

INDUSTRIAL WATER ANALYSIS HANDBOOK

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INDUSTRIAL WATER ANALYSIS HANDBOOK

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TO
THE LOTUS FEET OF
LORD MURUGA
AND TO MY PARENTS
C.K.NATARAJ & ARUNAGIRI AMMAL**



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PREFACE

Water analysis has become extremely important for many reasons. Not only to design suitable water treatment plant during commissioning of the industry but it is essential for continuous monitoring of the quality of treated water. Without a proper water analysis program, the efficacy of water treatment cannot be ascertained. A proper water analysis would also reduce the cost on treatment significantly. Knowing this fully well, every industry is setting up their own water analysis laboratory as a part of their industry. Abundant literature is available on the analysis of water, but this book is especially written to suit the needs of industries. All the test procedures for the parameters pertaining to industrial water analysis are provided in this book and discussed in detail. Another salient feature of this book is that the analytical procedures are given in a step by step way so that it becomes easier for the analyst to carryout analysis of water. Chapters are arranged in alphabetical order for easy access to the required chapter. Thus this book would serve as a valuable reference to carryout analysis of water for any intended industrial purpose. This apart, it is extremely useful to carryout examination of waster water too.

This book is divided into four parts.

Part – I 'Introduction' provides a detailed introduction on analysis of water along with parameters to be determined for each industrial use, thus helps to reduce the time required for analysis and labor involved in analysis.

In Part – II 'Chemical Analysis', elaborate testing procedures for all the parameters necessary for industrial uses are given. Exclusive chapters in the beginning on 'Sampling of water' and 'Sampling of Boiler water' will provide the analyst a detailed sampling program and the important sampling points so that the analysis would be more meaningful and more useful. Detailed analytical procedures for 65 chemical parameters are given which makes this book a handy reference for carrying out analysis without any difficulty.

Part – III 'Microbiological Analysis' deals with the identification and determination of the density of microbial organisms that are likely to interfere in industrial processes. To aid the analyst, separate chapters starting from the Requirement of Chemicals, Glassware and Equipment, Technics involved in

(ii)

Microbiological Analysis, Sampling of Water for Microbiological Examination and Preparation of Media and Reagents, to identification of specific organisms are provided with a detailed discussion.

In Part – IV 'Microscopical Examination', a brief account of microscopical organisms is given. The common organisms present in water along with their habitat and significance are also dealt.

This book would serve as a handy reference to all wet processing industries. This book would be helpful in multifarious ways to Analysts, Chemists, Engineers, and Managers of industries and Water Treatment Consultants, Firms engaged in Water Treatment and other personnel engaged in water analysis and water treatment. This apart, this book would also be a source book to students of Industrial Engineering, Chemical Engineering, Industrial Chemistry, Applied chemistry, Environmental Engineering and Environmental Science and other allied faculties of Colleges and Universities.

This book has been prepared with the help and assistance of a number of people. Their assistance made this book a most useful volume. I owe a great debt of gratitude to all of them. Some of the organizations have been most gracious in granting permission to reproduce certain illustrations, figures and portions from their publications. Their cooperation is gratefully acknowledged. A special debt of gratitude is due to M/S. Chemical Publishing Company, Gloucester, U.S.A., for their keen interest shown towards the publication of this book.

Comments and criticisms as well as suggestions for the improvement of the book are solicited.

**Coimbatore – 42 (TN)
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This book is divided into the following parts.

Part I. INTRODUCTION

Part II. CHEMICAL ANALYSIS

Part III. MICROBIOLOGICAL ANALYSIS

Part IV. MICROSCOPICAL EXAMINATION

CONTENTS

PART I INTRODUCTION

- Chapter 1 Introduction 3
Chapter 2 Parameters to be determined (industry wise) 8

PART II CHEMICAL ANALYSIS

- Chapter 3 Equipments, Glassware & Chemicals
Required for Chemical Analysis 29
Chapter 4 Water for Analytical Laboratory Use 41
Chapter 5 Sampling of Water for Chemical Analysis 44
Chapter 6 Sampling of Boiler Water 56
Chapter 7 Chemical Analysis – General Notes 60
Chapter 8 Expression of Results 61
Chapter 9 Preliminary Acid Digestion of the Sample 64
Chapter 10 Acidity 66
Chapter 11 Alkalinity 71
Chapter 12 Aluminium 80
Chapter 13 Arsenic 84
Chapter 14 Bio Chemical Oxygen Demand (BOD) 87
Chapter 15 Boron 99
Chapter 16 Cadmium 102
Chapter 17 Calcium 106
Chapter 18 Calcium Carbonate Stability Test 109

Chapter 19	Carbon dioxide (Free)	110
Chapter 20	Chemical Oxygen Demand (COD)	115
Chapter 21	Chloride	121
Chapter 22	Chlorine Demand	128
Chapter 23	Chromium	130
Chapter 24	Coagulant Demand	135
Chapter 25	Color	137
Chapter 26	Copper	139
Chapter 27	Cyanides (Total)	143
Chapter 28	Electrical Conductivity	147
Chapter 29	Equivalent Mineral Acidity (EMA)	149
Chapter 30	Fluoride	150
Chapter 31	Hardness (Total)	157
Chapter 32	Hydrazine	164
Chapter 33	Iodide	166
Chapter 34	Iron	169
	– Total	169
	– Ferrous	172
Chapter 35	Langelier Index, Ryznar Index and Puckorius Scaling Index	175
Chapter 36	Lead	181
Chapter 37	Magnesium	184
Chapter 38	Manganese	189
Chapter 39	Mercury	192
Chapter 40	Nickel	195
Chapter 41	Nitrate	198
Chapter 42	Nitrite	201
Chapter 43	Nitrogen (Ammonia)	205
Chapter 44	Nitrogen (Albuminoid)	209

