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最近の熱交換器に関する文献調査と
HTGR用熱交換器の開発上の問題点

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1967年から1976年までにNSA(Nuclear Science Abstracts)に掲載された熱交換器に関する文献索引を利用し、その開発上の問題点を抽出し、検討を行った。文献を、炉型、熱交換器の型式、国別、冷却材、研究テーマの種類各項目について分類した。その結果、炉型としては世界的にはLMFBRとHTGRと軽および重水炉用の開発に重点が置かれていることが明らかになった。一方、HTGR用熱交換器の開発研究は、耐熱材料、腐食に関するテーマのものが、他の炉に比べて多くなされており、また、水素透過防止は、多目的高温ガス炉では重要な課題であることが認識された。

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Bibliographical survey of heat exchangers for nuclear
power plants and problems of HTGR

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The problems in development of heat exchangers for nuclear reactors have been examined in literature survey through Annual Index Subjects of NSA (Nuclear Science Abstracts) for the past ten years. R and D on heat exchangers for LMFBR, HTGR, LWR and HWR are on the increase. In the case of HTGRs, R and D on heat resisting materials including the corrosion and on hydrogen permeation of heat exchanger walls in high temperature pressure helium environment are important. Future R and D subjects for HTGR heat exchangers in showing the high temperature endurance are presented.

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1. 序

多目的高温ガス炉 (High - Temperature Gas - cooled Reactor) の開発を推進する上には、高温高圧の条件のもとで、円滑にその機能を発揮し作動する熱交換器を開発することは不可欠の課題である。とくに、冷却材温度が 1000°C という環境では、これまで 500°C 程度の温度で使用されていた従来の搬用の原子炉熱交換器には見られない、高温固有の多くの問題に対処することが要求される。

本稿は、原子炉用熱交換器に関して、過去10年間に、NSA (Nuclear Science Abstracts) に掲載された文献の索引を紹介するとともに、それらの文献を用いて熱交換器の開発上の問題点を調査し、その世界的推移、動向を把握することを目的とした。

まず、2、3章では文献の調査方法、および文献の分類区分を説明した。引きつづき、4章ではそれらの結果をもとに、HTGRを中心とした各種型式の原子炉用熱交換器開発上の推移、および動向について述べた。また、5章ではとくに、HTGRを対象とした熱交換器開発上の問題点を抽出し、その内容について説明を加えた。

2. 文献調査方法

原子炉施設に用いられる熱交換器に関する文献を収集するため、NSA [Vol. 21 (1967) ~ Vol. 33 (1976)] の Annual Index Subjects の中で、Heat exchanger Steam generator 項の索引を利用し文献を抽出した。

これらの文献の索引を、巻末付録Aに掲載する。索引中には、熱交換器に関する文献を分類する目的で、次のキーワードを抽出して分類を行なった。

- (1) 炉型
- (2) 熱交換器の型式
- (3) 国名
- (4) 冷却材

これら4項目に関して、詳しくは表3-1にある記号を用いて分類がされている。

NSAによる索引番号は、21:17499 (P. A1) のように、索引中に記入されている。本報では、新しい索引番号として、5桁の数字で表わし、前の2桁の数は発行年度を、残りの3桁はその年にNSAに掲載された文献につけた通し番号を示す。1例として、67010は1967年に掲載された文献で 010 は通し番号である。

3. 分類区分

抽出した文献を、(1)炉型、(2)熱交換器の型式、(3)文献発表国、(4)冷却材の種類、および(5)文献の内容別、の5項目に大別し、さらに詳しくそれぞれ表3-1、3-2のように分類を行なった。

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(1)～(4)は表3-1の記号を用い巻末付録Aの索引中に分類記入し、(5)については文献の内容を、表3-2のように分類した。(1)～(4)はHeat exchanger, Steam generatorの2項目について、(5)ではHeat exchanger項を対象にして分類してある。Heat exchanger項の文献を用いて行なった分類の結果を表、および図にまとめた。

表3-3は、主要5ヶ国—アメリカ、フランス、イギリス、西ドイツ、日本を対象とした、各国の年代別の熱交換器に関する発表文献数を示す。

図3-1は、表3-3をもとに作成した、各国の年代別の発表文献数の折れ線グラフである。

表3-4は、冷却材として、Na (LMFBR), He (HTGR, AVR), CO₂ (GCR, AGR)のように、冷却材と炉型の関連性を考慮した表を表3-5に示し、冷却材、炉型を6項に大別して、各国の発表文献数と、その他の文献数を加えた数を、年代別に調べたものである。

図3-2は、表3-4をもとに作成した各国の冷却材、炉型別の発表文献数を年代別に、図3-3は、同じくその総数について、それぞれ棒グラフにしたものである。

表3-6は、内容別に分類した文献の数を年代別に調べたものであるが、1件の文献でも多種の内容テーマを扱ったものは、それぞれの内容別文献数の1件として、重複して数えてある。

表3-7は、内容別に分類した文献の索引である。

図3-4は、表3-6をもとに作成した、内容別文献数の年代別変化を棒グラフにしたものである。

4. 原子炉用熱交換器の開発の動向

3章で分類し作成した、各国の年代別文献発表数の図3-1から、各国の熱交換器開発の年代的推移を原子炉の開発と結びつけて分析することは、今後の研究開発の動向を予測し、開発の方向を見定める上で、有効な指針を与えてくれよう。各国の過去10年間の動向を次のようにまとめてみる。

アメリカ 図3-1に見られる1968, 73年の文献数の増加は、図3-2の冷却材、炉型別文献数の年代的推移を見れば、Na, LMFBR (SEFOR, FFTF)に関係した文献によるものである。LMFBRに関する文献数は他に比べて多いが、近年になってやや減少状態にあり、開発の停滞が推測できる。一方、HTGRについては、1974, 75年と発表数が増えつつあり開発の活発化が感じられる。水炉(主に軽水炉)では、過去10年間大きな増加はないものの、毎年1, 2の文献が発表されている。これは、その基礎的研究がほぼ終了したことを物語っていよう。

イギリス 文献は10年にわたって、目立った増減なしに発表されているが、1970年は図3-2よりDragon (HTGR)炉によるもので、73年代はLMFBR (PFR)の開発による。イギリスの初期の開発炉である炭酸ガス冷却炉 (GCR)あるいは、その改良型炉 (AGR)関係の文献は、1968年以後発表されていない。これはイギリスのAGRからSGHWRへの新型炉開発の移行による状態変化の影響とみられる。また、73年以後はLMFBR, HTGR共に減少し、原子炉開発の停滞が予想される。

(1)～(4)は表3-1の記号を用い巻末付録Aの索引中に分類記入し、(5)については文献の内容を、表3-2のように分類した。(1)～(4)はHeat exchanger, Steam generatorの2項目について、(5)ではHeat exchanger項を対象にして分類してある。Heat exchanger項の文献を用いて行なった分類の結果を表、および図にまとめた。

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フランス 1972～74年の文献数の増加は、図3-2 からLMFBR (Phenix)の開発に負うところが大きい。一方、GCRの開発によるものとして、EDF-1, 2, 3, EL-4などの炉に関連した文献が、1973年代まで毎年発表されていて、開発炉をGCRに絞っていたフランスの方針がよく表われている。近年のフランスの動向の特徴として、GCRやHTGRに比べてLMFBRの開発に重点が置かれているといえる。

西ドイツ 1973年前後の活発な研究成果の発表は、LMFBR (SN-300), PWR, HTGRの開発に関連している。

日本 1971年の増加はLMFBRの影響で、近年になりHTGR関係の文献も発表され、全体として、1969年以後文献は増加しており、研究開発が進んでいることを示す。

世界的動向 図3-3 の冷却材、炉型別文献の総数の年代変化を見ると、LMFBRについては、文献は他の炉に比べて非常に多く、開発のための多くの研究すべき問題点が伴っていたことを示す。1968年と73年に文献は増加しているが、73年以後減少の傾向が見られる。HTGRについては、1970年のDragon 炉によるものを除けば、近年になって文献は増加を辿っており、活発な開発姿勢を感じる。GCR, MHD, MSRに関するものは1973年以後文献はない。また、水炉では過去10年間、ほぼ定常的な発表の傾向にあり、同型炉の建設に関する改良研究として、今後もこの傾向を示すことが考えられる。このように世界的な原子炉開発の趨勢は、近年になってHTGR, LMFBR, 水炉(軽および重水炉)に集中されていることから関連して、熱交換器の研究も続けるといってもよく、とくに、HTGRではその意欲的な開発状況を示している。

文献内容の動向 過去10年間に発表された文献の扱っている内容は、炉全体で表3-6 のように、構造、建設的なテーマとして設計、伝熱管、性能、製作、溶接、また、現象的なテーマとして、流れ、熱伝達、振動、および材料と腐食、保守、安全のテーマが多い。過去3年間のテーマの動向としては、図3-4 からわかるように、設計、性能、製作、伝熱管、熱伝達、流れ、振動、応力解析、材料、最適化、腐食、および溶着などのテーマに関する文献が、他の年代に比べて多く発表されており、今後、着手すべき研究テーマの選定の有効な目安となろう。

5. HTGR用熱交換器の開発上の問題点

前章の文献内容のテーマ別の中で、HTGR用熱交換器に限って、その内容上の動向を調べ、問題点をまとめてみた。

本調査では、NSA中のHeat exchanger 項だけでなく、Steam generator 項の文献も参考とした。抽出した文献のリストを巻末付録Bに掲載した。本リストは、HTGR, AGR, およびMHDに関する熱交換器、蒸気発生器についての文献を取りあげており、索引番号と炉型、冷却材、および文献の内容を示すキーワードを記入してある。

