

# Arc Flash Basics: Testing Update

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**Abstract:** Arc flash hazard calculations used to predict the magnitude of the heat hazard are based on tests with open-tip vertical electrodes in enclosures. Arc ratings for PPE are developed using opposing vertical electrodes. Tests with electrode configurations that forced the arc plasma jets outward from the box yielded significantly higher heat energy measurements. When placed within this directional plasma flow, protective flame resistant (FR) fabrics yielded significantly lower arc ratings.

**Keywords:** arc flash hazard, current-limiting fuses, electric fuse, current limitation, arc rating, ATPV

## 1. Introduction

The last 15 years have seen tremendous progress being made in protecting workers against the heat energy associated with arc flash. Research into such injuries in the United States during the 1990's showed that over 2,000 workers were admitted to burn centers each year. One major area of improvement has been the steps taken to get workers into safer clothing. The arc rating system developed by ASTM and the development of the predictive equations identified in NFPA 70E and IEEE 1584 have been instrumental in this effort.

At the center of these developments has been arc flash testing. The arc thermal performance value (ATPV) of electrical personal protective equipment (PPE) relies on arc flash tests performed in a high power test lab. The IEEE 1584 equations were developed empirically from arc flash tests performed in North American test labs from the late 1990s through 2002.

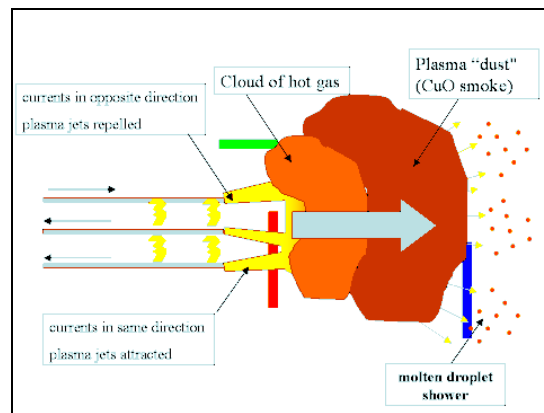
Recent research into arc flash phenomena, however, indicates that workers could be under-protected against the heat generated during an arc flash event. Test results presented at IEEE conferences [1-3] and at the 2007 IEEE Electrical Safety Workshop show that different configurations of electrodes (conductors) yielded heat energy higher than current predictions due to the directional nature of the arc development. Additionally, initial tests of PPE, when placed within this directional plasma flow, did not provide the level of thermal protection predicted by its Arc Rating as determined by the ASTM test method.

## 2. Directional nature of arc development

Unrestricted high-current arcs move according to magnetic forces to increase the area of the current loop. Currents flowing in the opposite direction in parallel conductors give rise to forces that drive the arc away from the source to the end of the conductors

where they typically burn off the tips of electrodes (busbars).

The behaviour of a 3-phase arcing fault in equipment is very chaotic, involving rapid and irregular changes in arc geometry due to convection, plasma jets and electromagnetic forces. Arc extinction and re-ignition, changes in arc paths due to restriking and reconnection across electrodes and plasma parts and many other effects add to this chaotic nature and make it difficult to create equations for accurate predictions of its properties (e.g. impedance). Although it does not capture this chaotic behaviour, Fig. 1 demonstrates an arc's general directional nature. The alternating 3-phase current creates successive attractive and repulsive magnetic forces, dramatically moving the plasma jets which feed an expanding plasma cloud. The cloud is driven outward, away from the tips, creating "plasma dust" as the highly energized molecules in the plasma cool, and recombine into various materials. The molten electrode material ejected off the tips also is in this flow.



**Fig. 1:** The general directional nature of an arc; this depiction does not reflect chaotic behaviour.

## 3. Arc flash hazards

When the arc is being established, current begins passing through ionized air generating massive

quantities of heat. Large volumes of ionized gases, along with metal from the vaporized conductors, are explosively expelled. As the arc runs its course electrical energy continues to be converted into extremely hazardous energy forms. Hazards include the immense heat of the plasma, radiated heat, large volumes of toxic smoke, molten droplets of conductor material, shrapnel, extremely intense light and a pressure wave from the rapidly expanding gases.

