↓)	On (↑)	On (↑)	Off (↓)	Off (↓)
8	On (↑)	On (↑)	On (↑)	Off (↓)	Off (↓)
9	Off (↓)	Off (↓)	Off (↓)	On (↑)	Off (↓)
10	On (↑)	Off (↓)	Off (↓)	On (↑)	Off (↓)
11	Off (↓)	On (↑)	Off (↓)	On (↑)	Off (↓)
12	On (↑)	On (↑)	Off (↓)	On (↑)	Off (↓)
13	Off (↓)	Off (↓)	On (↑)	On (↑)	Off (↓)
14	On (↑)	Off (↓)	On (↑)	On (↑)	Off (↓)
15	Off (↓)	On (↑)	On (↑)	On (↑)	Off (↓)
16	On (↑)	On (↑)	On (↑)	On (↑)	Off (↓)
17	Off (↓)	Off (↓)	Off (↓)	Off (↓)	On (↑)
18	On (↑)	Off (↓)	Off (↓)	Off (↓)	On (↑)
19	Off (↓)	On (↑)	Off (↓)	Off (↓)	On (↑)
20	On (↑)	On (↑)	Off (↓)	Off (↓)	On (↑)
21	Off (↓)	Off (↓)	On (↑)	Off (↓)	On (↑)
22	On (↑)	Off (↓)	On (↑)	Off (↓)	On (↑)
23	Off (↓)	On (↑)	On (↑)	Off (↓)	On (↑)
24	On (↑)	On (↑)	On (↑)	Off (↓)	On (↑)
25	Off (↓)	Off (↓)	Off (↓)	On (↑)	On (↑)
26	On (↑)	Off (↓)	Off (↓)	On (↑)	On (↑)
27	Off (↓)	On (↑)	Off (↓)	On (↑)	On (↑)
28	On (↑)	On (↑)	Off (↓)	On (↑)	On (↑)
29	Off (↓)	Off (↓)	On (↑)	On (↑)	On (↑)
30	On (↑)	Off (↓)	On (↑)	On (↑)	On (↑)
31	Off (↓)	On (↑)	On (↑)	On (↑)	On (↑)
32	On (↑)	On (↑)	On (↑)	On (↑)	On (↑)

Table 3. RS-485 Configuration Switch Settings

i. Baud Rate and Default Communication Parameters

The default communication parameters for the **CORR VELOX** transmitter are provided in Table 4 below. If necessary, the baud rate can be changed using Positions 1 and 2 of Switch 2, as illustrated in Table 3.

	Modbus RTU	Modbus ASCII	Serial ASCII
Parameter	Value	Value	Value
Baud Rate	19200	19200	2400
Data Bits	8	7	8
Parity	Even	Even	Even
Stop Bits	1	1	1
Response Time Out	3000 mS	3000 mS	3000 mS
Polling Interval	1 min	1 min	1 min
RTS Toggle	Active	Active	Active
RTS Disable Delay	1 mS	1 mS	1 mS

Table 4. Default Communication Parameters

ii. Device Address

Up to 32 **CORR VELOX** transmitters may be connected in a multi-drop network (“daisy-chained”) using a single cable run. However, each transmitter must be set to a unique device address to avoid conflicts. This is done using Positions 3 through 7 of Switch 2, as illustrated in Table 3.

CAUTION: Be sure to observe the appropriate gas group rating listed on page 3 for stand-alone or multi-drop operation.

iii. Communication Protocols

The **CORR VELOX** transmitter offers user-selectable RTU or ASCII communication protocols, giving the unit a broader range of compatibility. The communication protocol is set using Position 8 of Switch 2, as illustrated in Table 3.

iv. Termination Resistor

To ensure proper operation, the RS-485 network must be terminated properly with a termination resistor. To facilitate this, each **CORR VELOX** transmitter has a built-in 120Ω termination resistor that can be switched on or off using Position 10 of Switch 2. Once all units have been installed, be sure to enable the termination resistor of the last unit in the network. The termination resistors of all other transmitters should be turned off.

v. Data Registers

Table 5 lists the data registers of the **CORR VELOX** transmitter. Data Register 40024 and 40025 transmitted from the transmitter is the direct probe reading value.

