



**STANDARD FOR
EXTRUDED INSULATION POWER CABLES
RATED ABOVE 46 THROUGH 345 KV**

Publication ICEA S-108-720-2004

July 15, 2004

© 2004 by

INSULATED CABLE ENGINEERS ASSOCIATION, Inc.

STANDARD FOR
EXTRUDED INSULATION POWER CABLES
RATED ABOVE 46 THROUGH 345 KV

Standard
ICEA S-108-720-2004

Published By
INSULATED CABLE ENGINEERS ASSOCIATION, Inc.
Post Office Box 1568
Carrollton, Georgia 30112, U.S.A.

Approved by Insulated Cable Engineers Association, Inc.: June 7, 2004
Accepted by AEIC: Cable Engineering Committee: February 9, 2004
Approved by ANSI: May 12, 2005

© Copyright 2004 by the Insulated Cable Engineers Association, Inc. All rights including translation into other languages, reserved under the Universal Copyright Convention, the Berne Convention for the Protection of Literary and Artistic Works, and the international and Pan American Copyright Conventions.

FOREWORD

This Standards Publication for Extruded Insulation Power Cables Rated above 46 to 345 kV (ICEA S-108-720) was developed by the Insulated Cable Engineers Association Inc. (ICEA).

ICEA standards are adopted in the public interest and are designed to eliminate misunderstandings between the manufacturer and the purchaser and to assist the purchaser in selecting and obtaining the proper product for his particular need. Existence of an ICEA standard does not in any respect preclude the manufacture or use of products not conforming to the standard. The user of this Standards Publication is cautioned to observe any health or safety regulations and rules relative to the manufacture and use of cable made in conformity with this Standard.

Requests for interpretation of this Standard must be submitted in writing to the Insulated Cable Engineers Association, Inc., P. O. Box 1568, Carrollton, Georgia 30112. An official written interpretation will be provided. Suggestions for improvements gained in the use of this Standard will be welcomed by the Association.

The ICEA expresses thanks to the Association of Edison Illuminating Companies, Cable Engineering Committee for providing the basis for some of the material included herein through their participation in the Utility Power Cable Standards Technical Advisory Committee (UPCSTAC), and to the Institute of Electrical and Electronics Engineers, Insulated Conductors Committee, Subcommittee A, Discussion Group A-14 for providing user input to this Standard.

The members of the ICEA working group contributing to the writing of this Standard consisted of the following:

F. Kuchta, Chairman

E. Bartolucci
J. Cancelosi
L. Hiivala
R. Thrash

R. Bristol
P. Cinquemani
A. Pack
E. Walcott

S. Campbell
B. Fleming
B. Temple
N. Ware

TABLE OF CONTENTS

Part 1 GENERAL 1

1.1 SCOPE..... 1

1.2 GENERAL INFORMATION 1

1.3 INFORMATION TO BE SUPPLIED BY PURCHASER..... 1

 1.3.1 Characteristics of Systems on which Cable is to be Used 1

 1.3.2 Description of Installation 2

 1.3.3 Quantities and Description of Cable..... 2

1.4 INFORMATION TO BE SUPPLIED BY MANUFACTURER 2

1.5 DEFINITIONS AND SYMBOLS..... 2

Part 2 CONDUCTOR 6

2.0 GENERAL 6

2.1 PHYSICAL AND ELECTRICAL PROPERTIES 6

 2.1.1 Copper Conductors..... 6

 2.1.2 Aluminum Conductors 6

 2.1.3 Special Conductors..... 6

 2.1.3.1 Segmental Conductors..... 7

2.2 OPTIONAL SEALANT FOR STRANDED CONDUCTORS 7

2.3 CONDUCTOR SIZE UNITS 7

2.4 CONDUCTOR DC RESISTANCE 7

 2.4.1 Direct Measurement of dc Resistance Per Unit Length..... 7

 2.4.2 Calculation of dc Resistance Per Unit Length..... 8

2.5 CONDUCTOR DIAMETER 8

Part 3 CONDUCTOR SHIELD..... 14

3.1 MATERIAL 14

3.2 EXTRUDED SHIELD THICKNESS 14

3.3 PROTRUSIONS AND IRREGULARITIES 14

3.4 VOIDS 14

3.5 PHYSICAL REQUIREMENTS..... 15

3.6 ELECTRICAL REQUIREMENTS 15

 3.6.1 Extruded Semiconducting Material..... 15

 3.6.2 Extruded Nonconducting Material (For EPR Insulation Only) 15

 3.6.3 Semiconducting Tape 15

3.7 WAFER BOIL TEST..... 15

Part 4 INSULATION 16

4.1 MATERIAL 16

4.2 INSULATION THICKNESS 16

 4.2.1 Selection of Proper Thickness..... 17

 4.2.2 Insulation Eccentricity 18

4.3 INSULATION REQUIREMENTS..... 18

 4.3.1 Physical and Aging Requirements 18

 4.3.2 Electrical Test Requirements..... 19

 4.3.2.1 Partial-Discharge for Discharge-Free Designs only 19

 4.3.2.2 Voltage Tests..... 20

 4.3.2.3 Insulation Resistance Test..... 20

 4.3.2.4 Dielectric Constant and Dissipation Factor..... 21

 4.3.2.5 Discharge (Corona) Resistance fro Discharge-Resistant EPR Designs only 21

4.3.3 Voids, Ambers, Gels, Agglomerates and Contaminants as Applicable 21

 4.3.3.1 Crosslinked Polyethylene Insulation (XLPE) 21

 4.3.3.2 Ethylene Propylene Rubber (EPR) 21

4.3.4 Shrinkback - Crosslinked Polyethylene Insulation (XLPE) Only 22

Part 5 EXTRUDED INSULATION SHIELD 23

5.1 MATERIAL 23

5.2 THICKNESS REQUIREMENTS 23

5.3 PROTRUSIONS AND IRREGULARITIES 23

5.4 SEMICONDUCTING TAPE 23

5.5 INSULATION SHIELD REQUIREMENTS 23

 5.5.1 Removability 23

 5.5.2 Voids 24

 5.5.3 Physical Requirements 24

 5.5.4 Electrical Requirements 24

 5.5.5 Wafer Boil Test 24

Part 6 METALLIC SHIELDING 25

6.1 GENERAL 25

6.2 SHIELDS 25

 6.2.1 Helically Applied Tape Shield 25

 6.2.2 Longitudinally Applied And Overlapped Corrugated Tape Shield 25

 6.2.3 Wire Shield 25

 6.2.4 Flat Strap Shield 26

6.3 SHEATHS 26

 6.3.1 Lead Sheath 26

 6.3.2 Smooth Aluminum Sheath 26

