



# **Feasibility of Energy-Efficient Distribution Transformer Manufacturing in Zambia**

## ***LEAPFROGGING TO ENERGY EFFICIENT APPLIANCES AND EQUIPMENT (REFRIGERATORS AND TRANSFORMERS) IN ZAMBIA***

**Draft Version**

**Basel Agency for Sustainable Energy (BASE)**

**International Copper Association (ICA)**

**Southern African Development Community's (SADC) Centre for  
Renewable Energy and Energy Efficiency (SACREEE)**

**September 2022**

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## List of Abbreviations

BASE	Basel Agency for Sustainable Energy
CO <sub>2</sub>	Carbon Dioxide
CRGO	Cold Rolled Grain Oriented
CTCN	Climate Technology Centre & Network
DT	distribution transformer
EE	Energy efficiency
ERB	Energy Regulation Board
GCF	Green Climate Fund
GHG	Greenhouse Gas
ICA	International Copper Association
IDC	Industrial Development Corporation
IEC	International Electrotechnical Commission
IPP	Independent Power Producer
ISO	International Organization for Standardization
kV	kilovolt
kWh	kilowatt-hour
LL	Load Losses
MEPS	Minimum Energy Performance Standards
MNDP	Ministry of National Development and Planning
MoE	Ministry of Energy
MW	Megawatt
NDA	National Designated Agency
NDE	National Designated Entity
NLL	No Load Losses
PCB	Polychlorinated Biphenyls
PV	Photo Voltaic
PWG	Policy Working Group
REMP	Rural Electrification Master Plan
SACREEE	SADC Centre for Renewable Energy and Energy Efficiency
SADC	Southern African Development Community
TCO	Total Cost of Ownership
U4E	United for Efficiency
UNEP	United Nations Environment Programme



ZABS                      Zambia Bureau of Standards

ZESCO                    Zambia Electricity Supply Corporation

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## 1 Background

Zambia is among the eight countries<sup>1</sup> in Southern Africa that have embraced a common approach for the implementation of the Green Climate Fund (GCF) Readiness projects on “Developing a national framework for leapfrogging to energy efficient refrigerators and distribution transformers”. The network partners, comprising Basel Agency for Sustainable Energy (BASE), International Copper Association (ICA), and Southern African Development Community’s (SADC) Centre for Renewable Energy and Energy Efficiency (SACREEE), are providing technical services for the implementation of the GCF Readiness project entitled *National framework for leapfrogging to Energy Efficient Appliances and Equipment in Zambia (Refrigerators and Distribution Transformers) through regulatory and financing mechanism*. The technical assistance has been executed with the Climate Technology Centre and Network (CTCN) through the United Nations Environment Programme (UNEP) as implementing institution, and United for Efficiency (U4E) as the technical partner on national frameworks for leapfrogging to energy-efficient appliances and equipment in Zambia through regulatory and financing mechanisms. The GCF Readiness project has been implemented under the guidance of Ministry of Higher Education, the National Designated Entity (NDE); Ministry of National Development and Planning (MNDP), the National Designated Agency (NDA); and the Ministry of Energy (MoE).

The objectives of the GCF Readiness project in Zambia are to improve the country programming process regarding refrigerators and distribution transformers (DTs) and strengthen climate finance strategies. Specifically, the project aims to put in place mandatory Minimum Energy Performance Standards (MEPS) and a labelling scheme, which will create an enabling policy and regulatory environment for refrigerators and DTs in Zambia. In addition, the project will include key components such as national policy roadmaps and enabling environments for the implementation of standards and labels, appropriate financing mechanisms to accelerate deployment of energy-efficient refrigerators and DTs, and strengthen national capacity to develop standards and labels for other appliances in future. This will transform the market to energy-efficient refrigerators and DTs and ultimately reduce the strain on the electricity grid, increase disposable income for householders and potentially reduce greenhouse gases (GHG) emissions.

The report aims to summarize needs of the local DT industry in Zambia in design and manufacture of energy-efficient DTs in line with international best practices and feedback from the local industry during the training session organized on 20<sup>th</sup> September 2022.

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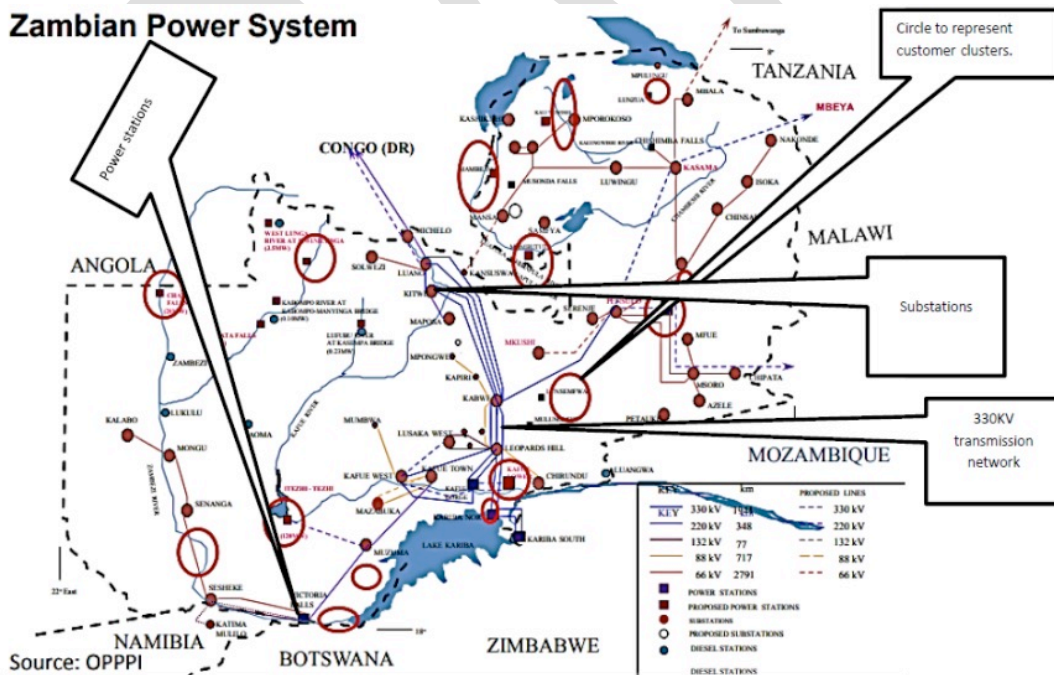
<sup>1</sup> Botswana, Eswatini, Lesotho, Malawi, Namibia, Tanzania, Zambia and Zimbabwe

## 2 Power Industry in Zambia

The power industry in Zambia has been restructured since 1994 with a focus on liberalizing and promoting private sector investment in the industry, particularly in power generation. The amendment of the Electricity Act in 1995 abolished the statutory monopoly of Zambia Electricity Supply Corporation (ZESCO), while the Energy Regulation Act of the same year established the Energy Regulation Board (ERB) as an independent regulator of the energy sector. Because of these reforms, the power sector has opened up to independent power producers (IPPs) for on-grid and off-grid transactions.

Key stakeholders in Zambia's electricity sector include ZESCO, the vertically integrated public utility, IPPs, and distribution utilities. ZESCO is a wholly state-owned enterprise through the Industrial Development Corporation (IDC), the holding company for most state-owned enterprises in Zambia. ZESCO operates under the policies established by the Ministry of Energy (MoE). ZESCO owns and operates over 90 % of the country's generation, transmission, and distribution assets and supplies electricity to all grid-connected consumers, except for some mining consumers in the Copperbelt Province, which are served by the Copperbelt Energy Corporation (CEC), a private company that purchases bulk power from ZESCO.

The ZESCO transmission grid comprises transmission lines and substations at 330 kilovolts (kV), 220 kV, 132 kV, and 66 kV, with the total length of transmission and distribution lines of 9,975 km. The CEC network consists of 220 kV and 66 kV lines, with 41 substations.



Source: (ERB, Energy Sector Report, 2019)

**Figure 2-1: Zambia's Power Network System**

In 2019, the overall electrification rate in Zambia was around 39.4% nationwide. Access to electricity in Zambia is still very low in rural areas, and it is estimated that only about 4.4% of households in rural areas have access to electricity. In contrary about 67.3% of households in urban areas are connected to the grid. Increasing access to energy is a key priority of the national development strategy and the government has set electrification targets at 90% for

urban areas and 51% for rural zones by 2030 resulting in 80% national average by 2030. However, at the current pace, it is very challenging for these targets to be achieved due to limited investment and macroeconomic growth in Zambia.

In 2019, the total installed capacity of electricity was 2,981.31 MW, representing a 2.86% increase from 2018.<sup>2</sup> The generation mix in 2019 was predominantly hydro, accounting for 80.45% of the total installed capacity. The remainder of the generation mix comprised coal (10.06%), heavy fuel oils (3.69%), diesel (2.80%), and solar (2.99%)<sup>3</sup> The country's electricity demand has been growing at an average of about 3%, or between 150 and 200 MW per year, annually based on historical data.<sup>4</sup> With an assumption of 150 MW growth in peak demand, Zambia's electricity demand is expected to double in 2030 to be over 4,500 MW, with the total installed capacity of about 5,500 MW (get-invest, 2020).<sup>5</sup>

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<sup>2</sup> ZESCO, 2020

<sup>3</sup> Energy Sector Report, Lusaka: ERB, 2019

<sup>4</sup> Zambia Energy, Zambia Development Agency, (ZDA, 2021).

<sup>5</sup> get-invest, 2020. Zambia Energy Sector\_ Market Overview. <https://www.get-invest.eu/market-information/zambia/energy-sector/>

### 3 Distribution Transformer Industry in Zambia

#### 3.1 Demand-Side and Key Players

It is estimated that more than 19,000 DTs installed in Zambia and ZESCO is responsible for the operations and maintenance of these transformers. Zambia plans to increase the national electrification rate to 80% by 2030, and the Rural Electrification Master Plan (REMP) targets increasing the electrification rate in rural areas from 3% to 51% by the year 2030. The Plan has identified a total of 1,217 Growth Centers in rural areas throughout the country for extension of the national electricity grid and installation of more DTs on the network. The main buyers of distribution transformers in Zambia include ZESCO, Copperbelt Energy Corporation and mining companies. Figure 3-1 shows projection of DT stock in Zambia from 2021 to 2040.

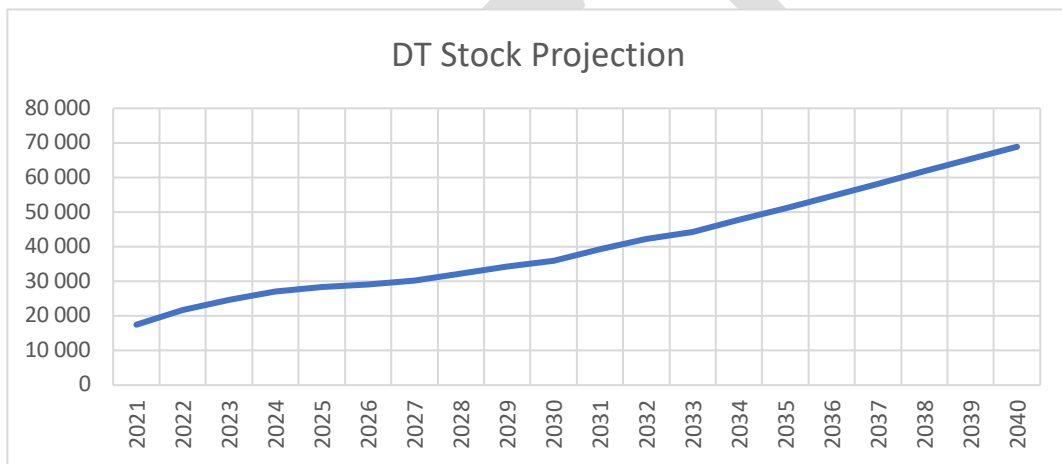


Figure 3-1: DT Stock Projection under BAU Scenario

#### 3.2 Supply-Side and Key Players

The DT market in Zambia is segmented by insulation type (oil immersed and dry-type), mounting type (pad-mounted and underground vault) and by phase. Typical DTs available on the Zambian market include dry-type DTs up to 36 kVA and oil immersed DTs from 25 kVA up to 4,000 kVA with a primary voltage up to 33 kV. Most of DTs in Zambia are imported with few local manufacturers supplying small size DTs as well as providing repairing services. Most imported DTs in Zambia are manufactured in or distributed by South African companies, accounting roughly about 69%. There are also some business ties along with competitive pricing of India and China suppliers/distributors, increased market share of imports transformer those two countries. The five key suppliers/manufacturers in Zambia include:

- Elsewedy Transformers;
- Afrizam Electrical Limited;
- Tanelec Zambia Limited;
- Marthinusen and Coutts; and
- Eugene Lottering.

Elsewedy Transformers a local manufacturer of oil immersed and cast resin DTs with capacity up to 250 MVA and voltage up to 220 kV, co-owned by Elsewedy Electric Company of Egypt and ZESCO. Elsewedy also offer services in transformer maintenance and installations. The

20,000 m<sup>2</sup> factory in Ndola, Zambia is ISO-certified and offers a one-stop shop for transformers and substation needs. Afrizam Electrical Limited is a newly registered company in partnership with Rongzhong of China which is currently supplying the Zambian market with electrical equipment such as sub stations, switch cabinets, switch gear, transformers and fuses. The company has plans to build a state-of-the-art manufacturing plant in Zambia to supplement the products they are supplying. Tanelec Zambia Limited on the other hand was incorporated in Zambia in 2013 and has been in operations in the Zambian mining services industry for over 20 years offering servicing and repair of distribution transformers. Tanelec Zambia is predominantly engaged in supply of transformer parts and repair of the transformers.