No	Register Address	Description
1	40024	DAC Value (Low)
2	40025	DAC Value (Hi)

To access all other registers for maintenance purpose, the Switch 1, Position # 4 (Maintenance) should be turned on.

No	Register Address	Description
1	40001	Device Status
2	40002	Device Address
3	40003	Baud Rate
4	40024	DAC Value (Low)
5	40025	DAC Value (Hi)
6	40026	Probe Switch Setting

Table 5. Modbus Data Registers

c. Calibration and Testing

i. Calibration

The **CORR VELOX** transmitter is fully calibrated when shipped from the factory. The calibration settings are fixed to avoid accidental change which could result in erroneous data. No field calibration is required. However, it is important to test the unit upon installation, and during periodic maintenance inspections, to ensure the unit is operating properly.

ii. Testing output zero and span

The **CORR VELOX** transmitter Probe Selection Switches (page 9) offer three test settings that allow the unit to be placed into various diagnostic modes as follows:

- 1) Zero Output – Forces a digital output of 0.
- 2) Maximum Output – Forces a digital output of 1,048,575.
- 3) Full Scale Sweep – Causes the output to continually cycle from 0 up to 1,048,575.

These test modes can be useful when troubleshooting communication problems between the transmitter and the DCS/PLC system.

iii. Testing the **CORR VELOX** transmitter with the Meter Prover

A Meter Prover is provided to allow routine checks of the **CORR VELOX** transmitter. The Meter Prover simulates a Wire Loop type probe at a fixed value. To test the unit with the Meter Prover:

- 1) Disconnect power.
- 2) Disconnect the **CORR VELOX** transmitter from the probe (or if the unit is remote-mounted, disconnect the probe extension cable from the probe.)
- 3) Connect the Meter Prover to the probe connector stem (or to the probe extension cable if the **CORR VELOX** transmitter is remote-mounted.)
- 4) Loosen the Enclosure Lock Screw.
- 5) Unthread and remove the transmitter cover.
- 6) Change the Probe Selection Switches to the Wire Loop position (see page 9.)
- 7) Reconnect power and allow the instrument to measure for several minutes to stabilize.
- 8) After several minutes observe the transmitter output. The output should closely match the value printed on the Meter Prover label.

If the transmitter output matches the Meter Prover value, you may return the Probe Selection Switches to their previous setting and reconnect the **CORR VELOX** transmitter to the probe. If the transmitter output shows a significant difference compared to the Meter Prover value, further troubleshooting may be required. Refer to page 16 for troubleshooting or contact the factory for further assistance.

Be sure to reinstall the enclosure cover and tighten the Lock Screw when putting the **CORR VELOX** transmitter back into service.

d. Interpreting Data

i. Metal Loss

The **CORR VELOX** transmitter measures the Metal Loss of an ER probe and converts that value to a digital 20-bit RS-485 Modbus output. This output is directly proportional to the cumulative Metal Loss of the ER probe at any given time. The overall span of the output is proportional to the life of the probe in use, so for DCS/PLC programming the RS-485 Modbus output can be scaled as follows:

0 = 0 mils (0% Metal Loss)

1,048,575 = Probe Life in mils (100% Metal Loss)

The Probe Life can be found in Table 1 and is also listed on the Metal Samples probe tag (as the “Multiplier”).)

Part#	_____	Date	_____
Serial#	_____	Element Type	_____
Alloy	_____	Multiplier	_____
Check	_____	Initial	_____

Figure 7. Metal Samples Probe Tag

Figure 8 illustrates the relationship between the digital output and Metal Loss. In this example a probe with a 10-mil life is assumed. However, the X axis could be changed to represent any Probe Life.