 6.3.3 Continuously Corrugated Sheath 26

6.4 RADIAL MOISTURE BARRIER 27

6.5 OPTIONAL LONGITUDINAL WATER BLOCKING COMPONENTS 27

Part 7 JACKET 28

7.1 MATERIAL 28

 7.1.1 Polyethylene, Black 28

 7.1.2 Polyvinyl Chloride 29

7.2 JACKET APPLICATION AND THICKNESS 30

 7.2.1 Thickness of Jacket for Tape and Wire Shields 30

 7.2.2 Thickness of Jacket for Sheaths 30

7.3 OPTIONAL SEMICONDUCTING COATING 30

7.4 JACKET IRREGULARITY INSPECTION 30

 7.4.1 Jackets without Optional Semiconducting Coating 30

 7.4.2 Jackets with Optional Semiconducting Coating 30

Part 8 CABLE IDENTIFICATION 33

8.1 CABLE IDENTIFICATION 33

 8.1.1 Optional Center Strand Identification 33

 8.1.2 Optional Sequential Length Marking 33

Part 9 PRODUCTION TESTS 34

9.1 TESTING 34

9.2 SAMPLING FREQUENCY 34

9.3 CONDUCTOR TEST METHODS 34

9.3.1	Method for DC Resistance Determination	34
9.3.2	Cross-Sectional Area Determination	34
9.3.3	Diameter Determination	34
9.4	TEST SAMPLES AND SPECIMENS FOR PHYSICAL AND AGING TESTS	34
9.4.1	General	34
9.4.2	Measurement of Thickness	34
9.4.2.1	Micrometer Measurements	35
9.4.2.2	Optical Measuring Device Measurements	35
9.4.3	Number of Test Specimens	35
9.4.4	Size of Specimens	35
9.4.5	Preparation of Specimens of Insulation and Jacket	36
9.4.6	Specimen for Aging Test	36
9.4.7	Calculation of Area of Test Specimens	36
9.4.8	Unaged Test Procedures	36
9.4.8.1	Test Temperature	36
9.4.8.2	Type of Testing Machine	36
9.4.8.3	Tensile Strength Test	36
9.4.8.4	Elongation Test	37
9.4.9	Aging Tests	37
9.4.9.1	Aging Test Specimens	37
9.4.9.2	Air Oven Test	37
9.4.9.3	Oil Immersion Test for Polyvinyl Chloride Jacket	37
9.4.10	Hot Creep Test	38
9.4.11	Solvent Extraction	38
9.4.12	Wafer Boil Test for Conductor and Insulation Shields	38
9.4.12.1	Insulation Shield Hot Creep Properties	38
9.4.13	Amber, Agglomerate, Gel, Contaminant, Protrusion, Irregularity and Void Test	38
9.4.13.1	Sample Preparation	38
9.4.13.2	Examination	38
9.4.13.3	Resampling for Amber, Agglomerate, Gel, Contaminant, Protrusion, Irregularity and Void Test	39
9.4.13.4	Protrusion and Irregularity Measurement Procedure	39
9.4.14	Physical Tests for Semiconducting Material Intended for Extrusion	40
9.4.14.1	Test Sample	40
9.4.14.2	Test Specimens	40
9.4.14.3	Elongation	40
9.4.15	Retests for Physical and Aging Properties and Thickness	40
9.5	DIMENSIONAL MEASUREMENTS OF THE METALLIC SHIELD	40
9.5.1	Tape Shield	40
9.5.2	Wire Shield	40
9.5.3	Sheath	41
9.5.4	Flat Straps	41
9.6	DIAMETER MEASUREMENT OF INSULATION AND INSULATION SHIELD	41
9.7	TESTS FOR JACKETS	41
9.7.1	Heat Shock	41
9.7.1.1	Preparation of Test Specimen	41
9.7.1.2	Winding of the Test Specimen on Mandrels	41
9.7.1.3	Heating and Examination	42
9.7.2	Heat Distortion	42
9.7.3	Cold Elongation	42
9.7.3.1	Test Temperature	42
9.7.3.2	Type of Testing Machine	42
9.7.3.3	Elongation Test	42