Chapter 45	Nitrogen (Organic)	211
Chapter 46	Nitrogen (Total Kjeldahl)	212
Chapter 47	Odor	214
Chapter 48	Oil and Grease	216
Chapter 49	Oxygen (Dissolved)	218
Chapter 50	Particle Counting	225
Chapter 51	Permanganate Value (Oxygen absorbed / Tidy's test)	226
Chapter 52	Phenols	230
Chapter 53	Phosphate	234
Chapter 54	pH value	239
Chapter 55	Potassium	243
Chapter 56	Residual Chelant	244
Chapter 57	Residual Chlorine	248
Chapter 58	Residual Sodium Carbonate (RSC)	253
Chapter 59	Selenium	257
Chapter 60	Silica	260
Chapter 61	Silt Density Index	265
Chapter 62	Silver	267
Chapter 63	Sodium	269
	– Percent Sodium	270
	– Sodium Adsorption Ratio (SAR)	273
Chapter 64	Sodium Slip Determination	276
Chapter 65	Solids	278
	– Total Solids	279
	– Dissolved Solids	280
	– Suspended Solids	281

	– Settleable Solids	283
Chapter 66	Sulfate	285
Chapter 67	Sulfide	290
Chapter 68	Sulfite	293
Chapter 69	Surfactants (Anionic)	295
Chapter 70	Tannin & Lignin	297
Chapter 71	Temperature	299
Chapter 72	Turbidity	300
Chapter 73	Volatile Acids	303
Chapter 74	Zinc	308
Chapter 75	Probable Combinations (Checking the Correctness of Analysis)	313
Chapter 76	Determination of Steam Purity	327

PART III MICROBIOLOGICAL ANALYSIS

Chapter 77	Microbiological Analysis of Industrial Waters – An Introduction	333
Chapter 78	Equipment, Glassware and Other Items Required for Microbiological Analysis	339
Chapter 79	Laboratory Technics	349
Chapter 80	Preparation of Media and Reagents	355
Chapter 81	Sampling of Water for Microbiological Analysis	359
Chapter 82	Standard Plate Count (Total Bacterial Count)	363
Chapter 83	Coliform Bacteria (Total Coliforms)	368
Chapter 84	Fecal Coliforms (Escherichia Coli)	382
Chapter 85	Proteolytic Bacterial Count	387
Chapter 86	Lipolytic Bacterial Count	388
Chapter 87	Thermophilic Bacterial Count	389
Chapter 88	Gelatin Liquefying bacteria	390

Chapter 89	Iron Bacteria	391
Chapter 90	Sulfate-Reducing bacteria	393
Chapter 91	Sulfur-Oxidizing bacteria	395
Chapter 92	Yeast and Mould	397
Chapter 93	Slime-Forming Organisms	399

PART IV MICROSCOPICAL EXAMINATION

Chapter 94	Microscopical Examination	403
------------	---------------------------	-----

APPENDIX	409
-----------------	-----

INDEX	433
--------------	-----

REFERENCES	441
-------------------	-----

PART I
INTRODUCTION

CHAPTER - 1

INTRODUCTION

Water analysis has become increasingly important for many reasons. Water is the material that is widely employed in industries in multifarious ways – water is the raw material, water is the ingredient, water is the medium of reaction, water is the conveying medium, water is used for washing, water is used to generate steam and it is the major cooling agent and so on. For each and every industrial use, the quality of water is very important and it is the judging factor of the quality of finished product as well as the criterion for protecting boilers, cooling systems, machineries and equipments from scale formation and corrosion. Water analysis is the key component in designing suitable water treatment plant and to maintain the water quality. Without a proper water analysis program, the efficacy of water treatment cannot be ascertained. A proper water analysis would also reduce the cost on treatment considerably. Since each industrial use needs a water of specific quality, a detailed analysis is essential to know the quality of water available and to apply suitable treatment to render the water fit for the specific purpose and to maintain the same.

Analysis of water includes four components namely,

1. *Chemical Analysis*
2. *Microbiological Analysis*
3. *Microscopical Examination*
4. *Testing for Radioactivity*

CHEMICAL ANALYSIS

Examination for physical characteristics and chemical composition together called as 'Chemical Analysis'. All the parameters that comes under chemical analysis are listed below.

4 Introduction

Physical Properties	Metals	Non-metallics	Dissolved Gases	Organics	Other Tests
Color	Aluminium	Acidity	Carbon - dioxide	Hydrazine	BOD
Electrical Conductivity	Arsenic	Alkalinity	Chlorine (Residual)	Nitrogen (Ammonia)	Calcium carbonate Stability Test
Odor	Boron	Chloride	Oxygen (Dissolved)	Nitrogen (Albuminoid)	Chlorine demand
pH Value	Cadmium	Cyanide		Nitrogen (Organic)	Coagulant demand
Solids	Calcium	Fluoride		Nitrogen (Total Kjeldahl)	COD
- Total	Chromium	Iodide		Oil and grease	Equivalent Mineral Acidity
- Dissolved	Copper	Nitrate		Phenols	Langellier Index
- Suspended	Hardness	Nitrite		Surfactants	Particle Counting
- Settleable	Iron	Phosphate		Tannin and Lignin	Permanganate Value
Temperature	Lead	Silica		Volatile acids	Residual Sodium Carbonate
Turbidity	Magnesium	Sulfate			Silt Density Index
	Manganese	Sulfide			Sodium - Adsorption Ratio
	Mercury	Sulfite			Sodium Slip
	Nickel				
	Potassium				
	Selenium				
	Sodium				
	Silver				
	Zinc				

MICROBIOLOGICAL ANALYSIS

Microbiological analysis is carried out to detect the presence and density of microbial organisms in water. These organisms may render the water unsuitable in one or other way for the intended use, especially for food industries, pharmaceutical industries, fermentation industries and electronics industries. Hence it is essential that the water used in industries should also be free from microorganisms. In this book, procedures for the following organisms, are given.