### 3.3 Procurement Practices

The IEC-60076 standard series for transformers have been adopted by Zambia Bureau of Standards (ZABS). However, Zambia has no mandatory energy performance standards for DTs but utility standard procurement specifications have included energy performance requirements for DTs, such as maximum losses or minimum efficiency. The South African standard SANS 780 for DTs has been recognized by most private firms procure these transformers from South Africa.

ZESCO procures their DTs through invitation to bids advertised in public media, while Copperbelt Energy Corporation and mining companies procure through private requests for competing quotations. ZESCO's procurement follows the national procurement procedures specified in the Public Procurement Act of 2008 and the Public Procurement Regulations of 2011. The procurement specifications for DTs, in some cases, reflects both aspects of safety and energy efficiency for DTs, such as maximum losses or minimum efficiency.

### 3.4 International Commitments on Distribution Transformer Efficiency

The amended version of the DT model regulation developed by United for Efficiency (U4E) was recommended for the implementation in all SADC GCF countries after significant PWG and TC consultations. The U4E Model Regulation Guideline 2019, on energy performance requirements for distribution transformers, requires that distribution transformers be reassessed for conformity as follows:

- Comply with minimum energy performance in terms of maximum allowed load and no-load losses
- Should not contain Polychlorinated biphenyls (PCB) contamination or other hazardous materials as defined in the relevant international, regional, and national regulations
- Product and technical information to include free access to websites of manufacturers and to durably mark on or near the rating plate of the distribution transformers
- Certification and registration to test transformer's energy performance in accordance with IEC 60076-1 and its fire performance in accordance with IEC 60076-11, for instance, for dry-type transformers and related reference test standards

## 4 Feasibility of Energy Efficient DT Manufacturing in Zambia

Energy-efficient transformers are more expensive compared with conventional, less-efficient transformers because of the higher costs associated with the use of either more or higher performance materials. The material cost of transformers is typically 80-90% of the selling price. Of the total material cost the core material cost contributes 35%-40%; conductor and insulation material costs (including oil) contribute the remaining 25%-30% and 20% respectively<sup>6</sup>. In addition, a manufacturer's production costs will also be determined to some extent by the additional investments necessary. Production of energy-efficient transformers also raises issues about the capability of raw material suppliers, however, in case of Africa, it is understood that most raw materials are imported and capability of raw material suppliers should not be an issue in Zambia.

In addition to higher cost and availability of raw materials, capabilities of manufacturers in production of energy-efficient transformers will be determined by capacity of the following three aspects: 1) human resources; 2) machinery; and 3) knowledge in design and production of energy-efficient transformers. Summarized in the table below are initial assessments of these three aspects of DT manufacturers in Zambia.

**Table 4-1: Initial Capacity Assessment of DT Manufacturers in Zambia**

Capability	Low	Medium	High
<b>Human Resources</b> – availability and skills in handling materials for production of energy-efficient transformers		X	
<b>Machinery</b> – availability and capacity of semi-automated/ automated machineries	X		
<b>Knowledge</b> – capability in design and production of energy-efficient transformers including utilization of design software	X		

Based on the above initial assessment, the main gaps in design and manufacturing energy-efficient DTs in Zambia include knowledge in energy-efficient transformer design and machineries for production of energy-efficient transformers such as wound core winding machines and foil winding machines. Assisting DT manufacturers in Zambia in development of few energy-efficient DT prototypes meeting the energy performance requirements in Zambia would help address these gaps and simultaneously identify the specific capacity building areas and overall investments needed by local DT manufacturers in Zambia. Generally, the investment required in DT design software with necessary training is about US\$100,000, and each energy-efficient DT prototype would cost about US\$10,000.

<sup>6</sup> Determination Analysis of Standards & Labeling Program for Distribution Transformers in India, 2004

## 5 Online Capacity Building and Training Session

### 5.1 Summary of Online Capacity Building and Training Session

An online capacity building and training session was organized by the GCF Readiness project and SACREEE on 20<sup>th</sup> September 2022, and this online training session aimed to build capacity for utilities, non-utility market players, Ministries of Energy, Ministry of Finance and Ministry or entity responsible public procurement on the recommended Total Cost of Ownership (TCO) and technology upgrade options for manufactures of distribution transformers. The online capacity building and training session was participated by 39 participants including policy makers and DT industry representatives from Zambia. The presentations made during the training are included as Annexes to this report, and key points of the presentations and discussions are captured below.

#### Presentation on the Total Cost of Ownership (TCO)

- The training aims to build capacity for utilities, non-utility market players, Ministries of Energy, Ministry of Finance and Ministry or entity responsible for public procurement on the recommended Total Cost of Ownership (TCO) and technology upgrade options for manufacturers of distribution transformers.
- Transformers are made of different materials (e.g., steel, aluminum and copper) and as materials change, efficient levels also changes. While transformers are expensive to purchase, they are also more expensive to own but efficient transformers have lower cost of ownership.
- TCO is the financing mechanism which helps one to understand the savings versus incremental cost of energy efficient transformers. How the decision for buying energy efficient transformers can be made. The TCO approach minimizes the total investment in a transformer over its lifetime, considering purchase price and the value of future losses also called “ loss evaluation”.
- During the TCO procurement process, the electric utility declares its loss evaluation formula with A and B factors in a monetary value per watt, for example US\$/Watt. “A” represents how much the utility values losses in the core (no load losses) and “B” represents how much the utility values losses in the coil (load losses). A is always greater than B. The A and B factors influence the transformer designs by suppliers in response to the tender, resulting in more energy efficient models, and the utility will benefit from the lower total cost of ownership.
- To help the utilities and buyers, IEC TS 60076-20 standard provides a TCO formula, and an Excel tool and a guide had been developed by U4E to promote use of TCO. U4E has also added a second TCO calculation methodology, which adds the price of a tonne of CO<sub>2</sub>. Utilities can customize the inputs such as operating hours, life expectancy, load growth, fuel costs and O&M, load profile generation mix for peak power to calculate their own A and B factors.

## Presentation on Capacity Building for Manufacturers of Distribution Transformers on Technology Upgrade Options

- DT customers can make orders with variation of requirements, and DTs are generally manufactured with a high degree of customization. Continuous optimization is necessary for DT manufacturers because the industry depends on materials and value additions. Important resources for DT manufacturing include skilled manpower, design skills, purchase skills, manufacturing skills, testing and quality assurance.
- The current DT manufacturing machineries in the market have improved drastically covering enhanced conductor winding / foil winding machine, core building / winding machine and testing set-up.
- To reduce no load losses, the magnetic circuit of DT, aka core, should provide a low reluctance flux path for the transformer to function. Design options for lower no load losses include the use of lower loss Cold Rolled Grain oriented (CRGO) steel sheets of high permeability and small thickness materials to reduce eddy current and hysteresis losses. Eddy current is further reduced by alloying the steel with silicon. The superior grades of CRGO are now available with losses up to 0.80, 0.75, 0.70 Watts/kg at 1.7 Tesla.
- Other materials used for transformer core is Amorphous metal, which is a non-crystalline substance formed as ribbons and has superior magnetic properties. Amorphous sheet is very thin compared to CRGO sheet, and the eddy current losses also are very low. However, the saturation flux density is low as compared to CRGO silicon steel and so is the case with mechanical strength against jerks during assembly and handling being softer than CRGO. Losses with Amorphous Alloy at 1.5 Tesla 50 Hz are as low as 0.325 Watts/kg, however, its saturation flux density is low as compared to CRGO and normally the designs never go beyond 1.38 to 1.4 Tesla for Amorphous core transformers, hence higher load losses.
- Old transformers have very high load losses, and, in Africa, old transformers are refurbished as opposed to getting new ones due to budgetary constraints.
- DT windings are made of high-grade copper or aluminum, which are designed to optimize thermal, mechanical and electrical stresses. The winding machines are equipped with different speed gears to ensure that proper tension is maintained on the windings. The conductors are suitably transposed at intervals to reduce the circulating current losses in winding. Different winding types are used in transformers, such as : Spiral / Layer Type winding; Helical winding; Cross-over winding; Continuous Disc winding; and Foil winding.
- Low voltage (LV) foil winding uses a single piece of thin strip as conductor with a width of the foil equal to length of the winding. This conductor strip (foil) wound along with a pre-impregnated interlayer insulation and during curing process foil and insulation are bonded together to form a rigid block. The LV coil becomes self-supporting against forces and later the coil is impregnated with resin for environmental protection. Eddy current losses in the thin foil are very small compared to thick rectangular wires, so windings made with foil are cooler than other types. Foil winding also minimizes the axial forces during short circuit, since currents in the winding are adjusted to the ampere turns in the high voltage winding.

- The construction of the Core and Coil Assembly (CCA) is significant from the performance point of the transformer. The CCA defines the insulation scheme, cooling, dynamic withstand capability, handling by providing sufficient radial and axial supports that prevents the stress from causing any damage to the windings. Clamping of the windings axially is necessary to hold the assembly firmly. Clamping structure of the assembly has supports to route the tap and line terminals, insulated vertical and horizontal strips of adequate thickness of a framework to assist the routing of terminals.
- Insulation scheme is categorized into major and minor insulation. Major insulation addresses the capability to withstand high voltages, isolation of the primary and secondary winding, clearances for voltage withstand, while minor insulation is the turn insulation, joint protection, etc. Both the major and minor insulation are equally important for the successful operation of the transformer. The thermal class of insulation depends on the Type of cooling medium.
- The significant part of the insulation used in oil immersed transformer is paper and wood based. This insulation material has high affinity to moisture which may weaken the insulation properties and reduce the insulation resistance to high voltages. Therefore, transformer windings and CCA have to undergo drying process at various stages depending on the rating and voltage class. There are two types of drying: Air drying and Vacuum drying. Air drying is used in DTs limited to voltage class below 33 kV, while Vacuum drying is predominantly used for all transformers of voltage class above 33 kV.
- The DT enclosure is generally referred to as tank and this is a fabricated structure constructed of mild steel of adequate thickness & generally rectangular shaped. The tank has two main functions: 1) To hold the CCA with proper clearances for voltage and oil flow; and 2) To facilitate cooling, safety and maintenance. The tank must be leak proof, and should withstand the specified pressure during all service as well as test conditions. Depending on heat dissipation requirements to keep the specified temperature rise requirements in test conditions and service, the transformer tank will either have corrugations or is fitted with pressed steel fin type radiator banks.
- After drying process, the CCA is inserted into the transformer tank. The CCA should stand freely inside the tank and inside clearances are to be maintained. The primary and secondary terminations are brought out through porcelain or epoxy cast bushing insulation. The transformer tank is also fitted with valves for oil filling, filtration, oil sampling, draining. Provision for safety devices like Buchholz relay, pressure relief valve, temperature recording and control instruments, neutral current transformer, protection and instrument transformer are customized features as per buyer's requirement. In a non-sealed transformers, conservator is provided for oil expansion and contraction during the operating cycle. For sealed type transformers DGPT Relay also is sometimes provided for protection. Terminal identification /marking are also done on/near the bushings.
- Transformer oil acts as cooling and insulating medium in a transformer. Generally mineral oil is used, however the mineral oil contains in transformers is environmentally harmful and synthetic and natural ester oils are also being used. The transformers being promoted in the U4E policy guidebook are the natural ester, which is derived from vegetable oil. Esters have a better insulating property and fire

performance, and it is environmentally friendly and helps to make the transformer more resilient.

- The list of essential plant and machinery are presented which covers core assembly, winding, insulation cutting, core-coil assembly and processing, tank assembly, and test equipment for electrical, mechanical and final testing before dispatching.

## 5.2 Discussion, Conclusions and Next Steps

- There is need for countries to submit request to implement technology upgrade of DTs, and SACREEE has requested all partner countries to provide input on the needs for energy efficient DT manufacturing upgrade. Zimbabwe has requested the followings: assistance in training & acquiring design software for distribution transformers; financial support for product development (prototype development and testing); and financial support for tooling / machinery costs needed to produce low loss transformers. Other country participants are encouraged to provide inputs, that SACREEE together with BASE can assist in developing a proposal for funding considering country request for phase 2.
- A question on lifespan of high and low losses DTs was raised and it was clarified that the lifespan of DTs is not dependent on low loss or high loss but the working condition. However, Amorphous core material is very delicate and poor handling during transportation and installation may impacts Amorphous DTs' lifespan.
- SACREEE will send a formal request to DT manufacturers in participating countries to indicate technical and financial resources required to implement technology upgrades to meet the proposed minimum energy standards for DTs that are included in the National Policy Roadmaps.

## 6 Annexes

### 6.1 ANNEX A – Virtual Training on Total Cost of Ownership and Technology Upgrade Options for DTs

#### LEAPFROGGING TO ENERGY EFFICIENT APPLIANCES AND EQUIPMENT (REFRIGERATORS AND DISTRIBUTION TRANSFORMERS) in Malawi, Namibia, Zambia, Zimbabwe.