9.8 VOLUME RESISTIVITY	43
9.8.1 Conductor Shield.....	43
9.8.2 Insulation Shield and Semiconducting Extruded Jacket Coating	43
9.8.3 Test Equipment	43
9.8.4 Test Procedure.....	44
9.9 SHRINKBACK TEST PROCEDURE	44
9.9.1 Sample Preparation	44
9.9.2 Test Procedure.....	44
9.9.3 Pass/Fail Criteria and Procedure.....	44
9.10 RETESTS ON SAMPLES	44
9.11 AC VOLTAGE TEST	45
9.11.1 General.....	45
9.11.2 AC Voltage Test.....	45
9.12 PARTIAL-DISCHARGE TEST PROCEDURE	45
9.13 METHOD FOR DETERMINING DIELECTRIC CONSTANT AND DIELECTRIC STRENGTH OF EXTRUDED NONCONDUCTING POLYMERIC STRESS CONTROL LAYERS	45
9.14 WATER CONTENT	45
9.14.1 Water Under the Jacket	46
9.14.2 Water in the Conductor	46
9.14.3 Water Expulsion Procedure	46
9.14.4 Presence of Water Test	46
9.15 PRODUCTION TEST SAMPLING PLANS	47
Part 10 QUALIFICATION TESTS	50
10.0 GENERAL	50
10.1 CABLE QUALIFICATION TESTS	50
10.1.1 Cable Design Qualification	50
10.1.2 Cable Bending Procedure.....	53
10.1.2.1 Bending Diameter.....	53
10.1.3 Thermal Cycling Procedure	53
10.1.3.1 Thermal Cycles.....	53
10.1.3.2 Voltage During Thermal Cycles	54
10.1.4 Hot Impulse Test Procedure	54
10.1.5 AC Voltage Withstand Test Procedure	54
10.1.6 Partial Discharge Test Procedure (For Discharge-Free Designs Only).....	54
10.1.7 Measurement of Dissipation Factor.....	54
10.1.8 Dissection and Analysis of Test Specimens	54
10.2 JACKET MATERIAL QUALIFICATION TESTS	55
10.2.1 Polyethylene Jackets	55
10.2.1.1 Environmental Stress Cracking Test	55
10.2.1.1.1 Test Specimen.....	55
10.2.1.1.2 Test Procedure	55
10.2.1.2 Absorption Coefficient Test.....	55
10.2.2 Semiconducting Extruded Jacket Coatings	55
10.2.2.1 Brittleness Temperature.....	55
10.2.3 Polyvinyl Chloride.....	55
10.2.3.1 Sunlight Resistance.....	55
10.2.3.1.1 Test Samples.....	55
10.2.3.1.2 Test Procedure	55
10.3 OTHER QUALIFICATION TESTS	56
10.3.1 Insulation Resistance.....	56
10.3.2 Accelerated Water Absorption Tests.....	56

10.3.3	Resistance Stability Test.....	56
10.3.4	Brittleness Temperature for Semiconducting Shields.....	57
10.3.5	Discharge Resistance Test for Discharge-Resistant EPR Designs only	57
10.3.5.1	Test Specimens.....	57
10.3.5.2	Test Environment	57
10.3.5.3	Test Electrodes.....	57
Part 11	APPENDICES	58
APPENDIX A	NEMA, ICEA, IEEE, ASTM AND ANSI STANDARDS (Normative)	58
A1	NEMA PUBLICATIONS	58
A2	ICEA PUBLICATIONS	58
A3	IEEE AND ANSI STANDARDS	58
A4	ASTM STANDARDS.....	58
APPENDIX B	EMERGENCY OVERLOADS (Normative).....	61
APPENDIX C	PROCEDURE FOR DETERMINING THICKNESS REQUIREMENTS OF THE INSULATION SHIELD, LEAD SHEATH AND JACKET (Normative)	63
APPENDIX D	CABLE COMPONENT FUNCTION (Informative).....	65
D1	CONDUCTOR.....	65
D1.1	Function	65
D1.2	Material	65
D2	CONDUCTOR SHIELD	65
D2.1	Function	65
D2.1.1	Nonconducting.....	65
D2.1.2	Semiconducting	65
D2.2	Voltage Stress	65
D3	INSULATION.....	66
D4	INSULATION SHIELD	66
D4.1	Semiconducting Shield.....	67
D4.2	Metallic Shield.....	67
D5	JACKET.....	67
APPENDIX E	HANDLING AND INSTALLATION PARAMETERS (Informative).....	69
E1	INSTALLATION TEMPERATURES.....	69
E2	RECOMMENDED MINIMUM BENDING RADIUS	69
E3	DRUM DIAMETERS OF REELS.....	69
E4	MAXIMUM TENSION AND SIDEWALL BEARING PRESSURES	69
E5	ELECTRICAL TESTS AFTER INSTALLATION	70
E5.1	Insulation.....	70
E5.2	Jacket.....	70
APPENDIX F	TRADITIONAL INSULATION WALL THICKNESS (Informative).....	71
APPENDIX G	ADDITIONAL SHIELD WIRE AND CONDUCTOR INFORMATION (Informative).....	72
APPENDIX H	ETHYLENE ALKENE COPOLYMER (EAM) (Informative).....	75
APPENDIX I	SPECIFICATION FOR ALLOY LEAD SHEATHS (Informative).....	76
I1	PURPOSE.....	76
I2	MATERIAL	76
I3	REQUIREMENTS	76

