

# **Steam Reformer - Startup SOP (Sample)**

Scope: Startup and normal operation of primary steam reformer in syngas-based ammonia plant.

Pre-startup checks:

- Verify mechanical completion and punchlist.
- Confirm refractory dry-out and lube/oil systems ready.
- Instrument calibration and safety interlocks tested.

Burner light-up:

- Purge furnace per NFPA/API timings.
- Light pilots, confirm flame scanners.
- Ramp fuel slowly monitoring bridge wall temps.

Ramp-up and handover:

- Increase firing in controlled steps, log temps.
- Optimize steam-to-carbon ratio before full load.