# Boiler Combustion Control Training Course: Air-Fuel Ratio, Oxygen Trim and Safeguards

7 – 11 June 2027
Amsterdam

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**Ref:** 920_41761 **Date:** 7 – 11 June 2027 **Location:** Amsterdam **Fees:** 4800 GBP

## Programme Summary

Boiler combustion control is the subject of this one-week training course for plant managers, instrumentation leads and operations heads, taught at managerial level and ending in a combustion control review for one boiler. Fuel and air must stay in step as steam demand moves, yet loops are often left on old settings. The programme moves from combustion principles to loop diagnosis, then to tuning rules and safeguards, using prepared trend records from a power plant and a process site. Mars Training Centre UK delivers this programme on boiler combustion control to mixed-organisation cohorts.

## The Business Case

Leaders who can read air-fuel behaviour from trends, judge whether a loop or the equipment is at fault and keep protective functions separate from control make better decisions on tuning, upgrades and shutdowns. Less fuel is lost to surplus air, and repeated trips are traced to a cause instead of being accepted as normal. The programme works on the measures below.

- Fuel Consumption: Falls when excess air is trimmed to what the load and the burner require.
- Unplanned Trips: Reduce when loop faults are found before they reach the safety layer.
- Emissions Performance: Improves when the air-fuel ratio holds across load changes.

## Principles and Evidence Base

- Feedback and feedforward control: The two basic ways a loop corrects error, applied in Sessions 2 and 3 to judge which loops need prediction.
- Combustion stoichiometry: The relation between fuel, air and excess oxygen, applied in Session 1 to explain efficiency and emissions.
- Cross-limiting air-fuel control: The scheme that makes air lead on load increases and trail on decreases, applied in Session 3 to set the firing sequence.

## Intended Participants

- Plant managers who answer for steam supply and fuel cost.
- Instrumentation and control leads who own loop settings and change requests.
- Operations heads who decide when a boiler runs in manual.
- Energy managers who track efficiency and review trip causes.

Typical settings include power generation, refining, food manufacturing and district heating.

## Learning Outcomes

1. Participants will be able to explain the effect of excess air on efficiency and emissions.
2. Participants will be able to diagnose combustion loop faults from trend records.
3. Participants will be able to construct tuning and firing rules for load changes.
4. Participants will be able to evaluate whether a protective function is independent of the control loops.
5. Participants will be able to prioritise control upgrades by fuel saving and trip risk.
6. Participants will be able to justify a combustion control review to a plant director.

## Programme Structure

## Day 1: Boiler Combustion Control Foundations

How do fuel, air and excess oxygen determine efficiency and emissions?

- Combustion Stoichiometry Chart
- Excess Air and Stack Loss Curve
- Flue Gas Oxygen Reading
- Burner Turndown Range Sheet
- Boiler Control Layer Map

## Day 2: Reading Combustion Loops from Trends

What do trend records show about whether a loop is healthy?

- Steam Pressure Master Loop Trend Review
- Fuel and Air Flow Tracking Plot
- Valve and Damper Linearity Check
- Hunting and Oscillation Pattern Guide
- Measurement Drift Checklist

## Day 3: Air-Fuel Ratio and Load Following Design

How should fuel and air be commanded so the flame stays safe as load changes?

- Cross-Limiting Firing Sequence Diagram
- Oxygen Trim Setpoint Rule
- Feedforward From Steam Demand Table
- Parallel Positioning Versus Metered Control Comparison
- Load Change Test Plan

## Day 4: Safeguards, Interlocks and Control Changes

How are protection and control kept apart, and how is a change approved?

- Safety Interlock Independence Review
- Flame Failure and Purge Logic Overview
- Manual Mode and Override Policy
- Control Change Approval Form
- Trip Cause Classification Log

## Day 5: Combustion Control Review for One Boiler

Do the findings join into a review that a director can approve?

- Applying the Session 1 Excess Air Curve
- Testing the Session 2 Loop Health Guide
- Checking the Session 3 Firing Sequence
- Reviewing the Session 4 Interlock Findings
- Completing the Combustion Control Review

## Methodology

The programme is a data-led simulation built on prepared trend records of steam pressure, fuel flow, air flow and flue gas oxygen from a power plant and a process site. Participants read the trends, name the likely fault, set rules for load changes and defend their conclusions to peers acting as a technical committee.

- Suggested activity: Finding the cause of a steady oxygen swing in a load-following boiler.
- Suggested activity: Drafting a firing sequence rule for a fast load rise.
- Suggested activity: Reviewing a trip log and sorting causes by control or equipment.

## Capstone Output

Each participant completes a combustion control review for one boiler. It holds a loop health table, an excess air target, firing and tuning rules, an interlock independence note and a ranked upgrade list. At work it goes to the plant director for approval and becomes the standard against which later control changes are judged.

## Frequently Asked Questions

### Is boiler combustion control training suitable for managers who are not control engineers?

Yes. Boiler combustion control is taught through trend records and templates. You need responsibility for a boiler, its fuel cost or its control settings, but no programming experience.

## Which principles does boiler combustion control rest on in this training?

Boiler combustion control here rests on combustion stoichiometry, feedback and feedforward control and cross-limiting air-fuel control, with protection kept separate from the control loops.

## How is the review from boiler combustion control training used at work?

You take the combustion control review to your plant director, use its loop health table to plan tuning work and keep its change form for later control modifications.

## How does boiler combustion control differ from a programme on boiler water treatment?

Boiler combustion control concentrates on fuel, air and flame behaviour in the furnace, while a programme on boiler water treatment concentrates on feedwater chemistry, scale and corrosion.