Recent tests have shown that an object in the expanding plasma cloud (refer to the red object in Fig. 1) is directly exposed to the highest heat of the event. Temperatures greater than 15,000 C have been cited for this area. In addition to the convective heat transfer from the plasma, this object is directly exposed to the molten metal ejected from the electrode tips and radiated heat from surrounding plasma.

Objects close to the arc but outside of the plasma jets (refer to the green object in Fig. 1) are not likely subjected to as high a quantity of heat. Exposure is predominately radiant heat, but includes convective flow from the thermal expansion of the gases. Objects in line with the electrodes but distant from the plasma jets (refer to the blue object in Fig. 1) receive lower convective heating and less radiant heat and molten metal spray.

The amount of heat absorbed varies with the method of heat transfer and receiving surface properties. For example, the amount of heat transferred from a mass of molten copper to a surface area would be greater if it adhered to the object instead of contacting it for a brief time.

## 4. Current test setups used for standards

Although the overriding principle of electrical safety is to de-energize equipment and place it into an electrically safe condition prior to work, there are numerous cases where companies put workers in PPE to perform tasks on energized equipment. The standards typically utilized to predict the magnitude of heat exposure and the protective ability of flame resistant (FR) fabric worn by exposed workers are based upon two unique electrode configurations in their test procedures as explained below. Heat transferred during tests with these orientations is most likely dominated by radiant heat.

### 4.1. NFPA 70E

First issued in 1979, NFPA 70E, Standard for Electrical Safety in the Workplace [4] covers the full range of electrical safety issues, from work practices to maintenance, special equipment requirements and installation. In the 1995 edition, arc flash hazards were first addressed with the addition of "arc flash

hazard boundaries," with the equations based on arcs in open air. "Arc-in-a-box" equations were added to the 2000 edition as options to calculate a worker's potential heat energy density exposure. These equations came from results of arc flash tests with a steel box and vertical electrodes with open tips [5-6] as shown in Fig. 2. The 2004 edition added the IEEE 1584 equations below.

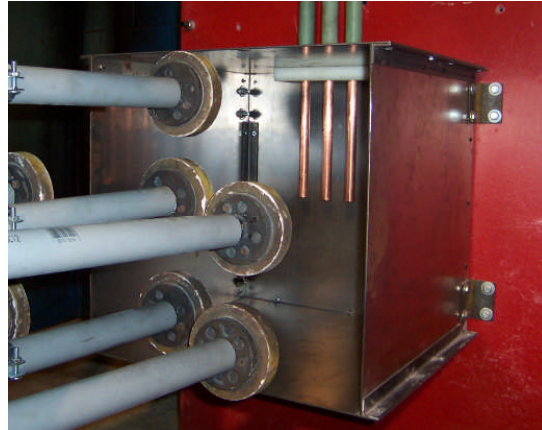


Fig. 2: Open-tip vertical electrode configuration

### 4.2. IEEE 1584

Issued in 2002, IEEE 1584<sup>TM</sup>-2002, Guide for Arc Flash Hazard Calculations, [7] provides guidelines for an analysis to "identify the flash-protection boundary and the incident energy at assigned working distances throughout any position or level in the overall electrical system." The results from over 300 arc flash tests were incorporated into the low-voltage predictive equations for enclosed equipment contained within IEEE 1584. Three enclosure sizes were used in these tests, but all tests also used the vertical electrodes with open tips shown in Fig. 2.

### 4.3. ASTM 1959

The current edition of ASTM F1959, Standard Test Method for Determining the Arc Rating of Materials for Clothing, [8] uses a single phase opposing electrode vertical orientation. This standard test method determines the arc rating of material used in arc rated PPE. The test procedure places materials in locations surrounding the area where the open air arc is initiated. The majority of the heat transferred to the material is likely radiated from the arc. This open air arrangement from the 1980s would simulate flashovers on overhead power systems.