表5-1 に内容別に分類した文献数を年代別に示し、それに該当する文献索引を表5-2 に掲載した。

フランス 1972～74年の文献数の増加は、図3-2 からLMFBR (Phenix)の開発に負うところが大きい。一方、GCRの開発によるものとして、EDF-1, 2, 3, EL-4などの炉に関連した文献が、1973年代まで毎年発表されていて、開発炉をGCRに絞っていたフランスの方針がよく表われている。近年のフランスの動向の特徴として、GCRやHTGRに比べてLMFBRの開発に重点が置かれているといえる。

西ドイツ 1973年前後の活発な研究成果の発表は、LMFBR (SN-300), PWR, HTGRの開発に関連している。

日本 1971年の増加はLMFBRの影響で、近年になりHTGR関係の文献も発表され、全体として、1969年以後文献は増加しており、研究開発が進んでいることを示す。

世界的動向 図3-3 の冷却材、炉型別文献の総数の年代変化を見ると、LMFBRについては、文献は他の炉に比べて非常に多く、開発のための多くの研究すべき問題点が伴っていたことを示す。1968年と73年に文献は増加しているが、73年以後減少の傾向が見られる。HTGRについては、1970年のDragon 炉によるものを除けば、近年になって文献は増加を辿っており、活発な開発姿勢を感じる。GCR, MHD, MSRに関するものは1973年以後文献はない。また、水炉では過去10年間、ほぼ定常的な発表の傾向にあり、同型炉の建設に関する改良研究として、今後もこの傾向を示すことが考えられる。このように世界的な原子炉開発の趨勢は、近年になってHTGR, LMFBR, 水炉(軽および重水炉)に集中されていることから関連して、熱交換器の研究も続けるといってもよく、とくに、HTGRではその意欲的な開発状況を示している。

文献内容の動向 過去10年間に発表された文献の扱っている内容は、炉全体で表3-6 のように、構造、建設的なテーマとして設計、伝熱管、性能、製作、溶接、また、現象的なテーマとして、流れ、熱伝達、振動、および材料と腐食、保守、安全のテーマが多い。過去3年間のテーマの動向としては、図3-4 からわかるように、設計、性能、製作、伝熱管、熱伝達、流れ、振動、応力解析、材料、最適化、腐食、および溶着などのテーマに関する文献が、他の年代に比べて多く発表されており、今後、着手すべき研究テーマの選定の有効な目安となろう。

5. HTGR用熱交換器の開発上の問題点

前章の文献内容のテーマ別の中で、HTGR用熱交換器に限って、その内容上の動向を調べ、問題点をまとめてみた。

本調査では、NSA中のHeat exchanger 項だけでなく、Steam generator 項の文献も参考とした。抽出した文献のリストを巻末付録Bに掲載した。本リストは、HTGR, AGR, およびMHDに関する熱交換器、蒸気発生器についての文献を取りあげており、索引番号と炉型、冷却材、および文献の内容を示すキーワードを記入してある。

表5-1 に内容別に分類した文献数を年代別に示し、それに該当する文献索引を表5-2 に掲載した。

表5-3は、HTGR用熱交換器の現象的テーマの分類項目の中で、文献数の多い6テーマを選び列記してみた。なお、同表にはすべての文献を炉型の区別なしに内容別に分類した時の総文献数も加え、HTGR用の数と比較検討をし、HTGR用熱交換器の持つ問題点、特徴を調べた。

図5-1は、表5-3中の6テーマを扱った文献の総数に対する各テーマの占める比率をグラフにしたもので、HTGR用と炉全体との傾向は似ているが、HTGRでは、流れや熱伝達の問題より材料、腐食の問題が、炉全体の傾向に比べて大きなテーマとなっている。HTGRの特質として高温環境は、耐熱材料、あるいは腐食の問題を他の炉以上に重要な研究要素としている。反面、熱伝達、流れの問題については、冷却材が単相ガスであるゆえにその流れ、熱伝達の取扱いの容易さは、他の炉に比べこのテーマでの研究を少なくしている、といった理由を考えれば上記の傾向はおのずと理解できる。

表5-4は、HTGR用熱交換器について研究されているテーマを表5-2の文献より調査し、キーワードと共に列記したものである。その主項目を列記すると次のようになる。

- (1) 冷却材（高温下での物性値の評価、など）
- (2) 材料（高温高圧He中での強度特性、耐食、耐水素透過性金属の選定、セラミック材料、など）
- (3) 腐食（耐腐食金属材料の選定、防止対策、など）
- (4) 熱伝達（高温高圧He中での熱伝達、伝熱促進技術、輻射の効果、など）
- (5) 振動（耐振設計、流体振動の解析、など）
- (6) 流れ（流れの不安定性解析、など）
- (7) 水素透過（防止対策、除去方法、など）
- (8) ガスタービン（設計上の検討、など）
- (9) 高温高圧ループ（実証運転、など）

多目的利用高温ガス炉では1000℃以上の一次系高温ガスにより、還元ガス、水蒸気を発生させ、製鉄、化学および発電などの多目的利用を意図しているのが特徴であり、従来にない高温度ガスという厳しい環境において使用する熱交換器の設計、開発には多くの解決すべき問題点がある。表5-4は、過去10年間に研究されてきたテーマであり、かつ今なお満足すべき答えの出されていない問題をも含んでいよう。そういった問題点を次にまとめてみる。

HTGRのように高温で用いる冷却材としてヘリウム、(Ne, H₂, CO₂)などは、炉内を単相の状態に冷却し、出力密度、および熱流束が幸いにも他の冷却材である水、および液体金属に比べて厳しい条件におかれているわけではないが、高温という条件が、その他の問題を誘発することになる。

冷却材、または構造材の高温下での物性値（比熱、粘性係数、熱伝導率）の変化を正しく評価することは、設計上、基本的な必要不可欠の事項である。

材料については、耐熱、耐食金属材料の多くの調査、開発研究が進められているが、今後は、より実地的な炉内照射試験の確認も必要とされよう。また多目的炉に用いられる水素の伝熱管壁透過は、炉内材料の劣化を招くことになり、その防止法、あるいは除去方法の対策は解決すべき重要な問題である。耐水素透過性材料の選定開発の必要なことはもちろんであるが、材料の強度、あるい

は、耐食性に対する配慮もされた材料の選定、開発の困難さを考慮すると、液体金属介在型の新型熱交換器の開発の必要性も場合により生じる。

腐食対策は、その材料選定と共に、水側では LiOH などの混入による防止、あるいはフレティング腐食の原因ともなる熱交換器内の流体の流れの不均一、不安定性の防止、あるいは伝熱管の有効な振動防止を意図した設計面の改善にも及ぶ。

伝熱管の振動防止は、腐食防止と関連して、対策を立てる必要があるが、振動は冷却材流体の運動により起こされる流体振動が支配的であるにもかかわらず、その詳細な機構は十分に解明されていないのが現状であり、現象の調査研究の必要性は大きい。

振動に関連して、熱交換器内の流体の流れは流体振動の起因力として作用する。また、その不均一性により生じる腐食の問題とも関連するばかりでなく、熱伝達特性の良否に大きな影響を与える。

熱伝達は、熱交換器の高熱流束、および高出力密度化を達成する上で必要となる伝熱促進技術の開発という主要な問題を含む。一方、高温高圧ループを使った機器の実証運転も必要とされる。

また、高効率化をねらった直接ガスタービンについての検討も、高温ガス炉の特質を生かす上で重要な課題である。とくに、再生熱交換器の効率はガスタービンプラントの効率を決定する最も主要な課題であり、最適化の研究を進める必要がある。

表5-4をもとに、HTGR用熱交換器開発上の問題点を明らかにしてきたが、材料と腐食、あるいは腐食と振動と流れ、あるいは流れと熱伝達の関係のように、その因果関係が複雑に結びついており、開発にあたっては、それら個々に秘められた問題を解決するばかりでなく、その結果が他の問題に波及する効果を常に念願においた研究姿勢が望まれよう。

6. あとがき

原子炉施設において使用される熱交換器の開発の動向を、過去10年間に発表された文献から調査したが、文献調査という大雑把な方法によるにもかかわらず、その文献の発表動向から世界、あるいは各国の開発の推移を辿ることができた。また、HTGR用熱交換器の開発上の問題点を、定量的に把握することはいかぬまでも、その定性的な骨子は浮かび上がってきたと考える。解決すべき問題は、これまで予想しなかった境界領域の問題とも複雑に関連し合っており、解決には、その両立性を考慮した研究姿勢が重要であることを、十分に認識しておく必要があろう。

は、耐食性に対する配慮もされた材料の選定、開発の困難さを考慮すると、液体金属介在型の新型熱交換器の開発の必要性も場合により生じる。

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伝熱管の振動防止は、腐食防止と関連して、対策を立てる必要があるが、振動は冷却材流体の運動により起こされる流体振動が支配的であるにもかかわらず、その詳細な機構は十分に解明されていないのが現状であり、現象の調査研究の必要性は大きい。

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熱伝達は、熱交換器の高熱流束、および高出力密度化を達成する上で必要となる伝熱促進技術の開発という主要な問題を含む。一方、高温高圧ループを使った機器の実証運転も必要とされる。

また、高効率化をねらった直接ガスタービンについての検討も、高温ガス炉の特質を生かす上で重要な課題である。とくに、再生熱交換器の効率はガスタービンプラントの効率を決定する最も主要な課題であり、最適化の研究を進める必要がある。

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表 3-1 分類記号一覧表

分 類	分 類 記 号
炉 型	(1) LWR, PWR, BWR, HWR, PHWR (2) LMFBR, Fast reactor (3) MSRE, MSBR (4) GCR, AGR (5) HTGR, AVR, HTR (6) その他 (MHD, SNAP)
熱交換器の型式	(1) IHX (intermediate heat exchanger) (2) SG (steam generator) (3) RHX (regenerative heat exchanger) (4) reheater (5) condenser
文 献 発 表 国	(1) 米 (U.S.A.) (5) ソ (ソ 連) (2) 英 (イギリス) (6) 日 (日 本) (3) 仏 (フランス) (7) 伊 (イタリア) (4) 西独 (西ドイツ) (8) その他
冷 却 材	(1) Na (6) Gas (2) 液体金属 (7) He (3) 有機材 (8) CO ₂ (4) 水 (9) Air (5) 溶融塩 (10) その他

