[[1]](#footnote-1)

Comparative Analysis of Corrosion Mitigation Strategies  
 in Water Pipeline Systems

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*Abstract*— This paper presents a quantitative comparison of two corrosion mitigation strategies for water pipelines: increasing wall thickness through a corrosion allowance versus applying an interior epoxy coating. The analysis evaluates the cost-effectiveness of each approach by examining both capital expenditures (CAPEX) and operational expenditures (OPEX) over the lifecycle of the pipeline infrastructure.

# Introduction

The strategic selection of corrosion mitigation approaches significantly impacts both operational longevity and lifecycle costs in water transmission infrastructure. This investigation evaluates two prevalent methodologies: corrosion allowance designs utilizing increased wall thickness versus epoxy-coated pipeline systems employing protective barriers.

Corrosion allowance designs employ structural overengineering to accommodate predictable material degradation rates, while epoxy coatings provide electrochemical isolation that prevents corrosive interactions. Though seemingly straightforward, these approaches carry divergent implications for hydraulic efficiency and operational expenditures.

Pipeline systems relying solely on wall thickness augmentation inherently reduce internal diameters, directly increasing pumping energy requirements. This hydraulic inefficiency becomes compounded by the elevated surface roughness characteristics of uncoated steel compared to epoxy-lined alternatives. Furthermore, bare steel systems necessitate continuous chemical inhibitor treatments to mitigate corrosion progression - introducing recurring material costs and operational complexities absent in coated systems.

This study conducts a comprehensive techno-economic analysis encompassing both capital expenditures (CAPEX) and operational costs (OPEX) across a 30-year service horizon. The evaluation framework incorporates hydraulic modeling, material degradation rates, and chemical treatment protocols to quantify total ownership costs for both mitigation strategies.

# Case Study Parameters and Computational Methodology

The analysis employs a representative industrial water transport scenario with parameters standardized for comparative evaluation. Key variables include pipe diameter (DN400), flow velocity (2.1 m/s), and water chemistry profiles typical of mineralized groundwater sources.

Table 1. Arbitrary Project Parameters

|  |  |  |
| --- | --- | --- |
| Parameter | Value | Unit |
| Pipeline length | 70 | km |
| Static head (elevation change) | 1000 | m |
| Pipeline outside diameter | 28 | inches |
| Corrosion rate per year | 0.15 | mm/yr |
| Density of water | 1030 | kg/m³ |
| Dynamic viscosity of water | 0.0013 | Pa·s |
| Design flow rate | 700 | L/s |
| Service life | 25 | years |
| Annual hours of operation | 8,400 | h/yr |
| Pump efficiency | 82 | % |
| Annual discount Rate | 10 | % |

All computational models and datasets are [publicly accessible via GitHub](https://github.com/ignaciomella/Bare-vs-Coated-Water-Pipelines/) [1], including an Excel workbook implementing the Newton-Raphson iterative technique for precise determination of Darcy-Weisbach friction factor [2]. This numerical approach resolves the implicit Colebrook-White equation with *ε/D* roughness coefficients ranging from 0.015 mm for epoxy-lined surfaces to 2.5 mm for corroding steel.

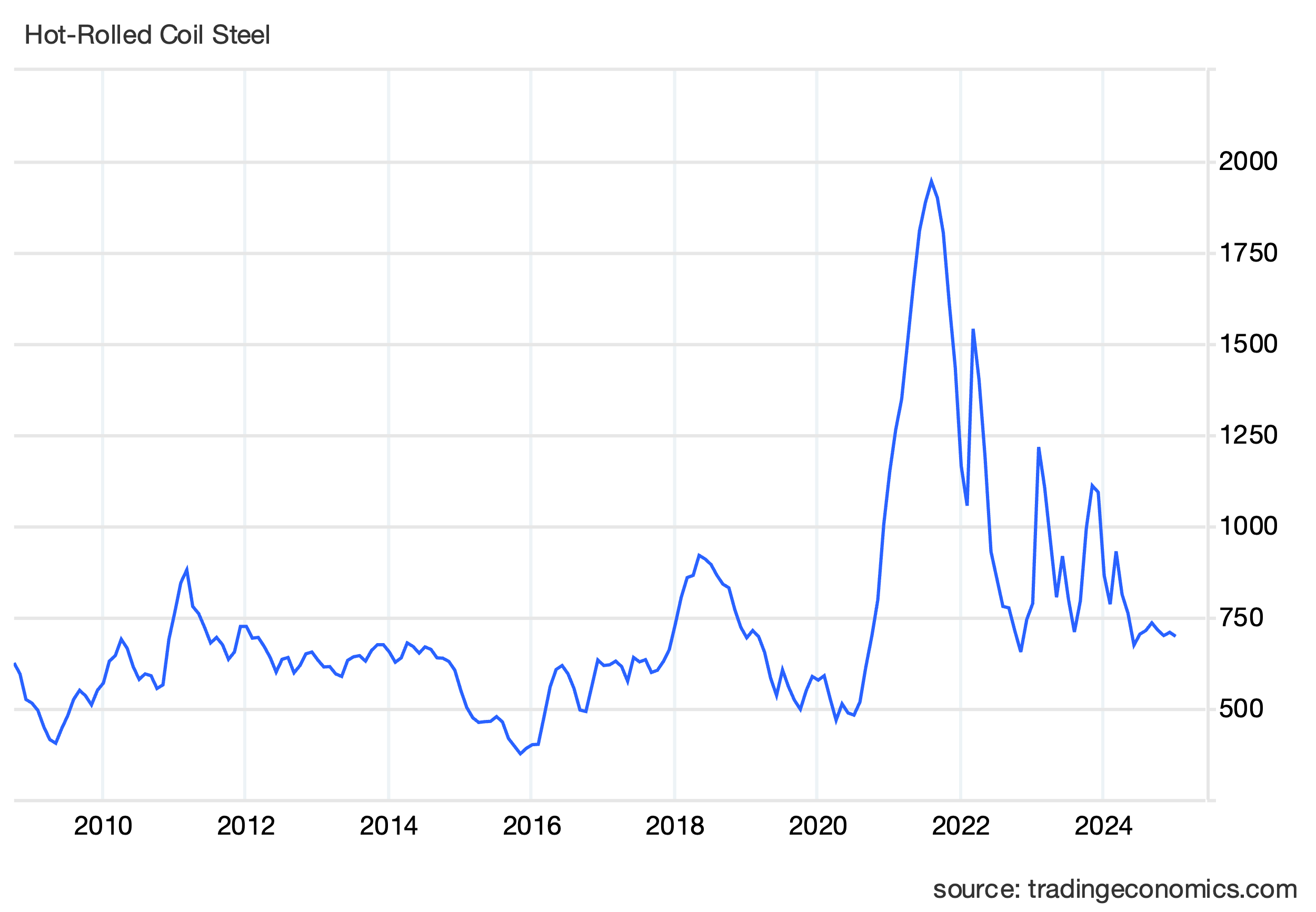
The methodological transparency enables independent verification of results while providing an adaptable framework for evaluating corrosion management strategies under diverse operational conditions. This systematic approach aims to advance evidence-based decision-making in pipeline engineering practices.