## 5. Effects on heat measurements with alternate test configurations

Research performed at Ferraz Shawmut's High Power Test Laboratory has uncovered electrode

configurations that project significantly more heat energy out of enclosures toward worker locations than currently predicted by the standards. To simulate components found in low-voltage electrical equipment, various setups were created for controlled testing. Heat was measured and compared with predictions of IEEE 1584 for switchgear. Results of these comparisons were published in two recent IEEE papers. [2-3] Configurations that forced the arc's plasma jets outward toward the worker produced heat measurements nearly twice those predicted by current IEEE 1584 equations when studied at typical working distances of 18 inches.

All arrangement described below are variations of an arrangement described in IEEE 1584 [7]. These test setups used a 508mm x 508mm x 508mm steel box with one side open. 3-phase arcing tests were conducted at 208V, 480 V and 600V. The gap between electrodes was 32mm and the distance between the electrodes and the back of the box was 102mm. Incident heat energy was measured with an array of 9 copper calorimeters as described in the IEEE 1584 test procedure. Photographs of the arcs were captured from video taken with a FASTCAM high-speed camera, at up to 10 000 frames per second. The station back up breaker was typically set at 6 cycles to limit arc duration.

### 5.1. Vertical Configuration

In the vertical configuration setup used in the IEEE1584 test program, the electrodes entered the box from the top. The electrode tips were open and 254 mm from the bottom of the box. This setup simulates equipment where bussing is vertical and open-ended such as a main-lugs power panel.

The arc development, similar to that described for Fig. 1, will be downward toward the bottom of the box in this case. As described in [2], there is an outward convective flow due to the thermal expansion of the gases and not magnetic forces. Photo of the arc development is shown in Fig.3. Most tests resulted in heat measurements consistent with the predicted levels of IEEE1584.



Fig. 3: Front view of arc development from vertical test 3ms into event.

### 5.2. Barrier Configuration

In the barrier configuration, the electrodes of the vertical setup are "terminated" into a block of

insulating material (barrier) as shown in Fig. 4. This setup represents conductors connected to equipment fed from the top.

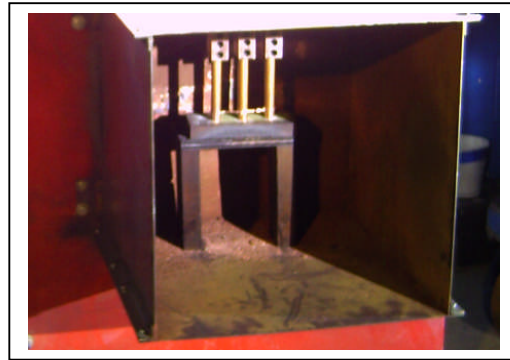


Fig. 4: Barrier test configuration simulating the line side connections of top fed equipment.

With the barrier in place, the arc's downward motion is halted and plasma jets are formed along the plane of the barrier top surface (i.e. perpendicular to the plane of the electrode). [3] This significant finding is demonstrated in Fig. 5. The photo on the top shows a side view of arc development along the plane of the barrier in a setup without side panels. The photo at the bottom shows the same test but recessed in the box. This test shows the possibility of higher convective heat transfer toward workers than the open vertical setup. The barrier configuration also ejected significantly more molten electrode material.

