

EnvirotempTM FR3TM fluid

Formulated for performance.



Envirottemp[™] FR3[™] fluid.
**Trusted worldwide
two million times over.**





With over two million installations across six continents and validated in over 250 tests, Cargill's Envirotemp™ FR3™ natural ester fluid is trusted by our customers to deliver cost-effective solutions that reliably and safely help improve transformer performance.

Our team of dielectric experts is active in the standards community globally and has extensive knowledge of not only dielectric fluid properties but also fluid performance in

application. And they have transformer design experience, too. This means our customers adopting FR3 natural ester technology have comprehensive dielectric fluids support from initial planning stages through best practices implementation and beyond.

Backed by Cargill's global supply chain network, our customers can rely on us to deliver the best solution for their application — when they need it, anywhere in the world.

With FR3 fluid, our customers can:

- Gain cost efficiencies either on initial cost or total cost of ownership.
- Extend transformer insulation and asset life.
- Optimize load capability.
- Significantly improve fire safety.
- Enhance their environmental footprint and sustainable supply chain initiatives.

Improve performance with life extension and flexibility.

Protect insulation life to extend asset life.

Insulation paper is one of the primary factors that determines the life of a transformer. FR3™ fluid's unique chemistry absorbs free water and essentially wicks it away from the insulation paper. FR3 fluid has over 10 times the water saturation level of mineral oil. This results in extending the insulation life 5-8 times longer than mineral oil.



Insulation aging study comparing thermally upgraded paper using FR3 fluid vs. mineral oil.



- Save significantly on replacement costs by extending the asset life with FR3 fluid.
- Reduce the risk of failure to improve reliability of the transformer.
- Reduce processing maintenance costs, since FR3 fluid does not sludge like mineral oil.

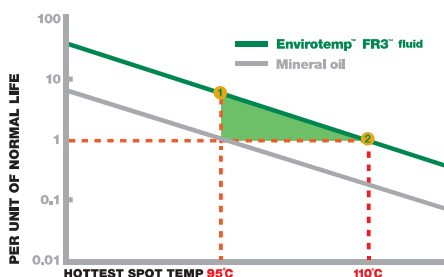
With FR3™ fluid's unique capabilities to extend insulation life and increase load capacity, organizations now have the flexibility to optimize their transformer fleet utilization in order to gain cost savings without sacrificing reliability.

Leverage higher thermal capability with FR3 fluid.

Historically, standards were written to accommodate a 95°C or 110°C hot spot for cellulose and Thermally Upgraded Kraft (TUK), respectively. However, published high temperature insulation system standards - IEC (60076-14) and IEEE (C157.154) – accommodate a 15°C or 20°C increase in hot spot without sacrificing the life or reliability of the transformer, when immersed in natural ester fluid.

Paper	Dielectric Fluid	Thermal Class	Hot spot	IEEE AWR	IEC AWR
Kraft	Mineral Oil	105	95°C	55°C	65K
Kraft	Natural Ester	120	110°C	65°C	75K

Standard Kraft life curves

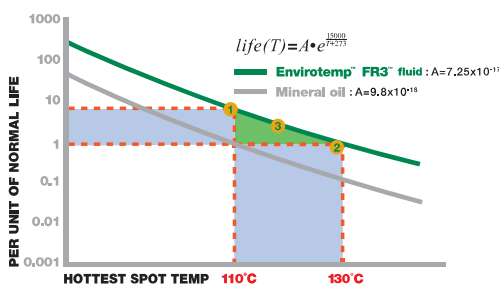


OPTION 1: Extend asset life at current 95°C hotspot.

OPTION 2: Increase load capability up to 15% with 110°C hotspot.

Paper	Dielectric Fluid	Thermal Class	Hot spot	IEEE AWR	IEC AWR
TUK	Mineral Oil	120	110°C	65°C	75K
TUK	Natural Ester	140	130°C	85°C	95K

TUK life curves



OPTION 1: Extend asset life at current 110°C hotspot.

OPTION 2: Increase load capability up to 20% with 130°C hotspot.

OPTION 3: Incrementally extend asset life and increase load capability with 120°C hotspot.

Improve fire safety.

Add more sustainability to your sustainable supply chain.



Reduce costs while increasing fire safety.

FR3™ fluid has the highest fire point of any dielectric fluid (360°C compared to 160°C for mineral oil) making it the ideal choice for densely populated areas where transformers are positioned indoors, underground or in close proximity to buildings and other equipment. FR3 fluid is a K-class, less flammable fluid as certified by Underwriters Laboratory and approved by FM Global.

- Reduce clearance to buildings which saves precious real estate, particularly in space-constrained areas.
- Retrofill older transformers with FR3 fluid instead of replacing or moving them to help comply with current fire code regulations.
- For power transformers, potentially eliminate the need for expensive fire walls and deluge systems (and their ongoing maintenance costs).

“Being green” also benefits your bottom line.

FR3 fluid not only has best-in-class environmental properties, but with its enhanced thermal capabilities enabling optimized transformer designs, your supply chain just got a whole lot more sustainable.

- More efficient transformer designs:
 1. Use less fluid and construction materials.
 2. Are typically lighter which could make installations easier for work crews and could reduce transportation costs.

