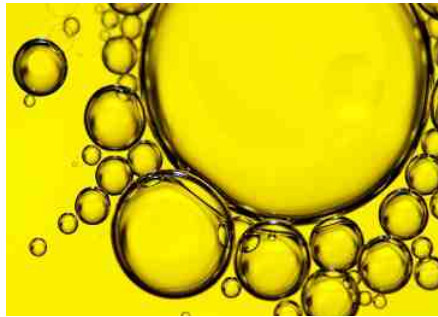


## Vaisala HUMICAP® Sensor for Measuring Moisture in Oil



Water is a common contaminant in industrial oils. Water contamination deteriorates the performance of the oil, be it used for lubrication, cooling, insulation or other purposes. High moisture content increases the risk of corrosion, overheating, machine malfunction and other problems and can ultimately lead to costly failure and unscheduled downtime. Monitoring the oil for moisture is a simple way of improving the reliability of industrial machinery and equipment. With time, substantial savings in maintenance costs can be achieved.

### Free Water Formation – the Critical Point

Water can dissolve in oil. When the water content of the oil increases, it eventually reaches the saturation point of the oil. Once the fluid has reached its saturation point, any additional water introduced will separate out as free water by forming a distinct layer. Alternatively, the oil can form dispersion with water, which turns the oil cloudy. Since most oils are less dense than water, the water

layer will usually settle below the oil with time.

Free water formation is critical in terms of problems related to water in oil. When water is no longer dissolved in the oil, corrosion and wearing of equipment increase rapidly. Therefore it is important to keep the moisture content safely below the saturation point.

The ability of oil to hold dissolved water depends on the type and age of the oil as well as its additives. Two major factors have an effect on the saturation point as the oil ages: temperature fluctuations and changes in the chemical make-up due to the formation of new substances as by-products of the chemical reactions.

### Water Activity ( $a_w$ ) – a Direct Measure of Oil Quality

The conventional measure for water content in oil is ppm (parts per million), which describes the absolute amount of water in the oil. Ppm measurement has,

### Unique Benefits of HUMICAP in Oil Moisture Measurements

- Fast. Online, real-time detection of moisture in oil without sampling
- Reliable. Tells the true margin to water saturation point in all changing conditions, taking into account e.g. temperature changes and aging of oil
- Highly stable. Excellent pressure and temperature tolerance
- Easy to install through ball valve - no need to shut down the process
- Enables predictive maintenance work. Trends can be quickly identified.

however, a major limitation. It does not account for any variations in the oil's saturation point. In other words, ppm measurement provides no indication of how close the moisture level is to the saturation point in a dynamic system with fluctuating saturation point. By measuring water activity instead of ppm, the risk of actually exceeding the saturation point can be avoided.

Water activity measurement indicates directly whether there is a risk of free water formation. With a relative scale from 0 (no water present) to 1 (the oil is saturated with water) it gives a reliable indication of how close the saturation point of water is.

In contrast to traditional measurement techniques, water activity measurement is independent of oil type. Regardless of the saturation point of the fluid, water activity measurement always provides a true indication for the risk of free water formation, even when the saturation point is increasing or decreasing. In its simplicity, water activity value is understandable at a glance. Trends can be quickly identified.

## Vaisala HUMICAP® for Measuring Water Activity

The Vaisala transmitters used for measuring moisture in oil feature the HUMICAP® sensor, a capacitive thin-film polymer sensor especially developed for demanding moisture measurements in liquid hydrocarbons.

The HUMICAP sensor consists of four functional layers: glass substrate, lower electrode, water-active polymer layer, and porous upper electrode. The thin-film polymer either absorbs or releases water as the surrounding moisture level changes. Water molecules move to/from the polymer layer

until there is moisture equilibrium between the polymer and the oil. The dielectric properties of the polymer depend on the moisture level. As the moisture level changes, the dielectric properties of the polymer film change, and so does the capacitance of the sensor. The instrument's electronics measure the capacitance of the sensor and convert it into water activity.

Oil molecules or additives do not penetrate the electrode. Thus the sensor output is independent of the oil type.

## On-line Measurement

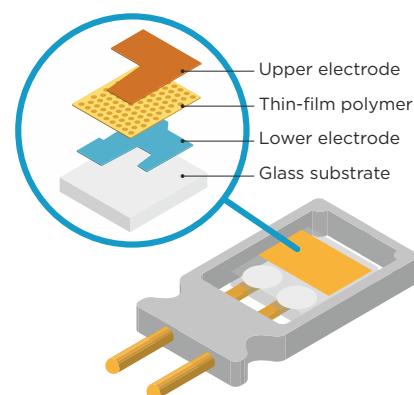
On-line water activity measurement ensures reliable performance of equipment at all times. Time-consuming sampling and laboratory analysis are no longer needed. This not only reduces the risk of human induced error but also provides cost savings in equipment and chemicals.

## Typical Applications for Moisture in Oil Measurement

Moisture is an important factor determining the condition of both lubricating and transformer oils. With on-line information on the quality of the oil, preventive actions can be taken and the maintenance costs cut substantially.

### HUMICAP in Brief

- A capacitive thin-film polymer sensor
- Water activity ( $a_w$ ) measurement within range 0 ... 1
- Measurement accuracy up to +/- 0.01 aw (1 %RS)
- Over 20 years of experience in measuring moisture in oil



Structure of the HUMICAP sensor.

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