Eaton Corporation is a diversified industrial manufacturer ranked among the largest Fortune 500 companies. The electrical group is Eaton's largest division and is a global leader in electrical control, power distribution, power quality, automation, and monitoring products and services. Eaton's electrical products include brands such as Cutler-Hammer®, MGE Office Protection Systems, Powerware®, Holec® and MEM®.

Eaton provides PowerChain Management® solutions to serve the needs of the industrial, institutional, IT, data center, mission critical, utility, residential and OEM markets worldwide.

PowerChain Management solutions help enterprises achieve sustainable and competitive advantages through proactive management of the power system as a strategic, integrated asset throughout its life cycle. With Eaton's distribution, generation and power quality equipment; full-scale engineering services; and information management systems, the power system is positioned to deliver powerful results: greater reliability, operating cost efficiencies, effective use of capital, enhanced safety and risk mitigation.

See labels on product for additional information.
# Power Factor Correction: A Guide for the Plant Engineer

<table>
<thead>
<tr>
<th>Description</th>
<th>Page</th>
</tr>
</thead>
<tbody>
<tr>
<td>PART ONE: POWER FACTOR</td>
<td></td>
</tr>
<tr>
<td>What is Power Factor?</td>
<td>2</td>
</tr>
<tr>
<td>Should I Be Concerned About Low Power Factor?</td>
<td>3</td>
</tr>
<tr>
<td>What Can I Do to Improve Power Factor?</td>
<td>4</td>
</tr>
<tr>
<td>How Much Can I Save by Installing Power Capacitors?</td>
<td>5</td>
</tr>
<tr>
<td>How Can I Select the Right Capacitors for My Specific Application Needs?</td>
<td>9</td>
</tr>
<tr>
<td>How Much kvar Do I Need?</td>
<td>10</td>
</tr>
<tr>
<td>Where Should I Install Capacitors in My Plant Distribution System?</td>
<td>15</td>
</tr>
<tr>
<td>Can Capacitors Be Used in Non-Linear, Non-Sinusoidal Environments?</td>
<td>17</td>
</tr>
<tr>
<td>What About Maintenance?</td>
<td>17</td>
</tr>
<tr>
<td>Code Requirements for Capacitors</td>
<td>17</td>
</tr>
<tr>
<td>Useful Capacitor Formulas</td>
<td>18</td>
</tr>
<tr>
<td>PART TWO: HARMONICS</td>
<td></td>
</tr>
<tr>
<td>Introduction</td>
<td>19</td>
</tr>
<tr>
<td>What are Harmonics?</td>
<td>19</td>
</tr>
<tr>
<td>What are the Consequences of High Harmonic Distortion Levels?</td>
<td>20</td>
</tr>
<tr>
<td>IEEE 519</td>
<td>20</td>
</tr>
<tr>
<td>How are Harmonics Generated?</td>
<td>21</td>
</tr>
<tr>
<td>What Do Power Factor Correction Capacitors Have to Do with Harmonics?</td>
<td>22</td>
</tr>
<tr>
<td>How Do I Diagnose a Potential Harmonics Related Problem?</td>
<td>22</td>
</tr>
<tr>
<td>How Can Harmonics Problems Be Eliminated?</td>
<td>23</td>
</tr>
<tr>
<td>What is a Passive Harmonic Filter?</td>
<td>23</td>
</tr>
<tr>
<td>Do I Need to Perform a System Analysis to Correctly Apply Harmonic Filters?</td>
<td>24</td>
</tr>
<tr>
<td>What is Eaton's Experience in Harmonic Filtering?</td>
<td>24</td>
</tr>
</tbody>
</table>
PART ONE: POWER FACTOR

What is Power Factor?

Special Electrical Requirement of Inductive Loads

Most loads in modern electrical distribution systems are inductive. Examples include motors, transformers, gaseous tube lighting ballasts and induction furnaces. Inductive loads need a magnetic field to operate.

Inductive loads require two kinds of current:
- Working power (kW) to perform the actual work of creating heat, light, motion, machine output, etc.
- Reactive power (kvar) to sustain the magnetic field

Working power consumes watts and can be read on a wattmeter. It is measured in kilowatts (kW). Reactive power doesn’t perform useful “work,” but circulates between the generator and the load. It places a heavier drain on the power source, as well as on the power source’s distribution system. Reactive power is measured in kilovolt-amperes-reactive (kvar).

Working power and reactive power together make up apparent power. Apparent power is measured in kilovolt-amperes (kVA).

Note: For a discussion on power factor in non-linear, non-sinusoidal systems, turn to Page 17.

Fundamentals of Power Factor

Power factor is the ratio of working power to apparent power. It measures how effectively electrical power is being used. A high power factor signals efficient utilization of electrical power, while a low power factor indicates poor utilization of electrical power.

To determine power factor (PF), divide working power (kW) by apparent power (kVA). In a linear or sinusoidal system, the result is also referred to as the cosine φ.

\[ PF = \frac{kW}{kVA} = \cosine \phi \]

For example, if you had a boring mill that was operating at 100 kW and the apparent power consumed was 125 kVA, you would divide 100 by 125 and come up with a power factor of 0.80.

\[ \frac{100}{125} = 0.80 \]

Figure 1. kW Power
Figure 2. kvar Power
Figure 3. kVA Power
Figure 4. Power Triangle

Note: A right “power” triangle is often used to illustrate the relationship between kW, kvar and kVA.
Should I Be Concerned About Low Power Factor?

Low power factor means you’re not fully utilizing the electrical power you’re paying for.

As the triangle relationships in Figure 5 demonstrate, kVA decreases as power factor increases. At 70% power factor, it requires 142 kVA to produce 100 kW. At 95% power factor, it requires only 105 kVA to produce 100 kW. Another way to look at it is that at 70% power factor, it takes 35% more current to do the same work.

Figure 5. Typical Power Triangles
What Can I Do to Improve Power Factor?

You can improve power factor by adding power factor correction capacitors to your plant distribution system.

When apparent power (kVA) is greater than working power (kW), the utility must supply the excess reactive current plus the working current. Power capacitors act as reactive current generators. (See Figure 6.) By providing the reactive current, they reduce the total amount of current your system must draw from the utility.

**95% Power Factor Provides Maximum Benefit**

Theoretically, capacitors could provide 100% of needed reactive power. In practical usage, however, power factor correction to approximately 95% provides maximum benefit.

The power triangle in Figure 7 shows apparent power demands on a system before and after adding capacitors. By installing power capacitors and increasing power factor to 95%, apparent power is reduced from 142 kVA to 105 kVA — a reduction of 35%.

---

**Figure 6. Capacitors as kvar Generators**

**Figure 7. Required Apparent Power Before and After Adding Capacitors**
How Much Can I Save by Installing Power Capacitors?

Power capacitors provide many benefits:
- Reduced electric utility bills
- Increased system capacity
- Improved voltage
- Reduced losses

**Reduced Utility Bills**

Your electric utility provides working (kW) and reactive power (kvar) to your plant in the form of apparent power (kVA). While reactive power (kvar) doesn’t register on kW demand or kW hour meters, the utility’s transmission and distribution system must be large enough to provide the total power. Utilities have various ways of passing along the expense of larger generators, transformers, cables, switches, etc., to you.

As shown in the following case histories, capacitors can save you money no matter how your utility bills you for power.

**kVA Billing**

The utility measures and bills every ampere of current, including reactive current.