# Capital Expenditure Analysis

## Steel Pipe Economics

This cost model integrates current hot-rolled coil (HRC) market indices, manufacturing premiums, and logistical expenses to establish baseline steel pipe pricing. Recent Chinese market data indicates API 5L X70 pipe costs typically range at 1.8–2.2x HRC spot prices, reflecting value-added processes from coil to finished pipe [3] [4].

Chart 1. Historical Price of China Hot-Rolled Steel Coils ($/t)



The delivered cost per ton (CPW) derives from three primary components: a $625/t HRC baseline, 2x manufacturing multiplier, and $170/t transportation cost for Chilean projects. This yields CPW = (625·2) + 170= $1,420/t through first-principles cost aggregation.

Pipeline material costs are calculated via hollow cylinder volumetrics:

(1)

Where *D* = 0.7112 m (external diameter), *t* = 13.28 mm (bare pipe) or 9.53 mm (coated system), *L* = 70 km (pipeline length), and *ρ* = 7850 kg/m³ (X70 steel density). This parametric approach enables direct comparison of wall thickness strategies while accounting for current metallurgical market conditions. Replacing these values in eq (1):

|  |  |  |
| --- | --- | --- |
| ***Item*** | ***Bare*** | ***Coated*** |
| Wall thickness | 13.28 mm | 9.53 mm |
| Steel Weight | 16,000 t | 11,544 t |
| Cost of steel | $22,720,068 | $16,391,992 |
|  | | |

## Bare Pipeline Systems: Chemical Dosing Infrastructure

Bare pipelines require integrated chemical dosing plants to maintain corrosion inhibition and biological control. These facilities combine storage tanks, injection pumps, precision metering systems, and automated controls to proportionally administer treatments relative to flow rates (0.7 m³/s baseline). Continuous operation ensures maintained inhibitor concentrations targeting a 0.15 mm/yr corrosion rate.

Capital expenditures for such systems range $208,000–$370,000, with a mid-range valuation of $272,160.applied in this analysis. This cost envelope reflects industrial-grade components, regional supply chain factors, and automation requirements for flow-responsive chemical management.

A critical limitation of corrosion allowance strategies lies in their presumption of uniform material degradation. Practical failure modes predominantly stem from localized pitting corrosion, where concentrated material loss penetrates wall thicknesses before nominal corrosion allowances are consumed. This discrepancy underscores the importance of complementary protective measures beyond structural overengineering.

## FBE Interior Coating Economics

Shop-applied fusion-bonded epoxy (FBE) coatings (0.3 mm thickness) demonstrate cost efficiencies through industrialized application processes. Current pricing of $3.50–$5.00/m² encompasses material inputs, thermal energy requirements, and automated surface treatment systems characteristic of modern pipe mills [7] [8] [9]. This analysis adopts a conservative $5.00 per square meter cost per interior surface area (CPS) to calculate coating expenditures:

(2)

Where *D* = 0.69214 m (coated interior diameter) and *L* = 70 km (pipeline length). Implementation costs total $761,048, representing 4.4% of baseline steel material expenditures.

Chart 2. Shop FBE coating compared to steel cost.



Industry benchmarks from the Saline Water Conversion Corporation's R&D Center corroborate this 5% average ratio of coating-to-steel costs in large-diameter pipelines [5].

## Internal Robotic Field Joint Coating

Post-weld interior coating requires specialized robotic systems to address heat-affected zone degradation of factory-applied FBE layers. These crawler-mounted units perform abrasive blasting (achieving ISO 8501-1 Sa 2.5 cleanliness) followed by epoxy application via rotating nozzles - utilizing either powder or liquid formulations [10] [11].

Field conditions, including temperature fluctuations (±15°C), humidity (30–95% RH), and airborne particulates, undermine coating adhesion and curing consistency. Studies reveal a 45–60% higher failure rate for field-applied coatings compared to shop-applied systems, with 60% of pipeline failures attributed to internal corrosion. Poor surface preparation further exacerbates these vulnerabilities, creating weak points prone to premature degradation. [24] [25] [26], [12, 13] [14] [15] [16] [17] [18] [19] [20].

|  |  |
| --- | --- |
|  |  |
| *Photo 1. Factory-applied Fusion Bonded Epoxy* | *Photo 2. Field-applied Liquid Epoxy next to weld inner seam* |

Studies on losses due to pipeline damage indicate that of all the factors or causes underlying failures, approximately 60% are due to internal corrosion

Currently there are only two providers for the internal field joint coating robot service:

* Aegion/CRTS. Higher upfront costs (+20–30%) but lower rework expenses. [21].
* TYHOO Group (cost-optimized for <28" diameters with modular robots) [22].