表 3-2 内容別分類項目一覧表

分	類	記 号
(1)	熱伝達	(heat transfer)
(2)	質量移動	(mass transfer)
(3)	流れ, 対流	(flow, convection)
(4)	応力解析	(stress analysis)
(5)	振動	(vibration)
(6)	過渡現象	(transient phenomena)
(7)	シミュレーション	(simulation)
(8)	デザイン	(design)
(9)	形状, 製作, 開発	(configuration, fabrication, development)
(10)	性能, 仕様	(performance, specification)
(11)	溶接	(welding)
(12)	管群	(tubes, pipes)
(13)	フィン付構造物	(finned elements)
(14)	材料	(material)
(15)	効率	(efficiency)
(16)	価格	(cost)
(17)	最適化	(optimization)
(18)	検査	(inspection)
(19)	保守, 清掃	(maintenance, cleaning)
(20)	安全	(safety)
(21)	不具合例	(failures)
(22)	腐食	(corrosion)
(23)	ファウリング	(fouling)
(24)	沈殿	(deposit)

表 3-3 各国の熱交換器関係文献数

国 \ 年度	1967	1968	1969	1970	1971	1972	1973	1974	1975
アメリカ	33	34	21	17	18	18	22	15	10
フランス	8	4	4	7	5	5	7	3	6
イギリス	4	5	2	6	3	10	7	9	2
西ドイツ	4	1	4	6	5	6	13	10	5
日 本				1	3	1	4	3	5
他	8	12	9	13	12	2	7	27	12
総 計	57	56	38	50	46	42	60	67	40

表 3-5 冷却材、炉型別分類項目表

区 分 項 目
1. Water, LWR, HWR 注1)
2. Na, Liquid metal, LMFBR
3. He, HTGR, AVR, HTR
4. CO ₂ , GCR, AGR
5. MSR 注2)
6. MHD

注 1) LWRはPWR, BWRを含み, HWRはPHWRを含む

注 2) MSRはMSRE, MSBRを含む

表 3-4 各国の冷却材、炉型別の文献数の年代別変化

国別	冷却材、炉型	年 度							
		1967	1968	1969	1970	1971	1972	1973	1974 1975
アメリカ	Water LWR, HWR	1	1	1		2	1	1	1
	Na, Liquid metal LMFBR	12	15	11	10	2	9	7	6 3
	He HTGR, AVR, HTR								1 3
	CO ₂ GCR, AGR								
	MSR MHD	2	4 1	3	2	3	2		
フランス	Water LWR, HWR		1						
	Na, Liquid metal LMFBR	1	2		2	2	1	4	2
	He HTGR, AVR, HTR							1	
	CO ₂ GCR, AGR	1	1	2	2		2	1	
	MSR MHD						1		
イギリス	Water LWR, HWR								
	Na, Liquid metal LMFBR		2	1		3	3	1	
	He HTGR, AVR, HTR		1		7		1	2	1
	CO ₂ GCR, AGR	2	1						
	MSR MHD								
西ドイツ	Water LWR, HWR	1							1
	Na, Liquid metal LMFBR			1	1	2	4	5	1
	He HTGR, AVR, HTR			1	1	2		2	2
	CO ₂ GCR, AGR			1	1		1		
	MSR MHD		1						
日本	Water LWR, HWR								
	Na, Liquid metal LMFBR				1	2		1	1
	He HTGR, AVR, HTR								3 2
	CO ₂ GCR, AGR					1			
	MSR MHD								
総数	Water LWR, HWR	2	3	3	2	2	1	1	1 3
	Na, Liquid metal LMFBR	14	21	16	17	14	19	20	17 7
	He HTGR, AVR, HTR	1	1	2	8	2	1	7	5 7
	CO ₂ GCR, AGR	3	3	3	3	1	3	2	
	MSR MHD	2	4 1	3	2	3	2 1	2	