**Case 1**

Assume an uncorrected 460 kVA demand, 480 volt, three-phase at 0.87 power factor (normally good).

<table>
<thead>
<tr>
<th>kW</th>
<th>PF</th>
<th>kVA</th>
</tr>
</thead>
<tbody>
<tr>
<td>400</td>
<td>0.87</td>
<td>460</td>
</tr>
</tbody>
</table>

Billing: $4.75/kVA demand

Correct to 0.97 Power Factor

From Table 6 Multipliers, to raise the Power Factor from 0.87 to 0.97 requires capacitor:

Multiplier of 0.316 x kW

From Table 6 Multipliers, to raise the Power Factor from 0.87 to 0.97 requires capacitor:

Multiplier of 0.316 x kW

Uncorrected Original Billing:

<table>
<thead>
<tr>
<th>kW</th>
<th>PF</th>
<th>kVA</th>
</tr>
</thead>
<tbody>
<tr>
<td>400</td>
<td>0.87</td>
<td>460</td>
</tr>
</tbody>
</table>

Corrected New Billing:

<table>
<thead>
<tr>
<th>kW</th>
<th>PF</th>
<th>kVA</th>
</tr>
</thead>
<tbody>
<tr>
<td>412</td>
<td>0.97</td>
<td>412</td>
</tr>
</tbody>
</table>

Corrected kVA:

<table>
<thead>
<tr>
<th>kW</th>
<th>PF</th>
<th>kVA</th>
</tr>
</thead>
<tbody>
<tr>
<td>412</td>
<td>0.97</td>
<td>412</td>
</tr>
</tbody>
</table>

140 kvar, 480 volt capacitor cost: $1600 (installation extra). This capacitor pays for itself in less than eight months.

---

Case 2

Assume the same conditions except that:
- 400 kW @ 97% = 460 kVA
- 400 kW @ 97% = 412 kVA Corrected Billing

**kVA Demand Charge**

$1.81/kVA/month (112,400 kwh/month energy consumed).

**Energy Charge**

- $0.0286/kWh (first 200 kWh/kVA of demand)
- $0.0254/kWh (next 300 kWh/kVA of demand)
- $0.0213/kWh (all over 500 kWh/kVA of demand)

**Uncorrected**

- 460 kVA x $1.81 = $878.82
- $788.92 Savings in Demand Charge

**Corrected**

- 412 kVA x $1.81 = $798.32
- $798.32 Savings in Demand Charge

**Energy**

- $0.0286/kWh (first 200 kWh/kVA of demand)
- $0.0254/kWh (next 300 kWh/kVA of demand)
- $0.0213/kWh (all over 500 kWh/kVA of demand)

**Energy Charge**

- $2356.64
- $729.00
- $3085.64

**Savings in Energy Charge Due to Rate Charge**

- $3085.64
- $788.92
- $1596.72

A 130 kvar capacitor can be paid for in less than 14 months.

---

**THE PRICES ABOVE ARE SUBJECT TO CHANGE WITHOUT NOTICE.**

www.eaton.com/pfc
KW Demand Billing with Power Factor Adjustment

The utility charges according to the kW demand and adds a surcharge or adjustment for power factor. The adjustment may be a multiplier applied to kW demand. The following formula shows a billing based on 90% power factor:

\[ \text{KWh Demand} = \text{Actual Power Factor} \times \text{KWh} \]

If power factor was 0.84, the utility would require

7% increase in billing, as shown in this formula:

\[ 0.275 \times 400 = 110 \text{kvar} \]

Some utilities charge for low power factor but give a credit or bonus for power above a certain level.

**Case 1**

Assume a 400 kW load, 87% power factor with the following Utility tariff.

**A. Demand Charges:**
- First 40 kW @ $10.00/kW monthly billing demand
- Next 160 kW @ $ 9.50/kW
- Next 800 kW @ $ 9.00/kW
- All over 1000 kW @ $ 8.50/kW

**B. Power Factor Clause:**
Rates based on power factor of 90% or higher. When power factor is less than 85%, the demand will be increased 1% for each 1% that the power factor is below 90%. If the power factor is higher than 90%, the demand will be decreased 1% for each 1% that the power factor is above 90%.

**Note:** There would be no penalty for 87% power factor. However, a bonus could be credited if the power factor were raised to 98%.

To calculate savings:

Normal 400 kW billing demand

- First 40 kW @ $10.00 = $400.00
- Next 160 kW @ $9.50 = $1520.00
- Bal. 200 kW @ $9.00 = $1800.00

Total 400 kW $3720.00 Normal Monthly Billing

New Billing:

\[ \text{KWh} = \frac{\text{New Power Factor}}{0.90} \times \text{KWh Demand} \]

First 40 kW @ $10.50 = $420.00
Next 160 kW @ $9.95 = $1592.00
Bal. 175 kW @ $9.39 = $1660.25

$3672.25 Power Factor Adjusted Billing

**Case 2**

With the same 400 kW load, the power factor is only 81%.

First 40 kW @ $10.15 = $406.00
Next 150 kW @ $9.90 = $1485.00
Next 244 kW @ $9.65 = $2330.60
Total 444 kW $5215.60

Yeary savings if corrected to 98%:

$4116.00 Charge at 81%
$2739.00 Normal kW Demand Charge
$1377.00 Power Factor/Thorn Adjustment for 87% Power Factor

To raise 81% power factor to 98%, select the multiplier from Table 6.422 x 400 kW = 173 kvar. Use 180 kvar to ensure the maintenance of the 90% level. (From Case 1. When the Power Factor = 96%, the billing demand is 375 kW = $3495.00 per month.)

55 kvar would eliminate the penalty by correcting power factor to 85%.

| kW Demand Billing with Power Factor Adjustment | www.eaton.com/pfc | THE PRICES ABOVE ARE SUBJECT TO CHANGE WITHOUT NOTICE. |
kvar Reactive Demand Charge

The utility imposes a direct charge for the use of magnetizing power, usually a waiver of some percentage of kW demand. For example, if this charge was 60 cents per kvar for everything over 50% of kW, and a 400 kW load existed at the time, the utility would provide 200 kvar free.

Case 1

Assume a 400 kW load demand at 81% power factor.

Tariff Structure:

Demand Charge is: $635.00 for the first 200 kW demand
$2.80 per kW for all addition

Reactive demand charge is:
$0.60 per kvar in excess of 50% of kW demand

In this example, kW demand = 400 kW, therefore 50% = 200 kvar which will be furnished at no cost.

This ratio is the basis for the Table of Multipliers (Table 6).

The same principle holds true for reducing current on overloaded facilities. Increasing power factor from 75% to 95% on the same kW load results in 21% lower current flow. Put another way, it takes 26.7% more current for a load to operate at 75%, and 46.2% more current to operate at 65%.

A plant has a 500 kVA transformer operating near capacity. It draws 480 kVA or 578 amperes at 480 volts. The present power factor is 75%, so the actual working power available is 360 kW.

It is desired to increase production by 25%, which means that about 450 kW output must be obtained. How is this accomplished? A new transformer would certainly be one solution. For 450 kW output, the transformer would be rated at 570 kVA to handle 75% power factor load. More likely, the next size standard rating would be needed (750 kVA).

Perhaps a better solution would be to improve the power factor and release enough capacity to accommodate the increased load.