#### Agenda

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#### Virtual Training on Total Cost of Ownership and Technology Upgrade options for Distribution Transformers

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DATE: 20 September, 2022

TIME: 9h00 – 11h30 (CAT)

Meeting Format: Virtual

#### Zoom Meeting details:

<https://us06web.zoom.us/j/85430710821?pwd=TWJVc2hPSW8rOSt3SXBoMUx1ZTM1dz09>

Meeting ID: 854 3071 0821

Passcode: 707248

#### Objective of the meeting

This training aims to build capacity for utilities, non-utility market players, Ministries of Energy, Ministry of Finance and Ministry or entity responsible public procurement on the recommended Total Cost of Ownership and Technology Upgrade options for manufactures of distribution transformers. The training will include participants from Malawi, Namibia, Zambia and Zimbabwe.

#### Agenda

1.	Welcome Remarks by SACREEE	9:00 – 9:05
2.	Objective of the training by ICA	9:05 – 9:15
3.	Presentation of the Total Cost of Ownership (TCO) by ICA	9:15 – 9:45
4.	Questions and discussions on the TCO by ICA	9:45 – 10:00
5.	Capacity building for manufacturers of Distribution Transformers on Technology Upgrade Options by ICA	10:00 – 11:00
6.	Questions and discussions by ICA	11:00 – 11:30

## Training on Total Cost of Ownership and Technology Upgrade options for Distribution Transformers.

**(Leapfrogging to Energy Efficient Appliances and Equipment (refrigerators and transformers) in Malawi, Namibia, Zambia and Zimbabwe.)**

**Date:** Sunday 20.09. 2022, 08:52 hrs.

**Location:**— online (zoom meeting)

### Attendees:

1. Mr. Mzwandile Thwala – SACREEE
2. Mr. Aurélien Pillet - BASE – International Finance Expert
3. Mr. Mayur Karmarkar - ICA – International Policy Expert
4. Mr. Omar Abdelaziz- ICA – International Refrigerators Expert
5. Fenni Shidhika - SACREEE Local Policy expert, Namibia
6. Mr Izaiah Mulenga –SACREEE Local Policy expert, Zambia
7. Mr Tenda Marowa – SACREEE Local Policy expert, Zimbabwe
8. Mr James Tsumba – ESCO South Africa
9. Readlay Makaliki-SACREEE
10. Welton Saiwa-SACREEE
11. Abdul Rahim Hassan – Bureau of Standards Malawi
12. Alinafe Kasinja- Ministry of Energy Malawi
13. Bodrick Mwansa - Copperbelt Energy Corporation Plc
14. Brian Khoriso - ESCOM Malawi
15. Carlos Siamalala- REA Zambia
16. Chasaya Mutambo- REA Zambia
17. Demetrius Jonas- Namibia
18. Enock Palapandu - Malawi Ministry of Energy
19. Fenni Shidhika- NEI/SACREEE
20. Fungai Nicholas Zowa - ZESA, Zimbabwe
21. Johnson Siamachira- SACREEE
22. James Tsumba- Malawi ESCOM
23. Joseph C Phiri- Mzuzu University
24. Arnold Kadzinye- MEGA Mini Grid (Mulanje, Malawi)
25. Kedrick Mulemwa
26. Kuunika Electricals
27. Lonjezo Bingalason-Churches Action in relief and Development (CARD)
28. Mwape CH – Copperbelt Energy Corporation
29. Moonga Muungo-REA Zambia
30. Odesi M Mwaamvwa-REA Zambia
31. Patrick Dongo-Rural Electrification Fund, Zimbabwe Harare
32. Sommai Phon-ICA
33. Susan Tise - MME Namibia
34. Tendayi Marowa- SACREEE
35. Tabby Moyo- SACREEE
36. Upile Kamoto- Ministry of ENERGY, Malawi
37. Robert Mbetewa- Journalist
38. Peter Makawa-Malawi Broadcasting Corporation
39. Jameson Chauluka Times – Journalist

### Agenda

1. Welcome remarks by SACREEE
2. Objective of the training by ICA
3. Presentation on the Total Cost of Ownership (TCO) by ICA
4. Capacity building for manufacturers of Distribution Transformers on technology upgrade options by ICA
5. Questions and discussions
6. Closing remarks by SACREEE

Agenda item	Discussion	Decisions taken/ Action points
<p><b>Welcoming remarks by Mr. Mzwandile Thwala – SACREEE</b></p>	<p><b>Mr. Mzwandile Thwala called the meeting to order at 08:52 hours and welcomed participants attending the virtual meeting on Total Cost of Ownership and Technology Upgrade options for Distribution Transformers from Malawi, Namibia, Zambia and Zimbabwe.</b></p> <ul style="list-style-type: none"> <li>• He explained that the meeting is one of the many meetings hosted by SACREEE, ICA and BASE under the project supported by Green Climate Fund focused on assisting eight SADC countries to leapfrog to energy efficient appliances and equipment.</li> <li>• The project aims to develop National Policy Roadmap for the eight countries.</li> <li>• He further explained that SACREEE, BASE and ICA are directly working with Malawi, Namibia, Zambia and Zimbabwe, and are at the stage where the project is concluding.</li> <li>• He said several meetings have been held with Policy Working Groups and Technical Committees on Minimum Energy Performance Standards as well as test Standards for refrigerator appliances and distribution transformers.</li> <li>• He also stated that recommendations have been made with regards to monitoring and verification enforcement framework.</li> <li>• Mr Thwala further explained that engagement have held around financing options for energy efficient equipment (refrigerators and Distribution transformers).</li> <li>• He also urged the participants, as key stakeholders to play a key role in providing information that would shape up the policy documents for the countries.</li> </ul>	
<p><b>Meeting Objective By Mayur Karmarkar - ICA</b></p>	<ul style="list-style-type: none"> <li>• Mr Karmarkar said the training aims to build capacity for utilities, non-utility market players, Ministries of Energy, Ministry of Finance and Ministry or entity responsible for public procurement on the recommended Total Cost of Ownership and Technology Upgrade options for manufacturers of distribution transformers.</li> </ul>	

Agenda item	Discussion	Decisions taken/ Action points
<p><b>Presentation on the Total Cost of Ownership (TCO) by Mr Mayur Karmarkar - ICA</b></p>	<ul style="list-style-type: none"> <li>• Making his presentation on Total Cost of Ownership (TCO), Mr Karmarkar started by explaining that transformers are used in electricity transmission and distribution system to adjust voltage and current.</li> <li>• He explained that electricity passes through transformers as it travels from the power plant to the consumer.</li> <li>• Further, he stated that energy efficient transformers can reduce transmission and distribution electricity losses.</li> <li>• He explained that electricity consumption for transformers could be increased by 49 percent by 2040 in Africa with demand to electrify the continent but noted that policies can reduce the losses to 23 percent.</li> <li>• However, with more stringent policies, this could be reduced further to 4 percent.</li> <li>• Mr Karmarkar further informed the meeting that annual electricity savings for transformers could reach almost 55 TWh in 2040, which is almost the same as current energy consumption of Singapore.</li> <li>• He added that energy efficient transformers could help reduce CO emissions by 45 million tons annually and save consumers US\$7 billion on their electricity bills.</li> <li>• Globally, Mr Karmarkar noted that many countries do not have energy efficient policies for DT.</li> <li>• The biggest market for energy efficient DT is China, followed by the United States, India and the EU.</li> <li>• He emphasized that the project objective is to provide technical assistance to improve programming process regarding refrigerators and DT energy efficient and strengthen climate finance strategies.</li> <li>• Further the project aims to create an enabling policy and regulatory environment for the adoption of energy efficient refrigerators and DT through the development of mandatory Minimum Energy Performance Standards (MSPS) and a labeling scheme.</li> <li>• It also aims to develop a national policy roadmap for the implementation of standards and labels as well as suggest appropriate financing mechanisms to accelerate deployment of energy - efficient DT.</li> <li>• Additional, it will coordinate with similar GCF readiness projects in Botswana, Eswati, Lesotho, Malawi, Tanzania, Zambia, Zimbabwe and the regional</li> </ul>	

Agenda item	Discussion	Decisions taken/ Action points
	<p>harmonization efforts coordinated by UNEP's United for Efficiency (U4E) initiative.</p> <ul style="list-style-type: none"> <li>• The project further aims to transform the market to energy -efficient refrigerators and distribution transformers by;           <ul style="list-style-type: none"> <li>➢ Reducing the strain on the electricity grid</li> <li>➢ Increase disposable income for households and potentially reduce greenhouse gases emissions.</li> </ul> </li> <li>• Mr Karmarkar said the training will focus on Total Cost of Owners (TCO) and the manufacturer's capacity development.</li> <li>• TCO is the financing mechanism which helps one to understand the savings versus incremental cost. How the decision for buying energy efficient transformers can be made.</li> <li>• Further the manufacturer's capacity development looks at promoting the local industry by helping to create a healthy competition in energy efficiency market.</li> <li>• He further informed the meeting that despite having energy efficient DT, they are not utilized because others feel its too much work to buy a transformer while some are not familiar with this method.</li> <li>• Life cycle cost consideration works on (ISO55001)- Asset management works on the Initial cost that is purchase, transport and installation.</li> <li>• It also looks at;           <ul style="list-style-type: none"> <li>➢ maintenance and inspection cost</li> <li>➢ Cost of energy loss</li> <li>➢ Salvage cost/ salvage value</li> </ul> </li> <li>• He explained that during the initial purchase stage, the energy efficient DT may appear to be expensive but the savings on the transformer pays off the cost during its saving life time.</li> <li>• Mr Karmarkar further informed the meeting that customers are faced with more challenges when they acquire a transformer with multiple design and efficiency.</li> <li>• He said transformers are made of different materials (Steel, Aluminum and Copper) and as materials change, efficient levels also changes.</li> <li>• Further, he noted that while transformers are expensive to purchase, they are also more expensive to own but efficient transformers have lower cost of ownership.</li> <li>• He further explained that the TCO approach minimizes the total investment in a transformer over its lifetime,</li> </ul>	

Agenda item	Discussion	Decisions taken/ Action points
	<p>considering purchase price and the value of future losses also called “ loss evaluation”</p> <p><b>How does it work?</b></p> <ul style="list-style-type: none"> <li>• During the procurement process, the electricity utility declares its loss evaluation formulae-A and B factors-in terms of the value per watt example Rand/watt, or US\$/Watt.</li> <li>• “A” represents how much the utility values losses in the core and “B” represents how much the utility values losses in the coil.</li> <li>• He explained that A is always greater than B (note: A=B means design for 100% load).</li> <li>• The A and B factors influence the designs created by suppliers in response to the tender, resulting in more energy – efficient models.</li> <li>• If the utility purchases those designs, the will benefit from lower total cost of ownership.</li> <li>• To help the utilities and buyers, there is the IEC TS 60076-20 standard that provides TCO formular.</li> <li>• Under the U4E, an excel tool and guide had been developed to promote use of TCO.</li> <li>• Mr Karmarkar said utilities can customize the inputs such as operating hours, life expectancy, load growth, fuel costs and O&amp;M, load profile generation mix for peak power to calculate their own A and B factors.</li> <li>• many inputs calculated A and B factors can then be included in a call for tender</li> <li>• U4E has also added a second TCO calculation methodology, which adds the price of a tonne of CO2</li> <li>• Advantage is that utilities could start using this in their next tender and it would increase efficiency.</li> <li>• He stated that the software guide explains key principles and equations in the Excel model looking at:             <ul style="list-style-type: none"> <li>➢ Transformer losses</li> <li>➢ Loss evaluation</li> <li>➢ TCO carbon factors</li> <li>➢ Conclusions and</li> <li>➢ references</li> </ul> </li> <li>• A calculation – an additional cost applied to the selling price to determine the lifetime cost.</li> <li>• <math>TCO=IC+Ax(Po+Pco)+Bx(Pk+Pcs-Pco)</math></li> <li>• IC is the initial Cost of the transformer; this cost may include installation costs</li> </ul>	

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	<p>such as foundation and erection cost ( this requires a more sophisticated evaluation);</p> <ul style="list-style-type: none"> <li>• Po is the no-load loss (kW) measured at the rated voltage and rated frequency, on the rated tap.</li> <li>• Pk is the load loss (kW) due to the load, measured at the rated currency and rated frequency on the rated tap at a reference temperature;</li> <li>• Pcs is the total cooling power(kw)needed for operation at the rated power (including three winding operation if any) note; this variable is set to zero for passively cooled transformer designs.</li> <li>• Pco is the cooling power (kW) needed for no-load operation (note: this variable is set to zero for passively cooled transformer designs.</li> <li>• A is the cost of capitalization of no-load losses in cost per kW and B is the cost of capitalization of the losses due to load in cost per kW.</li> </ul> <p><b>A factor – Value of losses in the core</b></p> <ul style="list-style-type: none"> <li>• Mr Karmarkar informed the meeting that Core losses are always present, 24 hours/365 days and do not vary with load.</li> </ul> $A = \sum_{j=1}^n \frac{O_{0j} \times C_j}{(1 + i_j)^j} \quad \text{Equation (A.2)}$ <ul style="list-style-type: none"> <li>• O<sub>0j</sub> is the operating time of the transformer at year j in h;</li> <li>• C<sub>j</sub> is the valorisation of the energy at year j in cost per KWh as losses are expressed in kW in the TCO formula;</li> <li>• I<sub>j</sub> is the real discount rate at year j in per unit;</li> <li>• N is the life expectancy of the transformer in years.</li> </ul> <p><b>B factor-Value of losses in the coil</b></p> <ul style="list-style-type: none"> <li>• The coil loses increases with load and peak losses during the peak loading (most expensive electricity)</li> </ul> $B = \sum_{j=1}^n \frac{\mu \times c_j \times (O_{aj} \times T_{aj} + O_{lj} \times T_{lj})}{(1 + i_j)^j} \left( \frac{1 + C_{lj}}{1 + C_{aj}} \right)^{2j}$	