Table 2. Cost components for robotic field coating. [23]

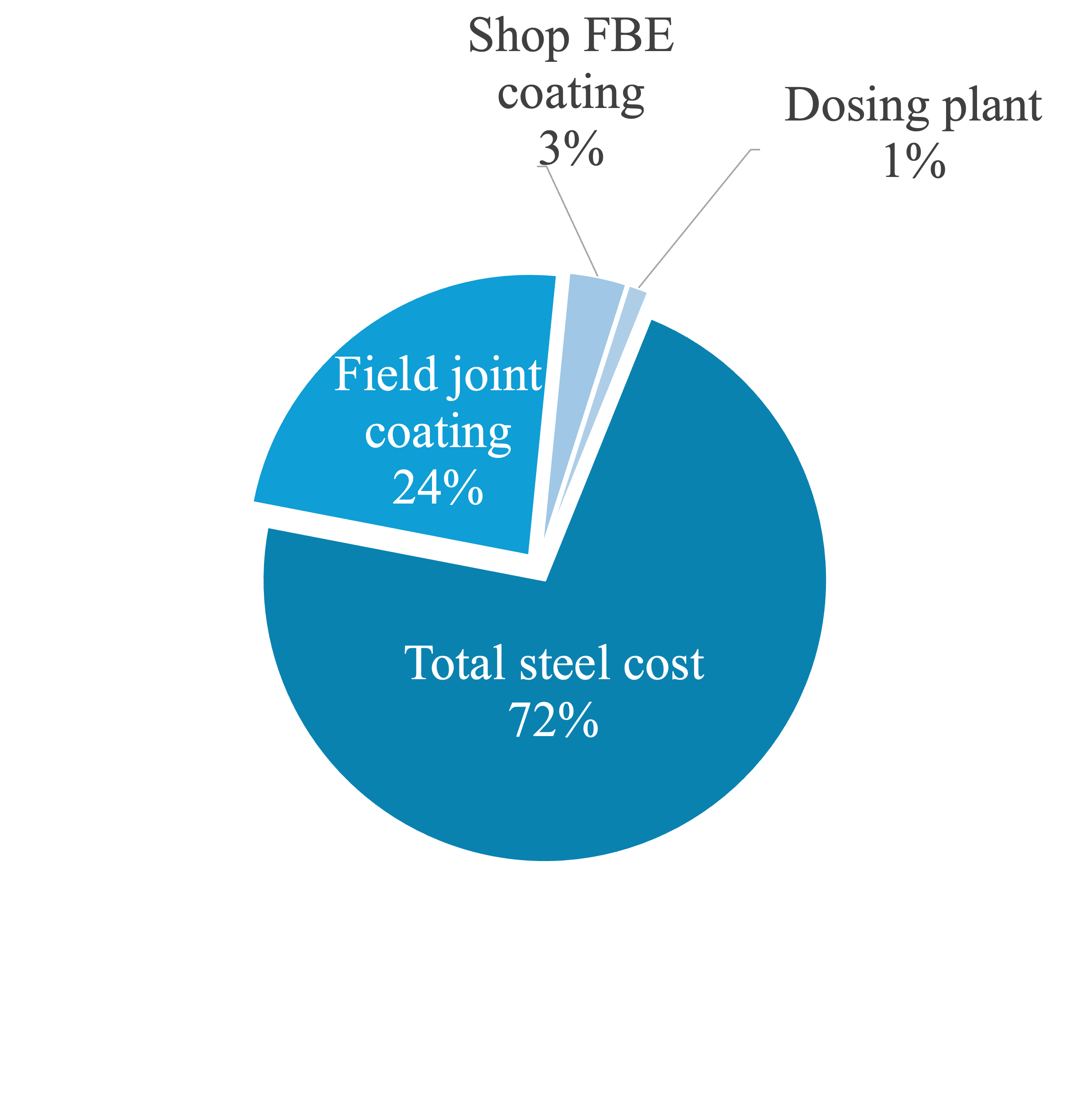
|  |  |
| --- | --- |
| ***Cost Component*** | ***Cost per Joint*** |
| Mobilization of Crew & Equipment | $22.08 |
| Demobilization of Crew & Equipment | $13.80 |
| Personnel & Robotic Equipment | $505.08 |
| Pre-blasting Personnel & Equipment | $149.04 |
| Internal Coating Application | $181.24 |
| Pipe-End Pre-blasting | $48.76 |
| Total Cost per Joint | $920.00 |

For the 5,834 -joint pipeline, this aggregates to $5,367,280 eightfold higher than factory coating expenditures.

Table 3. CAPEX composition

|  |  |
| --- | --- |
| CAPEX Item | Cost |
| Total steel cost | $16,391,992 |
| Field joint coating | $5,367,280 |
| Shop FBE coating | $761,048 |
| Dosing Plant | $272,160 |
| Total CAPEX | $22,520,319 |

Chart 3. Proportion of CAPEX items



The current landscape highlights stark disparities in cost-effectiveness and reliability between field and shop-applied methods. These challenges drive innovation in alternative solutions such as:

* **FlexSleeve**®. A stiff polymer sleeve with bore seals that is inserted into pipe ends before welding. [27].
* **SIDGMAN**®. A two-piece system—one male and one female—welded in the shop to the ends of each pipe, so that they end up as field welded pipe flanges [28].
* **Style X07**. A very high-pressure Victaulic coupling listed under ASME B31.4. It has been installed in two projects in Chile: 24" MLP INCO and 32" SQM TEA [29]. This alternative eliminate welds, takes 12 minutes in total (alignment and positioning of pipe inclusive) per joint, and does not require skilled labor.

|  |
| --- |
| **[A long pipe on a road  AI-generated content may be incorrect.](https://youtu.be/e14DHsekBIg?si=nDQ1uiHFtaoSzMGE)**  Photo 1. [SQM’s TEA project, a 32" seawater interior FBE coated pipeline](https://youtu.be/e14DHsekBIg?si=nDQ1uiHFtaoSzMGE) was joined by Victaulic’s X07 couplings. The need for robot field coating was eliminated. Project achieved a rate of 30 joints per day per crew using a single excavator and a Deckhand accessory [29] [59]. |
|  |

Such advancements aim to reduce costs and improve durability, addressing critical industry demands for more efficient and dependable post-weld solutions.

# Operational Expenditures

## Corrosion inhibitors injection

While corrosion allowance provides additional wall thickness to counteract material loss, corrosion inhibitors actively reduce the corrosion rate, offering a more economical long-term solution for pipeline protection. [30]. For long-distance pipelines, relying solely on corrosion allowance can result in prohibitively high costs [31]. The use of corrosion inhibitors usually offers a more economical solution to manage corrosion over time [32] [33].