To correct 450 kW from 75% to 95%, power factor requires 450 x 0.447 (from Table 6) = 200.7 kvar at about $2800.00.

The prices above are subject to change without notice.

www.eaton.com/pfc
Industries with Low Power Factor Benefit Most from Capacitors

Low power factor results when inactive motors are operated at less than full load. This often occurs in cycle processes — such as those using circular saws, ball mills, conveyors, compressors, grinders, punch presses, etc. — where motors are sized for the heaviest load. Examples of situations where low power factor (from 30% to 50%) occur include a surface grinder performing a light cut, an unloaded air compressor and a circular saw spinning without cutting.

The following industries typically exhibit low power factors:

Table 1. Typical Low Power Factor Industries

<table>
<thead>
<tr>
<th>Industry</th>
<th>Uncorrected Power Factor</th>
</tr>
</thead>
<tbody>
<tr>
<td>Saw Mills</td>
<td>65% – 75%</td>
</tr>
<tr>
<td>Plastic (Esp. Extruders)</td>
<td>55% – 70%</td>
</tr>
<tr>
<td>Machine Tools, Stamping</td>
<td>55% – 70%</td>
</tr>
<tr>
<td>Plating, Textiles, Chemicals, Breweries</td>
<td>65% – 75%</td>
</tr>
<tr>
<td>Hospitals, Granaries, Foundries</td>
<td>70% – 95%</td>
</tr>
</tbody>
</table>

Include Power Capacitors in New Construction/Expansion Plans

Including power capacitors in your new construction and expansion plans can reduce the size of transformers, bus, switches, etc., and bring your project in at lower cost.

Figure 9 shows how much system kVA can be released by improving power factor. Raising the power factor from 70% to 90% releases 0.32 kVA per kW. On a 400 kW load, 128 kVA is released.

Improved Voltage Conditions

Low voltage, resulting from excessive current draw, causes motors to be sluggish and overheated. As power factor decreases, total line current increases, causing further voltage drop. By adding capacitors to your system and improving voltage, you get more efficient motor performance and longer motor life.

Reduced Losses

Losses caused by poor power factor are due to reactive current flowing in the system. These are watt-related charges and can be eliminated through power factor correction.

Power loss (watts) in a distribution system is calculated by squaring the current and multiplying it by the circuit resistance (1/2). To calculate loss reduction:

\[
\% \text{ Reduction Losses} = 100 - 100 \times \left( \frac{\text{Original Power Factor}}{\text{New Power Factor}} \right)^{2}
\]
How Can I Select the Right Capacitors for My Specific Application Needs?

Once you’ve decided that your facility can benefit from power factor correction, you’ll need to choose the optimum type, size and number of capacitors for your plant.

There are two basic types of capacitor installations: individual capacitors on linear or sinusoidal loads, and banks of fixed or automatically switched capacitors at the feeder or substation.

Individual vs. Banked Installations

Advantages of individual capacitors at the load:
- Complete control: Capacitors cannot cause problems on the line during light load conditions
- No need for separate switching: Motor always operates with capacitor
- Improved motor performance due to more efficient power utilization and reduced voltage drops
- Motors and capacitors can be easily relocated together
- Easier to select the right capacitor for the load
- Improved motor performance due to more efficient power utilization and reduced voltage drops
- Motors and capacitors can be easily relocated together
- Easier to select the right capacitor for the load
- Increased system capacity

Advantages of bank installations at the feeder or substation:
- Lower cost per kvar
- Total plant power factor improved — reduces or eliminates all forms of kvar charges
- Automatic switching ensures exact amount of power factor correction, eliminates over-capacitation and resulting overvoltages

Table 2. Summary of Advantages/Disadvantages of Individual, Fixed Banks, Automatic Banks, Combination

<table>
<thead>
<tr>
<th>Method</th>
<th>Advantages</th>
<th>Disadvantages</th>
</tr>
</thead>
<tbody>
<tr>
<td>Individual Capacitors</td>
<td>Most technically efficient, most flexible</td>
<td>Higher installation and maintenance cost</td>
</tr>
<tr>
<td>Fixed Bank</td>
<td>Most economical, fewer installations</td>
<td>Less flexible, requires switches and/or circuit breakers</td>
</tr>
<tr>
<td>Automatic Bank</td>
<td>Best for variable loads, prevents overvoltages, low installation cost</td>
<td>Higher equipment cost</td>
</tr>
<tr>
<td>Combination</td>
<td>Most practical for larger numbers of motors</td>
<td>Least flexible</td>
</tr>
</tbody>
</table>

Consider the Particular Needs of Your Plant

When deciding which type of capacitor installation best meets your needs, you’ll have to weigh the advantages and disadvantages of each and consider several plant variables, including load type, load size, load constancy, load capacity, motor starting methods and manner of utility billing.

Load Type

If your plant has many large motors, 50 hp and above, it is usually economical to install one capacitor per motor and switch the capacitor and motor together. If your plant consists of many small motors, 1/2 to 25 hp, you can group the motors and install one capacitor at a central point in the distribution system. Often, the best solution for plants with large and small motors is to use both types of capacitor installations.

Load Size

Facilities with large loads benefit from a combination of individual load, group load and banks of fixed and automatically switched capacitor units. A small facility, on the other hand, may require only one capacitor at the control board.

Load Constancy

If your facility operates around-the-clock and has a constant load demand, fixed capacitors offer the greatest economy. If load is determined by eight-hour shifts five days a week, you’ll want more switched units to decrease capacitance during times of reduced load.

Load Capacity

If your feeders or transformers are overloaded, or if you wish to add additional load to already loaded lines, correction must be applied at the load. If your facility has surplus amperage, you can install capacitor banks at main feeders. If load varies a great deal, automatic switching is probably the answer.

Utility Billing

The severity of the local electric utility tariff for power factor will affect your payback and ROI. In many areas, an optimally designed power factor correction system will pay for itself in less than two years.

www.eaton.com/pfc
Power Factor Correction: A Guide for the Plant Engineer

How Much kVAR Do I Need?

Sizing Capacitors for Individual Motor Loads

The unit for rating power factor capacitors is a kVAR (kilo-var), which is a measure of the reactive power in a circuit.

The table below provides the kVAR ratings for various motor loads. The kVAR rating signifies how much reactive power the capacitor will provide.

<table>
<thead>
<tr>
<th>Motor Load (HP)</th>
<th>Capacitor Rating (kVAR)</th>
</tr>
</thead>
<tbody>
<tr>
<td>20</td>
<td>30</td>
</tr>
<tr>
<td>30</td>
<td>50</td>
</tr>
<tr>
<td>40</td>
<td>80</td>
</tr>
<tr>
<td>50</td>
<td>120</td>
</tr>
<tr>
<td>60</td>
<td>150</td>
</tr>
<tr>
<td>70</td>
<td>180</td>
</tr>
<tr>
<td>80</td>
<td>200</td>
</tr>
<tr>
<td>90</td>
<td>220</td>
</tr>
<tr>
<td>100</td>
<td>250</td>
</tr>
</tbody>
</table>

The table above shows the capacitor ratings for different motor loads. The motor loads are listed in HP (horsepower), and the corresponding capacitor ratings are shown in kVAR.

To calculate the kVAR rating for a specific motor load, you can use the formula:

\[ \text{kVAR} = \frac{\text{motor load (HP)} \times \text{kVAR per HP}}{1000} \]

This formula will give you the kVAR rating for the motor load specified.