Envirotemp™ FR3™ fluid properties: standard acceptance values and typical values

	Standard test methods		ASTM D6871/IEEE C57.147	IEC 62770	Envirotemp FR3 fluid	
PROPERTY	ASTM	ISO/IEC	As-received new fluid property requirements	Unused new fluid property requirements	TYPICAL	
Physical						
Color	D1500	ISO 2211	≤1.0	–	0.5	
Flash Point PMCC (°C)	D93	ISO 2719	–	≥250	260	
Flash Point COC (°C)	D92	ISO 2592	≥275	–	320-330	
Fire Point (°C)	D92	ISO 2592	≥300	>300	350-360	
Pour Point (°C)	D97	ISO 3016	<-10	≤-10	-21	
Density at 20°C (g/cm³)	–	ISO 3675	–	≤1.0	0.92	
Relative Density (Specific Gravity) 15°C	D1298	–	≤0.96	–	0.92	
Viscosity (mm²/sec)						
	100°C	D445	ISO 3104			
	40°C			≤15	≤15	7.7 - 8.3
	0°C			≤50	≤50	32 - 34
			≤500	–	190	
Visual Examination	D1524	IEC 62770 4.2.1	bright and clear	clear, free from sediment and suspended matter	clear, light green	
Biodegradation	OECD 301		readily biodegradable	readily biodegradable	readily biodegradable	
Electrical						
Dielectric Breakdown (kV)	D877	–	≥30	–	47	
Dielectric Breakdown (kV)						
	1mm gap	D1816	–	–	>25	
	2mm gap	D1816	–	–	>50	
	2.5mm gap	–	IEC 60156	–	>50	
Gassing Tendency (mm/min)	D2300	–	≤0	–	-79	
Dissipation Factor						
	25°C (%)	D924	–	–	0.010 - 0.15	
	90°C (tanδ)	–	IEC 60247	–	0.02	
	100°C (%)	D924	–	–	0.41 - 3.85	
Chemical						
Corrosive Sulfur	D1275	IEC 62697	non-corrosive	non-corrosive	non-corrosive	
Water Content (mg/kg)	D1533	IEC 60814	≤200	≤200	4 - 50	
Acid Number (mg KOH/g)	D974	IEC 62021.3	≤0.06	≤0.06	0.013 - 0.042	
PCB Content (mg/kg)	D4059	IEC 61619	not detectable	free from PCBs	not detectable	
Total Additives	–	IEC 60666		Max weight fraction 5%	<2%	
Oxidation Stability (48 hrs, 120°C)	–	IEC 61125C				
Total Acidity (mg KOH/g)	–	IEC 62621.3		≤0.6	0.1	
Viscosity at 40°C (mm²/sec)	–	ISO 3104		≤30% increase over initial	17.1% increase	
Dissipation Factor at 90°C (tanδ)	–	IEC 60247		≤0.5	0.1	

NOTE: Specifications should be written referencing only the defined ASTM or IEC industry standard acceptance values and test methods.

The listed 'typical' values are average values summarized from a significant number of data points over many years; they are not to be identified as acceptance values.

ASTM D6871 Standard Specification for Natural (Vegetable Oil) Ester Fluids Used in Electrical Apparatus.

IEC 62770: Fluids for electrotechnical applications – Unused natural esters liquids for transformers and similar electrical equipment.

A transformer filled with FR3™ fluid complies with the transformer temperature operating range requirements defined in IEEE C57.12.00 and IEC 60076-1.

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- Made from a renewable source with global, reliable supply.
- Carbon neutral (according to BEES 4.0 lifecycle analysis).
- Non-toxic and non-hazardous in soil and water.
- Readily Biodegradable per OECD 301.
- Contains no petroleum, halogens, silicones or sulfurs.
- Recyclable.



contact us - envirotempfluids.com

US

PO Box 5700
Minneapolis, MN 55443
USA
+1 800 842-3631
NAenvirotemp@cargill.com

Asia/Australia

138 Market Street #17- 01
CapitaGreen Singapore
048946
+65 6393-8552
AAenvirotemp@cargill.com

Brazil

Avenida Dr. Chucuri Zaidan 1240, Torre
Diamond – 6º andar Vila São Francisco -
São Paulo, SP CEP 04711-130, Brasil
+55 11 4718-8170
SAenvirotemp@cargill.com

China

Shanghai International Commerce Center
10F-12F, One ICC, 999 Huaihai Road(M),
200031 Shanghai, China
+86-21-3332-7107
Chinaenvirotemp@cargill.com

Europe

Evert van de Beekstraat 378,
1118 CZ Schiphol,
The Netherlands
+31 20 500-6695
EMEAenvirotemp@cargill.com

India

14th Floor, Building 9A
DLF Cyber City, Phase III
Gurgaon 122 002, Haryana, India
+91 124-4090489
Indiaenvirotemp@cargill.com

Turkey

Barbaros mah. Kardelen Sokak
Palladium Tower No:2/4-5-6-7
34746 Atasehir, Istanbul Turkey
+90 216 554-18 00
-CIS-SalesTR@Cargill.com