1. *Standard Plant Count (To detect the number of viable micro-organisms present in water)*
2. *Coliform bacteria (To detect fecal contamination)*
3. *Fecal coliforms (Escherichia coli) (To detect fecal contamination)*
4. *Proteolytic Bacteria (Protein degrading bacteria. Essential test for Food Industries)*
5. *Lipolytic Bacteria (Lipid degrading bacteria. Essential test for Food Industries)*
6. *Thermophilic Bacteria (To be tested for water used in Dairy)*
7. *Gelatin Liquefying Bacteria*
8. *Iron Bacteria*
9. *Sulfate-Reducing Bacteria*
10. *Sulfur-Oxidizing Bacteria*
11. *Yeast and Mould*
12. *Slime Forming Organisms*

See Part – III, 'MICROBIOLOGICAL ANALYSIS' for more details

MICROSCOPICAL EXAMINATION

Water may contain numerous minute organisms that could be detected only under microscope. Many industrial processes virtually require water free of such microscopical organisms, as they impart color, odor and turbidity to water. Some of the higher forms may affect the health also. A detailed microscopical examination will reveal the presence and concentration of phytoplanktons such as algae, diatoms, flagellates and zooplanktons such as protozoans, ciliated protozoans, rotifers, crustaceans and other forms. For details, refer Part – IV, 'MICROSCOPICAL EXAMINATION'.

TESTS FOR RADIO ACTIVITY

Radio active materials find their way into water courses mainly from the discharge of waste water from nuclear power plants and due to extensive use of radio tracers. They are highly undesirable in processing industries. Stringent limits for radio active materials are stipulated for drinking water and water used for food processing and fermentation industries. Water used in these industries must comply with these requirements. Radio active measurements are helpful to detect the radio active contamination and contaminant levels in water.

ANALYSIS OF RAW WATER & TREATED WATER

The primary objective of the analysis of raw water in industries is to find out its quality to design a suitable treatment plant and to plan a treatment program. Detailed analysis is necessary to design an effective and comprehensive treatment plant. Seasonal variations and corresponding fluctuations* in raw water quality have to be taken into account while designing a treatment plant. If two or more sources with plenty of water are available, raw water analysis would help to select the source to which minimum treatment is required. Such selection would result in considerable savings in treatment costs and in the subsequent control analysis.

After the treatment plant is installed, the treated water has to be tested periodically. The periodicity (hourly, daily, weekly etc.,) is dependent on the industrial purpose for which the water is used and the type of treatment plant installed. The treated waters are tested to find out the efficacy, uniformity and consistency of treatment. Any over treatment will lead to unnecessary expenditure and under treatment would result in poor quality water and consequently lead to equipment failure and / or inferior product.

* Throughout the world, rivers are the most commonly used water sources for industrial purposes. Since they are subject to pollution by industries, sewage, agricultural run-off and other man made activities, considerable variation in the concentration of many constituents should be anticipated along with variations due to seasonal changes. Whereas ground waters are essentially constant in composition and there may not be much variation in quality characteristics.

ANALYTICAL PROGRAM

Drawing an analytical program is highly imperative to attain the objective of the best performance of the treatment system and securing water of desired quality for the particular industrial use and maintaining the treatment. The basic components of an analytical program are,

- i. Fixing the sampling points [(i.e) the stages of treatment system that need control]
- ii. Frequency of sampling
- iii. Parameters to be determined [(i.e) constituents that affect the process at the particular stage]
- iv. Method of analysis.

All these components are entirely dependent on the quality requirement of water for the intended industrial use and the type of treatment plants installed.

While planning the program of sampling and analysis, care should be exercised that the program should not be too extensive incorporating unnecessary data which involve then more labour and also expensive and wastage of time. Similarly an inadequate program would lead to improper conclusions and improper treatment resulting in poor quality products and damage to equipments. The best program is the one with minimum sampling points and tests, at the same time providing necessary information. Regular analyses for raw water, treated water used in process have to be carried out. Analysis of condensate returns and recirculating cooling water is also necessary.

Most of the industries require testing of water, only to asses the physical characteristics and chemical composition. Some other industrial processes need water of satisfactory bacteriological quality also (eg) food industries, fermentation industries and electronics industries. In such cases, both chemical and bacteriological analysis need to be carried out. When the water is susceptible to radio active contamination, it has to be tested for radio activity also.

In Chapter - 2, the parameters that need to be determined are given industry wise and may be referred for further information. For fixing the right sampling points refer Chapter - 5, 'SAMPLING OF WATER FOR CHEMICAL ANALYSIS' and Chapter - 6 'SAMPLING OF BOILER WATER'. For detailed analytical procedures refer Part – II and Part – III.