For example, if you have a motor load of 70 HP, you can calculate the kVAR rating as follows:

\[ \text{kVAR} = \frac{70 \times 1.5}{1000} = 0.105 \text{ kVAR} \]

This means that a capacitor of 105 kVAR will be needed to correct the power factor for a 70 HP motor load.

Sizing Capacitors for Entire Plant Loads

The formula for sizing capacitors for entire plant loads is similar:

\[ \text{kVAR} = \frac{\text{total kW consumption of your plant}}{1000} \]

This formula will give you the kVAR rating for the entire plant.

For example, if your plant has a total kW consumption of 1000 kW, you can calculate the kVAR rating as follows:

\[ \text{kVAR} = \frac{1000}{1000} = 1 \text{ kVAR} \]

This means that a capacitor of 1 kVAR will be needed to correct the power factor for the entire plant.
Table 4. Suggested Capacitor Ratings, in kvars, for NEMA Design C, D and Wound-Rotor Motors

<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>10</td>
<td>5</td>
<td>5</td>
<td>5,5</td>
</tr>
<tr>
<td>20</td>
<td>5</td>
<td>6</td>
<td>7</td>
</tr>
<tr>
<td>30</td>
<td>6</td>
<td>6</td>
<td>7</td>
</tr>
<tr>
<td>40</td>
<td>9</td>
<td>10</td>
<td>11</td>
</tr>
<tr>
<td>50</td>
<td>10</td>
<td>12</td>
<td>13</td>
</tr>
<tr>
<td>60</td>
<td>12</td>
<td>15</td>
<td>15,5</td>
</tr>
<tr>
<td>75</td>
<td>18</td>
<td>22,5</td>
<td>18</td>
</tr>
<tr>
<td>90</td>
<td>22,5</td>
<td>22,5</td>
<td>20</td>
</tr>
<tr>
<td>125</td>
<td>27</td>
<td>30</td>
<td>25</td>
</tr>
<tr>
<td>150</td>
<td>30</td>
<td>30</td>
<td>30</td>
</tr>
<tr>
<td>200</td>
<td>37,5</td>
<td>45</td>
<td>40</td>
</tr>
<tr>
<td>250</td>
<td>45</td>
<td>60</td>
<td>50</td>
</tr>
<tr>
<td>300</td>
<td>70</td>
<td>75</td>
<td>65</td>
</tr>
<tr>
<td>350</td>
<td>100</td>
<td>95</td>
<td>85</td>
</tr>
</tbody>
</table>

Note: Applies to three-phase, 60 Hz motors when switched with capacitors as single unit.

Note: Use motor manufacturer’s recommended kvar as published in the performance data sheets for specific motor types: drip-proof, TEFC, severe duty, high efficiency and NEMA design.
Table 5. Suggested Capacitor Ratings for Medium Voltage Motors

<table>
<thead>
<tr>
<th>HP</th>
<th>2 — 3600 RPM</th>
<th>4 — 1800 RPM</th>
<th>6 — 1200 RPM</th>
<th>8 — 900 RPM</th>
<th>10 — 720 RPM</th>
<th>12 — 600 RPM</th>
</tr>
</thead>
<tbody>
<tr>
<td>75</td>
<td>75</td>
<td>75</td>
<td>75</td>
<td>75</td>
<td>75</td>
<td>75</td>
</tr>
<tr>
<td>150</td>
<td>150</td>
<td>150</td>
<td>150</td>
<td>150</td>
<td>150</td>
<td>150</td>
</tr>
<tr>
<td>250</td>
<td>250</td>
<td>250</td>
<td>250</td>
<td>250</td>
<td>250</td>
<td>250</td>
</tr>
<tr>
<td>300</td>
<td>300</td>
<td>300</td>
<td>300</td>
<td>300</td>
<td>300</td>
<td>300</td>
</tr>
<tr>
<td>400</td>
<td>400</td>
<td>400</td>
<td>400</td>
<td>400</td>
<td>400</td>
<td>400</td>
</tr>
<tr>
<td>500</td>
<td>500</td>
<td>500</td>
<td>500</td>
<td>500</td>
<td>500</td>
<td>500</td>
</tr>
<tr>
<td>600</td>
<td>600</td>
<td>600</td>
<td>600</td>
<td>600</td>
<td>600</td>
<td>600</td>
</tr>
<tr>
<td>75</td>
<td>75</td>
<td>75</td>
<td>75</td>
<td>75</td>
<td>75</td>
<td>75</td>
</tr>
<tr>
<td>100</td>
<td>100</td>
<td>100</td>
<td>100</td>
<td>100</td>
<td>100</td>
<td>100</td>
</tr>
<tr>
<td>150</td>
<td>150</td>
<td>150</td>
<td>150</td>
<td>150</td>
<td>150</td>
<td>150</td>
</tr>
<tr>
<td>200</td>
<td>200</td>
<td>200</td>
<td>200</td>
<td>200</td>
<td>200</td>
<td>200</td>
</tr>
<tr>
<td>250</td>
<td>250</td>
<td>250</td>
<td>250</td>
<td>250</td>
<td>250</td>
<td>250</td>
</tr>
<tr>
<td>300</td>
<td>300</td>
<td>300</td>
<td>300</td>
<td>300</td>
<td>300</td>
<td>300</td>
</tr>
<tr>
<td>350</td>
<td>350</td>
<td>350</td>
<td>350</td>
<td>350</td>
<td>350</td>
<td>350</td>
</tr>
<tr>
<td>400</td>
<td>400</td>
<td>400</td>
<td>400</td>
<td>400</td>
<td>400</td>
<td>400</td>
</tr>
<tr>
<td>450</td>
<td>450</td>
<td>450</td>
<td>450</td>
<td>450</td>
<td>450</td>
<td>450</td>
</tr>
<tr>
<td>500</td>
<td>500</td>
<td>500</td>
<td>500</td>
<td>500</td>
<td>500</td>
<td>500</td>
</tr>
<tr>
<td>550</td>
<td>550</td>
<td>550</td>
<td>550</td>
<td>550</td>
<td>550</td>
<td>550</td>
</tr>
<tr>
<td>600</td>
<td>600</td>
<td>600</td>
<td>600</td>
<td>600</td>
<td>600</td>
<td>600</td>
</tr>
</tbody>
</table>

Above sizes are intended to provide a corrected power factor of approximately 95% at full load. Because of the limited number of capacitor ratings available, it is not possible to raise every motor PF to 95%.

To calculate kvar required to correct power factor to a specific target value, use the following formula:

\[
\text{kvar (required)} = \frac{\text{hp} \times 0.746 \times (1 - \text{PFa})}{\% \text{EFF}}
\]

Where:
- hp: Motor Nameplate Horse Power
- %EFF: Motor Nameplate Efficiency (Enter the value in decimal)
- PFa: Motor Nameplate Actual Power Factor
- PFt: Target Power Factor

Note: Consult the motor manufacturer’s data sheet to verify the maximum kvar of capacitors that can be directly connected at motor terminals. To avoid “self-excitation,” do not exceed the maximum kvar rating that is specified by the motor manufacturer.
To increase the power factor to 95%, you would:

1. Find 0.73 in column 1.

2. Read across to 0.167 in column 2. Multiply 0.167 by 410 = 249 (round to 250).

This means that 250 kW is the amount of power you would need to bring your power factor to 95%.
**Power Factor Correction:**
**A Guide for the Plant Engineer**

For field installations and reflects the manufacturer's suggested rating for overcurrent protection and disconnect means in accordance with the National Electrical Code.