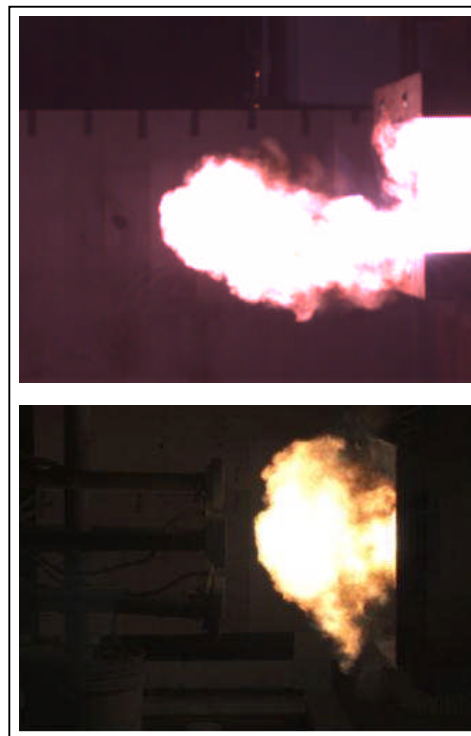


Fig. 5: Side view of arc development from barrier tests 4ms into a 42kA, 480V event. Open configuration (Top) and in a enclosure (Bottom)

Chart 1 compares heat measurements with the barrier setup to standard predictions. The black line represents predictions of IEEE 1584 equations for switchgear (508mm cubic box) for the available fault currents with a fixed 6-cycle clearing time. Alarmingly, the barrier test results almost always rose above the line--*sometimes more than twice the prediction.*

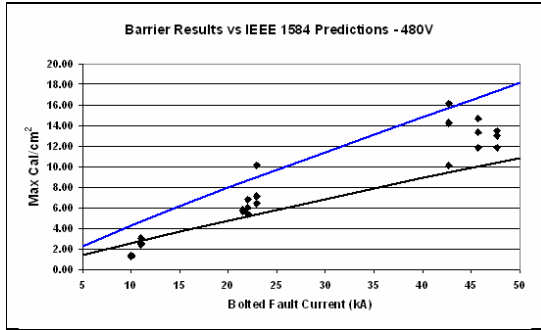


Chart I: Comparison of barrier results to predictions of IEEE 1584 equations for switchgear. The black line represents prediction; the blue line is 167% of the prediction.

### 5.3. Horizontal Configuration

Another configuration that deserves serious consideration is the “horizontal electrode configuration.” This setup simulates equipment where bussing is open-ended, but pointing toward the front of the enclosure, like that in the equipment shown in Fig. 6.



Fig. 6: The horizontal test setup was designed to simulate rear-fed equipment like this unit.

When the electrodes are horizontal and fed from the back, the arc development is very similar to that described for Fig. 1 and is shown in Fig. 7. In the top picture of Fig 7 the electrodes were brought to the front of the box, clearly showing the plasma jets formed on the tips of the electrodes. In the bottom picture, the electrodes were moved to 104 mm from the back of the box. Although the plasma jets are not visible there is a greater outward flow, since the walls of the enclosure give a more focused expansion of the plasma.



Fig. 7: Side view of plasma flow at 8 milliseconds into a 44kA 600V arcing event for horizontal electrodes. Electrode tips are flush with the front of the box (T) and recessed to 104mm from the back of the horizontal setup test box (B).

Like the barrier configuration, all tests resulted in heat measurements significantly above the predicted levels. In some case, the incident heat energy density was more than three times that of the vertical tests.

Of equal concern is the fact that arcing currents were below predicted levels for this configuration (see Chart II). In some applications, clearing times will be significantly longer than expected if the arcing current is too low to operate the short circuit element of the upstream overcurrent protective device (OCPD). In these applications, the increase in arc flash heat energies will be far greater than the differences obtained in tests with a fixed clearing time of six cycles.

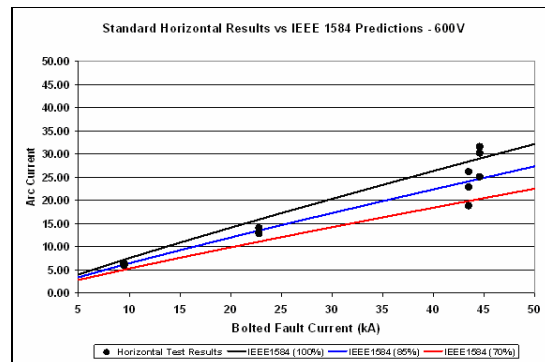


Chart II: Comparison of arc currents from horizontal tests to predictions of IEEE 1584 equations for switchgear. Note that some of the test results were below even the 85% value recommended by the standard.