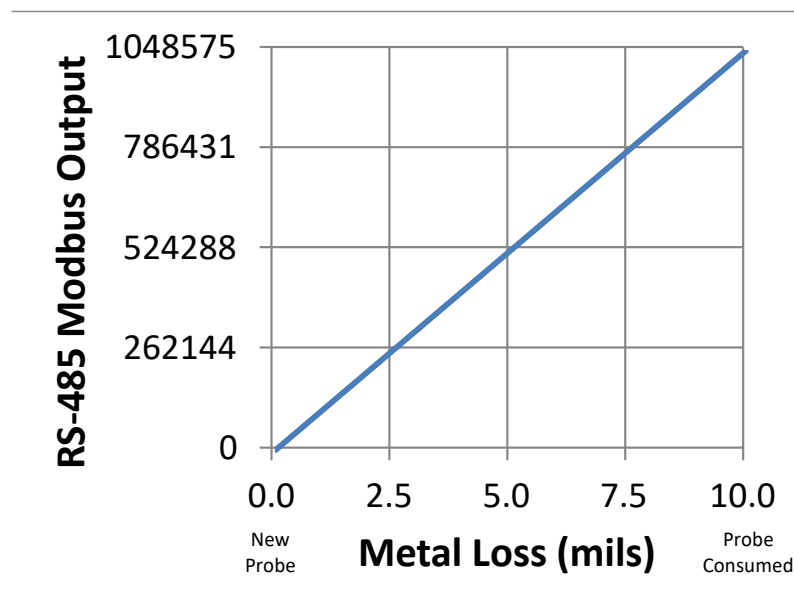


Figure 8. Output Relationship

As seen here, the transmitter output begins at 0 for a new probe (zero Metal Loss) and increases as the probe element corrodes, eventually reaching a maximum of 1,048,575 when the probe sensing element has been completely consumed by corrosion (in this case, 10 mils of Metal Loss.) At this time the probe has reached its end-of-life and must be replaced.

ii. Calculating Corrosion Rate

As explained previously, ER probes and instruments report *Metal Loss*. However, the value that is of ultimate interest is Corrosion Rate. The Corrosion Rate is essentially Metal Loss over time, so the Corrosion Rate can be calculated using the following formula:

$$\text{Corrosion Rate (mpy)} = \frac{\Delta \text{Metal Loss (mils)}}{\Delta \text{Time (days)}} \times 365$$

where:

$\Delta \text{Metal Loss (mils)}$ is the difference between two Metal Loss readings

$\Delta \text{Time (days)}$ is the time difference between those two readings

It is a common practice to program this formula into the control (DCS/PLC) system and have it calculate Corrosion Rate on a continual basis from the Metal Loss data. The challenge in doing this is selecting an appropriate time interval. Using an interval that is too short may give erratic results, while selecting an interval that is too long may give results that are insensitive to system upsets. The ideal time period depends on many factors, and will vary from system to system. It may take some trial and error to settle on the best time period for your installation.

In some cases it may be necessary to review the raw Metal Loss data and manually apply the Corrosion Rate formula to periods of interest. For example, look at the graph below and see how much the calculated Corrosion Rate can vary depending on the time period used.