Based on experimental data, a 26 ppm dosage of sodium polyphosphate inhibitor is recommended to maintain a corrosion rate at or below 0.15 mm/year [34] [35]. Sodium polyphosphate acts as a passivating agent, forming a thin protective film on the metal surface that serves as a barrier against corrosive agents. Additionally, a biocide is applied weekly as a 4-hour shock treatment at 20 ppm (equivalent to a continuous dose of 0.46 ppm) to prevent microbial growth, including bacteria, fungi, and algae [36] [37] [38].

Given the pipeline's flow rate of 0.7 m³/s, and the annual operating hours is 8,400 , the total annual volume transported is 21,168,000 m³. Using these parameters and the dosages above, the operational expenditures (OPEX) for corrosion and biocide inhibitors are calculated as follows:

Table 4. Calculated Dosage to achieve  
at least 0.15 mm/yr corrosion rate.

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| ***Chemical item*** | ***Dosage*** *ppm* | ***Price*** *per  kg* [39] | ***Mass*** *kg per year* | ***Cost*** *($/year)* |
| Inhibitor | 26.00 | $1.7 | 550,368 | $920,215 |
| Biocide | 0.46 | $12.8 | 9,660 | $123,648 |
|  |  |  | Total OPEX | $1,043,863 |

To compare future OPEX cash flows with CAPEX on an equal footing, future cash flows must be discounted to their present value (PV). The present value is calculated using the following equation (1):

(1)

Where *PV* is the Present Value, *FV* is the future value (annual OPEX of $1,043,863); *r* is the discount rate, 10%; *n* is the number of years into the future. Assuming cash flows occur at the end of each period over a 25-year service life, the inhibitors' OPEX present value is calculated as $9,475,189.

## Inspections

Bare uncoated steel pipes with corrosion allowance and internally epoxy-coated pipes require distinct inspection strategies due to their differing corrosion management approaches.

For bare steel pipes, inspections focus on monitoring wall thickness loss over time, typically using magnetic flux leakage (MFL) or ultrasonic testing (UT). These methods detect material degradation, with repairs involving weld patches, sleeves, or complete section replacements. Inspection intervals are generally every 3–5 years, with annual costs ranging from $8,000 to $15,000 per kilometer.

In contrast, internally epoxy-coated pipes require inspections to assess the integrity and effectiveness of the coating. Techniques such as electrochemical impedance spectroscopy (EIS) or linear polarization resistance (LPR) are employed to evaluate coating performance. Repairs involve reapplying liquid epoxy to compromised areas. Coated pipes benefit from longer inspection intervals of 5–10 years, with annual costs of $4,000 to $8,000 per kilometer.

Table 5 summarizes the key differences in inspection methodologies, frequencies, and costs:

Table 5. Inspections feature comparison.

|  |  |  |
| --- | --- | --- |
| ***Concept*** | ***Bare Pipe*** | ***Coated pipe*** |
| Main Inspection Methodology | Magnetic flux leakage (MFL) and/or ultrasonic testing (UT). | Electrochemical impedance spectroscopy (EIS) and/or linear polarization resistance (LPR). |
| Repair | Weld patches, sleeves or replace entire section. | Reapply liquid epoxy to the interior surface. |
| Periodicity | 3–5 years. | 5–10 years. |
| Cost/Year | $8,000–$15,000/km | $4,000–$8,000/km |

For analytical purposes, this study assumes annual inspection costs of $8,000/km for internally FBE-coated pipes and $4,000/km for bare steel pipes. Given a pipeline length of 70 km:

* The annual OPEX for bare pipes is $560,000.
* The annual OPEX for coated pipes is $280,000.

Using a 10%, discount rate over a 25-year service life:

* The present value (PV) of inspection costs for bare pipes is $5,083,142.
* The PV for coated pipes is $2,541,571.

## Energy consumption

Chile's industrial electricity pricing incorporates generation costs, transmission fees, and distribution charges. The generation component reflects marginal system costs influenced by fossil fuel prices and renewable penetration [40] [41]. Transmission and distribution costs remain regulated, with recent tariff adjustments adding complexity to pricing calculations. [42].

For large industrial consumers, July 2024 data showed an average rate of $128/MWh [43]. This baseline industrial rate of $128/MWh requires adjustment through three critical factors: fuel price volatility (45.77% fossil dependency amid declining coal production) [44], renewable integration costs ($5-8/MWh for grid stability with 27% solar/wind penetration) [41], and transmission constraints ($3-12/MWh regional differentials) [41]. Chile's 2024 Tariff Stabilization Law further modifies pricing via:

* Generation component adjustments. (+15% from 2022 baseline, CPI-indexed) [45].
* Debt servicing surcharge ($0.02/kWh until 2035) [46] [47].
* Transmission upgrades. ($1.2/MWh fee) [48].

This comprehensive adjustment framework elevates the 2024 effective rate to:

It is important to note that the energy costs for the Chilean mining sector costs rose from $85/MWh (2015) to $112/MWh (2024), 40% above Peruvian competitors [49]. The successful execution of coal phase-outs and renewable integration will determine whether the next decade sustains the deflationary trends of 2015-2020 or reverts to the volatility of earlier periods.

As shown in Table 6, historical context, this analysis adopts a projected rate of *P* = $175/MWh for years 2025 onwards. This rate *P* is used in equation (2) which calculates de cost of energy consumed by the pipeline project pump(s).

Table 6.Historical Price Context

|  |  |  |
| --- | --- | --- |
| **Year** | **Avg. Industrial Rate** | **Key Influencers** |
| 2022 | $145/MWh | Coal phase-out begins |
| 2023 | $158/MWh | Gas price spike |
| 2024 | $168/MWh (adjusted) | Debt repayment initiated |
| 2025 | $175/MWh (projected) | Full tariff normalization |

(2)

Where is fluid density; *g* is the gravitational acceleration; *Q* is the volumetric flow rate; is the total head loss due to friction losses () plus elevation head ( = 1000 m); is the pump efficiency (82%) and *t* is the annual operating time (8400 hours).