#### 5.4. Tests with current-limiting fuses

IEEE 1584 has equations to predict incident energy from equipment when protected by UL Class RK1 fuses [9] and UL Class L fuses [10] with ampere ratings of 2000A and less. These equations were derived from 600V tests using the vertical configuration of Fig. 2 [7, 11]. Plots of the predicted incident energy for two fuses are shown in Chart III.

If the arc fault current is large enough for these fuses to be in their current-limiting ranges, the fuses will dramatically reduce the electrical energy delivered to the arc. Extensive testing has shown that Class RK1 fuses and Class L fuses of 1600A and less can limit incident energies to below the 1.2 cal/cm<sup>2</sup> (5 J/cm<sup>2</sup>) critical value accepted for a second degree burn.

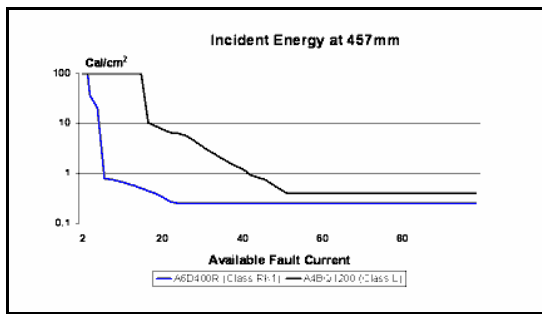


Chart III: Plot of predicted incident energies.

A number of tests with current-limiting fuses showed, with proper fuse selection, that workers would be exposed to far less heat energy even when standing in locations subject to the plasma flow from the alternate configurations (see Fig. 8). The heat measured during tests with all configurations was very close to those predicted by current IEEE 1584 equations. Plants currently employing this conservative method of protection will still need to recalculate arc fault currents and determine if fuses will be operating in their current-limiting modes for arc faults on equipment with horizontal electrodes.

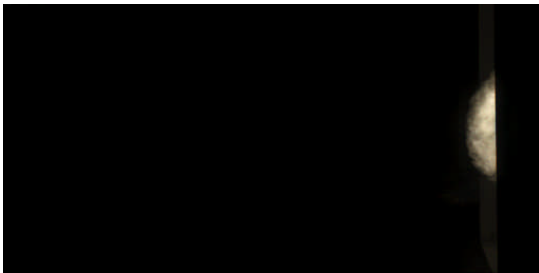


Fig. 8: Photo of maximum reach of plasma with current-limiting effect of 600A UL Class RK1 fuses. Test conditions are the same as those described in Fig. 7.

#### 6. Effects of alternate configuration tests on PPE

Preliminary investigations showed that many protective FR fabrics did not yield the same level of thermal protection when placed within the directional plasma flow for the barrier configuration. Tests were performed with FR fabric placed at 18 inches from the electrodes of the vertical, barrier and horizontal configurations. See Fig. 9 for the fabric test setup. A variety of currents and clearing times were used in these 480V tests to generate a range of heat energies for the tests.