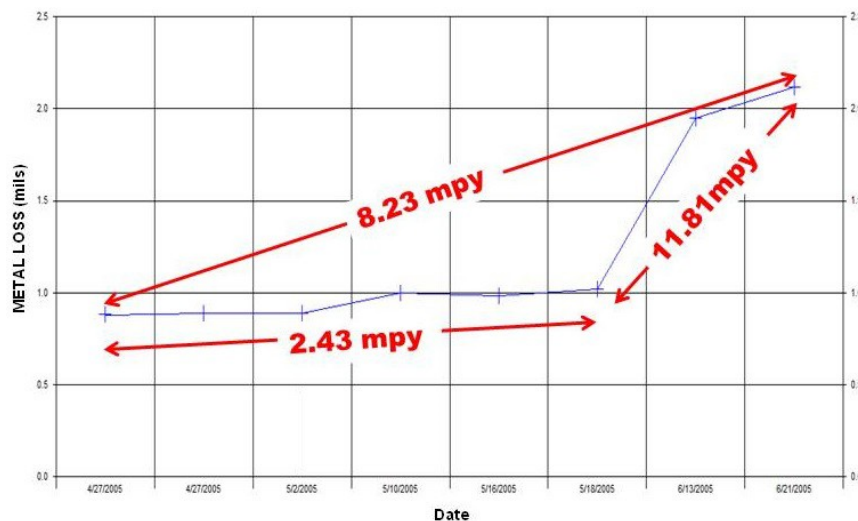


Figure 9. Corrosion Rates calculated from Metal Loss data

While each of the results is valid for the selected time period, the one of most interest is the value of 11.81 mpy which represents some type of system upset. When the Corrosion Rate is calculated automatically on a pre-selected time period, there is no guarantee that the selected time period will always coincide with system upsets such as this. That is why manual review and interpretation of Metal Loss data is also helpful.

e. Commissioning

Once the **CORR VELOX** transmitter has been installed, tested, and properly configured for the probe in use, it can then be closed and put into service. First, perform one last visual inspection to ensure that all electrical connections are secure and that the enclosure o-ring is in place and is in good condition. Then thread the enclosure lid onto the base fully. Once the lid has been threaded into place, tighten the Lock Screw to prevent unauthorized tampering.

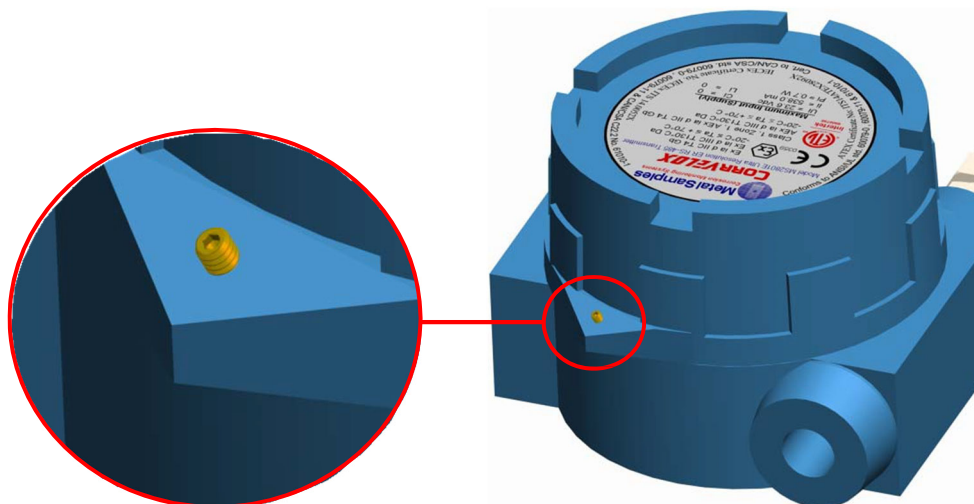


Figure 10. Enclosure Lock Screw

CAUTION: The Lock Screw on the instrument base must be tightened securely to prevent unauthorized personnel from opening the **CORR VELOX** transmitter, and ensure that the intrinsic safety is not violated. Only qualified personnel should be allowed to install, operate, and maintain the **CORR VELOX** transmitter.

C. Maintenance

Once installed, the **CORR VELOX** transmitter requires little maintenance. However, it is important to verify the following items periodically to ensure continued safe operation.

CAUTION: Before performing any tests or maintenance on the **CORR VELOX** transmitter, ensure that all hazardous area requirements are met.