To estimate energy required to overcome friction losses in the pipeline the Darcy-Weisbach equation (3) is used. For this analysis.

(3)

Where is the head loss due to friction losses in the pipeline; *f* is the Darcy-Weisbach friction factor, a dimensionless parameter representing energy loss due to friction in a pipe; *L* is the length of the pipeline; is the velocity of the fluid; *g* is the acceleration due to gravity, which normalizes the equation for gravitational effects; and *D* is the inside diameter of the pipeline, where larger diameters reduce friction losses by lowering fluid velocity for a given flow rate.

To calculate the Darcy-Weisbach friction factor *f*, the Colebrook-White equation is utilized.

(4)

Where *f* is the Darcy-Weisbach friction factor; *k* is the pipe’s roughness height and *D* is the pipe inside diameter; *Re* is the Reynolds number; and the logarithmic term accounts for both surface roughness and viscous effects in turbulent flow. The equation is implicit in *f* and requires iterative or numerical methods to solve.

**Bare Pipe Case Calculations**

For the bare pipe case, on year 1, the Reynolds number is calculated as using equation:

(5)

Where is the fluid density (1030), is the fluid velocity on year 1 (1.915 m/s) derived from the flow ratio of 0.7 m³/s, is the pipe inside diameter (0.68464m) for wall thickness of 13.28 mm on year 1, is the dynamic viscosity (0.0013 Pa·s). Substituting values, . Again, substituting values on eq (4):

(6)

Solving for *f* using the Newton-Raphson iterative numerical technique which converges to *f* = 0.014030.

Substituting values on eq (3):

(7)

Again, substituting values on eq (2):

(8)

For the bare pipe case, previous calculation procedure is repeated for the next 25 years, decreasing the wall thickness by the design corrosion rate of 0.15 mm/yr; from 13.28 mm on year 1 to 9.53 mm on year 25; and increasing the pipe roughness from 0.1 mm on first year to 0.3 mm by the end of year 25.

Same procedure is done for the **coated pipe case**, only this time, wall thickness is maintained at 9.53 mm, and pipe roughness increases from 0.01 mm on first year to 0.05 mm by year 25 end. The results for both the bare and coated pipe are listed on Annex A – Energy Consumption Calculations.

The consequent Present Value for the cost of electricity during these 25 years at a discount rate of 10% presented for both cases in the next table.

Table 7. Electricity Consumption Present Value Comparison

|  |  |  |  |
| --- | --- | --- | --- |
| Energy Cost | Bare Pipe | Coated Pipe | Difference |
| Friction | $32,323,586 | $25,223,188 | $7,100,398 |
| Elevation | $115,054,517 | $115,054,517 | $0 |

As shown in Table 7, friction-related energy consumption for coated pipes is significantly lower than for bare pipes due to reduced roughness and hydraulic inefficiencies over time.

# Analysis of Results

As shown in Table 9, a comparison of CAPEX and the Present Value (PV) of OPEX over the 25-year service period reveals a 10.6%% cost advantage for the coated pipeline strategy, with a total lifecycle cost of $165,339,595 versus $184,928,662 for the bare pipe approach. This translates to a savings of $19,589,067 over the evaluation period.

Table 8. CAPEX and Present Value of OPEX   
for each corrosion mitigation strategy.

|  |  |  |  |
| --- | --- | --- | --- |
| Item | Bare Pipe | Coated Pipe | Difference |
| Inhibitors | $9,475,189 |  | $9,475,189 |
| Steel | $22,720,068 | $16,391,992 | $7,100,398 |
| Field Joint Coating |  | $5,367,280 | ($5,367,280) |
| Friction Energy | $32,323,586 | $25,223,188 | $7,100,398 |
| Elevation Energy | $115,054,517 | $115,054,517 | $0 |
| Inspections | $5,083,142 | $2,541,571 | $2,541,571 |
| Shop FBE |  | $761,048 | ($761,048) |
| Dosing Plant | $272,160 |  | $272,160 |
| Total | $184,928,662 | $165,339,595 | $19,589,067 |

However, this comparison includes elevation energy costs ($115,054,517) which are equal for both strategies and therefore irrelevant to this analysis. Excluding these costs provides a clearer picture of the differential impact between approaches. Table 10 highlights these differences:

Table 9. Differential comparison excluding Elevation Costs.

|  |  |  |  |
| --- | --- | --- | --- |
| Item | Bare Pipe | Coated Pipe | Difference |
| Extra Inhibitors | $9,475,189 |  |  |
| Extra Friction Energy | $7,100,398 |  |  |
| Extra Steel | $6,328,077 |  |  |
| Joint Field Coating |  | $5,367,280 |  |
| Extra Inspections | $2,541,571 |  |  |
| Shop Coating |  | $761,048 |  |
| Dosing Plant | $272,160 |  |  |
| Total | $25,717,395 | $6,128,328 | $19,589,067 |

As shown in Table 10, the primary cost drivers of the corrosion allowance strategy are the additional expenses associated with corrosion inhibitors, increased electricity consumption due to higher friction losses, and the extra steel required to compensate for material loss over time. Remarkably, each of these cost components individually exceeds the combined cost of shop and field coatings for an internally coated pipeline.