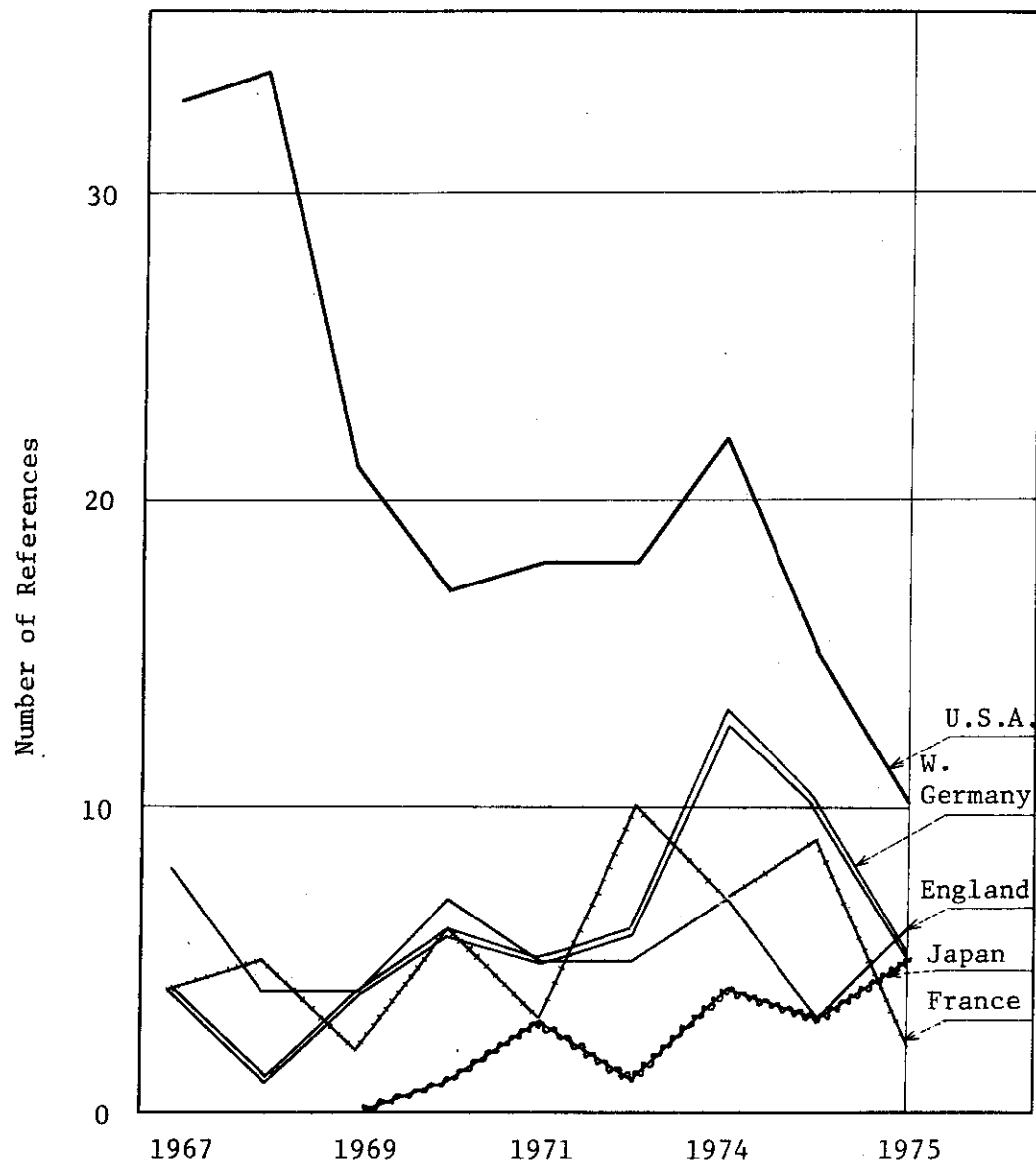


図 3-1 各国の熱対換器関係文献発表数

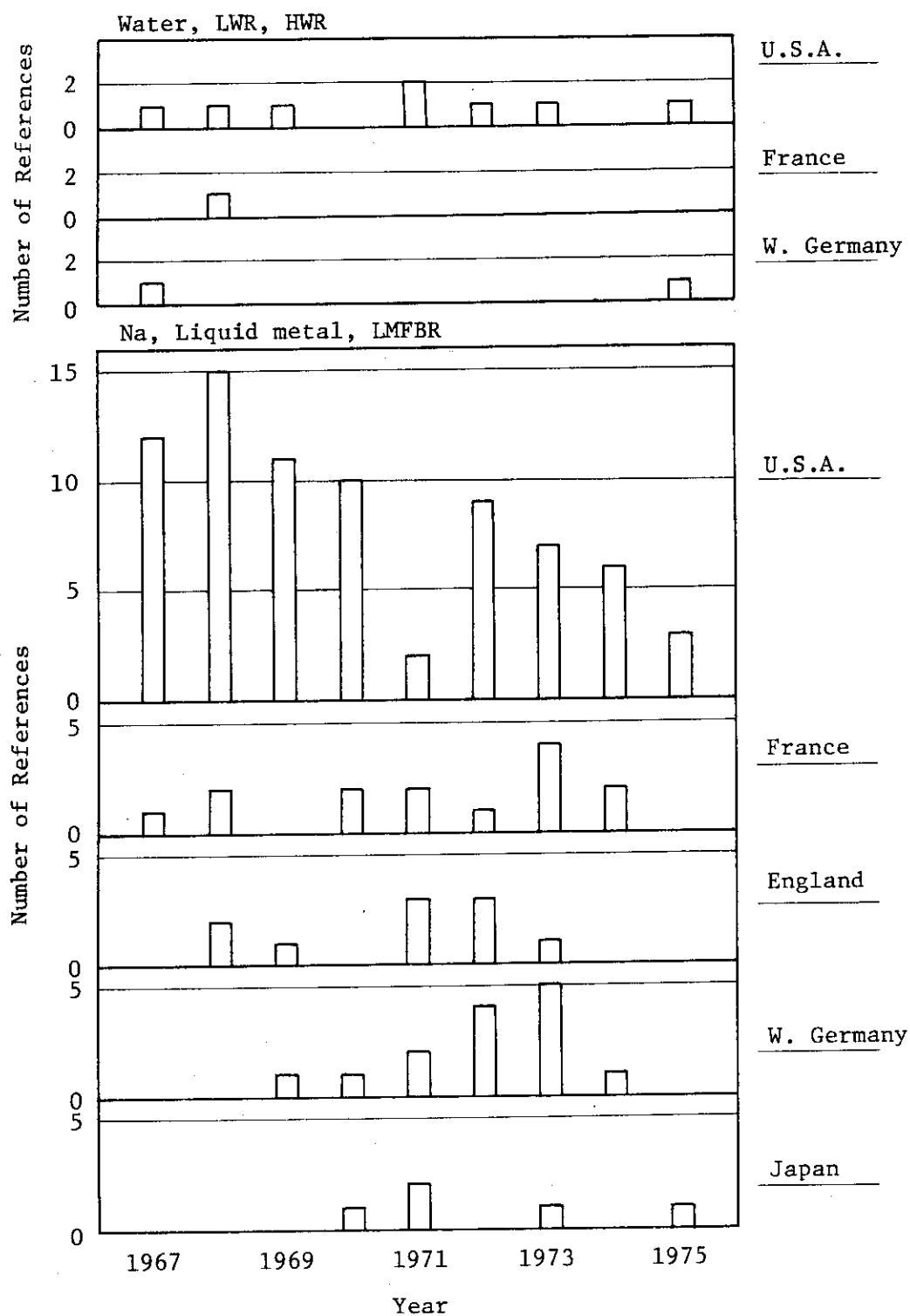


図3-2 各国の冷却材、炉型別の文献数の年代変化

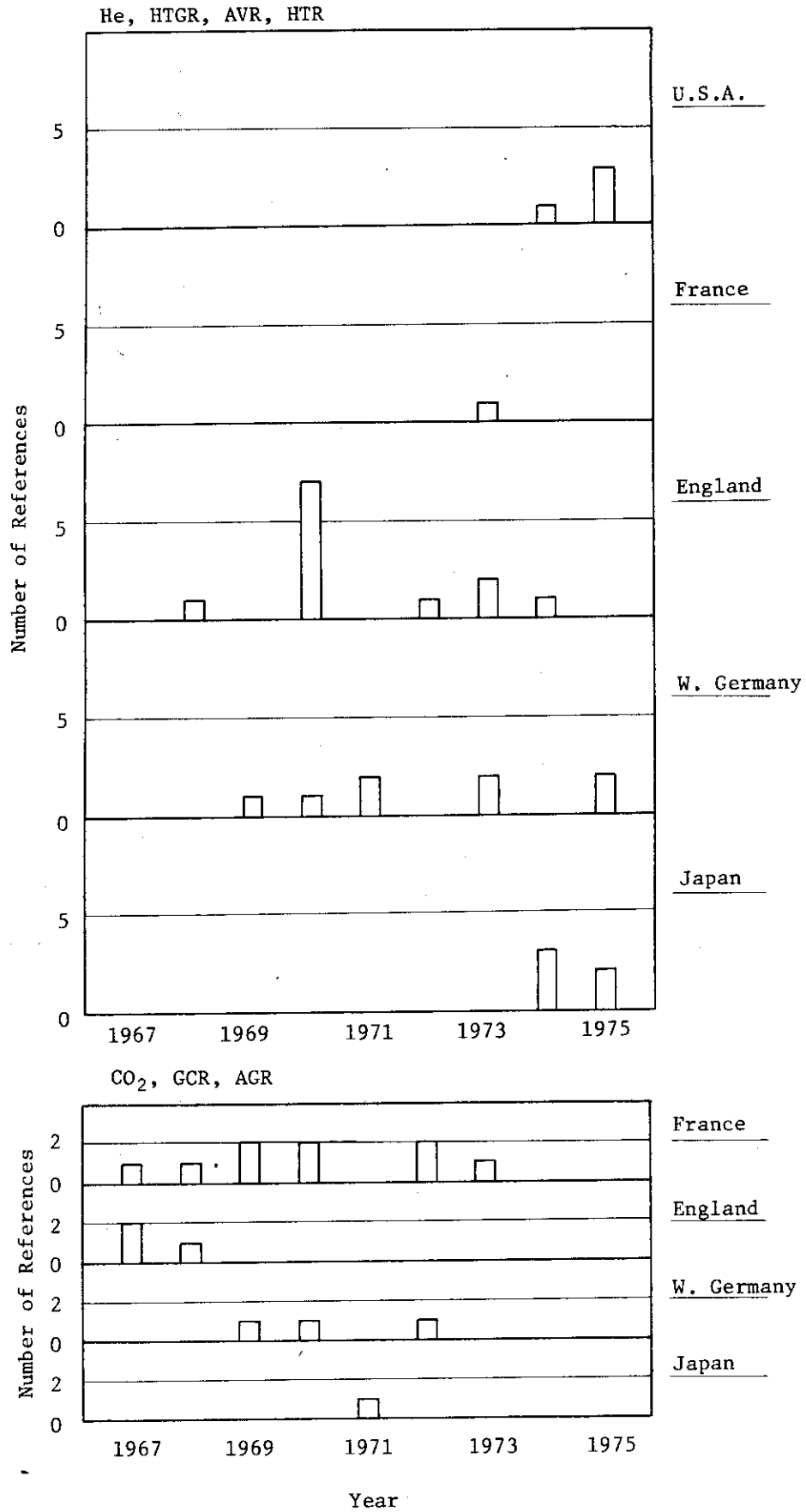


図 3-2 (続)

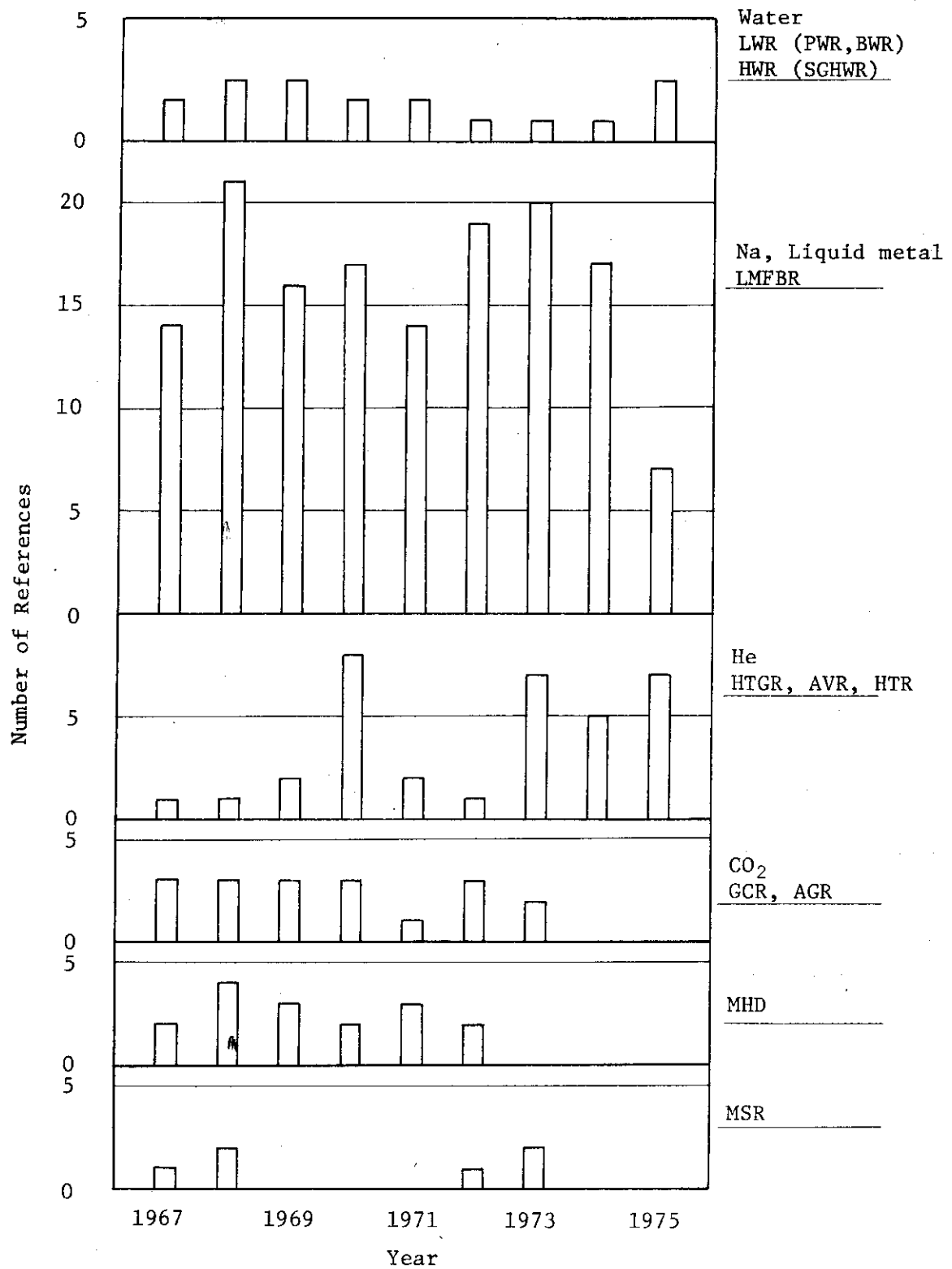


図3-3 冷却材，炉型別文献数の世界的な年代変化

表 3-6 内容別文献数の年代別変化

内 容*	総計	1967	1968	1969	1970	1971	1972	1973	1974	1975
Design	120	16	16	10	8	15	14	20	16	5
Tubes, Pipes	91	13	5	15	7	11	10	12	14	4
Flow, Stability	64	3	7	6	6	5	10	6	12	9
Performance	61	10	12	5	5	3	3	3	12	8
Heat transfer	56	11	7	6	6	4	3	4	6	9
Fabrication	30	4	1	3	7	4	1	7	3	
Vibration	29	2	2	4	2	2	5	2	9	1
Material	27	2	3	2	1	3	3	3	6	4
Inspection	24	3	1	5	4	8	1	1	1	
Corrosion	14	2	1		2		2	4	3	
Welding	14	1	1	1	2	3		2	1	3
Optimization	12	1	1	1		2	1	3	3	
Leak	12	2	1	1		4	1	1	1	1
Stress analysis	11	3		1				4	2	1
Deposit Fouling	10	2		1		1	2	3		1
Finned elements	10	2	2	1	1			2	2	
Simulation	7				5					2
Efficiency	6	2	1		1		1			1
Transient phenomena	5	2	1				1			1
Cost	4						3	1		
Mass transfer	2								2	