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	<ul style="list-style-type: none"> <li>➤ <math>\mu</math> is the average load loss factor as defined in Equation (A.4)</li> <li>➤ <math>C_j</math> is the total cost of the energy at year <math>j</math> in cost per kWh as losses are expressed in kilowatts; no CO2 price.</li> <li>➤ <math>C_j</math> is the total cost of the energy at year <math>j</math> in cost per kWh as losses are expressed in kilowatts; including CO2 price.</li> <li>➤ <math>l_j</math> is the real discount rate at year <math>j</math> in per unit; generally the weighted average cost of capital, provided by the regulator.</li> <li>➤ <math>O_{aj}</math> is the operating time of the transformer at variable load during year <math>j</math> in h;</li> <li>➤ <math>O_{fj}</math> is the operating time of the transformer at fixed load during year <math>j</math> in h, usually 8 760 h if the transformer is operated all year round;</li> <li>➤ <math>T_{aj}</math> is the share of variable load in the total load loss factor at year <math>j</math>;</li> <li>➤ <math>T_{fj}</math> is the share of fixed load in the total load loss factor at year <math>j</math>;</li> <li>➤ <math>n</math> is the life expectancy of the transformer in years;</li> <li>➤ <math>C_{uj}</math> is the rate of load loss factor increase at year <math>j</math>;</li> <li>➤ <math>C_{aj}</math> is the rate of installed power increase at year <math>j</math>.</li> <li>➤ Further, Mr Karmarkar cited the following formulas as the most popular in distribution utilities.</li> <li>➤ <math>TOC = IC + (A * Wi) + B (Wc)</math></li> <li>➤ Factor <math>A = H * (Ec/1000) * ((1+r)^n - 1) / (r * (1+r)^n)</math></li> <li>➤ Factor <math>B = A * LLF</math></li> <li>➤ <math>LLF = A</math> dimensionless ratio between average and peak values of load loss  <math>LLF = \sum_{i=1}^{ni} Load_i^2 / NI * Load_{peak}^2</math></li> <li>➤ <math>NI</math> - total number of short intervals (there are 8760 hrs or 17,520 half-hrs per year)</li> <li>➤ <math>Load_i</math> – Load during the short interval <math>i</math></li> <li>➤ <math>Load_{peak}</math> - Peak load within the long interval (typically a year)  <math>LLF = 0.35 LF + 0.65 LF^2</math>  <math>LF</math> for rural area &lt; <math>LF</math> for urban area</li> </ul> <p><b>A simplified approach to buy a transformer</b></p> <ul style="list-style-type: none"> <li>• Mr Karmarkar explained that a simplified approach to buy a transformer is for the purchase managers of buildings or industry to specify loss requirements as per the standards.</li> <li>• He also stated that managers are to use a simple formula specifying A &amp; B factors as below;</li> </ul> <p><b><math>C_t = \text{Purchase price} + A * P_o + B * P_k</math></b></p>	

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	$A = \frac{(1+i)^n - 1}{i \cdot (1+i)^n} \times C_{kWh} \times 8760$ $B = \frac{(1+i)^n - 1}{i \cdot (1+i)^n} \times C_{kWh} \times 8760 \times \left(\frac{I_l}{I_r}\right)^2$ <ul style="list-style-type: none"> <li>➤ I = interest rate 7 %</li> <li>➤ N = lifetime 30 yrs</li> <li>➤ C<sub>kWh</sub> = cost / KWh (0.05 c)</li> <li>➤ I<sub>l</sub>/I<sub>r</sub> = loading 50%</li> </ul> <ul style="list-style-type: none"> <li>• To summarise his presentation, Mr Karmarkar informed the meeting that MEPS give a good 'push' to the market:</li> <li>• He explained that the draft regulation is based on SAN 780 and a good starting point, but in the Africa region, more ambition is needed on the smaller kVA ratings.</li> <li>• He also stated that need for policy process to be adopted as they may take 2 years before there are in place.</li> <li>• Commenting on the TCO methodology, he explained that it offers a 'pull' based on IEC TS 60076-20 Annex A methodology.</li> <li>• TCOs allows utilities and industrial, commercial customers to calculate economic cost optimal for their situation and adds the option of including cost of CO<sub>2</sub> emissions.</li> <li>• There are also quick and easy to implement – potential fast-track.</li> </ul>	
<b>Presentation on capacity building for manufacturers of Distribution Transformers on technology upgrade options by Mr Muyur Karmarkar</b>	<ul style="list-style-type: none"> <li>• Making his presentation, Mr Karmarkar said SACREEE has asked all partner countries to provide input on the need for technology energy efficient upgrade.</li> <li>• He explained that request has been received from Zimbabwe for technology upgrade and this will involve:           <ul style="list-style-type: none"> <li>➤ Assistance in training &amp; acquiring design software for distribution transformers.</li> <li>➤ Financing the product development (proto-type development &amp; testing)</li> <li>➤ Financing tooling / machinery costs needed to produce low loss transformers</li> </ul> </li> <li>• He further encouraged the participants to provide inputs, that SACREEE together with BASE can assist to develop proposal for funding considering country request for phase 2.</li> <li>• He explained to the meeting that transformers are the principal medium for transferring energy from one circuit to</li> </ul>	

Agenda item	Discussion	Decisions taken/ Action points
	<p>another circuit by following the process of electromagnetic induction.</p> <ul style="list-style-type: none"> <li>• In general, transformers are responsible for supplying and regulating voltage levels by either increasing (step-up) or decreasing (step-down) it down.</li> <li>• He stated that distribution transformers are mainly used for lower voltage distribution networks for use in individual homes or commercial and industrial establishments.</li> <li>• The primary voltage is generally below 36 kV and secondary voltage can be 250 Volts or Less per phase.</li> <li>• He further explained that the basic classification of distribution transformers can be number of phases looking at single phase or three phase, design/Construction focusing on core type or shell type and cooling medium which can either be oil immersed or dry type.</li> </ul> <p><b>Distribution Transformer manufacturing</b></p> <ul style="list-style-type: none"> <li>• Mr Karmarkar explained that distribution transformers can be made with highest customization for each contract. Customer can make an order, with variation in requirements.</li> <li>• He also stated that continues optimization is necessary because the industry depends on material and value addition.</li> <li>• To manufacture DT, one needs resources that include skilled manpower, design skills, purchase skills, manufacturing skills, testing and quality assurance</li> <li>• He also noted that current DT machine on market has improved drastically covering enhanced conductor winding / foil winding machine, core building / winding machine and testing set-up.</li> <li>• Design options for efficient transformers should focus on no load losses such as use of lower-loss CRGO material.</li> <li>• Decreasing flux density by increasing core cross and decreasing flux path length by decreasing the conductor.</li> <li>• There is need to also decrease current path length by increasing volts/turn.</li> <li>• He explained that manufacturing process for oil filled transformer involves buying the core and sending it through the winding and convert that into the assembly, painting and tank outsourcing.</li> </ul> <p><b>Major materials / Manufacturing Process</b></p> <ul style="list-style-type: none"> <li>• Mr Karmarkar said the magnetic circuit of transformer, core provides a low</li> </ul>	

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	<p>reluctance flux path for the transformer to function.</p> <ul style="list-style-type: none"> <li>• Generally, it is made of Cold Rolled Grain oriented (CRGO) steel sheets of high permeability and small thickness coated with high temperature materials (Carlite or equivalent) to reduce eddy current losses and hysteresis losses. Their carbon content is maintained below 0.1%. Eddy current is further reduced by alloying the steel with Silicon.</li> <li>• Other materials used for transformer core is Amorphous metal, which is a non-crystalline substance formed as ribbons and has a superior magnetic properties.</li> <li>• It is very thin compared to CRGO Sheets, the eddy current losses also are very low.</li> <li>• However, the saturation flux density is low as compared to CRGO silicon steel and so is the case with mechanical strength against jerks during assembly and handling being softer than CRGO.</li> <li>• Various Cross-sections circular / rectangular, Core type / Shell Type may be opted depending on design.</li> </ul> <p><b>Core – Cold Roller Grain Oriented Silicon steel</b></p> <ul style="list-style-type: none"> <li>• These DT are manufactured by a few steel mills across the world with specialized material.</li> <li>• Mr Karmarkar noted that superior grades of CRGO are now available with Losses upto 0.80, 0.75, 0.70 Watts/Kg at 1.7 T.</li> <li>• He stated that losses with Amorphous Alloy at <u>1.5 Tesla</u> 50 Hz are as low as 0.325 Watts/Kg, however, its saturation flux density is low as compared to CRGO and normally the designs never go beyond 1.38 to 1.4 Tesla for Amorphous core transformers. Hence higher load losses.</li> <li>• He also explained that old transformers have very high load losses and in Africa, there is a lot of refurbishing of old transformers as opposed to getting a new one due to budgetary constraints.</li> <li>• One can replace the core, which may not be the same as buying a new DT.</li> <li>• He explained that there are a few new technologies on the market with reduced losses below one.</li> <li>• He also stated that the steel industry has improved the steel grade, which has helped to make the transformers more efficient.</li> <li>• Mr Karmarkar said 3 D core is a new technology on the market that is becoming</li> </ul>	

Agenda item	Discussion	Decisions taken/ Action points
	<p>popular, reducing the flux path is the way to reduce losses in the transformer.</p> <ul style="list-style-type: none"> <li>• Wound core CRGO &amp; AMT single Ph (a) Core Type (b) Shell Type are also energy efficient transformer that can help improve productivity as well reduce on labour.</li> <li>• Further, the meeting was informed of conducting material such as copper and alluminum</li> </ul> <p><b>Conducting materials</b></p> <ul style="list-style-type: none"> <li>• Mr Karmarkar said DT distribution windings are made of high grade electrolytic copper or aluminum, which are designed to optimize thermal, mechanical and electrical stresses.</li> <li>• The winding machines are equipped with different speed gears to ensure that proper tension is maintained on the windings.</li> <li>• Similarly, the conductors are suitably transposed at intervals to reduce the circulating current losses in winding. Axial and radial wedges and dove-tailed / T-spacers are provided as cooling ducts as per the design.</li> <li>• He highlighted that different winding types are used in transformers, such As :             <ul style="list-style-type: none"> <li>➤ Spiral / Layer Type winding</li> <li>➤ Helical winding</li> <li>➤ Cross-over winding</li> <li>➤ Continuous Disc winding</li> <li>➤ Foil winding</li> </ul> </li> </ul> <p><b>LV Foil winding:</b></p> <ul style="list-style-type: none"> <li>• LV foil winding uses a single piece of thin strip as conductor with a width of the foil equal to length of the winding.</li> <li>• This conductor strip (foil) wound along with a pre-impregnated interlayer insulation and during curing process foil and insulation are bonded together to form a rigid block.</li> <li>• Mr Karmarkar said the LV coil becomes self-supporting against forces and later the coil is impregnated with resin for environmental protection.</li> <li>• Eddy losses in the thin foil are very less compared to thick rectangular wires, so windings made with foil are cooler than other types.</li> <li>• Equally, foil winding minimizes the axial forces during short circuit , since currents in the winding are adjusted to the ampere turns in the high voltage winding.</li> </ul> <p><b>Core Coil Assembly (CCA)</b></p>	

Agenda item	Discussion	Decisions taken/ Action points
	<ul style="list-style-type: none"> <li>• He explained that the construction of the Core and Coil Assembly is significant from the performance point of the transformer. The CCA defines the insulation scheme, cooling, dynamic withstand capability, handling by providing sufficient radial and axial supports that prevents the stress from causing any damage to the windings.</li> <li>• He said clamping of the windings axially is necessary to hold the assembly firmly. Clamping structure of the assembly has supports to route the tap and line terminals, insulated vertical and horizontal strips of adequate thickness of a frame work to assist the routing of terminals.</li> <li>• Further, insulation scheme is categorized into major and minor insulation.</li> <li>• He explained that major insulation addresses the capability to withstand high voltages, isolation of the primary and secondary winding, clearances for voltage withstand while minor insulation is the turn insulation, joint protection etc.</li> <li>• Both the major and minor insulation are equally important for the successful operation of the transformer.</li> <li>• Further, the thermal class of insulation depends on the Type of cooling medium.</li> </ul> <p><b>The drying process</b></p> <ul style="list-style-type: none"> <li>• Mr Karmarkar highlighted that the significant part of the insulation used in oil immersed transformer is paper and wood based.</li> <li>• This insulation material has high affinity to moisture which may weaken the insulation properties and reduce the insulation resistance to high voltages.</li> <li>• For the above reasons, transformer windings and Core Coil Assembly undergo drying process at various stages depending on the rating and voltage class.</li> <li>• There are two types of drying:             <ul style="list-style-type: none"> <li>➢ Air drying</li> <li>➢ Vacuum drying.</li> </ul> </li> <li>• <b>Air drying</b> is used in distribution transformers limited to voltage class below 33 KV, while <b>Vacuum drying</b> is predominantly used for all transformers of voltage class above 33 KV.</li> </ul> <p><b>Tank &amp; radiators</b></p> <ul style="list-style-type: none"> <li>• The Transformer enclosure is generally referred to as tank and this is a fabricated structure constructed of mild steel of adequate thickness &amp; generally</li> </ul>	