**Table 7. Recommended Wire Sizes, Switches and Fuses for Three-Phase, 60 Hz Capacitors**

<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>2/0</td>
<td>100</td>
<td>2/0</td>
<td>200</td>
<td>2/0</td>
<td>300</td>
<td>2/0</td>
<td>400</td>
</tr>
<tr>
<td>1/0</td>
<td>150</td>
<td>1/0</td>
<td>250</td>
<td>1/0</td>
<td>350</td>
<td>1/0</td>
<td>450</td>
</tr>
<tr>
<td>3/0</td>
<td>200</td>
<td>3/0</td>
<td>300</td>
<td>3/0</td>
<td>400</td>
<td>3/0</td>
<td>500</td>
</tr>
<tr>
<td>4/0</td>
<td>250</td>
<td>4/0</td>
<td>350</td>
<td>4/0</td>
<td>450</td>
<td>4/0</td>
<td>550</td>
</tr>
<tr>
<td>5/0</td>
<td>300</td>
<td>5/0</td>
<td>400</td>
<td>5/0</td>
<td>500</td>
<td>5/0</td>
<td>600</td>
</tr>
<tr>
<td>6/0</td>
<td>350</td>
<td>6/0</td>
<td>450</td>
<td>6/0</td>
<td>550</td>
<td>6/0</td>
<td>650</td>
</tr>
</tbody>
</table>

Note: These wire sizes are based on 135% of rated current in accordance with the National Electrical Code—Article 460.

---

**Cutler-Hammer**

Visit www.eaton.com/pfc for more information.
Where Should I Install Capacitors in My Plant Distribution System?

At the Load
Since capacitors act as kvar generators, the most efficient place to install them is directly at the motor, where kvar is consumed. Three options exist for installing capacitors at the motor. Use Figures 10 – 16, and the information below to determine which option is best for each motor.

Location A — Motor Side of Overload Relay
- New motor installations in which overloads can be sized in accordance with reduced current draw
- Existing motors when no overload change is required

Location B — Line Side of Starter
- Existing motors when overload rating surpasses code (see Appendix for NEC code requirements)

Location C — Line Side of Starter
- Motors that are jogged, plugged, reversed
- Multi-speed motors
- Starters with open transition and starters that disconnect/reconnect capacitor during cycle
- Motors that start frequently
- Motor loads with high inertia, where disconnecting the motor with the capacitor can turn the motor into a self-excited generator

At the Service Feeder
When correcting entire plant loads, capacitor banks can be installed at the service entrance, if load conditions and transformer size permits. If the amount of correction is too large, some capacitors can be installed at individual motors or branch circuits.

When capacitors are connected to the bus, feeder, motor control center or switchboard, a disconnect and overcurrent protection must be provided.

![Diagram of motor circuits](Figure 10. Locating Capacitors on Motor Circuits)

![Diagram of service feeder](Figure 11. Installing Capacitors Online)
Locating Capacitors on Reduced Voltage and Multi-Speed Motors

**Figure 12. Autotransformer — Closed Transition**
Note: Connect capacitor on motor side of starting contacts (2, 3, 4) at points A – B – C.

**Figure 13. Series Resistance Starting**
Note: Connect capacitor on motor side of starting contactor (1, 2, 3) at points A – B – C.

**Figure 14. Part-Winding Starting**
Note: Connect capacitor on motor side of starting contacts (1, 2, 3) at points A – B – C.

**Figure 15. Wye-Delta Starting**
Note: Connect capacitor on motor side of starting contacts (1, 2, 3) at points A – B – C.

**Figure 16. Reactor Starting**
Note: Connect capacitor on motor side of starting contactor (1, 2, 3) at points A – B – C.
Can Capacitors Be Used in Non-Linear, Non-Sinusoidal Environments?

Until recently, almost all loads were linear, with the current waveform closely matching sinusoidal voltage waveform and changing in proportion to the load. Lately, non-linear loads — which draw current at frequencies other than 60 Hz — have increased dramatically.

Examples of linear and non-linear devices are as follows:

**Linear Devices**
- Motors
- Incandescent lighting
- Heating loads

**Non-Linear Devices**
- dc drives
- Variable frequency drives
- Programmable controllers
- Arc-type lighting
- Personal computers
- Uninterruptible power supplies (UPS)

The increase in non-linear loads has led to harmonic distortion in electrical distribution systems. Although capacitors do not cause harmonics, they can aggravate existing conditions.

Because harmonic voltages and currents are affected by all of the equipment in a facility, they are sometimes difficult to predict and model.

**Capacitor Banks and Transformers Can Cause Resonance**

Capacitors and transformers can create dangerous resonance conditions when capacitor banks are installed at the service entrance. Under these conditions, harmonics produced by non-linear devices can be amplified many fold.

Problematic amplification of harmonics becomes more likely as more kvar is added to a system which contains a significant amount of non-linear load.

You can estimate the resonant harmonic by using the following formula:

\[ h = \frac{\sqrt{\text{VKA}_{\text{sys}}}}{\text{kVA}_{\text{sys}}} \]

where:
- \( h \) = The Harmonic Number referred to a 60 Hz Base
- \( \sqrt{\text{VKA}_{\text{sys}}} \) = Short Circuit Capacity of the System
- \( \text{kVA}_{\text{sys}} \) = Amount of Capacitor kvar on the Line
- \( \sqrt{\text{VKA}_{\text{sys}}} \) = The Short Circuit Capacity of the System
- \( \text{kVA}_{\text{sys}} \) = The Short Circuit Capacity of the System

If \( h \) is near the values of the major harmonics generated by a non-linear device — i.e., 3, 5, 7, 11 — then the resonance circuit will greatly increase harmonic distortion.

**What About Maintenance?**

Capacitors have no moving parts to wear out and require very little maintenance. Check fuses on a regular basis. If high voltages, harmonics, switching surges or vibration exists, fuses should be checked more frequently.

Capacitors from Eaton® operate warm to the touch. If the case is cold, check for blown fuses, open switches or other power losses. Also check for bulging cases and puffed up covers, which signal operation of the capacitor interrupter.

**Code Requirements for Capacitors**

Nameplate kvar: Tolerance +15, -0%.

Discharge Resistors: Capacitors rated at 600 volts and less must reduce the charge to less than 50 volts within 1 minute of de-energization. Capacitors rated above 600 volts must reduce the charge within 5 minutes.

Continuous Operation: Up to 135% rated (nameplate) kvar, including the effects of 110% rated voltage (121% kvar), 15% capacitance tolerance and harmonic voltages over the fundamental frequency (60 Hz).

Dielectric Strength Test: Twice the rated ac voltage (or a dc voltage 4.3 times the ac rating for non-metalized systems).

Overcurrent Protection: Fusing between 1.65 and 2.5 times rated current to protect case from rupture. Does not preclude NEC requirement for overcurrent protection in all three ungrounded conductors.