Inspection Item	Frequency
Inspect the enclosure o-ring for any signs of damage. Replace as necessary.	Annually
Inspect the probe connector o-ring for any signs of damage. Replace as necessary.	Annually
Inspect all electrical connections for signs of corrosion, mechanical damage, or foreign matter that could cause improper operation or cause an electrical short. Clean as necessary.	Annually
Ensure that the locking screw is in place and is secure.	Annually
Inspect the enclosure for any signs of corrosion or paint damage.	Annually
Check for any signs of moisture ingress within the enclosure.	Annually

Contact Metal Samples for replacement parts or if instrument repair is necessary.

D. Troubleshooting

If the **CORR VELOX** transmitter does not seem to perform as expected, check the following items:

CAUTION: Before performing any tests or maintenance on the **CORR VELOX** transmitter, ensure that all hazardous area requirements are met.

1. Ensure that the probe is operational and is not completely corroded. This can be done in two ways.
 - a. Test the probe with a portable ER meter if available.
 - b. Test the probe with a portable resistance or continuity meter as follows:
 - i. Connect one test lead to pin 'A' of the probes 6-pin connector.
 - ii. Measure continuity to each of the other pins. There should be continuity (low resistance) to each pin.

NOTE: Continuity on each pin does not ensure that the probe is good. However, if you find an open circuit on any pins then it is almost certain that the probe is bad and should be replaced.
2. Ensure that the Probe Selection Switches are set correctly for the probe being used. Confirm the probe type and refer to Table 2 on page 9 to verify the appropriate switch settings.
3. Perform a visual inspection of the circuit boards to look for any signs of mechanical or electrical damage.
4. Ensure that all electrical cables and wiring are in good condition.
5. Ensure that all electrical contacts are secure and free of corrosion.
6. Ensure that there is adequate supply voltage at the power connector.
7. Verify that the supply voltage polarity is correct.
8. If there is insufficient supply voltage on the power connector, check the safety barrier (if applicable) for a blown fuse or any other failure.
9. Test the **CORR VELOX** transmitter using the supplied Meter Prover (see page 12.)

These basic checks should indicate the source of any problem (probe, power supply, wiring, etc.). If it is determined that the **CORR VELOX** transmitter is malfunctioning, or if you need further assistance in troubleshooting, contact Metal Samples Technical Support.

CAUTION: If the **CORR VELOX** transmitter shows any signs of damage, remove it from service immediately and consult the factory.

III. Service and Warranty Information

A. Warranty

Metal Samples warrants that any part of the model MS2801E **CORR VELDIX** transmitter and accessories which proves to be defective in material or workmanship within one year of the date of original shipment to Purchaser will be repaired or replaced, at Metal Samples option, free of charge. This warranty does not cover (1) probe assemblies, (2) items expendable in nature, or (3) items subject to damage from normal wear, misuse or abuse, or failure to follow use and care instructions.

All damaged items are to be shipped at Purchaser's expense to and from Metal Samples which shall have the right to final determination as to the existence and cause of a defect.

The foregoing shall constitute the sole and exclusive remedy of any purchaser of Metal Samples products for breach of warranty and IS EXCLUSIVE AND IN LIEU OF ALL OTHER WARRANTIES, EXPRESSED, IMPLIED OR STATUTORY, INCLUDING THE IMPLIED WARRANTIES OR MERCHANTABILITY AND FITNESS. IN NO EVENT SHALL METAL SAMPLES BE LIABLE FOR SPECIAL OR CONSEQUENTIAL DAMAGES, OR FOR ANY DELAY IN THE PERFORMANCE OF THIS WARRANTY DUE TO CAUSES BEYOND ITS CONTROL.

The technical information and suggestions contained herein are believed to be reliable, but they are not to be construed as warranties since conditions of use are beyond our control.