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	<p>rectangular shaped. The tank has two main functions:</p> <ul style="list-style-type: none"> <li>➤ To hold the CCA with proper clearances for voltage and oil flow.</li> <li>➤ To facilitate cooling, safety and maintenance.</li> </ul> <ul style="list-style-type: none"> <li>• The tank must be leak proof, and should withstand the specified pressure during all service as well as test conditions.</li> <li>• He stated that depending on heat dissipation requirements to keep the specified temperature rise requirements in test conditions and service, the transformer tank will either have corrugations or is fitted with pressed steel fin type radiator banks.</li> </ul> <p><b>Final assembly &amp; fitting</b></p> <ul style="list-style-type: none"> <li>• After drying process, the CCA is inserted into the transformer tank.</li> <li>• The CCA should stand freely inside the tank and inside clearances are to be maintained.</li> <li>• The primary and secondary terminations are brought out through porcelain or epoxy cast bushing insulation.</li> <li>• Off circuit Tap Switch or OLTC connections are to be secured tightly and separated.</li> <li>• Mr Karmarkar said handling, jacking facility to lift the transformer or jack it for fixing detachable rollers is normally provided.</li> <li>• The transformer tank is also fitted with valves for oil filling, filtration, oil sampling, draining.</li> <li>• Provision for safety devices like Buchholz relay, pressure relief valve, temperature recording and control instruments, neutral current transformer, protection and instrument transformer are customized features as per buyer's requirement.</li> <li>• He explained that in a non-sealed transformers, conservator is provided for oil expansion and contraction during the operating cycle.</li> <li>• For sealed type transformers DGPT Relay also is sometimes provided for protection. Terminal identification /marking are also done on/near the bushings.</li> </ul> <p><b>Oil plant</b></p> <ul style="list-style-type: none"> <li>• Mr Karmarkar also highlighted that there is a programme of chemical management under the pop material management the world transformers in Africa.</li> </ul>	

Agenda item	Discussion	Decisions taken/ Action points
	<ul style="list-style-type: none"> <li>• He said the oil contains in transformers is environmentally harmful and the replacing of both power and oil disposable is a separate programme.</li> <li>• He further explained that the transformers being promoted in the policy right book are the natural ester, which is derived from vegetable oil</li> <li>• He noted that esters have a better insulating property, fire performance and mineral oil very wet.</li> <li>• It is environmental friendly and helps to make the transformer more resilient.</li> </ul> <p><b>List of plant machinery (for testing oil immersed distribution transformers upto 25000 KVA)</b></p> <ul style="list-style-type: none"> <li>➤ Core assembly tables/platforms</li> <li>➤ Core lifting/handling fixtures</li> <li>➤ Mandrals</li> <li>➤ Winding section</li> <li>➤ Foil winding machines for LV Coil</li> <li>➤ Cross over type HV Coil winding machines</li> <li>➤ Rectangular Coil winding machines</li> <li>➤ Decoilers/conductor feeding stands,</li> <li>➤ Adjustable winding former</li> <li>➤ Coil pressing jigs and fixtures</li> <li>➤ Power supply source/generator</li> <li>➤ Three phase variac/regulator</li> <li>➤ Intermediate testing transformers for load tests /temperature rise test.</li> <li>➤ High voltage testing transformer</li> <li>➤ Double/triple frequency generator</li> <li>➤ High accuracy three phase power analyzer</li> <li>➤ Multiple range CTs and PT with high accuracy</li> <li>➤ Noise level meter</li> <li>➤ Vacuum test kits with gauges</li> <li>➤ Pressure test kits with gauges etc.</li> <li>➤ Oil BDV test kit</li> <li>➤ Portable HV tester</li> <li>➤ Paint thickness gauge</li> </ul> <ul style="list-style-type: none"> <li>• He further explained that other extra test equipment may also be installed depending on plant capacity as feasible.</li> </ul>	


Agenda item	Discussion	Decisions taken/ Action points
<b>Questions discussions</b> and	<ul style="list-style-type: none"> <li>• Opening up the floor for discussions, Mr Karmarkar said there is need for countries to submit request to implement technology upgrade of DTs.</li> <li>• He informed the meeting that participants will be communicated to via email for their formal submissions.</li> <li>• And Mr Tendayi Marowa noted that the need to engage key stakeholders like the manufacturers as countries draft the national roadmap policy.</li> <li>• Mr Marowa also stated as such as plans are underway by the project facilitate to host public consultations, those meeting will not be as detailed as the meeting held.</li> <li>• He called for future capacity building to include manufacturers who were absent in the meeting as they are key stakeholders.</li> <li>• Other participants sought clarity on the lifespan of the transformers considering the low losses and high losses</li> </ul>	<ul style="list-style-type: none"> <li>• In response to the query on the lifespan of the transformer, Mr Karmarkar said it is not dependent on low loss or high loss but the working condition, in the case of amorphous work material that is very delicate.</li> <li>• He explained the need to handle transformers very careful during transportation explaining that factors like the conductor life and paper insulation do not change</li> </ul>
<b>Closing remarks Mr.</b>	<ul style="list-style-type: none"> <li>• Closing the meeting, Mr Mzwandile Thwala thanked presenter and all the participants for attending the meeting.</li> <li>• Mr Thwala said the meeting was informative and believe that everyone had learnt a lot in procurement of energy efficient DTs.</li> <li>• He assured the meeting that a formal request will be sent to manufacturers from participating countries to provide an indicate of how much they would require to implement technology upgrade to meet the proposed minimum energy standards that are included in the National policy roadmaps</li> </ul>	

## 6.2 ANNEX B – Training on Procurement of energy efficient transformers on Total Owning Cost Presentation

### Training on Procurement of energy efficient transformers on Total Owning Cost

*LEAPFROGGING TO ENERGY-EFFICIENT APPLIANCES AND EQUIPMENT (REFRIGERATORS AND TRANSFORMERS)*

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1

#### Agenda

- Introduction and overview of the project
- Introduction to TCO
- Transformers – Various options, how to evaluate
- Total owning cost U4E tool kit
- Total owning cost – Simple tool for buildings or industry purchases
- Case study – Iron & Steel Industry
- Summary
- Questions and discussions

2

2

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### Project overview

- **Objective:** Provide technical assistance to improve programming process regarding refrigerators and distribution transformers energy efficiency and strengthen climate finance strategies
- **Aims**
  - Create an enabling policy and regulatory environment for the adoption of energy-efficient refrigerators and distribution transformers through the development of mandatory Minimum Energy Performance Standards (MEPS) and a labeling scheme
  - Develop a national policy roadmap for the implementation of standards and labels
  - Suggest appropriate financing mechanisms to accelerate deployment of energy-efficient distribution transformers
  - Coordinate with similar GCF readiness projects in Botswana, Eswatini, Lesotho, Malawi, Tanzania, Zambia, Zimbabwe and the regional harmonization efforts coordinated by UNEP's United for Efficiency (U4E) initiative
  - Transform the market to energy-efficient refrigerators and distribution transformers
    - Reduce the strain on the electricity grid
    - Increase disposable income for householders and potentially reduce greenhouse gases (GHG) emissions

3

### How to buy a car?

**Toyota Prius**  
For sale Price € 25250  
Fuel consumption 4.3 l/100 km

**VW Golf**  
For sale Price € 22875  
Fuel consumption 6.2 l/100 km

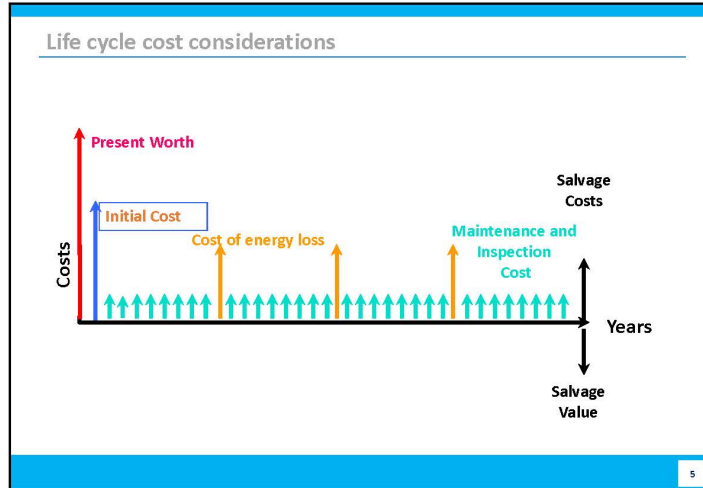
**Costs of fuel € 1.30 per litre**

Let's presume you want to drive 25000 km per year during 5 years

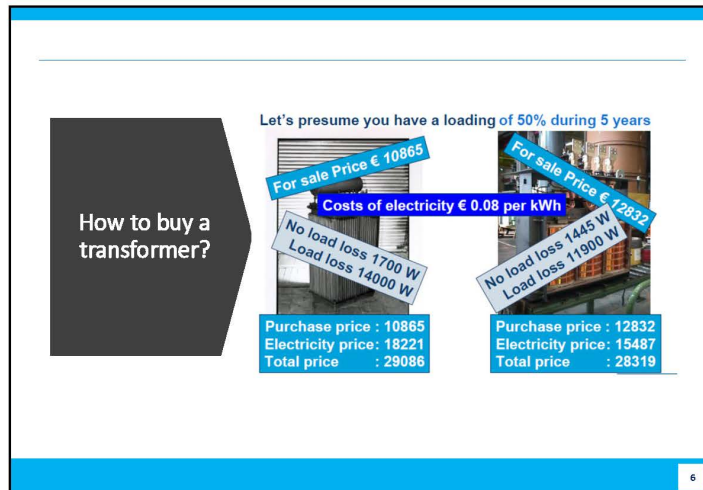
<b>Purchase price : 25250</b> <b>Fuel price : 6988</b> <b>Total price : 32238</b>	<b>Purchase price : 22875</b> <b>Fuel price : 10075</b> <b>Total price : 32950</b>
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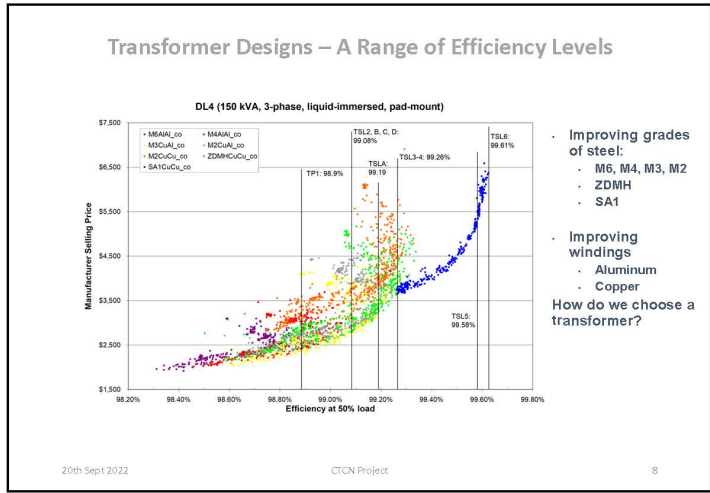
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Why don't we use it if we are buying transformers?

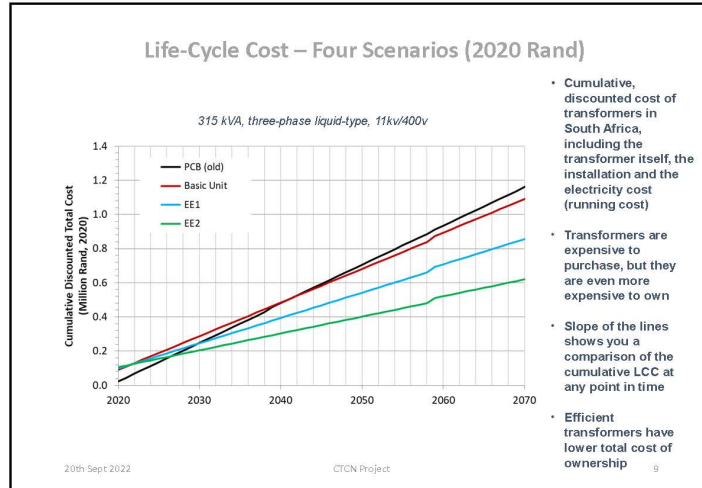
- May be because:
  - We did not know it was that easy
  - It's too much work for buying a transformer
  - We are not familiar with this method
    - NEED MORE INFORMATION.....
  - We are not interested in energy or cost saving
    - How about your boss?
  - We are only interested for short time period
  - This method neglect a lot of aspects
    - Which aspects?
  - Others?