CHAPTER - 2
PARAMETERS TO BE DETERMINED
(INDUSTRY WISE)

Given below is the list of parameters to be tested on a regular basis. To aid the analyst the list is given industry wise. These are the minimum tests to be carried out regularly which are also termed as 'Control Tests'. Even among these, if some of the parameters remain constant and exhibit no variation, they need not be done. It is reiterated however, while commissioning the industry the water has to be tested for all parameters to assess its suitability for the particular industrial use and to design a suitable treatment plant. If surface waters are used, their characteristics have to be studied seasonally prior to designing treatment plant. In addition to the control parameters, they have to be checked for other parameters also when they are suspected to vary in character due to seasonal variations and/or pollution from upstream side.

The present day softeners, demineralizers, reverse osmosis plants and steam generation systems are equipped with fully automatic (or semiautomatic) continuous analyzers which measure the pH, temperature, turbidity conductivity, hardness, dissolved oxygen and silica. A schematic diagram of water treatment plants and steam generating equipments along with continuous analyzers are depicted in Fig. 2 – 1. Needless to say that in addition to such measurements, a testing schedule has to be established to make sure that sufficient information is obtained with the minimum number of tests. Such schedules and control parameters are described in the following sections.

CONTROL PARAMETERS FOR TREATMENT PROCESSES

Lime – Soda Softening

1. **pH value** : Continuous analysis is desirable
 2. **Hardness**: May be tested once per shift
 3. **Phosphate**: For a significant reduction of hardness, phosphate is usually added in hot lime-soda softening. Maintenance of a residual of 6 – 8 ppm is necessary. May be tested once per shift.
-

Demineralization

1. Conductivity
2. pH value
3. Silica
4. Hardness
5. Sodium
6. Alkalinity
7. Turbidity.

The Demineralizers are usually installed with continuous analyzers for monitoring pH and conductivity. Both conductivity and pH measurements are used to indicate breakthrough in demineralization. As the resin becomes exhausted, the pH falls and the conductivity rises.

In normal operation, the pH of the anion exchanger effluent is about 8. If the pH becomes 9 or more it is an indication of excessive sodium ion leakage from the cation exchanger. The present day trend is to install a continuous analyzer for sodium in the cation exchanger outlet so that sodium leakage could be immediately known.

Automatic silica analyzers are also installed at the anion exchanger outlet. When demineralizers approach exhaustion, silica is the first impurity to breakthrough into the effluent. Due to its low ionic strength, silica cannot be detected readily by conductivity meters. However automatic analyzers are capable of detecting increasing levels of silica that occur before complete exhaustion. Regeneration can then be initiated.

CONTROL PARAMETES FOR STEAM GENERATION SYSTEMS

Feed Water

Boiler feed water is a mixture of condensate and makeup water. Usually condensate will be in high proportion (ranging from 95% to 99% - sometimes total feed water is condensate) and make up will be in a lower proportion. Before feeding, the quality must be known in order to protect the boiler system from scaling and corrosion. Detailed analysis may be carried out at suitable intervals. However, all the parameters need not be done daily. A few

control tests alone have to be done which clearly give a picture on the quality of feed water. Necessary control parameters are tabulated (See Table 2 – 1)

Boiler Water

The analysis of boiler water is extremely useful in detecting the conditions inside the boiler and to detect under or over treatment. Based on the analysis of boiler water, dosage of chemicals can be controlled. In this case also certain chemical parameters have to be checked frequently which are given in Table 2 – 2.

Steam

It is extremely important to determine the purity of steam frequently. Needless to say that steam purity is affected by certain operating variables and therefore it is best to sample and monitor continuously the quality of steam. Unlike with other samples, obtaining a representative sample of steam is very difficult and hence several precautions need to be observed. Purity of steam is determined by measuring either the conductivity or sodium concentration in a condensed sample. For a detailed analytical procedure refer, chapter – 76.

Condensate

Condensate is nothing but the condensed steam and is a water of extreme purity. The condensate return system is a revealing sampling point to monitor total boiler water treatment performance. The parameters, turbidity, electrical conductivity and hardness are used to find out in-leakage through heat exchangers and condensers. If the conductivity of the combined condensate rises, individual returned streams should be checked for hardness. Test for silica also may be carried out on such return streams to detect contamination. Regular measurement of the pH of the condensate is necessary to regulate the dosage of amines. (After the addition of neutralizing amines the pH should be in the range of 8 – 9). Tests for iron, copper and dissolved oxygen are carried out to detect corrosion problems. Silica and sodium are important parameters which indicate carryover problems and / or condenser leakage (see Table 2 – 3). As indicated already, continuous analyzers are available for the measurement of sodium as low as 0.1 ppb. The major advantage with these analyzers is that these instruments suffer no interference from hydrazine, morpholine, cyclohexylamine or ammonia.

12 Introduction / Parameters to be determined

Blow Down

Blowing down is an essential operation in any boiler water treatment program. Blowdown removes precipitated sludge and dissolved solids from the boiler before harmful levels are reached. Blowdown can be continuous or intermittent. In either case, analysis is required to maintain the critical balance between solids removal and the loss of heat and treatment chemicals that must be replaced. The control parameters are listed below. (See Table 2 – 4).

Raw Water

Raw waters have also to be tested occasionally to detect any variations in quality. Ground waters normally do not show any variations. Surface waters, however are subject to fluctuations in quality due to seasonal variations and/or pollution from upstream side and may require frequent checking.