**Note:** When capacitor is connected to the load side of the motor overcurrent protection, fused disconnects or breaker protection is not required. However, Eaton highly recommends fusing for all indoor applications whenever employees may be working nearby.
Useful Capacitor Formulas

A. Additional Data

1. Simplified Voltage Rise:
   \[ \% \text{V.R.} = \frac{\text{actual kvar output}}{\text{rated kvar}} \times 100 \]

2. Loss Reduction:
   \[ \% \text{L.R.} = \frac{\text{improved PF}}{\text{original PF}} \times 100 \]

3. Operation at other than rated voltage and frequency:
   \[ \text{Actual kvar} = \frac{\text{rated kvar}}{\sqrt{2}} \times \left( \frac{\text{rated voltage}}{\text{actual voltage}} \right) \]

B. Miscellaneous

1. Power Factor:
   \[ \text{PF} = \frac{\text{cos} \theta}{\sqrt{\text{cos}^2 \theta + \text{tan}^2 \theta}} \]

2. Voltage Drop:
   \[ \frac{V}{\text{PF}} = \frac{\text{cos} \theta}{\sqrt{\text{cos}^2 \theta + \text{tan}^2 \theta}} \]

3. Capacitor Current:
   \[ \text{Current} = \frac{\text{kvar}}{\sqrt{2}} \times \text{frequency} \]

4. Capacitor kVA:
   \[ \text{kVA} = \frac{\text{kvar} \times \text{frequency}}{\sqrt{2}} \]

5. Capacitor kW:
   \[ \text{kW} = \frac{\text{kvar} \times \text{frequency}}{\sqrt{2}} \]

6. Capacitor Efficiency:
   \[ \text{Efficiency} = \frac{\text{kvar}}{\text{kW}} \]

C. Standard Data

<table>
<thead>
<tr>
<th>Voltage</th>
<th>kvar</th>
<th>kVA</th>
<th>Single-Phase</th>
<th>Three-Phase</th>
</tr>
</thead>
<tbody>
<tr>
<td>208</td>
<td>15</td>
<td>14.6</td>
<td>1.81</td>
<td>2.78</td>
</tr>
<tr>
<td>240</td>
<td>20</td>
<td>20</td>
<td>2.08</td>
<td>3.20</td>
</tr>
<tr>
<td>380</td>
<td>35</td>
<td>34</td>
<td>—</td>
<td>—</td>
</tr>
<tr>
<td>440</td>
<td>50</td>
<td>49</td>
<td>—</td>
<td>—</td>
</tr>
<tr>
<td>500</td>
<td>60</td>
<td>59</td>
<td>0.56</td>
<td>0.56</td>
</tr>
<tr>
<td>600</td>
<td>70</td>
<td>69</td>
<td>0.62</td>
<td>0.62</td>
</tr>
<tr>
<td>800</td>
<td>100</td>
<td>99</td>
<td>0.40</td>
<td>0.40</td>
</tr>
</tbody>
</table>

Note: Above is at nominal voltage @ 60 Hz = nominal kvar, kVA and current.
PART TWO: HARMONICS

Introduction

There has been much discussion and interest in recent years on the subject of power quality. Whereas in the past, power received from the electric utility and utilized by an industrial plant was generally a pure sinusoidal waveform — i.e., clean power — more frequently today industrial plants are finding they have to deal with the problem of “dirty” power. “Dirty power” is a slang expression used to describe a variety of voltage and current contaminations on the pure sinusoidal waveform. Dirty power can come in the form of short-term transients or steady-state, continuous distortions. In addition, the sources of dirty power can be external to a plant (as might be the case if a neighboring plant is contaminating the utility’s distribution system) or the source can reside within the plant itself.

Harmonic distortion is a specific type of dirty power that is usually associated with an industrial plant’s increased use of adjustable speed drives, power supplies and other devices using solid-state switching. However, harmonic distortion can be generated by any of a variety of non-linear electrical devices existing within a manufacturing plant or within nearby plants. Because harmonic distortion can cause serious operating problems in certain plant environments, it is important that the plant engineer or facilities personnel understand the fundamentals of harmonic distortion, know how to recognize the symptoms of this problem, and know what can be done to solve the problems once they are identified.

What are Harmonics?

A harmonic is a component of a periodic wave having a frequency that is an integral multiple of the fundamental power line frequency of 60 Hz. For example, 300 Hz is a fifth order harmonic of the fundamental frequency Figure 17. Figure 18 shows the resultant wave when the fundamental and fifth harmonic are combined. The result is harmonic distortion of the power waveform.

Harmonics which are typically seen on a power system can be subdivided into two distinct categories by the nature of problems they create and the remedies they usually require.

1. Those harmonic currents which are the dominant harmonic orders created by three-phase non-linear loads — 5th, 7th, 11th, 13th, and higher order odd harmonics which are not multiples of 3.

2. Those harmonics created primarily by single-phase non-linear loads — 3rd order harmonics and higher multiples of 3. These are sometimes referred to as a “triplet” or “zero-sequence” harmonics and are usually accompanied by some 5th, 7th and other higher order harmonics.

Harmonics are a steady-state phenomenon and should not be confused with short-term phenomena that last less than a few cycles. Transients, electrical disturbances, overvoltage surges and undervoltage sags in the supplied voltage are not harmonics. Some of these short-term disturbances in voltage or current can be mitigated by transient voltage surge suppressors, line reactors, or isolation transformers. However, these devices usually have little, if any, effect on harmonic currents or voltages.

The level of voltage or current harmonic distortion existing at any one point on a power system can be expressed in terms of the total harmonic distortion (THD) of the current or voltage waveform. The THD (for a voltage waveform) is given by the following formula:

\[
\text{THD} = \sqrt{V_2^2 + V_3^2 + \ldots + V_n^2}
\]

where: \( V_1 \) = Fundamental Voltage Value

\( V_{(m \times 3)} = 2, 3, 4, \text{etc.} \) = Harmonic Voltage Values
What are the Consequences of High Harmonic Distortion Levels?

Just as high blood pressure can create stress and serious problems in the human body, high levels of harmonic distortion can create stress and resultant problems for the utility’s distribution system, the plant’s distribution system, as well as all of the equipment that is serviced by that distribution system. The result may be the plant engineer’s worst fear — the shutting down of important plant equipment ranging from a single machine to an entire line or process.

Equipment shutdown can be caused by a number of events. As an example, the higher voltage peaks that are created by harmonic distortion put extra stress on motor and wire insulation which ultimately can result in insulation breakdown and failure. In addition, harmonics increase rms current resulting in increased operating temperatures for many pieces of equipment resulting in greatly reduced equipment life.

Table 8 summarizes some of the negative consequences that harmonics can have on typical equipment found in the plant environment. While these effects are categorized by problems created by current and voltage harmonics, current and voltage harmonic distortion usually exist together (current harmonic distortion causes voltage harmonic distortion).

Harmonic distortion disrupts plants. Of greatest importance is the loss of productivity, throughput and possibly sales. These occur because of process shutdowns due to the unexpected failure of motors, drives, power supplies or just the spurious tripping of breakers. Plant engineers realize how costly this can be and pride themselves in maintaining low levels of plant downtime. In addition, maintenance and repair budgets can be severely stretched. For example, every 10°C rise in the operating temperatures of motors or capacitors can cut equipment life by 50%.

IEEE 519

IEEE® Standard 519-1992, “IEEE Recommended Practices and Requirements for Harmonic Control in Electrical Power Systems®” represents the most recent effort to establish a standard level of acceptable harmonic distortion levels on a power system. The following two Tables 9 and 10 summarize the voltage and current harmonic distortion limits.