B. Obtaining Service and Returning the Instrument for Repair

If you experience problems with your instrument please contact the factory at 256-358-4202 and ask for customer support for instrumentation. Our customer support department will assist you in troubleshooting your instrument.

Most issues can be resolved over the phone, but in some cases it may be necessary to return your instrument for further evaluation and repair. In this case, please obtain a Return Materials Authorization (RMA) number from the sales person or support technician. This RMA number will ensure that your instrument is routed to the correct department when it is received at the factory.

After receipt of an RMA number you may pack your instrument for return. Be sure to pack your instrument in a sturdy box and to pad it sufficiently to avoid damage during transit. Also be sure to complete the "Instrument Repair Form" on the next page and include a copy with your repair. This will ensure that the repair department has sufficient information regarding the problems you are experiencing with your instrument, as well as the billing, contact, and return shipping details for the repair.

Once you have obtained an RMA number, completed the "Instrument Repair Form", and packed your instrument securely, please ship it prepaid to the following address:

Metal Samples
152 Metal Samples Road
Munford, AL 36268
ATTN: RMA# _ _ _ _ _

NOTE: Be sure to list your RMA number in the attention line (shown as blanks in the example above.)

C. Instrument Repair Form

This form may be photocopied for use when returning an instrument to Metal Samples for repair.
Please fill in all known information and enclose a copy of the completed form with the instrument.

General Information

Model Number		Serial Number	
RMA Number		Date of Purchase*	

**If known.*

Contact Information for Repair

Contact Name		Company	
Phone Number		E-mail Address	

Return Shipping Information

Recipient Name*		Company*	
Return Address			

**If different than above.*

Reason for Return. (Provide as much detail as possible. Attach additional pages if required.)

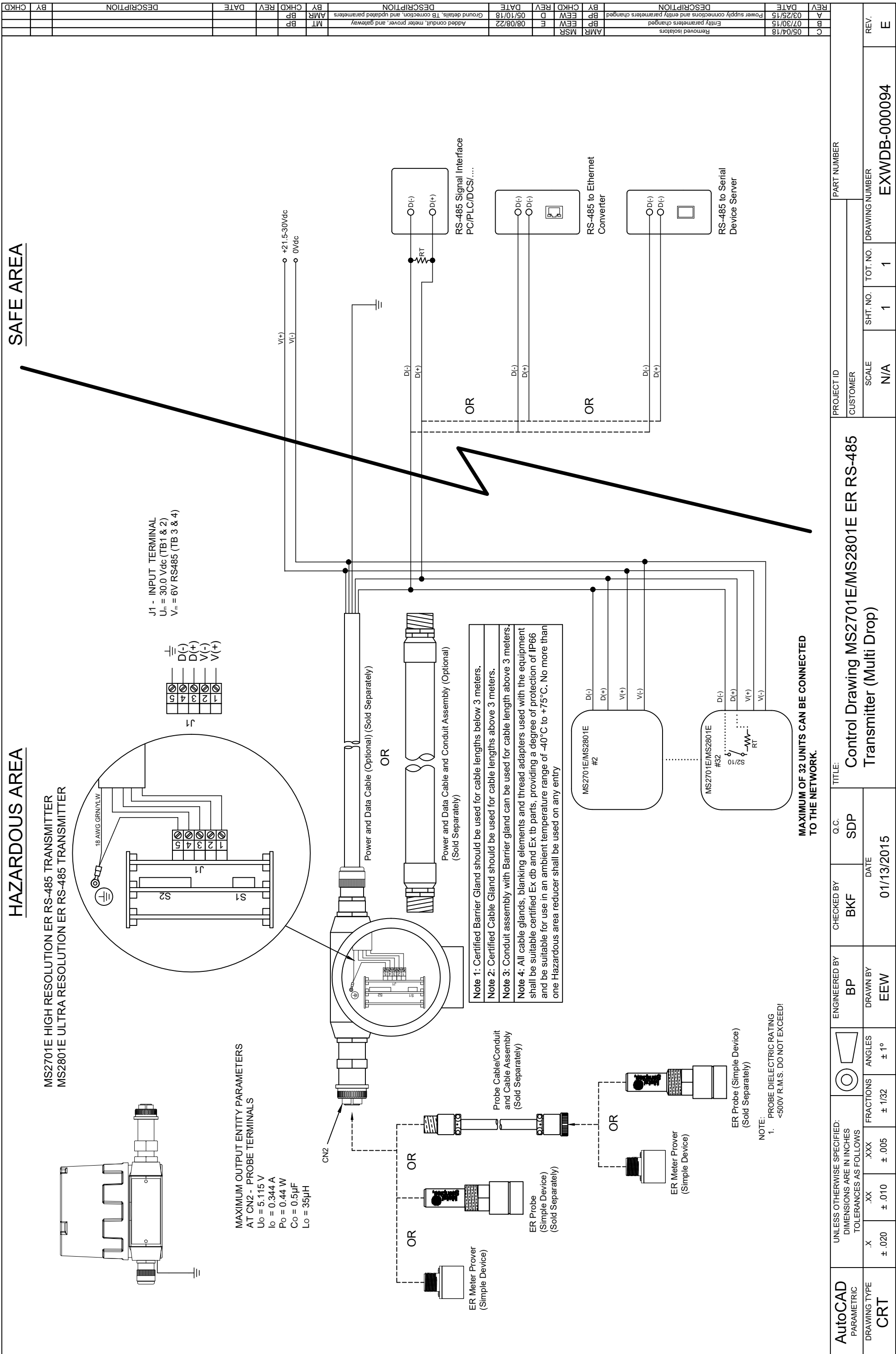
Invoice Instructions (For non-warranty repairs)