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### Total Cost of Ownership (TCO)

- The Total Cost of Ownership (TCO) approach **minimises the total investment in a transformer** over its lifetime, considering purchase price and the value of future losses (also called “loss evaluation”)
- How does it work?
  - During the procurement process, the electric utility declares its **loss evaluation formulae – A and B factors** – in terms of the value per watt (e.g., Rand/Watt, or US\$/Watt)
  - “A” represents how much the utility values **losses in the core** and “B” represents how much the utility values **losses in the coil**
  - A is always greater than B (note: A = B means design for 100% load)
  - The A and B factors influence the designs created by suppliers in response to the tender, resulting in **more energy-efficient models**
  - If the utility purchases those designs, they will benefit from lower total cost of ownership

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### Total Cost of Ownership – IEC’s Methodology

- The Transformer Technical Committee at the IEC Developed a standardised method for conducting TCO Calculation, published in Annex A of IEC TS 60076-20
- Informative Annex (not Normative)
- Contents:
 

Annex A (informative) Capitalisation of losses .....	26
A.1 General theory, concept of capitalisation .....	26
A.2 Impact of capitalisation values .....	27
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A.3.1 General .....	27
A.3.2 Calculation of factor <i>A</i> .....	28
A.3.3 Calculation of factor <i>B</i> .....	28
A.3.4 Use of <i>A</i> and <i>B</i> for tender evaluation .....	30
A.3.5 Determination of factors <i>A</i> and <i>B</i> .....	31
- Very few utilities in the SADC region use TCO

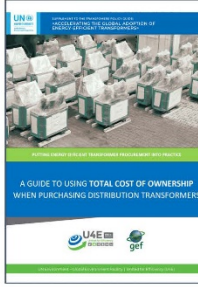


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### U4E Developed Excel Tool and Guide to Promote Use of TCO

- U4E developed an **M5 Excel tool** and **software guide** following the IEC methodology
- Utilities can customize the inputs in the tool to calculate their own A and B factors
  - Many inputs – operating hours, life expectancy, load growth, fuel costs, O&M, load profile, generation mix for peak power...
- Calculated A and B factors can then be included in a call for tender tomorrow
- U4E added a second TCO calculation methodology which adds the price of a tonne of CO<sub>2</sub>
- Advantage: Utilities could start using this in their next tender, and it would increase efficiency**



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## Total Cost of Ownership Guide

- Software guide explains key principles and equations in the Excel model

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## Total Cost of Ownership Spreadsheet ... 1 of 2

- A calculation – an additional cost applied to the selling price to determine the lifetime cost

$$TCO = IC + A \times (P_0 + P_{Co}) + B \times (P_L + P_{Cs} - P_{Co})$$

Eqn. A.1

- IC is the initial cost of the transformer; this cost may include installation costs such as foundation and erection costs (requires a more sophisticated evaluation);
- P<sub>0</sub> is the no-load loss (kW) measured at the rated voltage and rated frequency, on the rated tap;
- P<sub>L</sub> is the load loss (kW) due to the load, measured at the rated current and rated frequency on the rated tap at a reference temperature;
- P<sub>Co</sub> is the total cooling power (kW) needed for operation at the rated power (including three winding operation if any) (note: this variable is set to zero for passively cooled transformer designs);
- P<sub>Cs</sub> is the cooling power (kW) needed for no-load operation (note: this variable is set to zero for passively cooled transformer designs);
- A is the cost of capitalisation of no-load losses in cost per kW;
- B is the cost of capitalisation of the losses due to load in cost per kW.



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### Total Cost of Ownership Spreadsheet ... 2 of 2

**TCO = IC + A x (P<sub>0</sub> + P<sub>CO</sub>) + B x (P<sub>k</sub> + P<sub>CS</sub> - P<sub>CO</sub>)** Eqn. A.1

Description:		315 KVA, 3 Phase Oil-filled, 11/0.4 KV DT							
Calculation:	Baseline	Option #1	Option #2	Option #3	Option #4	Option #5	Units	Description	
IC (price standard)	\$ 4,500	\$ 5,420	\$ 6,350				USD	Initial Cost of the transformer	
PL (load losses)	0.84	0.64	0.42				kW	no load losses (kW) at rated voltage and frequency	
PR (load losses)	2.80	2.80	1.90				kW	load losses (kW) at rated current and frequency	
PCO (cooling losses)	-	-	-	-	-	-	kW	total cooling power (kW) for operation at the rated power	
PCO (cooling losses)	-	-	-	-	-	-	kW	total cooling power (kW) for operation at no-load	
No CO2 Price:	A	\$ 4,102	\$ 4,102	\$ 4,102	\$ 4,102	\$ 4,102	\$ 4,102	\$/AW	cost of capitalisation of no-load losses
	B	\$ 1,536	\$ 1,536	\$ 1,536	\$ 1,536	\$ 1,536	\$ 1,536	\$/AW	cost of capitalisation of load losses
With CO2 Price:	A	\$ 4,555	\$ 4,555	\$ 4,555	\$ 4,555	\$ 4,555	\$ 4,555	\$/AW	cost of capitalisation of no-load losses
	B	\$ 1,770	\$ 1,770	\$ 1,770	\$ 1,770	\$ 1,770	\$ 1,770	\$/AW	cost of capitalisation of load losses
TCO <sub>baseline</sub>	\$ 13,781	\$ 12,375	\$ 10,991	\$ -	\$ -	\$ -	USD	total cost of ownership	
TCO <sub>baseline</sub>	\$ 15,090	\$ 13,320	\$ 11,625	\$ -	\$ -	\$ -	USD	total cost of ownership	

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### A Factor – Value of Losses in the Core

- Core losses are always present, 24hr/365day
- Do not vary with load

$$A = \sum_{j=1}^n \frac{O_{0j} \times G_j}{(1 + i_j)^j}$$

Equation (A.2)

- O<sub>0j</sub> is the loading of the transformer core at year (j);
- G<sub>j</sub> is the real value of the energy price (j) used for the losses are expressed in kWh/100 kVAh;
- i<sub>j</sub> is the discount rate applied for year (j);
- N is the life expectancy of the transformer in years.

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### B Factor – Value of Losses in the Coil

- Coil losses increase with load
- Peak losses during peak loading (most expensive electricity)

$$B = \sum_{j=1}^n \frac{\mu \times c_j \times (O_{aj} \times T_{aj} + O_{fj} \times T_{fj})}{(1+i_j)^j} \left( \frac{1+C_{uj}}{1+C_{aj}} \right)^{2j} \quad (A.5)$$

- $\mu$  is the average load loss factor as defined in Equation (A.4)
- $C_j$  is the total cost of the energy at year j in cost per kWh as losses are expressed in kilowatts; no CO2 price.
- $C_j$  is the total cost of the energy at year j in cost per kWh as losses are expressed in kilowatts; including CO2 price.
- $i_j$  is the real discount rate at year j in per unit; generally the weighted average cost of capital, provided by the regulator.
- $O_{aj}$  is the operating time of the transformer at variable load during year j in h;
- $O_{fj}$  is the operating time of the transformer at fixed load during year j in h, usually 8760 h if the transformer is operated all year round;
- $T_{aj}$  is the share of variable load in the total load loss factor at year j;
- $T_{fj}$  is the share of fixed load in the total load loss factor at year j;
- $n$  is the life expectancy of the transformer in years;
- $C_{uj}$  is the rate of load loss factor increase at year j;
- $C_{aj}$  is the rate of installed power increase at year j.



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### Most popular formula in distribution utilities

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TOC = IC + (A\*Wi) + B (Wc)

- Factor A =  $H * (Ec/1000) * ((1+r)^n - 1) / (r * (1+r)^n)$
- Factor B = A \* LLF

LLF = A dimensionless ratio between average and peak values of load loss

$$LLF = \frac{\sum_{i=1}^{NI} Load_i^2}{NI * Load_{peak}^2}$$

*NI* - total number of short intervals (there are 8760 hrs or 17,520 half-hrs per year)

*Load<sub>i</sub>* – Load during the short interval *I*

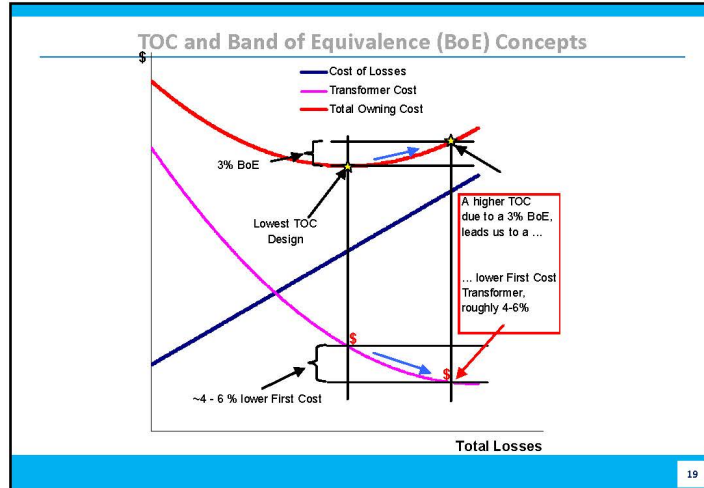
*Load<sub>peak</sub>* - Peak load within the long interval (typically a year)

$$LLF = 0.35 LF + 0.65 LF^2$$

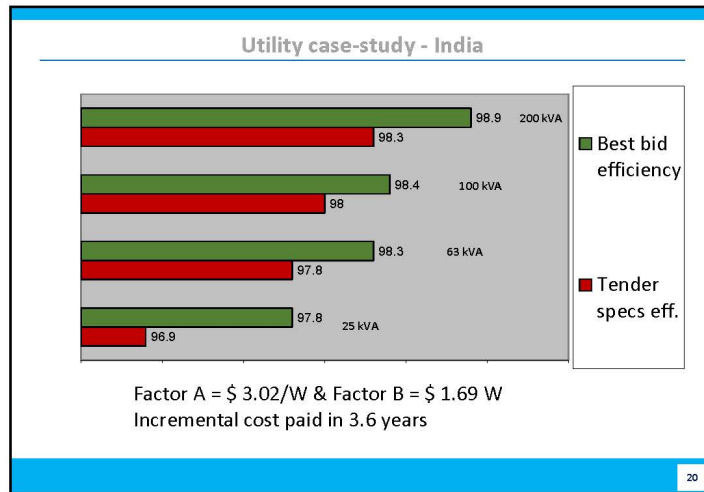
LF for rural area < LF for urban area

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**For purchase managers of buildings or industry**

- A simplified approach to buy a transformer
  - Specify loss requirements as per the standards.
  - Use a simple formula specifying A & B factors as below;

**Ct = Purchase price + A \* Po + B \* Pk**

$$A = \frac{(1+i)^n - 1}{i \cdot (1+i)^n} \times C_{kWh} \times 8760$$

$$B = \frac{(1+i)^n - 1}{i \cdot (1+i)^n} \times C_{kWh} \times 8760 \times \left(\frac{I_l}{I_r}\right)^2$$

Here as an example  
 I = interest rate 7 %  
 N = lifetime 30 yrs  
 C<sub>kWh</sub> = cost / kWh (0.05 c)  
 I<sub>l</sub>/I<sub>r</sub> = loading 50%

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**Case study – Iron steel plant in Europe**

- A typical rating – 1250 kVA
- Average loading of 65% with 6 pulse convertor
- Loading 24 hours a day & 7 days a week
- Average electricity price 40 Euro/MWh
- Average interest rate 7% PA
- Average age transformer 15 years but economic life time 10 years
- Plant used dry-type transformer

Based on above figures A = 2.46 Euro/W & B = 1.04 Euro/W

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### Cost evaluation of 1250 kVA transformer

Vendor Name	Pn (Watts)	Pk (Watts)	Bid price (Euro)
A	2400	13568	12250
B	2200	11712	13000

**Ct = Purchase price + A \* Po + B \* Pk**

**Vendor A Ct=12250+ 2400\*2.46 + 13568\*1.04 = 32265**

**Vendor B Ct= 13000+ 2200\*2.46 + 11712\*1.04 = 30592**


**Vendor B was cheaper on the life time basis with payback less than 2.50 years.**

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### Key take-aways

- MEPS give a good 'push' to the market:
  - The draft Regulation is based on SAN 780
  - A good starting point, but in the Africa region, more ambition is needed on the smaller kVA ratings
  - Policy process to adopt, may take 2 years before in place
- TCO methodology offers a 'pull'
  - Based on IEC TS 60076-20 Annex A methodology
  - Allows utilities & industrial, commercial customers to calculation economic cost optimal for their situation
  - Adds the option of including cost of CO<sub>2</sub> emissions
  - Quick and easy to implement – potential fast-track...



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### Information Resources on Transformers

- U4E Policy Guide for Transformers – Accelerating the Global Adoption of Energy-Efficient Transformers – [click here](#)
- U4E Model Regulation - Guidelines for Energy Performance Requirements for Distribution Transformers – [click here](#)
- U4E Procurement Guidelines: Model Liquid Immersed Distribution Transformer Technical Specification – [click here](#)
- IEC TR 60076-20: Power transformers - Part 20: Energy efficiency – [click here](#)
- PROPHET II: The potential for global energy savings from high-efficiency distribution transformers – [click here](#)
- SEAD Distribution Transformers - Internationally Comparable Test Methods and Efficiency Class Definitions – Four Part Study – [click here](#)
- IEA 4E Benchmarking Report for Distribution Transformers – [click here](#)
- Energy-efficient distribution transformers in Europe: impact of Ecodesign regulation – [click here](#)



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## 6.3 ANNEX C – Capacity Building – DT Manufacturers Presentation

### Capacity Building – DT Manufacturers

**LEAPFROGGING TO ENERGY-EFFICIENT APPLIANCES AND EQUIPMENT  
(REFRIGERATORS AND TRANSFORMERS)**

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1

#### Purpose

**ENERGY-EFFICIENT TRANSFORMERS  
REDUCE TRANSMISSION  
AND DISTRIBUTION ELECTRICITY LOSSES**

Transformers are used in the electricity transmission and distribution system to adjust voltage and current. Generally, electricity passes through up to five transformers as it travels from the power plant to the customer.