LIST OF TABLES

Table 2-1	Weight Increment Factors	8
Table 2-2	Nominal Direct Current Resistance in Ohms Per 1000 Feet at 25 °C of Concentric Lay Stranded and Segmental Conductor	9

Table 2-2 (Metric)	Nominal Direct Current Resistance in Milliohms Per Meter at 25 °C of Concentric Lay Stranded and Segmental Conductor	10
Table 2-3	Nominal Diameters for Round Copper and Aluminum Conductors	11
Table 2-3 (Metric)	Nominal Diameters for Round Copper and Aluminum Conductors	12
Table 2-4	Nominal Diameters for Segmental Copper and Aluminum Conductors	13
Table 2-5	Factors for Determining Nominal Resistance of Stranded Conductors Per 1000 Feet at 25 °C	13
Table 3-1	Extruded Conductor Shield Thickness	14
Table 4-1	Conductor Maximum Temperatures	16
Table 4-2	Conductor Sizes, Maximum Insulation Eccentricity, Insulation Maximum Stress and Test Voltages	18
Table 4-3	Insulation Physical Requirements	19
Table 4-4	Partial-Discharge Requirements	19
Table 4-5	Test Voltages for Partial-Discharge Measurements	20
Table 4-6	Impulse Values	20
Table 4-7	Dielectric Constant and Dissipation Factor	21
Table 4-8	Shrinkback Test Requirements	22
Table 5-1	Insulation Shield Thickness	23
Table 6-1	Lead Sheath Thickness	26
Table 7-1	Polyethylene, Black	28
Table 7-2	Polyvinyl Chloride	29
Table 7-3	Semiconducting Extruded Coating	31
Table 7-4	Jacket Thickness and Test Voltage for Tape or Wire Shield Cables	31
Table 7-5	Jacket Thickness and Test Voltage for All Sheath Cables	32
Table 9-1	Test Specimens for Physical and Aging Tests	35
Table 9-2	Bending Requirements for Heat Shock Test	42
Table 9-3	Summary of Production Tests and Sampling Frequency Requirements	47
Table 9-4	Plan E	49
Table 9-5	Plan F	49
Table 10-1	Generic Grouping of Cable Components	51
Table 10-2	Accelerated Water Absorption Properties	56
Table D-1	Jacket Functions	67
Table E-1	Recommended Minimum Bending Radius	69
Table F-1	Traditional Insulation Thickness from AEIC CS7-93, Test Voltages and Conductor Sizes	71
Table G-1	Solid Copper Shield Wires	72
Table G-2	Concentric Stranded Class B Aluminum and Copper Conductors	73
Table G-3	Concentric Stranded Class C and D Aluminum and Copper Conductors	74
Table I-1	Chemical Requirements for Alloy Lead Sheaths	76

Part 1 GENERAL

1.1 SCOPE

This standard applies to materials, constructions, and testing of crosslinked polyethylene (XLPE) and ethylene propylene rubber (EPR) insulated single conductor shielded power cables rated above 46 to 345 kV used for the transmission of electrical energy.

1.2 GENERAL INFORMATION

This publication is arranged to allow for selection of individual components (such as conductors, insulation, semiconducting shields, metallic shields, jackets, etc.) as required for specific installation and service conditions.

Parts 2 to 7 cover the major components of cables:

- Part 2 - Conductor
- Part 3 - Conductor Shield
- Part 4 - Insulation
- Part 5 - Extruded Insulation Shield
- Part 6 - Metallic Shielding
- Part 7 - Jacket

Each of these parts designates the materials, material characteristics, dimensions, and tests applicable to the particular component.

Part 8 covers identification of cables.

Part 9 covers production test procedures applicable to cable component materials and to completed cables.

Part 10 covers qualification test procedures.

Part 11 contains appendices of pertinent information.

U.S. customary units, except for temperature, are specified throughout this standard. Approximate International System of Units (SI) equivalents are included for information only.