<input type="checkbox"/> Invoice me for the repair (Requires an open account with Metal samples.)	→	Reference PO#	
<input type="checkbox"/> Contact me for credit card information			

Appendix A: Revision History

[illegible]

Appendix B: Control Drawing



THIS DOCUMENT, INCLUDING THE INFORMATION HEREIN, IS PROPRIETARY PROPERTY, AND MAY NOT BE REPRODUCED OR COPIED IN WHOLE OR IN PART, NOR MAY IT BE FURNISHED TO OTHERS WITHOUT EXPRESS WRITTEN CONSENT. NOR MAY IT BE USED IN ANY WAY THAT IS OR MAY BE HARMFUL TO THE ISSUING COMPANY. THIS PRINT MUST BE RETURNED UPON REQUEST.

REV	DATE	DESCRIPTION	BY	CHKD	REV	DATE	DESCRIPTION	BY	CHKD
C	05/04/18	Removed isolators	AMR	MSR					
B	07/30/15	Entity parameters changed	BP	EEW	E	08/08/22	Added conduit, meter prover, and gateway	MT	BP
A	03/25/15	Power supply connections and entity parameters changed	BP	EEW	D	05/10/18	Ground details, TB correction, and updated parameters	AMR	BP

AutoCAD PARAMETRIC		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES AS FOLLOWS				 		ENGINEERED BY BP	CHECKED BY BKF	TITLE: Control Drawing MS2701E/MS2801E ER RS-485 Transmitter (Multi Drop)					PROJECT ID MS2701E/MS2801E		PART NUMBER ER RS-485	
DRAWING TYPE CRT	X ± .020	.XX ± .010	.XXX ± .005	FRACTIONS ± 1/32	ANGLES ± 1°	DRAWN BY EEW	DATE 01/13/2015		SCALE N/A		SHT. NO. 1	TOT. NO. 1	DRAWING NUMBER EXWDB-000094		REV. E			

www.alspi.com **info@alspi.com**
152 METAL SAMPLES RD., MUNFORD, AL 36268
PHONE:(256)-358-4202 FAX:(256)-358-4515