* DesignはDesignとDescriptionを含む

PerformanceはPerformanceとSpecificationを含む

FabricationはFabricationとDevelopmentとConfigurationを含む

InspectionはInspectionとMaintenanceとSafetyとFailuresを含む

表 3-7 内容別文献の索引

contents	index
Design	67005,67006,67007,67008,67010,67011,67014,67016,67019,67026, 67027,67045,67058,67077,67081,67082,68019,68021,68023,68027, 68029,68030,68031,68032,68033,68034,68074,68076,68077,68084, 68087,68088,69002,69004,69005,69012,69014,69020,69021,69033, 69056,69059,70002,70005,70006,70010,70011,70014,70052,70057, 71003,71004,71006,71008,71009,71010,71013,71016,71027,71028, 71030,71044,71049,71050,71052,72006,72009,72010,72011,72013, 72014,72015,72016,72023,72024,72026,72027,72039,72052,73003, 73004,73006,73009,73010,73011,73012,73013,73014,73015,73016, 73017,73018,73019,73020,73021,73052,73054,73055,73056,74011, 74012,74013,74014,74017,74018,74040,74050,74051,74052,74063, 74064,74067,74070,74071,74072,75035,75037,75040,75041,75055
Performance	67049,67050,67051,67052,67053,67054,67055,67056,67057,67080, 68047,68048,68049,68050,68051,68052,68053,68054,68087,68091, 68092,68094,69032,69033,69034,69049,69063,70027,70028,70029, 70030,70061,71023,71024,71027,72040,72041,72042,73003,73030, 73031,74038,74039,74040,74041,74042,74043,74044,74045,74074, 74080,74081,74082,75021,75022,75023,75050,75051,75052,75053, 75054
Fabrication	67001,67030,67034,67083,68008,69022,69023,69026,70018,70019, 70022,70023,70045,70052,70058,71041,71048,71057,71058,72028, 73023,73024,73040,73042,73064,73068,73070,74007,74013,74024
Finned elements	67043,67070,68041,68058,69027,70032,73040,73060,74045,74077
Tubes, Pipes	67019,67031,67032,67038,67040,67042,67044,67046,67063,67064, 67068,67069,67072,68039,68040,68041,68043,68055,69023,69027, 69028,69041,69043,69044,69047,69048,69049,69060,69061,69065, 69066,69067,69068,70014,70032,70036,70044,70045,70040,70048, 71024,71029,71034,71035,71036,71037,71038,71039,71043,71044, 71057,72013,72016,72024,72032,72036,72037,72041,72044,72053, 72054,73010,73011,73033,73034,73036,73037,73038,73040,73041, 73064,73071,73076,74022,74023,74024,74032,74033,74056,74057, 74064,74076,74077,74078,74081,74088,74089,75011,75042,75042, 75047

表 3-7 内容別文献の索引 (続)

contents	index
Welding	67075, 68069, 69045, 70044, 70047, 71020, 71039, 71040, 73023, 73077, 74059, 75011, 75030, 75061
Heat transfer	67036, 67037, 67038, 67039, 67040, 67041, 67042, 67043, 67044, 67045, 67084, 68003, 68009, 68039, 68040, 68041, 68042, 68043, 69027, 69028, 69029, 69030, 69060, 69061, 70024, 70049, 70050, 70052, 70053, 70054, 71018, 71019, 71053, 71057, 72036, 72037, 72055, 73010, 73019, 73026, 73062, 74017, 74038, 74074, 74075, 74076, 74077, 75014, 75015, 75016, 75023, 75034, 75042, 75043, 75044, 75053
Flow	67039, 67041, 67084, 68003, 68037, 68044, 68064, 68067, 68068, 68090, 69028, 69043, 69047, 69059, 69065, 69066, 70024, 70026, 70039, 70042, 70046, 70048, 71019, 71042, 71044, 71054, 71056, 72002, 72033, 72034, 72036, 72037, 72051, 72053, 72054, 72055, 72059, 73011, 73024, 73025, 73046, 73060, 73061, 74013, 74021, 74022, 74026, 74033, 74034, 74053, 74057, 74075, 74076, 74077, 74080, 75013, 75034, 75042, 75048, 75049, 75053, 75058, 75059, 75060
Vibration	67068, 67069, 68067, 68068, 69043, 69044, 69065, 69066, 70046, 70048, 71038, 71043, 72053, 72054, 72057, 72058, 72059, 73038, 73042, 74030, 74031, 74032, 74033, 74034, 74053, 74057, 74058, 74089, 75019
Stress analysis	67061, 67065, 67066, 69041, 73035, 73063, 73064, 73073, 74021, 74084, 75029
Transient phenomena	67065, 67066, 68052, 72042, 75015
Simulation Mass transfer	70025, 70033, 70034, 70035, 70037, 70056 74028, 74076
Material	67003, 67083, 68004, 68047, 68048, 69031, 69049, 70045, 71025, 71037, 71049, 72030, 72031, 72039, 73029, 73044, 73059, 74004, 74010, 74019, 74046, 74054, 74073, 75032, 75045, 75048, 75049
Efficiency	67037, 67084, 68035, 70020, 72015, 75010
Cost	72030, 72031, 72044, 73047
Optimization	67027, 68009, 69021, 71022, 71031, 72014, 73015, 73017, 73018, 74011, 74018, 74037

表 3-7 内容別文献の索引 (続)

contents	index
Inspection	67046,67060,67072,68046,69055,69064,69065,69066,69067,70047, 70053,70060,70062,71036,71040,71027,71028,71029,71057,71040, 71047,72032,72055,72048
Leak	67047,67079,68078,69068,71020,71039,71055,71056,72038,73037, 74027,75018
Corrosion	67003,67004,68048,70003,70055,72002,72003,73004,73037,73046, 73062,74010,74023,74062
Deposit, Fouling	67057,67078,69038,71002,72046,72047,73031,73049,73062,75024