TABLE 2-1

BOILER FEED WATERS – CONTROL PARAMETERS AND TESTING SCHEDULE

Sl.No.	Parameter	Frequency
1.	Electrical Conductivity	Continuously
2.	pH value	- do -
3.	Total Hardness	Daily
4.	Total Alkalinity	- do -
5.	Chloride	Once per shift (i.e., once in 8 hrs)
6.	Silica	- do -
7.	Dissolved Oxygen	- do -
8.	Residual Sodium sulfite / Hydrazine	- do -
9.	Phosphate	Need to be done only if the water is softened by Lime – Soda process. Once per day.
10.	Iron	Occasionally
11.	Copper	- do -
12.	Oil	- do -

TABLE 2-2
BOILER WATER - CONTROL PARAMETERS AND TESTING SCHEDULE

Sl.No.	Parameter	Frequency
1.	pH value	Continuously
2.	Total Hardness	Once per shift (once in 8 hrs)
3.	Total Alkalinity	- do -
4.	Caustic Alkalinity	- do -
5.	Chloride	- do -
6.	Silica	- do -
7.	Dissolved Oxygen	Continuously
8.	Residual Sodium sulfite / Hydrazine	Once per shift
9.	Phosphate	- do -
10.	Iron	- do -
11.	Copper	- do -
12.	Oil	Occasionally
13.	Residual Chelant	Once per day

TABLE 2-3
CONDENSATE-CONTROL PARAMETERS AND TESTING SCHEDULE

Sl.No.	Parameter	Frequency
1.	Turbidity	Once per day
2.	Electrical conductivity	Continuously
3.	pH value	- do -
4.	Total Hardness	Once per day
5.	Silica	- do -
6.	Sodium	- do -
7.	Iron	- do -
8.	Copper	- do -
9.	Oil	- do -

INDEX**A**

4-Amino antipyrone for phenols, 233
Acetate buffer solution, for Zn, 309
Acetic acid for Cl₂, 249
 for Zn, 309, 311
 for Al, 81
Acid cuprons chloride solution, for CN, 143
Acid Zirconium-alizarin solution, for F, 153
Acid Zirconyl-SPADNS reagent for F, 151
Acidity, 66-70
 methyl orange, 68
 total, 68
Albuminoid Nitrogen, 209-210
Alkali-iodide-azide reagent, for DO, 221
Alkaline phosphate solution, for surfactants, 295
Alkaline potassium permanganate solution, 209
Alkalinity, 71-79
 definition 71
 phenolphthalein, 74
 total, 75
 hydroxide alkalinity-B value, 78
 soluble, 78
Aluminium sulfate solution, for Mg, 187
Aluminium, 80-83
 intermediate solution, 81
 stock solution, 81
 working solution, 81
Aluminium hydroxide suspension
 for Cl, 122
 for NO₂, 203
Alum stock solution, 136
Amine-sulfuric acid solution for S
 stock solution, 291
 working solution, 291
4-Amino antipyrone soln for phenol, 233
Ammonia-ammonium chloride buffer,
 for hardness, 158
 for phenols, 233
Ammonia Nitrogen, 205-208
Ammonia soln, conc, 140, 185, 311
Ammonium
 intermediate solution, 206
 stock solution, 206
 working solution, 206
Ammonium bifluoride, for Cr, 134
Ammonium citrate solution 20% for Cu, 142
Ammonium bifluoride, for Cr, 134
Ammonium hydroxide
 1+1, for Se, 258
 1+9, for Pb, 183
 1+19, for Mg, 185

 1+49, for Ni, 196
Ammonium molybdate solution,
 for PO₄, 235
 for Silica 261, 263
Ammonium oxalate solution, for Mg, 185
Ammonium persulfate, for Mn, 190
Analytical Program, 7
Apparatus for sampling boiler water, 56, 57, 58
Arsenic, 84-86
 intermediate solution, 85
 standard solution, 86
 stock solution, 85
Arsenious acid solution,
 for CN, 145
 for iodide, 167
Artificial standard solution, for silica, 262
Ascorbic acid, 81

B

Barium chloride solution, 5% for SO₄, 286
Bio chemical Oxygen Demand (BOD), 87-98
 application of, 97
 checking the correctness, 95
 preparation of dilutions, 91
 pretreatment, 90
 ratio of BOD : PV, 97
Biological examination, 403-408
Bis (2-hydroxy ethyldithio)
 carbamate solution, for Zn, 311
Bis-pyrazolone, for CN, 145
Blow down, percent, 127
BOD bottle, 220
Borax for silica, 262
Boric acid soln, 212
Boron, 99-101
 standard solution, 99
 stock solution, 99
Brilliant yellow solution, for Mg, 187
Bromine water, for CN, 144
B-value (hydroxide alkalinity), 78
α-α bipyridyl
 for ferrous iron, 173

C

Cadmium, 102-105
 stock solution, 102
 working solution, 103
Calcium carbonate Stability Test, 109
Calcium chloride solution, for BOD 89
Calcium standard solution for hardness, 158

Calcium sulfate solution, for Mg, 187
Calcium, 106-108
Carbon dioxide (Free), 110-114
 - in degasser effluent, 111
 - in steam, 113
Carbonate hardness, 160,161,162
Ceric ammonium sulfate solution
 0.02N for iodide, 167
Chemical Oxygen Demand (COD), 115-120
 definition of, 115
Chemicals required for chemical analysis, 36-40
Chloride, 121-127
 by mercuric nitrate method, 124-125
 by silver nitrate method, 121-123
Chlorine demand, 128-129
Chlorine residual – See Residual Chlorine
Chlorine solution, standard, 128
Chromium, 130-134
 hexavalent, 130-131
 total, 131-133
 in cooling waters, 133-134
 stock solution, 130
 working solution, 130
Citrate-cyanide reducing solution for lead, 182
Coagulant demand, 135-136
Cobaltous chloride, 137
Coliform bacteria, 333, 334, 368-381
Coliform (fecal), 382-386
Color, 137-138
 standard color solution, 137
Combined chlorine, 248
Composite sample, 45
Conditioning reagent, for sulfate, 288
Continuous sampling, 46
Copper, 139-142
 neocuproine method, 139-141
 sodium diethyldithio carbamate method, 141-142
 standard solution, 140
 stock solution, 140
Copper sulfate solution
 for Total Kjeldahl Nitrogen, 212
 for Phenols, 231
Corrosivity test, 109
Cupric diethyl dithio carbamate reagent for Ag, 267
Curcumin reagent for B, 100
Cyanides (total), 143-146
 intermediate solution, 144
 stock solution, 144
 standardization, 144
 working solution, 144