Note: The current distortion limits are dependent upon the size of the customer’s load relative to the available short-circuit capacity of the utility (stiffness). In this way, customers whose loads potentially have more effect on the utility system and neighboring customers are held to the tighter limits.

Table 9: End User Limits — Current Distortion Limits for General Distribution Systems End-User Limits (120 – 69,000 Volts) Maximum Harmonic Current Distortion in % of 1. Individual Harmonic Order (Odd Harmonics)

<table>
<thead>
<tr>
<th>Individual Harmonic Order (Odd Harmonics)</th>
<th>/L SC/IL</th>
<th>3</th>
<th>5</th>
<th>7</th>
<th>9</th>
<th>11</th>
<th>13</th>
<th>15</th>
<th>17</th>
<th>19</th>
</tr>
</thead>
<tbody>
<tr>
<td>1&lt;30</td>
<td>≤1</td>
<td>≤1</td>
<td>≤1</td>
<td>≤1</td>
<td>≤1</td>
<td>1.5</td>
<td>3.0</td>
<td>5.0</td>
<td>7.5</td>
<td>10.0</td>
</tr>
<tr>
<td>30&lt;100</td>
<td>≤1</td>
<td>≤1</td>
<td>≤1</td>
<td>≤1</td>
<td>≤1</td>
<td>1.5</td>
<td>3.0</td>
<td>5.0</td>
<td>7.5</td>
<td>10.0</td>
</tr>
<tr>
<td>100&lt;200</td>
<td>≤1</td>
<td>≤1</td>
<td>≤1</td>
<td>≤1</td>
<td>≤1</td>
<td>1.5</td>
<td>3.0</td>
<td>5.0</td>
<td>7.5</td>
<td>10.0</td>
</tr>
<tr>
<td>200&lt;500</td>
<td>≤1</td>
<td>≤1</td>
<td>≤1</td>
<td>≤1</td>
<td>≤1</td>
<td>1.5</td>
<td>3.0</td>
<td>5.0</td>
<td>7.5</td>
<td>10.0</td>
</tr>
<tr>
<td>500&lt;1000</td>
<td>≤1</td>
<td>≤1</td>
<td>≤1</td>
<td>≤1</td>
<td>≤1</td>
<td>1.5</td>
<td>3.0</td>
<td>5.0</td>
<td>7.5</td>
<td>10.0</td>
</tr>
<tr>
<td>1000&lt;1M</td>
<td>≤1</td>
<td>≤1</td>
<td>≤1</td>
<td>≤1</td>
<td>≤1</td>
<td>1.5</td>
<td>3.0</td>
<td>5.0</td>
<td>7.5</td>
<td>10.0</td>
</tr>
</tbody>
</table>

Table 10: Utility Limits — Voltage Distortion Limits

<table>
<thead>
<tr>
<th>Bus Voltage at PCC</th>
<th>Individual Voltage Distortion (%)</th>
<th>Total Voltage Distortion THD (%)</th>
</tr>
</thead>
<tbody>
<tr>
<td>15 kV and Below</td>
<td>2.0</td>
<td>0.5</td>
</tr>
<tr>
<td>15.001 kV – 34.5 kV</td>
<td>2.5</td>
<td>1.0</td>
</tr>
<tr>
<td>34.5 kV and Above</td>
<td>3.0</td>
<td>1.5</td>
</tr>
</tbody>
</table>

Note: High voltage systems can have up to 2.0% THD where the cause is an HVAC terminal that will attenuate by the time it is tapped for a user.

Two very important points must be made in reference to the above limitations:

1. The customer is responsible for maintaining a current distortion to within acceptable levels, while the utility is responsible for limiting voltage distortion.

2. The limits are only applicable at the Point of Common Coupling (PPC) between the utility and the customer. The PPC, while not explicitly defined, is usually regarded as the point at which the utility equipment ownership meets the customer’s, or the metering point. Therefore, the above limits cannot be meaningfully applied to, say, distribution panels or individual equipment within a plant — the entire plant must be considered when complying with these limits.

Electric utilities are currently considering financial penalties and/or service interruption for customers injecting excessive harmonics into the utility system. Therefore, while a customer may not be currently penalized for low power factor, a harmonic distortion-based penalty structure, in the manner...
of IEEE 519, may be forthcoming.

How are Harmonics Generated?

Harmonics are generated by non-linear loads. A non-linear load is a circuit element that draws current in a non-sinusoidal manner. Until recently, most factory loads were primarily linear, with current waveform closely matching the sinusoidal voltage waveform and changing in proportion to the load. More recently, however, factory loads with major non-linear components have increased dramatically. Table 11 gives typical examples of linear and non-linear devices.

Table 11. Examples of Linear and Non-Linear Devices

<table>
<thead>
<tr>
<th>Primarily Linear Devices</th>
<th>Devices with Major Non-Linear Components</th>
</tr>
</thead>
<tbody>
<tr>
<td>Some Motors</td>
<td>6-pulse VFDs</td>
</tr>
<tr>
<td>Incandescent Lighting</td>
<td>Variable Frequency Drives</td>
</tr>
<tr>
<td>Heating Loads</td>
<td>Programmable Controllers</td>
</tr>
<tr>
<td></td>
<td>Induction Furnaces</td>
</tr>
<tr>
<td></td>
<td>Solid-State Uninterruptible Power Supplies (UPS)</td>
</tr>
<tr>
<td></td>
<td>Arc Furnaces</td>
</tr>
<tr>
<td></td>
<td>Arc Welders</td>
</tr>
</tbody>
</table>

Table 11. Examples of Linear and Non-Linear Devices

Harmonics are generated by non-linear loads. A non-linear load is a circuit element that draws current in a non-sinusoidal manner. Until recently, most factory loads were primarily linear, with current waveform closely matching the sinusoidal voltage waveform and changing in proportion to the load. More recently, however, factory loads with major non-linear components have increased dramatically. Table 11 gives typical examples of linear and non-linear devices.

Electronic Power Converters

Electronic power converters — e.g., adjustable speed drives, power supplies — are by far the largest contributors to harmonic distortion in today’s plant environment. An electronic power converter changes electrical energy from one form to another, typically by rectifying the ac voltage into dc and utilizing the dc voltage directly or synthesizing a new ac voltage. This change is accomplished by using solid-state devices — silicon control rectifiers (SCRs), diodes, transistors — to periodically switch in the conducting circuits of the converter. Figure 19 shows a typical harmonic current spectrum for six-pulse electronic power converter. Below are some common names that are typically associated with electronic power converters.

Common Names Given to Electronic Power Converters

- Adjustable Speed Drives
- Variable Frequency Drives
- SCR Drives
- ac Motor Drives (ac/dc/ac)
- dc Motor Drives (ac/dc)
- Three-phase Full Wave Rectifiers
- Three-phase Full Wave Converters
- Six-pulse Converters

As most plant engineers appreciate, there is an increased use of electronic drives due to their ability to more efficiently or precisely drive a motor or process.

Arcing Devices

Arc furnaces and welders are the two types of arcing devices that cause the most harmonic distortion, although arc lighting (fluorescent, mercury vapor) will also cause small degrees of harmonic distortion.

Other Equipment

Motors, generators, transformers and arc lighting also have small non-linear components, although the contribution of these devices to total harmonic distortion in a plant tends to be relatively small.
What Do Power Factor Correction Capacitors Have to Do with Harmonics?