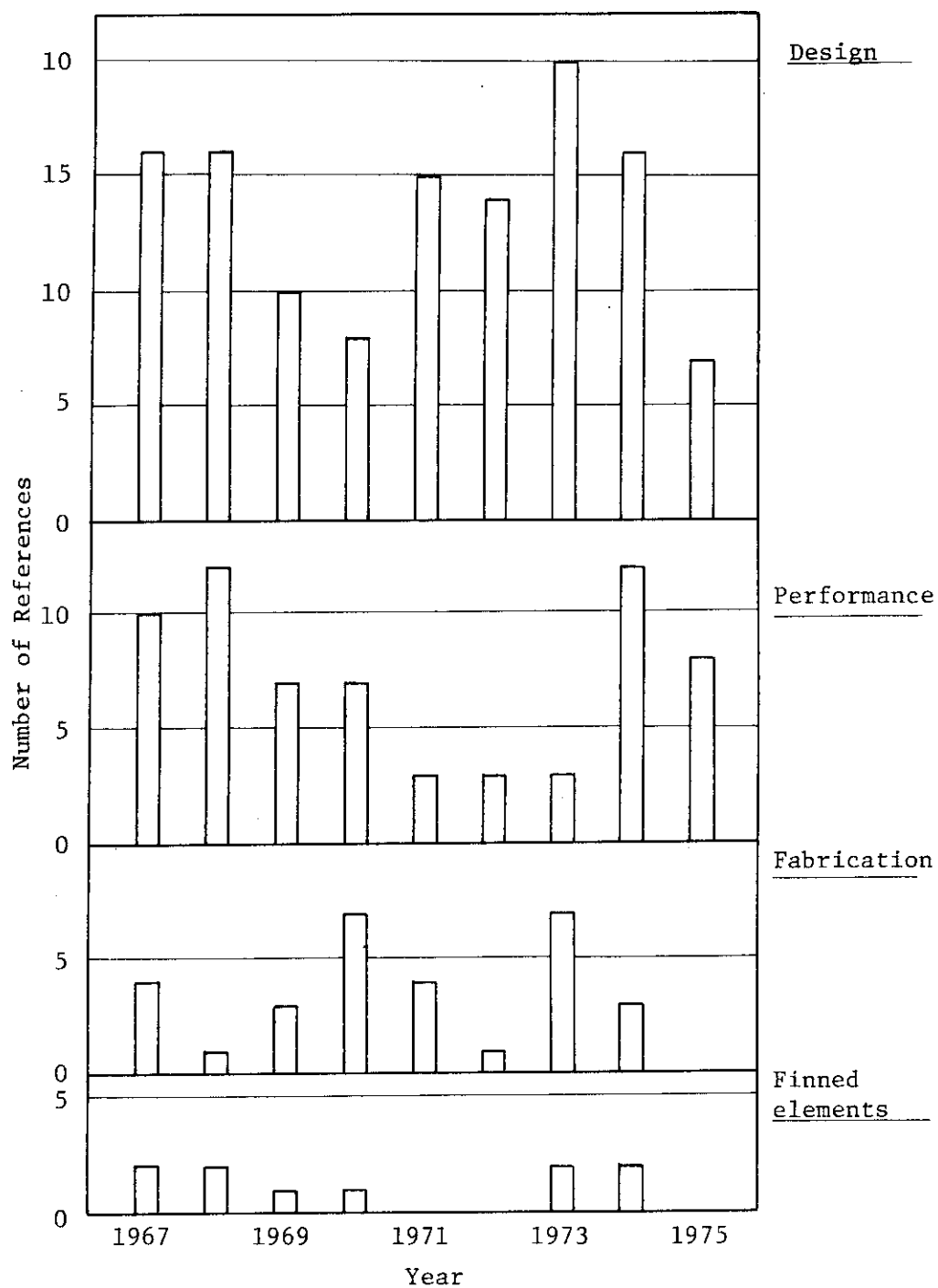


図3-4 内容別文献数の年代別変化

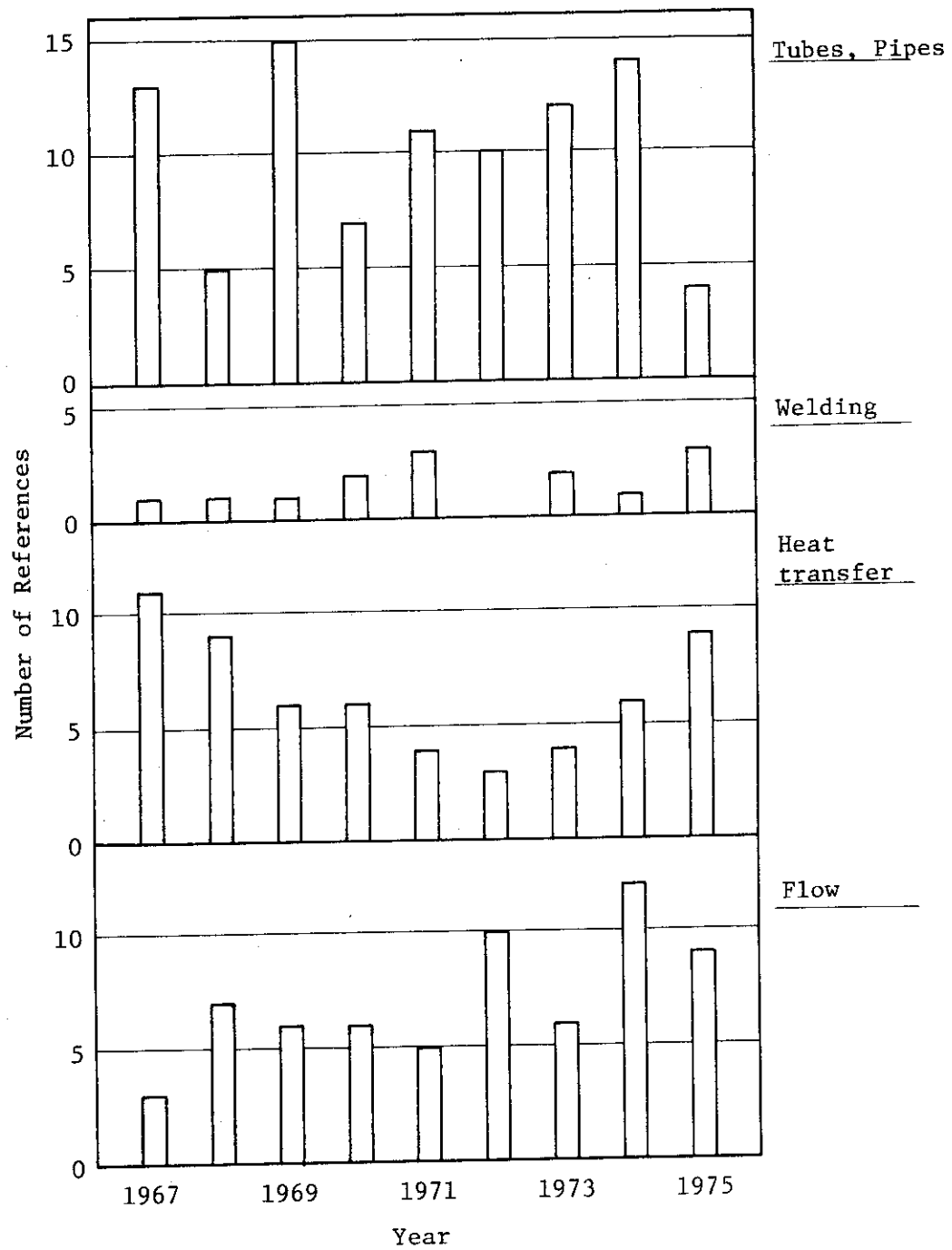


図 3-4 (続)

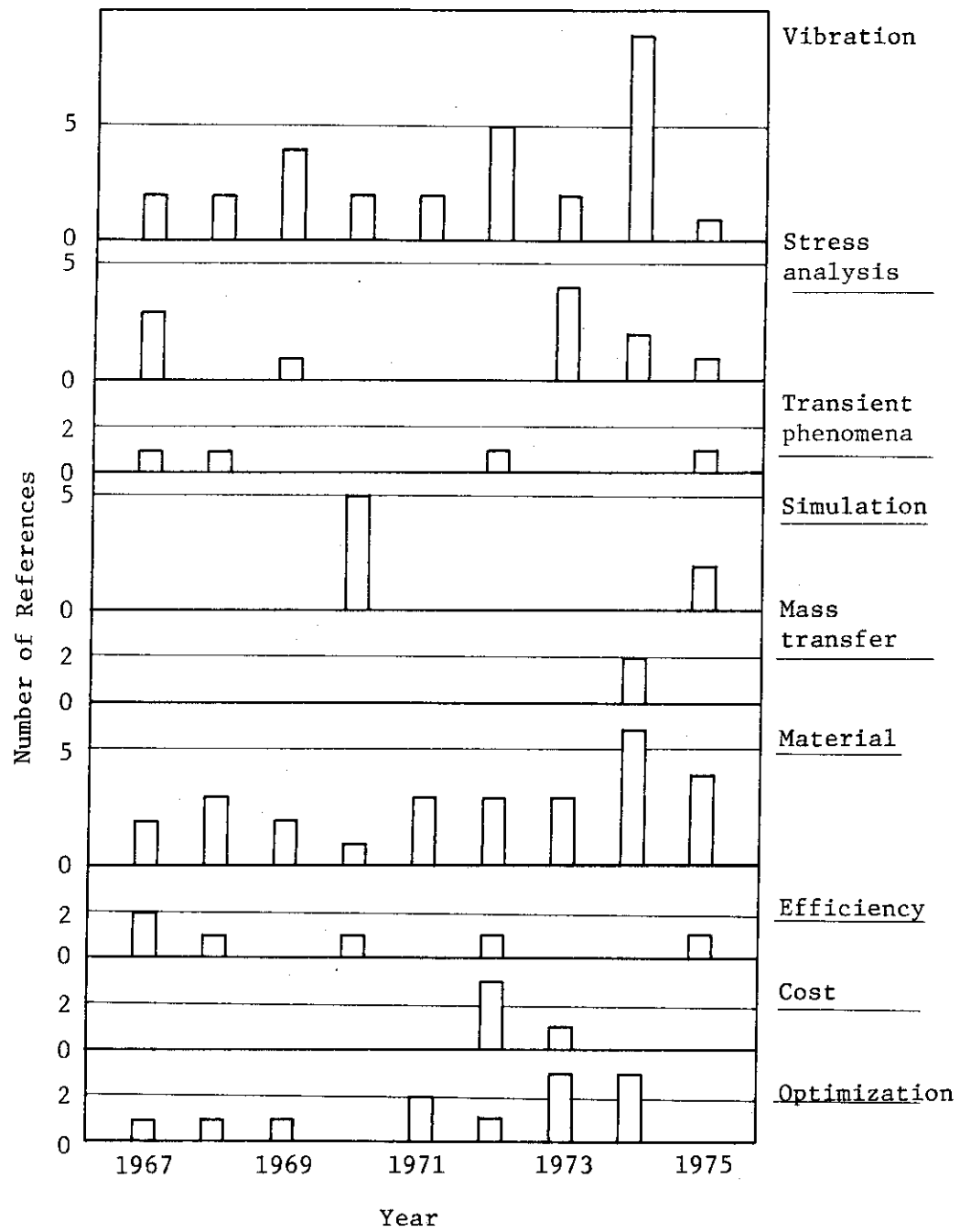


図 3-4 (続)