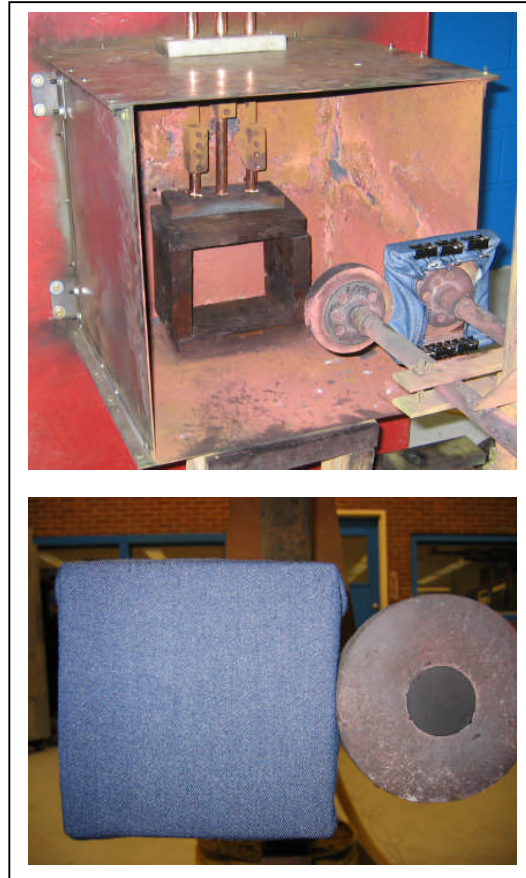


Fig. 9: (Top): Fabric test setup with barrier test. (Bottom): Front view of bare and fabric covered calorimeter.

There were surprising results with the barrier and horizontal tests, as some fabrics performed at only 50% of their arc ratings. Initial testing of the vertical configuration without the barrier also indicated that the arc rating of FR fabrics is reduced. It is suspected that greater heat transfer through the material because of the increased convective energy component is responsible for its decreased performance in the plasma-rich region of the arc. Equally surprising results were obtained for arc rated faceshields, which exhibited an increased arc rating. This would be expected since, unlike the permeable FR fabrics,

faceshields are impermeable to the increased convective energy component.

## 7. Moving forward

There are two major areas of improvement for better protection of workers against the heat of arc flash events. Both areas are related to the possibility that workers could be directly immersed in the developing plasma flow described in the foregoing text.

First, equipment configurations that would direct arc development outward need to be clearly identified and models developed to better predict the levels of heat energy that can be presented to workers from arc flashes in such equipment.

Second, the test method and a modified arc rating system for PPE need to be developed to address the reduced performance of PPE for hazards involving equipment configurations that would direct the plasma flow outward toward the worker.

Arc flash hazard analysis studies will be more important than ever. As better models of arc faults become available, users will be able to quickly update and assess situations where greater hazards will be expected.

For those who have already completed studies, it is strongly recommended that you review these studies and implement projects to mitigate the hazards wherever possible. Among other things, actions should include standardizing on UL Class J fuses and switching Class H, K and RK-5 fuses to RK-1s. Lower threshold currents provide the widest range of current-limiting operation and lowest energies. Tests with all configurations yielded results of 0.5 cal/cm<sup>2</sup> or less when these fuses operated in their current-limiting modes.

Until further testing is done, consider modifying your PPE strategy as follows. If equipment is suspected to be similar to the alternate plasma flow configurations described above, then consider the rating of protective clothing to be half the listed arc rating. When using the NFPA 70E Tables 130.7(C)(9)(A) and 130.7(C)(10) to select protective clothing and PPE, add one Hazard Risk Category (HRC) number to HRC0, HRC1, HRC2 and HRC3. For HRC4 hazards, avoid using the Tables or select PPE with a rating of at least 80 cal/cm<sup>2</sup>.

## 8. Industry action

Leading organizations concerned with electrical safety are currently investigating the results of the research outlined in this article. The IEEE 1584 working group has joined with the NFPA 70E committee to form the IEEE/NFPA joint collaborative initiative on arc flash research. The

goal of this research is to provide the information and knowledge needed to enhance safety standards that predict the hazards of arc flash events and improve safeguards for workers. The research and test planning committee has already developed a comprehensive test protocol to further quantify these findings and investigate the many other hazards of arcing events (e.g. pressure waves, sound, toxic smoke).

Additionally, the ASTM F18.65 subcommittee on Wearing Apparel has formed a task force to further study the performance of materials in the plasma flow. The task force will identify any needed modification or additions to the test protocols of ASTM F 1959F/ F1959M-06a for material performance.

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