D

3-3, Diamino benzidine, for Se, 258
Diammonium hydrogen phosphate solution
 for Mg, 185

 for S, 291
Diatomaceous-silica filter aid, 306
Digestion with
 nitric and sulfuric acids, 64
 nitric and perchloric acids, 65
Dilution water for BOD, 88,89,90
Dimethyl glyoxime solution, for Ni, 196
s-Diphenyl carbazide reagent, for Cr, 131
Diphenyl carbazone indicator, for Cl, 125
Dissolved solids, 280-281
Dithizone
 stock solution,
 for Cd, 103
 for Pb, 182
 for Zn, 309, 311
 working solution
 for Cd, 103
 for Hg, 193
 for Pb, 182
 for Zn, 309, 311

E

EDTA solution
 0.02N, 82, 107, 158
 8% for Se, 258
 for NO₃, 199
EDTA standard soln for residual chelant, 244
EDTA working std for total chelant, 246
Electrical conductivity, 147-148
 neutralized conductivity, 148
 standard KCl solution, 147
Equipments required for
 chemical analysis, 29
 microbiological analysis, 339
Equivalent Mineral Acidity (EMA), 149
Eriochrome black-T, for hardness, 159
Eriochrome cyanine-R, for Al, 81
Escherichia coli, see Fecal coliform, 99
Ethyelene diamine, 173
Expression of results, 61-63

F

Fecal Coliform, 334, 382-386
Ferric chloride solution
 for BOD, 89
 for S, 291
 for volatile acids, 306
Ferroin indicator for COD, 118
Ferrous ammonium sulfate solution
 0.01N for COD, 118
 0.1N for COD, 118
 standardization, 118
 for iodide, 167
Ferrous iron

- determination, 172-174
stock solution, 173
working solution, 173
- Fluoride
electrode method, 155-156
preliminary distillation, 153-155
Scott-Sanchis method, 152-153
SPADNS method, 150-152
standard solution, 151
stock solution, 150
- Formate Ricinoleate broth, 369-370
- Formic acid, 258
- Free chlorine, 248
- Free Mineral Acidity (FMA), 69,276
- Frequency of sampling, 47
- G**
- Gelatin-liquefying bacteria, 335,390
- Gelatin medium, 390
- Glassware required
for chemical analysis, 31-35
for microbiological analysis, 341-344
- Grab sample, 45
- Grease - see ' Oil and Grease', 216-217
- Gutzeit apparatus for As, 84,85
- H**
- Hardness (total), 157-163
classification, 160
carbonate hardness,160,161
non-carbonate hardness,160,161
conversion factors, 163
- Hydrazine, 164-165
standard solution, 165
stock solution, 165
- Hydrochloric acid
0.02N, 309
0.05N, 196
0.5N, 164
1+1, 169, 185, 261, 263, 286
10%, 387
conc, 85, 103, 140, 144, 169, 172, 185
- Hydrogen peroxide, 122, 296
- Hydroquinone solution, for Cl, 125
- Hydroxide alkalinity-B value, 78
- Hydroxyl amine hydrochloride
for Cd, 103
for Cu, 139
for Fe²⁺, 173
for Hg, 193
- I**
- Immediate Dissolved Oxygen Demand (IDOD), 95
- Iodide solution, for Ni, 196
- Iodide, 166-168
stock solution, 167
working standard solution, 167
- Iron bacteria, 335-336, 391-392
- Iron, 169-174
ferrous iron, 172-174
total iron
by colorimetric method, 169-171
standard solution, 170
stock solution, 170
by titrimetric method, 171-172
- Isopropyl alcohol, 74, 140
- J**
- Jar Test, 135-136
- L**
- Labelling of sample, 50, 362
- Langelier Saturation Index, 175-178
- LAS solution
standard solution, 296
stock solution, 295
- Lead, 181-183
intermediate solution, 181
stock solution, 181
working solution, 182
- Lead acetate solution, 10% for As, 85
- Lime stock solution, 136
- Lipolytic bacteria, 335, 388
- M**
- Magnesium 184-188
by gravimetric method, 185-186
by photometric method, 186-188
stock solution, 187
working solution, 187
- Magnesium standard soln for Res. Chelant, 244
- Magnesium sulfate
for BOD, 89
for volatile acids, 306
- Manganese, 189-191
stock solution, 190
working standard solution, 190
- Manganous sulfate solution, 221
- Marble test, 109
- Medium for Thiobacillus thiooxidans (Sulfur medium), 395
- Medium for Thiobacillus thioparus (Thiosulfate oxidizing medium), 395
- Mercuric chloride soln for iron, 172
- Mercuric nitrate, 0.0282N solution for Cl, 105