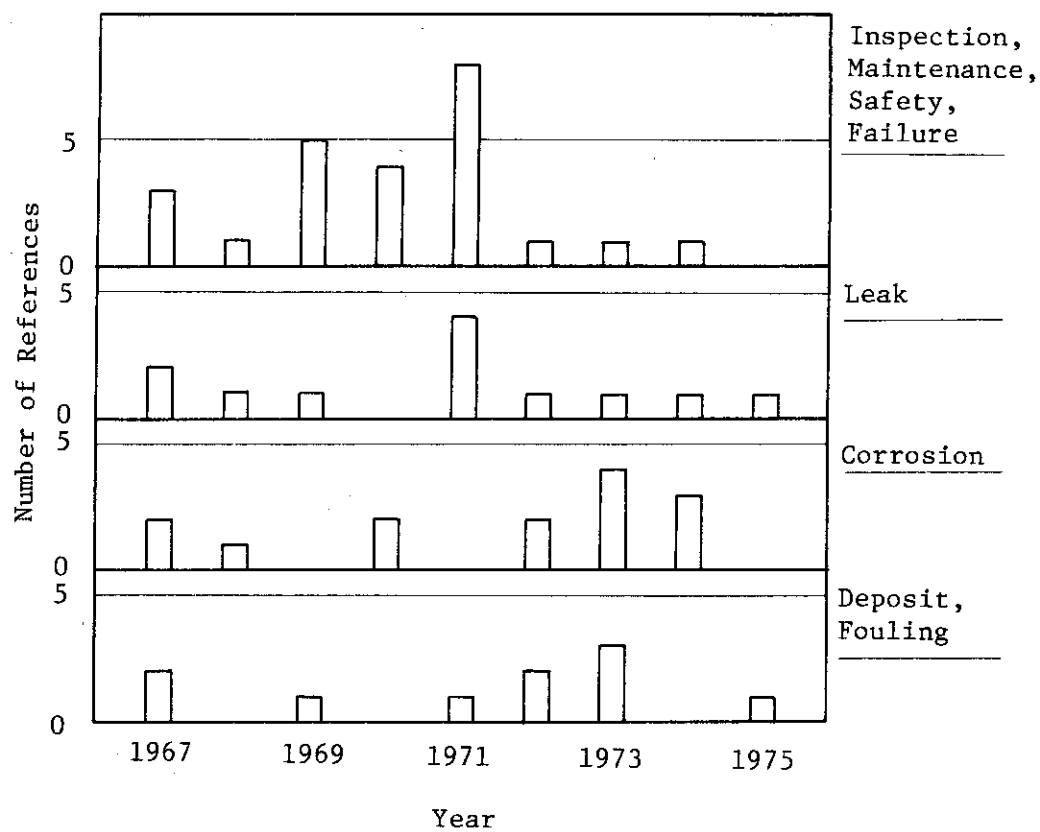


図 3-4 (続)

表5-1 HTGRに関する主要テーマ別文献数

年 度 contents	1967	1968	1969	1970	1971	1972	1973	1974	1975	1976	総 計
Design	1 (3)		(5)	1 (4)	(4)	(1)	(1)	3 (1)	(1)	(1)	5 (21)
Performance	(1)	(2)		(1)			(1)		2	1	3 (5)
Fabrication		(1)		1	(1)						1 (2)
Development	(1)				(1)						(2)
Material		1		1	(1)		(1)	3 (1)	1 (2)	(1)	6 (6)
Corrosion		1 (1)		1 (1)	(1)	1	1		(1)	(1)	4 (5)
Heat transfer				4	1	1	(1)	(1)	4 (1)	1	11 (3)
Contamination							1				1
Cost							1				
Flow-stability	(3)		(1)	(1)			1	(2)	1 (2)		2 (9)
Flow	(1)		(1)	1		1		(1)	(1)		2 (4)
Vibration	(2)		(2)			(1)	1	(2)	(1)		1 (8)
Welding			(1)	(2)	(1)						(4)
Optimum			1		(1)						1 (1)
Deposit						(2)					(2)
Safety	1			1					(1)		2
Testing	(1)	(1)	(2)	1			(1)				1 (5)
Hydrogen permeation						(1)			2		2 (1)
Gas turbine			1					1			2

() 内は Steam generator 項より抽出した文献数

表 5-2 HTGR 用熱交換器に関する文献の内容別索引表

contents	index
Design	67006, 70052, 74007, 74014, 74067, (67003, 67022, 67036, 69010, 69031, 69025, 69043, 69074, 70009, 70015, 70027, 70024, 71022, 71025, 71019, 71023, 72029, 73009, 74013, 75093, 76017)
Performance	75021, 75022, 76036, (67067, 68079, 68080, 70094, 73078)
Fabrication	70052, (68076, 71025)
Development	(67036, 71036)
Material	68048, 70031, 74004, 74067, 74073, 75032, (67075, 71087, 73009, 74114, 75005, 75084, 76007)
Corrosion	68048, 70055, 72003, 73004, (68058, 70104, 70105, 71092, 75084, 76007)
Heat transfer	70049, 70050, 70053, 70052, 71046, 72055, 75014, 75016, 75043, 75045, 76026, (73052, 74052, 75103)
Contamination	73045
Cost	73047
Flow- stability	73024, 75014, (67003, 67074, 67075, 69050, 70052, 74052, 74134, 75103, 75105)
Flow	70026, 72055, (67051, 69005, 74052, 75103)
Vibration	73004, (67074, 67075, 69083, 69084, 72093, 74034, 74035, 75039)
Welding	(69098, 70104, 70105, 71092)
Optimum	69021, (71023)
Deposit	(72015, 72098)
Safety	67006, 70053, (75053)
Testing	70041, (67036, 68079, 69083, 69084, 73052)
Hydrogen permeation	75032, 75045, (72098)
Gas turbine	69021, 74007

() 内は Steam generator 項中の索引番号

表 5-3 HTGR および 炉全体における主要テーマ

テ　　マ	HTGR	炉 全 体
	文 献 総 数	文 献 総 数
Flow, Flow-stability	17	64
Heat transfer	14	56
Material	12	27
Vibration	9	29
Corrosion	9	14
Welding	4	14

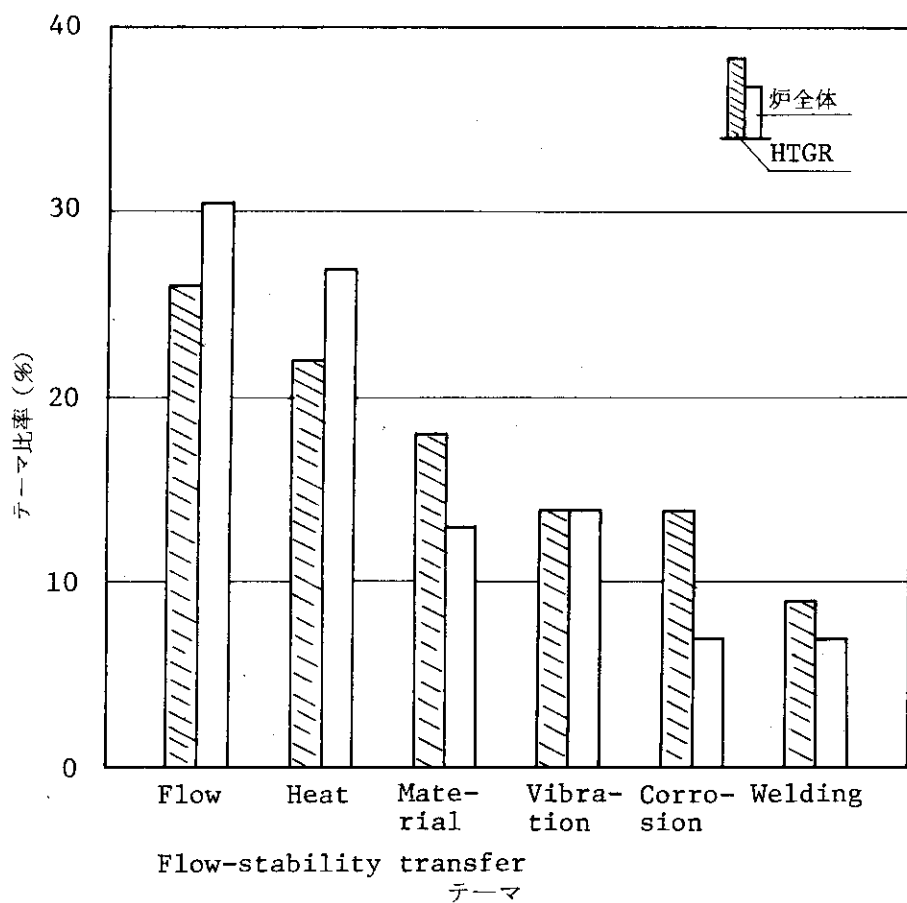


図 5-1 HTGR と炉全体における 6 テーマに対する各テーマの比率と比較

表 5-4 HTGR 用熱交換器に関する文献で扱われた問題点一覧表

分 類	研 究 テ ー マ	分 類	研 究 テ ー マ
冷 却 材	① 高温下での物性値 (He, He-空気混合ガス, H ₂ O) ② 金属材料との適合性	流 れ	① 流れの不安定性解析, モデル試験 ② 流体振動抑制のための流れの均一化を企ったデザイン ③ 流れの速度, 温度分布測定
材 料	① 伝熱管材料の高温 He 中での高温強度特性と耐食性を備えた金属材料の開発 ② 溶接性 ③ 冷却材と金属材料との適合性 ④ セラミック材料の使用 ⑤ 輻射の影響 ⑥ 耐水性透過性金属材料	溶 接	① 溶接性
腐 食	① 耐腐食金属の選定, 開発 ② 腐食防止対策 (LiOH の混入, 流れの均一安定化, 熱伝達の均一化) ③ 伝熱管の振動によるフレッキング問題 (振動の抑制, サポートの改良) ④ 応力腐食による伝熱管の欠損の処置 (材料交換)	溶 着	① 高温化の侵炭問題
熱 伝 達	① 作動媒体の選定 (Ne, He, CO ₂) ② 高温下での物性値 (He, 混合ガス) ③ 熱伝達の均一化 ④ 伝熱促進技術 (フィン付伝熱面) ⑤ 輻射の効果 ⑥ 高温, 高圧 He 中での熱伝達性能試験 ⑦ ヘリカルコイルチューブ式熱交換器の性能試験 ⑧ 蒸気発生器の膜沸騰熱伝達時の安全マージン評価 ⑨ 伝熱面の縮小化	安 全	① 製作, 建設時の安全要求 ② 保守と検査 ③ 遠隔操作機器の開発 ④ 膜沸騰時の安全マージン評価 ⑤ 伝熱管の寿命評価 ⑥ 過渡現象の予測計算 ⑦ 伝熱管ブラギング装置
振 動	① 耐震設計 ② 数学的振動モデル (空力, 音響, 地震による起因力を考慮) を用いた解析とモデル試験 ③ 流体振動によるフレッキング問題, 防止策 ④ 流れの安定性, 均一性を企るデザイン	水素透過	① 水素透過特性試験 ② 水素除去方法 (チタンスポンジ) ③ 水素透過防止方法 (コーティング) ④ 新型熱交換器 (液体金属介在型)
		汚 染	① 二次系への P P 混入による汚染評価
		ガスタービン	① 直接ガスタービンクローズサイクルの設計, 検討 ② 作動流体の選定 (He, Ne, CO ₂)
		高温高圧ループ	① 実証運転 (高温機器の性能, 信頼性)
		設 計	① 蒸気発生器のプラント内配置問題 ② ヘリカルコイルチューブ ③ 熱伝達, 流れの均一化 ④ 伝熱面の縮小