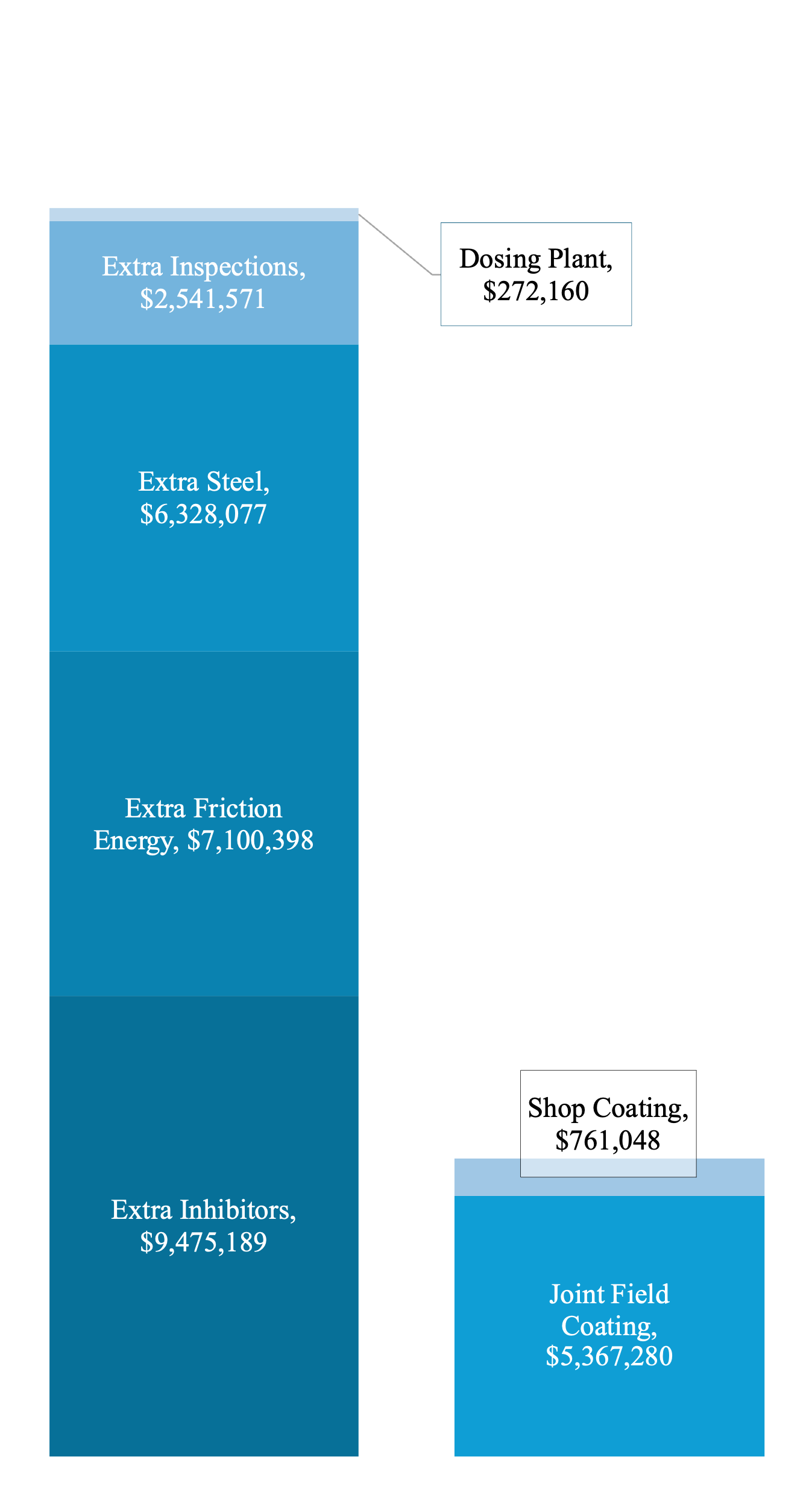
This stark contrast underscores the inherent cost inefficiency of the bare pipe strategy. Further exploration into niche applications or unique project constraints could provide valuable insights into this question.

• **Material Savings**: The bare pipe requires 29.6% more steel by mass (13.28 mm vs 9.53mm wall thickness), accounting for $6,328,077 in additional capital expenditure.

• **Operational Efficiencies**: The coated system demonstrates $7,100,398 savins in net present value energy savings from reduced pipe roughness (0.01-0.05mm vs 0.1-0.3mm) and increased pipe inside diameter, and does not require inhibitors, saving $9,475,189 in present value from the OPEX of inhibitors injection.

• **Maintenance Optimization**: Combined inspection and chemical treatment costs for the bare pipe total $2,541,571 higher than the coated pipe strategy.

Chart 4. Differential comparison between corrosion mitigation strategies. Elevation energy OPEX are excluded.



# Conclusion

This study provides a comprehensive evaluation of two corrosion mitigation strategies—corrosion allowance via increased wall thickness and interior Fusion Bonded Epoxy (FBE) coating—for water transport pipelines. The analysis, grounded in a 25-year lifecycle cost assessment, highlights **significant economic and operational advantages** of the epoxy-coated pipeline approach over the corrosion allowance strategy. Key findings include:

1. **Cost-Effectiveness**: The epoxy-coated pipeline demonstrates a 10.6% total lifecycle cost advantage when elevation energy costs are included. When excluding these unavoidable costs, the coated pipeline's differential advantage becomes even more pronounced, driven by reduced material requirements, lower energy consumption, and minimized maintenance costs.
2. **Material Efficiency**: The corrosion allowance strategy requires 29.6% more steel due to increased wall thickness (13.28 mm vs. 9.53 mm), resulting in an additional capital expenditure of $6.33 million. This highlights the inefficiency of using thicker walls to account for long-term corrosion.
3. **Operational Savings**: The epoxy-coated pipeline achieves $7.1 million in energy savings due to its smoother internal surface and larger effective diameter, which reduce friction losses during pumping operations. Additionally, it eliminates the need for costly corrosion inhibitors, saving $9.48 million in present value over the service life.
4. **Maintenance Optimization**: Inspection and repair costs for the epoxy-coated pipeline are substantially lower than those for the bare pipe with corrosion allowance, yielding $2.54 million in savings over 25 years due to less frequent and less invasive maintenance requirements.
5. **Technical Viability**: While robotic field joint coating for FBE pipelines incurs higher costs and unreliability risks compared to factory-applied coatings, alternative solutions such as Victaulic’s X07 couplings and other innovative technologies can eliminate this expense altogether, further enhancing the feasibility of epoxy-coated pipelines.