Mercuric sulfate
 for COD, 117
 for Mn, 190
Mercury, 192-194
 stock solution, 193
 working solution, 193
Method of taking sample, 49-50
Methyl orange acidity, 68
Methyl orange indicator, 67
Methyl red indicator, 185, 286, 311
Methylene blue solution, (acid), 295
Methylene blue solution, (neutral), 295
Methylene blue solution-I, for S, 291
 standardization, 291
Methylene blue solution-II, for S, 292
Microbiological analysis, 5, 333-400
Microbiological analysis-Laboratory technics, 349-354
Microgram, definition, 61
Microscopical examination, 5, 403-408
Milli equivalent, definition, 61
Miscellaneous items
 for chemical analysis, 35-36
 for microbiological analysis, 344-345
Mixed indicator
 for alkalinity, 74
 for aluminium, 82
 for total kjeldahl nitrogen, 213
Modified Formate Lactose Glutamate Medium (double strength), 368, 369
Modified Formate Lactose Glutamate Medium (single strength), 368, 369
MPN Table, 371-375
Murexide indicator, for Ca, 107

N

α -Naphthylamine hydrochloride solution, for NO_2 , 202
Neocuproine solution, for Cu, 140
Nessler reagent, 206
Neutralized conductivity, 148
Nickel, 195-197
 stock solution, 195
 working solution, 196
Nitrate, 198-200
 electrode method, 200
 phenol disulfonic acid method, 198-200
 stock solution, 199
 working standard solution, 199
Nitric acid
 0.05N, 125
 1+4, 182
 conc, 64, 140, 185, 191
Nitrite, 201-204
 intermediate solution, 203
 stock solution, 202

 working solution, 203
Nitrogen (albuminoid), 209-210
Nitrogen (ammonia), 205-208
Nitrogen (organic), 211
Nitrogen (total kjeldahl), 212-213
Non-carbonate hardness, 160, 161, 162

O

Odor, 214-215
 qualitative determination of, 215
Oil and Grease, 216-217
Order of testing, 54-55
Organic nitrogen, 211
Ortho tolidine solution for Cl_2 , 251
Oxalic acid, 10% for Silica, 262, 263
Oxygen (dissolved), 218-224
 electrode method, 224
 sample collection, 218
Oxygen absorbed - see Permanganate Value

P

Para-dimethyl amino benzaldehyde solution, for hydrazine, 165
Parameters to be determined, 8-26
Particle counting, 225
Patton-Reeders indicator, for Ca, 107
Percent definition, 61
Percent sodium, 270-272
Perchloric acid digestion, 65
Permanganate value, 226-229
Persulfate digestion, for PO_4 , 237-238
Petroleum ether, 216
pH value, 239-242
pH4 buffer solution, 240
pH7 buffer solution, 241
pH9 buffer solution, 241
Phenol disulfonic acid, for NO_3 , 198
Phenolphthalein alkalinity, 74, 75
Phenolphthalein indicator, 67, 74, 110, 212, 304
Phenols, 230-233
 intermediate solution, 232
 stock solution, 232
 standardization, 232
 working solution, 232
N-phenyl anthranilic acid for iron, 172
1-phenyl-3methyl-5pyrazolone reagent, for CN, 145
Phosphate, 234-238
 inorganic phosphates, 236
 ortho phosphates, 235-236
 standard solution, 235
 stock solution, 235
 total phosphates, 237-238
Phosphate buffer solution
 for ammonia nitrogen, 206

for BOD, 89
Phosphate-carbonate buffer for Hg, 193
Phosphoric acid, 221
1+3, 230
1+9, 230
Points of sampling, 47
for boiler water, 56
Potassium, 243
electrode method, 243
flame photometric method, 243
Potassium bromide solution, for Hg, 193
Potassium chloride
standard solution for electrical conductivity, 147
Potassium chloroplatinate, 137
Potassium chromate for Silica, 262
Potassium chromate indicator, for Cl, 122
Potassium cyanide solution, for Zn, 311
Potassium dichromate solution
0.025N, for COD, 118
0.25N, for COD, 117, 249
Potassium ferricyanide solution, for phenols, 233
Potassium hydroxide, 12N, for NO₃, 199
Potassium iodate-iodide solution for SO₃, 294
Potassium iodide, 134
10% solution for Permanganate value, 228
15% solution for As, 84
stock solution, for iodide, 167
working standard, for iodide, 167
Potassium permanganate solution,
0.01250N, 227
0.1250N, 226
0.1N, 132
0.2N, for Iron, 170
5% for Hg, 193
Potassium persulfate
for Cr, 134
for Hg, 193
Potassium sulfate, 212
Potassium thiocyanate solution
for Iodide, 167
for Iron, 170
Potato-dextrose Agar, 397
Preliminary acid digestion of sample, 64
Preparation of dilutions, for BOD, 91-92
Preparation of Media, 355-358
Preservation of samples, 51, 52-54
Probable combinations, 313-326
Proteolytic bacteria, 335, 387
Puckorius Scaling Index, 179
Pyridine, 145
Pyridine-Pyrazolone reagent, for CN, 145

R

Radio activity, tests for, 6

Reducing solution, for Silica, 263
Reference solution, for F, 151
Residual Chelant (EDTA), 244-247
Residual Chlorine, 248-252
iodometric method, 249-250
orthotolidine method, 250-252
Residual Sodium Carbonate (RSC), 253-256
Ringer solution (Quarter strength), 352, 364
Ryznar Stability Index, 175-178