A discussion of power system harmonics is incomplete without discussing the effects of power factor correction capacitors. In an industrial plant containing power factor correction capacitors, harmonic currents and voltages can be magnified considerably due to the interaction of the capacitors with the service transformer. This is referred to as harmonic resonance or parallel resonance. For a typical plant containing power factor correction capacitors, the resonant frequency (frequency at which amplification occurs) normally falls in the vicinity of the 5th to the 13th harmonic. Since non-linear loads typically inject currents at the 5th, 7th, 11th and 13th harmonics, a resonant or near-resonant condition will often result if drives and capacitors are installed on the same system, producing the symptoms and problems outlined in the previous section.

Note: Capacitors themselves do not cause harmonics, but only aggravate potential harmonic problems. Often, harmonic-related problems do not “show up” until capacitors are applied for power factor correction.

It is a common misconception that the problem of applying capacitors in harmonic environments is limited to problems caused for the capacitor itself — that the capacitor’s lower impedance at higher frequencies causes a current overload into the capacitor and, therefore, must be removed. However, the capacitor/harmonics problem must be viewed from a power system standpoint. The capacitor-induced increase of harmonic voltages and currents on a plant’s system may be causing problems while the capacitor itself remains within its acceptable current rating.

How Do I Diagnose a Potential Harmonics Related Problem?

If a plant engineer suspects that he might have a harmonics problem, the following steps can easily be performed as an initial investigation into potential problems:

1. Look for symptoms of harmonics as listed in Table 8. If one or more of these symptoms occurs with regularity, then the following steps should be taken.

2. If the plant contains power factor correction capacitors, the current into the capacitors should be measured using a ‘true rms’ current meter. If this value is higher than the capacitor’s rated current at the system voltage (by >5% or so), the presence of harmonic voltage distortion is likely.

3. Conduct a paper audit of the plant’s harmonic-producing loads and system configuration. This analysis starts with the gathering of kVA or horsepower data on all the major non-linear devices in the plant, all capacitors, and rating information on service entrance transformer(s). Eaton has specific analysis forms with instructions to guide the plant engineer in collecting this information, and engineers or sales representatives can provide assistance as needed.

4. If the electrical distribution system is complex — e.g., multiple service entrances, distributed capacitors — or if the paper audit is incomplete or considered to be too burdensome, the most definitive way to determine whether harmonics are causing a problem is through an on-site plant audit. This audit involves an inspection of the electrical system layout and connected loads, as well as harmonic measurements taken at strategic locations. This data can then be assembled and analyzed to obtain a clear and concise understanding of the power system. Eaton provides an engineering service to conduct these on-site plant audits.
How Can Harmonics Problems Be Eliminated?

When power factor correction is required in the presence of non-linear loads, or the amount of harmonic distortion must be reduced to solve power quality problems or avoid penalties, the most reliable, lowest cost solution is often realized with the use of harmonic filters.

What is a Passive Harmonic Filter?

A shunt harmonic filter (see Figure 20) is, essentially, a power factor correction capacitor combined with a series iron core reactor. A filter provides power factor correction at the fundamental frequency and becomes an inductance (like a motor) at frequencies higher than its 'turning point.' Cutler-Hammer® harmonic filters are almost always tuned below the 5th harmonic. Therefore, the filter provides an inductive impedance path to those currents at harmonic frequencies created by nearly all three-phase non-linear loads (5th, 7th, 11th, 13th, etc.). Since the filter is not capacitive at these frequencies, the plant electrical system can no longer resonate at these frequencies and cannot magnify the harmonic voltages and currents.

A shunt harmonic filter therefore accomplishes three things:

1. Provides power factor correction.
2. Prevents harmonic overvoltages due to parallel resonance.
3. Reduces voltage harmonic distortion and transformer harmonic loading at frequencies above its turning point.

In some circumstances, a harmonic resonance condition may accrue gradually over time as capacitors and non-linear loads are installed in a plant. In those instances, replacement of such capacitors with harmonic filters is in order to correct the problem.

![Figure 20. Shunt Harmonic Filter](image-url)
Do I Need to Perform a System Analysis to Correctly Apply Harmonic Filters?

The proper application of harmonic filters can be greatly simplified by recognizing that there are only a few pieces of pertinent information and analysis steps which need to be taken for most systems in order to correctly deal with the problem.

Eaton's approach to power system harmonic diagnosis and solutions has evolved, via years of accumulated knowledge and experience, to an approach which eliminates needless analytical complexity in the majority of circumstances. Rather, it relies on the relatively few pieces of information which are required to make the correct applications decision. If this information indicates that some type of metering and measurement is required, then only those select measurements which yield useful information will be performed, keeping the complexity and cost to a minimum without sacrificing solution correctness.

Our abilities in the area of harmonic analysis, however, extend to the state-of-the-art in computerized analysis tools should the customer require the thoroughness afforded by such tools.

One of the most basic and useful pieces of information which must be known before attempting to correct power factor in the presence of non-linear loads is the ratio of the total non-linear kVA to the service transformer kVA rating. This ratio alone can often be used to determine whether harmonic filters are necessary to correct power factor or whether plain capacitors can be added without experiencing problems as follows:

1. If the plant's total three-phase non-linear load (in kVA, 1 hp = 1 kVA) is more than 25% of the main transformer capacity, harmonic filters will almost always be required for power factor correction.
2. If the plant's total three-phase non-linear load is less than 15% of the main transformer capacity, capacitors can usually be applied without problems.
3. If the plant's total non-linear load is between 15 and 25%, other factors should be considered.

Starting with this most basic information, your Eaton sales representative will work with you to determine what additional information or measurement, if any, is required in order to recommend the correct solution to your problem.

What is Eaton’s Experience in Harmonic Filtering?

Eaton has been in the power capacitor business for 70 years, manufacturing power factor correction capacitors used in low voltage and medium voltage applications. In the 1980s, we began working with a number of customers to help resolve problems related to harmonic distortion. During this time period, we developed a number of designs to incorporate harmonic filtering in both fixed and automatic capacitor banks. The success of these installations has made Eaton the leader in the field of harmonic filters.

With a fully integrated manufacturing process, we maintain the strictest quality control systems in the industry. All power capacitors are 100% tested at various stages in their manufacture and prior to shipment to ensure a long service life. In addition, Eaton provides on-site supervision and start-up assistance to ensure that all capacitor and harmonic filtering assemblies are properly applied in the plant environment.

Please call 1-800-809-2772 for assistance in understanding and solving any problems that you have involving capacitors or harmonics in your facility.
Eaton Corporation is a diversified industrial manufacturer ranked among the largest Fortune 500 companies. The electrical group is Eaton’s largest division and is a global leader in electrical control, power distribution, power quality, automation, and monitoring products and services. Eaton’s electrical products include brands such as Cutler-Hammer®, MGE Office Protection Systems, Powerware®, Holec® and MEM®. Eaton provides PowerChain Management® solutions to serve the needs of the industrial, institutional, IT, data center, mission critical, utility, residential and OEM markets worldwide.

PowerChain Management solutions help enterprises achieve sustainable and competitive advantages through proactive management of the power system as a strategic, integrated asset throughout its life cycle. With Eaton’s distribution, generation and power quality equipment; full-scale engineering services; and information management systems, the power system is positioned to deliver powerful results: greater reliability, operating cost efficiencies, effective use of capital, enhanced safety and risk mitigation.

CAPACITOR BANKS & PASSIVE HARMONIC FILTERS

See labels on product for additional information.