|  |  |  |
| --- | --- | --- |
| ****Aspect**** | ****Corrosion Allowance**** | ****Internally Coated Pipe (FBE)**** |
| **Capital Expenditure (CAPEX)** | Requires 29.6% more steel due to increased wall thickness, adding $6.33 million to initial costs | Lower initial steel cost; additional $761,048 for shop coating and $5.37 million for field joint coating1. |
| **Operational Costs  (OPEX)** | - High energy costs due to increased friction from rougher pipe surface and smaller internal diameter. - Requires corrosion inhibitors, adding $11.84 million in present value over 25 years. | - Smoother surface reduces friction, saving $7.1 million in energy costs. - No need for inhibitors, reducing complexity and cost. |
| **Maintenance** | - Frequent inspections and repairs due to progressive wall thinning. - Higher inspection costs ($5.08 million over 25 years). | - Less frequent inspections (every 5-10 years) and lower costs ($2.54 million over 25 years). |
| **Durability** | Relies on material thickness; prone to localized pitting corrosion that may lead to failures. | Effective barrier against corrosion; weak points at field joints if improperly coated. |
| **Technical Challenges** | Simple design but less adaptable to varying corrosion rates or localized damage. | Requires specialized application techniques; challenges with field joint coating quality. |
| **Energy Efficiency** | Higher friction losses increase pumping energy consumption by $7.1 million in present value. | Improved hydraulic efficiency reduces energy consumption. |

# Summary

**Corrosion Allowance**: While simpler to implement, this strategy incurs higher material, energy, and maintenance costs over the pipeline's lifecycle. It is less adaptable to localized corrosion risks and relies heavily on chemical inhibitors, which pose environmental concerns.

**Internally Coated Pipe (FBE):** Offers better long-term cost savings due to reduced energy consumption and maintenance needs. However, it requires careful application and quality control during installation, particularly at field joints.

Overall, the internally coated pipe strategy demonstrates superior lifecycle performance but involves higher initial technical complexity.

Appendix A

Table 10. Bare pipe Electricity cost calculations.

|  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| #NAME? | | | | | | | | | | |
| Yr | Pipe  roughness  [ mm ] | Interior  Diameter  [ mm ] | Wall  thickness  [ mm ] | Fluid  Velocity  [m/s] | Friction  factor f  [ ] | Head  Loss  [ m ] | Pump  Friction  [ kW ] | Pump  Elevation  [ kW ] | Electricity  Friction  [ M$ ] | Electricity  Elevation  [ M$ ] | |
| 1 | 0.100 | 682.140 | 14.53000 | 1.915 | 0.014030 | 269.32 | 2322 | 8623 | $3,413,697 | $12,675,334 | |
| 2 | 0.108 | 682.557 | 14.32167 | 1.913 | 0.014180 | 271.37 | 2340 | 8623 | $3,439,685 | $12,675,334 | |
| 3 | 0.117 | 682.973 | 14.11333 | 1.911 | 0.014325 | 273.31 | 2357 | 8623 | $3,464,266 | $12,675,334 | |
| 4 | 0.125 | 683.390 | 13.90500 | 1.908 | 0.014466 | 275.14 | 2372 | 8623 | $3,487,545 | $12,675,334 | |
| 5 | 0.133 | 683.807 | 13.69667 | 1.906 | 0.014602 | 276.89 | 2387 | 8623 | $3,509,618 | $12,675,334 | |
| 6 | 0.142 | 684.223 | 13.48833 | 1.904 | 0.014734 | 278.54 | 2402 | 8623 | $3,530,569 | $12,675,334 | |
| 7 | 0.150 | 684.640 | 13.28000 | 1.901 | 0.014862 | 280.11 | 2415 | 8623 | $3,550,473 | $12,675,334 | |
| 8 | 0.158 | 685.057 | 13.07167 | 1.899 | 0.014987 | 281.60 | 2428 | 8623 | $3,569,398 | $12,675,334 | |
| 9 | 0.167 | 685.473 | 12.86333 | 1.897 | 0.015108 | 283.02 | 2440 | 8623 | $3,587,405 | $12,675,334 | |
| 10 | 0.175 | 685.890 | 12.65500 | 1.895 | 0.015227 | 284.38 | 2452 | 8623 | $3,604,550 | $12,675,334 | |
| 11 | 0.183 | 686.307 | 12.44667 | 1.892 | 0.015342 | 285.66 | 2463 | 8623 | $3,620,882 | $12,675,334 | |
| 12 | 0.192 | 686.723 | 12.23833 | 1.890 | 0.015455 | 286.89 | 2474 | 8623 | $3,636,447 | $12,675,334 | |
| 13 | 0.200 | 687.140 | 12.03000 | 1.888 | 0.015565 | 288.06 | 2484 | 8623 | $3,651,288 | $12,675,334 | |
| 14 | 0.208 | 687.557 | 11.82167 | 1.885 | 0.015673 | 289.18 | 2493 | 8623 | $3,665,442 | $12,675,334 | |
| 15 | 0.217 | 687.973 | 11.61333 | 1.883 | 0.015778 | 290.24 | 2503 | 8623 | $3,678,945 | $12,675,334 | |
| 16 | 0.225 | 688.390 | 11.40500 | 1.881 | 0.015881 | 291.26 | 2511 | 8623 | $3,691,830 | $12,675,334 | |
| 17 | 0.233 | 688.807 | 11.19667 | 1.879 | 0.015983 | 292.23 | 2520 | 8623 | $3,704,127 | $12,675,334 | |
| 18 | 0.242 | 689.223 | 10.98833 | 1.876 | 0.016082 | 293.16 | 2528 | 8623 | $3,715,863 | $12,675,334 | |
| 19 | 0.250 | 689.640 | 10.78000 | 1.874 | 0.016179 | 294.04 | 2535 | 8623 | $3,727,065 | $12,675,334 | |
| 20 | 0.258 | 690.057 | 10.57167 | 1.872 | 0.016275 | 294.88 | 2543 | 8623 | $3,737,757 | $12,675,334 | |
| 21 | 0.267 | 690.473 | 10.36333 | 1.869 | 0.016368 | 295.69 | 2550 | 8623 | $3,747,962 | $12,675,334 | |
| 22 | 0.275 | 690.890 | 10.15500 | 1.867 | 0.016461 | 296.46 | 2556 | 8623 | $3,757,699 | $12,675,334 | |
| 23 | 0.283 | 691.307 | 9.94667 | 1.865 | 0.016551 | 297.19 | 2563 | 8623 | $3,766,990 | $12,675,334 | |
| 24 | 0.292 | 691.723 | 9.73833 | 1.863 | 0.016640 | 297.89 | 2569 | 8623 | $3,775,852 | $12,675,334 | |
| 25 | 0.300 | 692.140 | 9.53000 | 1.860 | 0.016728 | 298.56 | 2574 | 8623 | $3,784,304 | $12,675,334 | |
|  | Bare Pipe Case. Present Value (annual OPEX discounted at 10% rate) | | | | | | | | $32,323,586 | $115,054,517 | |