S

Sample container, 46
for boiler water, 57
Sampling of boiler water, 56-59
Sampling of industrial effluents, 51-52
Sampling of water
for chemical analysis, 44-55
for microbiological analysis, 359-362
Seed for BOD dilution water, 90
Selenium, 257-259
intermediate solution, 258
standard solution, 258
stock solution, 258
Settleable solids, see Solids (settleable)
Silica, 260-264
heteropoly blue method, 263-264
molybdo silicate method, 261-263
Silica
standard solution, 264
stock solution, 263
Silt Density Index, (SDI), 265
Silver, 267-268
stock solution, 267
working solution, 267
Silver diethyl dithio carbamate
0.5% solution, for As, 85
Silver nitrate solution
0.0282N for Cl, 122
1N, for Cr, 134
Silver nitrate-nitric acid reagent, 286
Skimmed milk, 387
Slime forming organisms, 337-338, 399-400
Sodium, 269-275
flame photometric method, 269-270
ion selective electrode method, 270
stock solution, 270
Sodium acetate buffer solution
for Al, 81
for Fe²⁺, 173
for NO₂, 202
Sodium Adsorption Ration (SAR), 273-275
Sodium arsenite solution, 152, 251
Sodium azide solution
for Cr, 132

- for Oxygen (dissolved), 221
 - Sodium carbonate solution
 - 1N, 74
 - 20%, 297
 - Sodium chloride solution 0.0282N, for Cl, 122
 - Sodium chloride solution, for iodide, 167
 - Sodium citrate solution
 - for Cu, 140
 - for Ni, 196
 - for Zn, 309, 311
 - Sodium diethyl dithio-carbamate solu
 - for Cu, 142
 - for Ag, 268
 - Sodium hydroxide-potassium cyanide solution- I,
 - for Cd, 103
 - Sodium hydroxide-potassium cyanide solution- II,
 - for Cd, 103
 - Sodium hydroxide solution
 - 0.0227N, for CO₂, 110
 - 0.02N, 67
 - 0.1N, 304
 - 0.5N, 144
 - 1N, 107, 122
 - 6N, 103, 187
 - 12N, for NO₃, 199
 - 4%, 258
 - 50%, 212
 - Sodium potassium tartrate, for Cd, 103
 - Sodium slip, detn, 276
 - Sodium sulfide inhibitor, for hardness, 159
 - Sodium sulfide solution-I, for Zn, 311
 - Sodium sulfide solution-II, for Zn, 311
 - Sodium sulfite solution, 206
 - Sodium thiosulfate solution
 - 0.0025N, 250
 - 0.0125N, 227
 - 0.0250N, 128, 221
 - 0.1250N, 227
 - 0.1N, 221, 249
 - 25% for Zn, 309
 - Solids, 278-284
 - dissolved, 280-281
 - settleable, 283-284
 - suspended, 281-283
 - total, 279-280
 - Soluble alkalinity, 78
 - Special reagent, for Mn, 190
 - Stabilizing solution, for Mg, 187
 - Standard Plate Count, 363-367
 - Stannous chloride solution
 - 40% for As, 85
 - 15% for iron, 172
 - 2.5% for PO₄, 235
 - Starch indicator solution, 128, 222, 228, 249, 294
 - Steam purity, detn, 327-329
 - conductivity method, 327
 - Sulfamic acid
 - for COD, 118
 - for Cr, 134
 - Sulfanilic acid solution, for NO₂, 202
 - Sulfate, 285-289
 - gravimetric method, 285-287
 - turbidimetric method, 287-289
 - standard solution, 288
 - Sulfate-reducing bacteria, 336, 393-394
 - Sulfate-reducing medium (Starkeys' medium), 393
 - Sulfide, 290-292
 - Sulfite, 293-294
 - Sulfuric acid
 - 0.02N, 74, 81, 186, 213
 - 0.25N, 193
 - 1+1, 216, 291, 294 304
 - 1+3, 228
 - 10N, 134
 - 6N, 83
 - 1N, 64, 67, 74, 122
 - 2N, 172
 - conc, 117, 132, 167, 191, 192, 212, 221
 - Sulfuric acid-nitric acid digestion, for PO₄, 216
 - Sulfuric acid-nitric acid solution, for PO₄, 235
 - Sulfuric acid-silver sulfate reagent, for COD, 117
 - Sulfur-oxidizing bacteria, 337, 395-396
 - Surfactants (anionic), 295-296
 - Suspended solids, see Solids (suspended)
- ## T
- Taking the sample - see Method of taking sample
 - Tannin and Lignin, 297-298
 - standard tannin solution, 297
 - stock tannin solution, 297
 - Tannin-Lignin reagent, 297
 - Tartaric acid 2% solution, for Cd, 103
 - Temperature, 299
 - Test for Thiobacillus thiooxidans, 395, 396
 - Test for Thiobacillus thioparus, 395, 396
 - Thermophilic bacteria, 335, 389
 - Thymol blue indicator, for Cd, 103
 - Tidy's test, see Permanganate Value
 - Time interval between collection and analysis, 51
 - Toluene, for Se, 258
 - Total acidity, 68
 - Total alkalinity, 75
 - Total Bacterial Count, 333-334, 363-367
 - Total Ionic Strength Adjustment Buffer (TISAB) for F, 155
 - Total Kjeldahl Nitrogen, 212-213
 - Total solids, 279-280
 - Tributyryn agar, 388
 - Turbidity, 300-302
-

Turbidity suspension
 standard, 301
 stock, 301
 working standard, 302

V

Volatile acids, 303-307
 direct distillation method, 304-305
 steam distillation method, 305-307

W

Water for analytical laboratory use, 41-43

X

Xylenol orange soln for total chelant, 246

Y

Yeast and mould, 337, 397-398
Yeast extract agar, 363, 387

Z

Zinc, 308-312
 20-30 mesh, for As, 84
 mixed color method, 308-310
 mono color method, 311-312
 stock solution, 309
 working solution, 309
Zirconyl chloride for total chelant
 stock soln, 246
 working soln, 246

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