付 録 A

Heat exchangers 1967 Vol. 21

67000	HEAT EXCHANGERS see also Boilers see also Heat Transfer see also Radiators			
1	construction and control methods for graphite-gas, review of, 21:17499	仏	CO ₂	Marcoule Chinon(GCR)
2	coolant-duct seals for, design of, 21:8007(P)	英		
3	corrosion of metallic, effects of heat transfer phenomena on, 21:39553	英		
4	corrosion of sodium--water, 21:30972		Na	
5	design and fabrication for Delft Molten Salt Project, 21:43087 (DMSP-G-8)	オランダ		
6	design and performance of AVR, 21:12173	西独	He	AVR
7	design for 250 MW(e) heavy water reactor, 21:4650	西独	重水	HWR
8	design for dissipating accelerator heat, engineering drawings for, 21:6122	米		
9	design for gas-cooled reactors, 21:46909(P)			GCR
10	design for liquid sodium loop for operation at 800°C, 21:30969	オーストリア	Na	
11	design for organic cooled reactors, 21:21709	伊	有機材	
12	design for power reactors, 21:31992(P)			
13	design for steam generators using liquid metals as heating media, 21:36257(P)			液体金属
14	design for studying heat-transfer properties of liquid metals, 21:41588	仏	IHX SG	液体金属
15	design for use with reactors, 21:23776(P)			
16	design of bellows-free piping system for, for sodium Components Test Installation, 21:6128 (NAA-SR-Memo-12018)	米	Na	
17	design of circular cross-section, 21:1498(P)	英		
18	design of coolers for use with reactor loading machines, 21:32045(P)			
19	design of double-pipe, mathematical analysis for, 21:43146	米		
20	design of improved, for nuclear power plants, 21:43127(P)			
21	design of improved, to transfer heat from hot gaseous fluids, 21:8525(P)	米		
22	design of liquid metal, using double tube arrangement and intermediate heat transfer fluid, 21:17763(P)			
23	design of movable, for gas-cooled reactors, 21:5668(P)			GCR
24	design of sheath duct, for sodium or other liquid metals, 21:39101(P)		Na, 液体金属	
25	design of shielded, for gas cooled reactors, 21:40648(P)			GCR
26	design of silver and lithium vapor, for use in space reactor, engineering drawings for, 21:10526	米		スペース
27	design of SNAP-8, optimization of, 21:44916 (N-67-22845)	米		SNAP-8
28	design of stainless steel-lined zirconium alloy, for pressurized-water reactors, 21:46976(P)			PWR
29	design of vortex flow, 21:39109(P)			
30	development of cryogenic fluid, for nuclear rocket propulsion systems, 21:43131 (LA-DC-8716)	米		

31	development of finned tubes for, for increased thermal exchange surface, 21:10520(P)			
32	dynamics of double tube, 21:28156 (SGAE-RT-9/1967)	西独		
32	effect of velocity field on dynamic behavior of double tube, 21:28156 (SGAE-RT-9/1967)	西独		
33	equipment for supporting, design of, 21:31987(P)			
34	fabrication of, for potassium cooling systems, 21:4919 (ORNL-TM-1600)	米	K	
35	finned tubes for, design of tapered, 21:19829(P)			
36	heat transfer analysis of MSRE, 21:35627	米		MSRE
37	heat transfer efficiency of, effects of heating wall calefaction spots on, 21:41138	仏		
38	heat transfer in double-pipe, liquid metal, 21:36781 (BNL-50054)	米	液体金属	
39	heat transfer in longitudinal laminar flow in, effect of flow rate on, 21:229	チェコ		
40	heat transfer in tube, (T), 21:43098(T) (AEC-tr-6893)	米		
41	heat transfer in two-phase flow in, use of differential equations for analysis of, 21:30610 (EUR-3459.e)	コーラトム		
42	heat transfer measurements in double-pipe, 21:31898(R) (ANL-7329)	米		
43	heat transfer to finned surfaces in, 21:4665	日		
44	heat transfer to water in 180°-bent tube bundles of, 21:43144	英		
45	heat-transfer rates in, for liquid-metal systems, design improvements in, 21:30624	米	液体金属	
46	inspection of thin-walled tubes for, use of eddy currents, infrared radiation, and ultrasonics for, 21:10557 (BNWL-SA-404)	米		
47	leakage control methods in dual-purpose boiling water reactors, 21:21750 (ACNP-65568)	米	水	BWR
48	mounting method for, in pressure vessels, 21:2863(P)			
49	performance evaluation of, use of Sodium Components Test Installation for, 21:35590(R) (UNC-5182)	米		Na
50	performance evaluation program for sodium-cooled reactors, 21:2830(R) (UNC-5162)	米	IHX, SG	Na
51	performance of cryogenic-fluid, using Teflon-lined tubes, 21:41098 (LA-DC-8659)	米		
52	performance of liquid sodium, 21:23622(R) (UNC-5166)	米	IHX, SG	Na
53	performance of MOSEL, calculations of, 21:27685 (JUL-422-RG)	西独	IHX, SG	
54	performance of sodium-cooled, for reactors, 21:25637(R) (UNC-5174)	米	IHX, SG	Na
55	performance of, conference on, 21:41118	米		
56	performance of, effects of exchange surface roughness on, 21:43136	ソ		
57	performance of, effects of surface fouling on, 21:41116	英		
58	pressure-tube support design for reactor, 21:46978(P)			
59	review of 1966 literature on, 21:41119	英		
60	safety device design for system of, 21:23677(P)			
61	steel plates for, determination of stresses in, 21:32868(T) (WAPD-Trans-54)	仏		

62	testing for quality of Hanford Reactor, method for nondestructive, 21:36296 (BNWL-SA-901)	米		Hanford炉
63	testing of double-pipe, 21:23589(R) (ANL-7308)	米		
64	testing Teflon tubes for cryogenic, 21:41098 (LA-DC-8659)	米		
65	transient dynamics and thermal stress analysis of, for nuclear rocket, 21:12574 (N-66-39722)	米		ロケット
66	transient thermal stress analysis of, method for, 21:6129 (NAA-SR-Memo-12129)	米	IHX,SG	
67	tube bundles for, design of support system for, 21:43114(P)			
68	tube vibration and repair in HFBR, 21:35732	米		HFBR
69	tube vibrations in HFBR, repair of, 21:38658 (BNL-11585)	米		HFBR
70	tubes for, design of finned, 21:19512(P)			
71	tubes for, design of grooved-profile, 21:36255(P)			
72	tubing for, ultrasonic inspection of tapered, 21:245	米		
73	use in isotopic heated thermoelectric generator, 21:3223(P)			
74	use of radioisotopic, for attitude control engine, 21:8551(P)			
75	welding methods for, 21:4920	英		GCR
76	HEAT EXCHANGERS (GAS-GAS) mass exchange in low-temperature MHD, 21:9362	ソ		MHD
77	HEAT EXCHANGERS (GAS-LIQUID) design and fabrication of, for high pressure system, 21:41115	英		
78	fouling in dust suspension cooling systems, use of graphite powder in carbon dioxide gas in studies of, 21:17772 (AEEW-R-509)	英	CO ₂	
79	leak protection system for reactor, 21:1183(T) (ORNL-tr-1309)			
80	performance testing methods for, 21:41117	英		
81	HEAT EXCHANGERS (LIQUID-LIQUID) design for 1000 MW(e) fused-salt breeder reactor, 21:40570 (ORNL-TM-1545)	米		MSBR
82	design of 30-MW sodium, for reactor cooling system, 21:15640 (APAE-112(Vol.1))	米	IHX,SG Na	
83	development for metals, 21:30093(R) (ANL-7317)	米		
84	heat transfer efficiency in, with countercurrent turbulent liquid-metal flow, 21:40694 (ANL-7349, pp 92-109)	米		液体金属

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68000	HEAT EXCHANGERS see also Boilers see also Heat Transfer see also Radiators			
1	afterheat generation in MSBR fuel loop, 22:7816(R) (ORNL-TM-2057)	米		MSBR
2	analysis of high temperature liquid carbon--niobium-- uranium alloy, for high pressure hydrogen, 22:49022	米		
	analysis of high temperature liquid carbon--uranium-- zirconium alloy, for high pressure hydrogen, 22:49022	米		
3	annular geometry in, heat transfer for fully developed turbulent flow in concentric, 22:16765	米		
4	brazing alloys for shell-and-tube type, review of, 22:45758	力		
5	cell structure of, effects on burnout of, 22:227(P)	米		
6	cladding process for, arc strip, 22:15164			
7	configuration of power reactor multiple hairpin-loop pressure vessel-enclosed, description of, 22:48706(P)	英		
8	construction for gas-cooled graphite-moderated power reactors, standards for steel, 22:30183			GCR
9	control by feedback optimization in, description of outlet coolant temperature dynamics system for, 22:20948			
10	control valves in large water-to-hydrogen, interactions with oscillations, 22:45241 (LA-DC-9781)	米		H ₂ -H ₂ O
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