Table 11. Coated pipe Electricity cost calculations

|  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| Analyzed case: FBE coated. Initial wall thickness = 9.53 mm; year 25 wall thickness = 9.53 mm. Initial pipe roughness = 0.01 mm; year 25 pipe roughness = 0.05 mm. Fixed parameters: Elevation head = 1000 m; pump efficiency = 0.82%; energy cost = 0.174 $/kWh; outside diameter = 28''; flow rate = 700 L/s; density of water = 1030 kg/m3; viscosity of water = 0.0013 Pa·s | | | | | | | | | | |
| Yr | **Pipe**  **roughness**  **[ mm ]** | **Interior**  **Diameter**  **[ mm ]** | **Wall**  **thickness**  **[ mm ]** | **Fluid**  **Velocity**  **[m/s]** | **Friction**  **factor**  **f** | **Head**  **Loss**  **[ m ]** | **Pump**  **Friction**  **[ kW ]** | **Pump**  **Elevation**  **[ kW ]** | **Electricity**  **Friction**  **[ M$ ]** | **Electricity**  **Elevation**  **[ M$ ]** |
| 1 | 0.0100 | 692.140 | 9.53000 | 1.860 | 0.011929 | 212.91 | 1836 | 8623 | $2,698,730 | $12,675,334 |
| 2 | 0.0117 | 692.140 | 9.53000 | 1.860 | 0.011980 | 213.83 | 1844 | 8623 | $2,710,311 | $12,675,334 |
| 3 | 0.0133 | 692.140 | 9.53000 | 1.860 | 0.012031 | 214.73 | 1852 | 8623 | $2,721,728 | $12,675,334 |
| 4 | 0.0150 | 692.140 | 9.53000 | 1.860 | 0.012080 | 215.61 | 1859 | 8623 | $2,732,985 | $12,675,334 |
| 5 | 0.0167 | 692.140 | 9.53000 | 1.860 | 0.012130 | 216.49 | 1867 | 8623 | $2,744,089 | $12,675,334 |
| 6 | 0.0183 | 692.140 | 9.53000 | 1.860 | 0.012178 | 217.35 | 1874 | 8623 | $2,755,043 | $12,675,334 |
| 7 | 0.0200 | 692.140 | 9.53000 | 1.860 | 0.012226 | 218.21 | 1882 | 8623 | $2,765,852 | $12,675,334 |
| 8 | 0.0217 | 692.140 | 9.53000 | 1.860 | 0.012273 | 219.05 | 1889 | 8623 | $2,776,522 | $12,675,334 |
| 9 | 0.0233 | 692.140 | 9.53000 | 1.860 | 0.012319 | 219.88 | 1896 | 8623 | $2,787,055 | $12,675,334 |
| 10 | 0.0250 | 692.140 | 9.53000 | 1.860 | 0.012365 | 220.70 | 1903 | 8623 | $2,797,457 | $12,675,334 |
| 11 | 0.0267 | 692.140 | 9.53000 | 1.860 | 0.012411 | 221.51 | 1910 | 8623 | $2,807,731 | $12,675,334 |
| 12 | 0.0283 | 692.140 | 9.53000 | 1.860 | 0.012456 | 222.31 | 1917 | 8623 | $2,817,880 | $12,675,334 |
| 13 | 0.0300 | 692.140 | 9.53000 | 1.860 | 0.012500 | 223.10 | 1924 | 8623 | $2,827,908 | $12,675,334 |
| 14 | 0.0317 | 692.140 | 9.53000 | 1.860 | 0.012544 | 223.89 | 1930 | 8623 | $2,837,819 | $12,675,334 |
| 15 | 0.0333 | 692.140 | 9.53000 | 1.860 | 0.012587 | 224.66 | 1937 | 8623 | $2,847,616 | $12,675,334 |
| 16 | 0.0350 | 692.140 | 9.53000 | 1.860 | 0.012630 | 225.42 | 1944 | 8623 | $2,857,302 | $12,675,334 |
| 17 | 0.0367 | 692.140 | 9.53000 | 1.860 | 0.012672 | 226.18 | 1950 | 8623 | $2,866,879 | $12,675,334 |
| 18 | 0.0383 | 692.140 | 9.53000 | 1.860 | 0.012714 | 226.93 | 1957 | 8623 | $2,876,351 | $12,675,334 |
| 19 | 0.0400 | 692.140 | 9.53000 | 1.860 | 0.012756 | 227.66 | 1963 | 8623 | $2,885,721 | $12,675,334 |
| 20 | 0.0417 | 692.140 | 9.53000 | 1.860 | 0.012797 | 228.40 | 1969 | 8623 | $2,894,990 | $12,675,334 |
| 21 | 0.0433 | 692.140 | 9.53000 | 1.860 | 0.012837 | 229.12 | 1976 | 8623 | $2,904,163 | $12,675,334 |
| 22 | 0.0450 | 692.140 | 9.53000 | 1.860 | 0.012877 | 229.84 | 1982 | 8623 | $2,913,240 | $12,675,334 |
| 23 | 0.0467 | 692.140 | 9.53000 | 1.860 | 0.012917 | 230.54 | 1988 | 8623 | $2,922,224 | $12,675,334 |
| 24 | 0.0483 | 692.140 | 9.53000 | 1.860 | 0.012956 | 231.25 | 1994 | 8623 | $2,931,118 | $12,675,334 |
| 25 | 0.0500 | 692.140 | 9.53000 | 1.860 | 0.012995 | 231.94 | 2000 | 8623 | $2,939,924 | $12,675,334 |
| Bare Pipe Case. Present Value (annual OPEX discounted at 10% rate) | | | | | | | | | **$25,223,188** | **$115,054,517** |

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