THE ELECTRICITY CONSUMPTION FOR  
TRANSFORMERS COULD INCREASE BY  
**OVER 49% BY 2040**

POLICIES CAN REDUCE THIS INCREASE TO 23%.  
MORE STRINGENT POLICIES  
TO AS LITTLE AS 4%.

**ANNUAL  
ELECTRICITY  
SAVINGS**  
for transformers  
could reach almost  
**55 TWh in 2040**

AVOIDING THE  
CONSTRUCTION OF  
**25 LARGE  
POWER PLANTS**

REDUCING CO<sub>2</sub>  
EMISSIONS BY  
**45  
MILLION TONNES  
ANNUALLY**

SAVING CONSUMERS  
**\$7 BILLION**  
ON THEIR  
ELECTRICITY BILLS

THESE SAVINGS ARE NEARLY EQUIVALENT TO THE CURRENT CONSUMPTION OF SINGAPORE

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**Many countries in the world don't have national energy efficiency policies for DT**



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**Total Cost of Ownership & capacity development of manufacturers**

TCO

- Imperative to finance the incremental cost

Manufacturers' capacity development

- Helps to create a healthy competition in energy efficiency market

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### Requests received for technology upgradation (Zimbabwe)

- Assistance in training & acquiring design software for distribution transformers
- Financing the product development (proto-type development & testing)
- Financing tooling / machinery costs needed to produce low loss transformers

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### Estimate (Zimbabwe)

ITEM	DESCRIPTION	UOM	QTY	UNIT PRICE	TOTAL
Product Development Phase					
1	Benchmarking activities	Lot	1	USD 15,000.00	USD 15,000.00
2	Selection of tech transfer partner	Lot	1	USD 1,500,000.00	USD 1,500,000.00
3	Transformer Design Software	Lot	1	USD 50,000.00	USD 50,000.00
4	Training for design software	Engineer	4	USD 3,000.00	USD 12,000.00
5	Hardware and tooling meeting MEPS	Lot	1	USD 720,000.00	USD 720,000.00
6	Prototype Tier 1-Tier 3 MEPS	Ea	12	USD 10,000.00	USD 120,000.00
7	Temporary export to SA + transportation	Lot	12	USD 1,800.00	USD 21,600.00
8	Type tests at NETFA (South Africa)	ea	15	USD 5,000.00	USD 75,000.00
9	Estimated Subtotal for the transition				USD 2,513,600.00

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## Project overview

- **Objective:** Provide technical assistance to improve programming process regarding refrigerators and distribution transformers energy efficiency and strengthen climate finance strategies
- **Aims**
  - Create an enabling policy and regulatory environment for the adoption of energy-efficient refrigerators and distribution transformers through the development of mandatory Minimum Energy Performance Standards (MEPS) and a labeling scheme
  - Develop a national policy roadmap for the implementation of standards and labels
  - Suggest appropriate financing mechanisms to accelerate deployment of energy-efficient distribution transformers
  - Coordinate with similar GCF readiness projects in Botswana, Eswatini, Lesotho, Malawi, Tanzania, Zambia, Zimbabwe and the regional harmonization efforts coordinated by UNEP's United for Efficiency (U4E) initiative
- **Transform the market to energy-efficient refrigerators and distribution transformers**
  - Reduce the strain on the electricity grid
  - Increase disposable income for householders and potentially reduce greenhouse gases (GHG) emissions

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## Introduction

Transformers are the principal medium for transferring energy from one circuit to another circuit by following the process of electromagnetic induction. In general, they are responsible for supplying & regulating voltage levels by either increasing (step-up) or decreasing (step-down) it down.

Distribution transformers are mainly used for lower voltage distribution networks for use in individual homes or commercial & industrial establishments. The primary voltage is generally below 36 kV and Secondary Voltage can be 250 Volts or Less per phase.

Basic Classification of Distribution Transformers can be :

No. of Phases	:	Single Phase or Three Phase
Design/Construction	:	Core Type or Shell Type
Cooling Medium	:	Oil Immersed or Dry Type

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**Distribution Transformer manufacturing**

Highest customization for each contract

- Make to order
- Variation in customer requirements
- Continues optimization
  - Higher material dependency, fluctuations in raw material cost

Resources

- Man – Skilled manpower
  - Design skills
  - Purchase skills
  - Manufacturing skills
  - Testing & Quality Assurance
- Machine – Updated manufacturing processes & machinery
  - Conductor winding / foil winding machine
  - Core building / winding machine
  - Testing set-up
- Money – Capital investment & working capital

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**Design options for efficient transformers (1/2)**

Loss reduction intervention		Effect on No Load Loss	Effect on Load Loss	Effect on material cost
Decrease No Load Loss	Use lower-loss CRGO material	Lower	No change*	Higher
	Decrease flux density by increasing core Cross section area of core	Lower	Higher	Higher
	Decrease flux density by decreasing volts/turn	Lower	Higher	Higher
	Decrease flux path length by decreasing conductor Cross-section Area	Lower	Higher	Lower

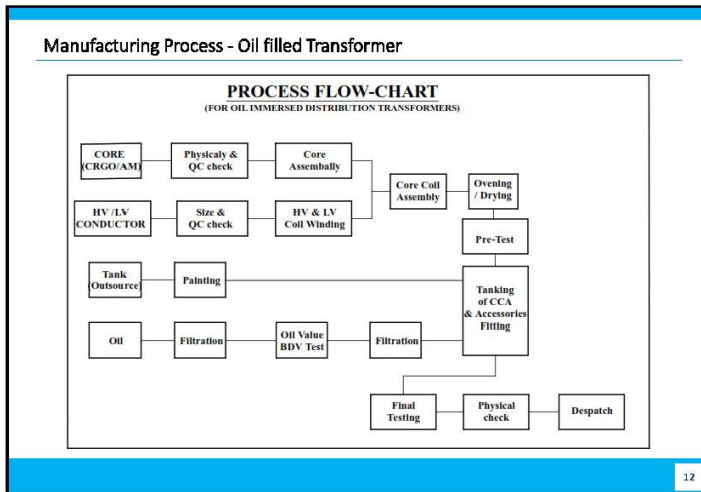
\* Amorphous core materials would result in higher load losses because flux density drops, requiring a larger core volume.

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### Design options for efficient transformers (2/2)

Loss reduction intervention		Effect on No Load Loss	Effect on Load Loss	Effect on material cost
Decrease Load Loss	Use lower-loss conductor material	No change	Lower	Higher
	Decrease current density by increasing conductor cross-section area of core	Higher	Lower	Higher
	Decrease current path length by decreasing core cross-section area	Higher	Lower	Lower
	Decrease current path length by increasing volts/turn	Higher	Lower	Higher

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### Major materials / Manufacturing Process

The magnetic circuit of transformer, core provides a low reluctance flux path for the transformer to function. Generally, it is made of CRGO (Cold Rolled Grain oriented) steel sheets of high permeability & small thickness coated with high temperature materials (Carlite or equivalent) to reduce eddy current losses and hysteresis losses. Their carbon content is maintained below 0.1%. Eddy current is further reduced by alloying the steel with Silicon.

Another material used for transformer core is Amorphous metal, which is a non-crystalline substance formed as ribbons. And has a superior magnetic properties. Also being very thin as compared to CRGO Sheets, the eddy current Losses also are very low. However, the saturation flux density is low as compared to CRGO silicon steel. And so is the case with mechanical strength against jerks during assembly & handling being softer than CRGO.

Various Cross-sections circular / rectangular, Core type / Shell Type may be opted depending on design.

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### Core – Cold Roller Grain Oriented Silicon steel

- Manufactured by a few steel mills across the world
- Specialized material

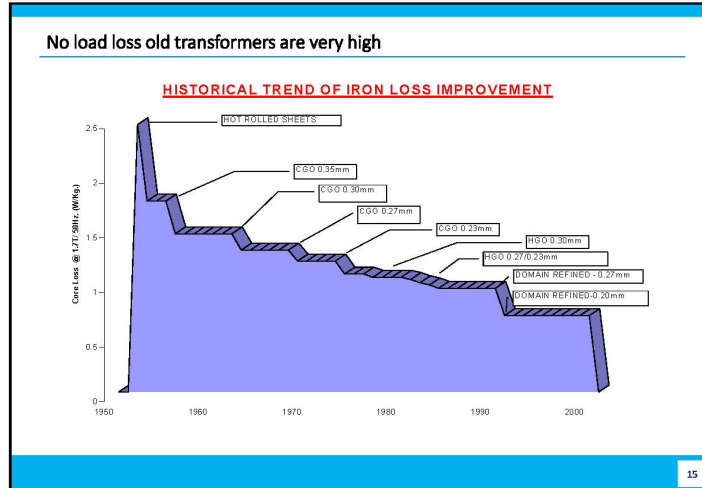
Typical Losses of Various CRGO Core

Grades	Grade of CRGO	Thickness in mm	Watts/Kg (1.7T 50Hz)
	23ZDKH (or Equi)	0.23	0.85
	23M0-H (or Equi)	0.23	0.9
	23M0-H (or Equi)	0.23	0.95
	23M0-H (or Equi)	0.23	1
	M3 (or Equi)	0.23	1.1
	27ZDKH (or Equi)	0.27	0.95
	27M0-H (or Equi)	0.27	1

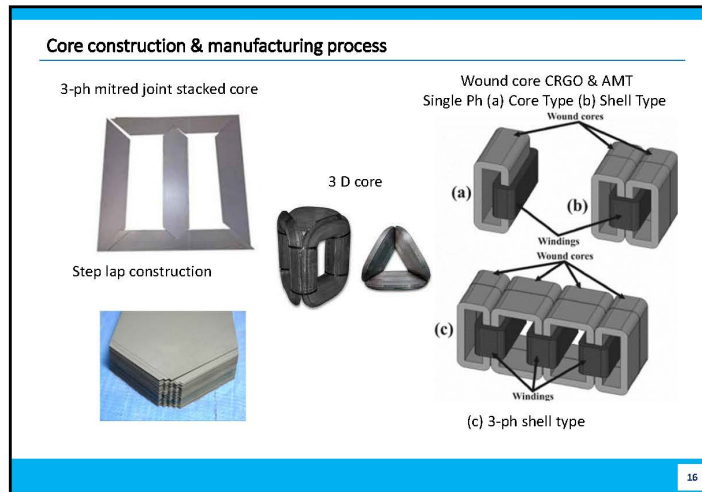
- Superior Grades of CRGO are now available with Losses upto 0.80, 0.75, 0.70 Watts/Kg at 1.7 T.
  - Losses with Amorphous Alloy at 1.5 Tesla 50 Hz are as low as 0.325 Watts/Kg(Approx.)
- However, its saturation Flux density is low as compared to CRGO & normally the designs never go beyond 1.38 to 1.4 Tesla for Amorphous core transformers. Hence higher load losses.

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### Automation

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### Conducting material

Properties	Unit	Aluminium (Al)	Copper (Cu)
Density	g/cm <sup>3</sup>	2.70	8.94
Resistance	(Ωmm <sup>2</sup> /m) × 10 <sup>2</sup>	2.66	1.68
Thermal conductivity	cal/cm <sup>2</sup> /cm <sup>2</sup> /°C	0.52	0.92
Thermal coefficient of linear expansion	(mm/mm°C) × 10 <sup>6</sup>	24.00	16.70
Melting temperature	°C	660.00	1083.00
Tensile strength	N/mm <sup>2</sup>	91.50	220.50
Elongation	%	30.10	36.67
Hardness	HV	57.98	106.90

Creep curves of the EC grade Aluminum HV winding conductors

Creep curves of the electrolytic copper HV winding conductors

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### Conductor windings

Distribution Windings are made of high grade electrolytic copper or aluminium, which are designed to optimize thermal, mechanical and electrical stresses. The winding machines are equipped with different speed gears to ensure that proper tension is maintained on the windings. The conductors are suitably transposed at intervals to reduce the circulating current losses in winding. Axial & Radial wedges and dove-tailed / T-spacers are provided as cooling ducts as per the design.

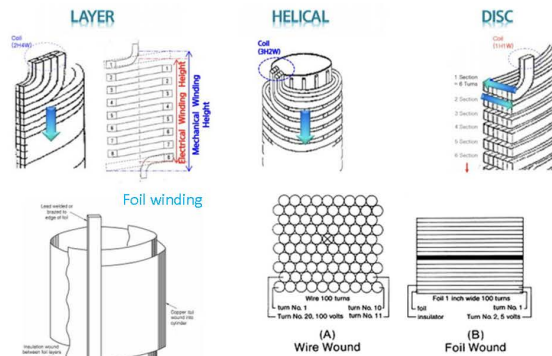
Using single / multiple winding conductors as per current & voltage Ratings, Different winding types are used in transformers, Such As :

- Spiral / Layer Type winding
- Helical winding
- Cross-over winding
- Continuous Disc winding
- Foil winding

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### Winding types



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### LV Foil winding

LV Foil winding:

- It uses a single piece of thin strip as conductor. Width of the foil is equal to length of the winding.
- This conductor strip (foil) wound along with a pre-impregnated interlayer insulation. During curing process foil and insulation are bonded together to form a rigid block. The LV coil becomes self supporting against forces.
- Later the coil is impregnated with resin for environmental protection.
- Eddy losses in the thin foil are very less compared to thick rectangular wires, so windings made with foil are cooler than other types.
- Foil winding minimizes the axial forces during short circuit, since currents in the winding are adjusted to the ampere turns in the high voltage winding.
- Is simple introduce cooling duct without decreasing the mechanical strength.
- It is easy and quick to manufacture this type of winding.

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### Manufacturing – Core Coil Assembly (CCA)

The construction of the Core & Coil Assembly is significant from the performance point of the transformer. The CCA defines the insulation scheme, cooling, dynamic withstand capability, handling. The construction of the CCA by providing sufficient radial and axial supports prevents the stress from causing any damage to the windings. Clamping of the windings axially is necessary to hold the assembly firmly. Clamping structure of the assembly has supports to route the tap and line terminals. Insulated vertical and horizontal strips of adequate thickness of a frame work to assist the routing of terminals.

Insulation scheme is categorized into major and minor insulation. Major insulation addresses the capability to withstand high voltages, isolation of the primary and secondary winding, clearances for voltage withstand. Minor insulation is the turn insulation, joint protection etc. Both the major and minor insulation are equally important for the successful operation of the transformer. The Thermal class of insulation depends on the Type of cooling medium.

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**Manufacturing – Core Coil Assembly (CCA)**

3 D Core Coil Wining machine

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**Drying**

Significant part of the insulation used in oil immersed transformer is paper and wood based. This insulation material has high affinity to moisture which may weaken the insulation properties and reduce the insulation resistance to high voltages. It

For the above reasons, transformer windings & Core Coil Assembly undergo drying process at various stages depending on the rating and voltage class.

There are two types of drying: Air drying and Vacuum drying. Air drying is used in distribution transformers limited to voltage class below 33 KV, while Vacuum drying is predominantly used for all transformers of voltage class above 33 KV.

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### Tank & radiators

The Transformer enclosure is generally referred to as tank. This is a fabricated structure constructed of mild steel of adequate thickness & generally rectangular shaped. The tank has two main functions:

- i) To hold the CCA with proper clearances for voltage and oil flow.
- ii) To facilitate cooling, safety and maintenance.

The tank must be leak proof, and should withstand the specified pressure during all service as well as test conditions.

Depending on heat dissipation requirements to keep the specified temperature rise requirements in test conditions & service, the transformer tank wall either has corrugations or is fitted with pressed steel fin type radiator banks.



Corrugated tank

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### Final assembly & fitting

After drying process, the CCA is inserted into the transformer tank. The CCA should stand freely inside the tank & inside clearances are to be maintained. . The primary and the secondary terminations are brought out through porcelain or epoxy cast bushing insulation.

Off circuit Tap Switch or OLTC connections are to be secured tightly & separated.

Handling, jacking facility to lift the transformer or jack it for fixing detachable rollers is normally provided. The transformer tank is also fitted with valves for oil filling, filtration, oil sampling, draining. Provision for safety devices like Buchholz relay, pressure relief valve, temperature recording and control instruments, neutral current transformer, protection and instrument transformer are customized features as per buyer's requirement. In non-sealed transformers, conservator is provided for oil expansion and contraction during the operating cycle. For sealed type transformers DGPT Relay also is sometimes provided for protection. Terminal identification /marking are also done on/near the bushings.

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### Transformer oil (Mineral PCB free)

Table 1 – General specifications, Type A (fully inhibited high-grade oils)

Property	Test method	Limits	
		Transformer oil	Low-temperature switchgear oils
<b>1 – Function</b>			
Viscosity at 40 °C	ISO 3104 a or ASTM D7042	Max. 12 mm <sup>2</sup> /s	Max. 3.5 mm <sup>2</sup> /s
Viscosity at –30 °C *	ISO 3104 a or ASTM D7042	Max. 1800 mm <sup>2</sup> /s	–
Viscosity at –40 °C *	IEC 61868	–	Max. 400 mm <sup>2</sup> /s
Pour point	ISO 3016	Max. – 40 °C	Max. – 60 °C
Water content	IEC 60814	Max. 30 mg/kg <sup>d</sup> / 40 mg/kg <sup>e</sup>	
Breakdown voltage	IEC 60156	Min. 30 kV / 70 kV <sup>f</sup>	
Density at 20 °C	ISO 12185 a or ISO 3675 or ASTM D7042	Max. 895 kg/m <sup>3</sup>	
DDF at 90 °C	IEC 60247 a or IEC 61620	Max. 0,005	
Flash point	ISO 2719	Min. 135 °C	Min. 100 °C

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### K Class liquid (Natural Ester)

FR3 fluid Acceptance Limits

PROPERTY	Standard test methods		ASTM D6871/IEEE C57.147	IEC 62770	FR3 fluid
	ASTM	ISO/IEC	As-received new fluid property requirements	Unused new fluid property requirements	TYPICAL
<b>Physical</b>					
Color	D1500	ISO 2211	≤1.0	–	0.5
Flash Point PMCC (°C)	D93	ISO 2719	≥250	≥250	260-270
Flash Point OGC (°C)	D92	ISO 2592	≥275	–	310-330
Fire Point (°C)	D92	ISO 2592	≥300	≥300	300-360
Pour Point (°C)	D97	ISO 3016	<-10	>-10	-10 to -21
Density at 20°C (g/cm <sup>3</sup> )	–	ISO 3675	–	≤1.0	0.92
Relative Density (Specific Gravity) 15°C	D1298	–	≤0.96	–	0.92
<b>Viscosity (mm<sup>2</sup>/sec)</b>					
100°C	D445	ISO 3104	≤15	≤15	7.7 - 8.3
40°C	–	–	≤50	≤50	31 - 34
0°C	–	–	≤500	–	195
-20°C	–	–	–	–	500
<b>Visual Examination</b>					
	D1524	IEC 62770 4.21	bright and clear	clear, free from sediment and suspended matter	clear, light green
<b>Biodegradation</b>					
	–	–	readily biodegradable	readily biodegradable	readily biodegradable
<b>Aquatic and Oral Acute Toxicity</b>					
	–	–	non-toxic	non-toxic	non-toxic
<b>Electrical</b>					
Dielectric Breakdown (kV)	D877	–	≥30	–	≥45
<b>Dielectric Breakdown (kV)</b>					
1mm gap	D816	–	≥20	–	≥25
2mm gap	D816	–	≥35	–	≥50
3.2mm gap	–	IEC 60156	–	≥35	≥50
Dielectric Breakdown under Impulse (kV) 25.4mm gap	D3300	–	>130	–	140
Gassing Tendency (µl/min)	D2300	–	<0	–	-79
<b>Dissipation Factor</b>					
25°C (%)	D924	–	≤0.20	–	0.010 - 0.15
80°C (tanδ)	–	IEC 60247	–	≤0.05	0.01 - 0.03
100°C (%)	D264	–	<4.0	–	1.00 - 3.85

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## Manufacturing process

### TRANSFORMER OIL:

Transformer oil acts as cooling & insulating medium in a transformer. Generally, mineral oil as per IEC-60296 is used. Oil is filtered under vacuum before filling into the transformer. In recent times, due to Health safety & Environmental concerns ester (synthetic as well as natural) oils are also being used in distribution transformers.

### PAINTING:

Before Use, All fabricated steel tanks internally & externally cleaned thoroughly of all scales etc. For interior walls, anti-corrosive paint like Zinc chromate with excellent chemical resistance is used. For Exteriors, two coats of glossy, oil & weather resisting, non fading Epoxy paint is generally applied.

### TESTING & DISPATCH:

Apart from in process checks as per QC plan, All routine tests as per IEC 60076 on each transformer are carried out. Type Tests and special tests forming part of acceptance tests as per customer requirement are also carried out.

Inspection before dispatch is required to ensure that the transformers are fitted with all accessories as per customer specification etc. The transformers need to be secured / locked against any possible damage/ defect during transportation to the consignee's storage area of installation site.

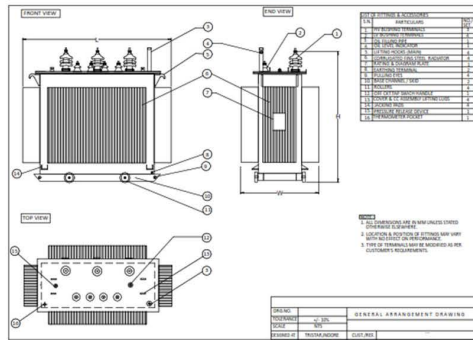
### INSTRUCTION MANUAL:

An instruction manual containing, the guidelines for unloading, handling, storage, installation, commissioning, periodic diagnostics & maintenance etc is also provided.

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## Documentation - General arrangement drawing



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**List of plant machinery (1/3)**

**LIST OF ESSENTIAL PLANT & MACHINERY**  
(FOR MANUFACTURING OIL IMMersed DISTRIBUTION TRANSFORMERS UPTO 2500 KVA)

S.No.	Description
<b>1</b>	<b>Core Assembly Section</b>
a	Core Assembly Tables / Platforms
b	Core lifting / Handling Fixures
c	Mandrals etc
<b>2</b>	<b>Winding Section</b>
a	Layer / Spiral / Disc Type Coil Winding Machines for LV Coil (can also wind HV coil over LV) - Circular Coils
b	Foil Winding Machines for LV Coil (can also wind HV coil over LV) - Circular Coils
c	Cross-over Type HV Coil winding Machines -Circular Coils
d	Rectangular Coil winding machines
e	Decoilers / Conductor Feeding Stands, Tenstioners etc
f	Adjustable winding formers
g	Coil Pressing Jigs & Fixures

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**List of plant machinery 2/3**

**LIST OF ESSENTIAL PLANT & MACHINERY**  
(FOR MANUFACTURING OIL IMMersed DISTRIBUTION TRANSFORMERS UPTO 2500 KVA)

S.No.	Description
<b>3</b>	<b>Insulation Cutting Section</b>
a	Paper Insulation Cutting / Sheering Machines
b	Spacer / Block puncing press machines
c	Multi Purpose Wood working & Sawing Machines
<b>4</b>	<b>Core-Coil Assembly &amp; Proceesing Section</b>
a	Core-Coil Assembly Platforms / Tables / Floor space
b	Trolleys etc handling equipments
c	Air Drying Oven
d	Vacuum Oven (Optional)
e	Tools & Fixures, Workstations etc

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### List of plant machinery (3/3)

#### LIST OF ESSENTIAL PLANT & MACHINERY

(FOR MANUFACTURING OIL IMMERSED DISTRIBUTION TRANSFORMERS UPTO 2500 KVA)

S.No.	Description
5	Tank Assembly Section & others (common)
a	EOT Crane/s
b	Trolleys, Fork lift etc handling equipments
c	Tools & Fixures, Workstations etc
d	High Vacuum Oil Filter Plant & pipelines
e	Oil Storage Tanks
f	Compressors, vacuum pumps etc
g	Painting booth with dust free environment

Any other Extra Machinery may also be installed depending on plant capacity & level of automation as feasible.

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### Quality assurance - Testing equipment (1/2)

#### LIST OF ESSENTIAL TEST EQUIPMENTS

(FOR TESTING OIL IMMERSED DISTRIBUTION TRANSFORMERS UPTO 2500 KVA)

S.No.	Description
1	Electrical Tests (In Process / Final )
a	Winding Resistance meters
b	Turn ratio & Polarity test meters
c	Insulation Resistance Testers
d	Multimeters/ Clamp Testers
e	Oil BDV Test Kit
f	Portable HV tester
2	Mechanical Tests (In Process / Final )
a	Dimensional Check - Micrometers & verniers, Scales etc
b	Pressure Test kit with gauges
c	Vacuum Test kit with gauges
d	Paint Thickness Gauge

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**Quality assurance - Testing equipment (2/2)**

**LIST OF ESSENTIAL TEST EQUIPMENTS**  
(FOR TESTING OIL IMMERSSED DISTRIBUTION TRANSFORMERS UPTO 2500 KVA)

S.No.	Description
<b>3</b>	<b>Final Testing before Dispatch ( Additional to the above )</b>
a	Power supply Source / Generator
b	Three Phase Variac / Regulator
c	Intermediate Testing Transformers (For Load tests/ Temperature Rise Test etc)
d	High Voltage Testing Transformer (For Separate Source high Voltage Test)
e	Double/Tripplle Frequency Generator ( For Induced Overvoltage Test)
f	High Accuracy Three Phase Power Analyser
g	Multiple Range CTs & PTs with high accuracy
h	Noise Level (dB) Meter
i	Thermometers / Multichannel Temperature Indicators
j	Integrated or classified Transformer Test Bench comprising of Indicators, Protection & Controls for various Tests
k	Tan Delta & Resistivity Test kit (Optional)

Any other Extra Test Equipment may also be installed depending on plant capacity as feasible.

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