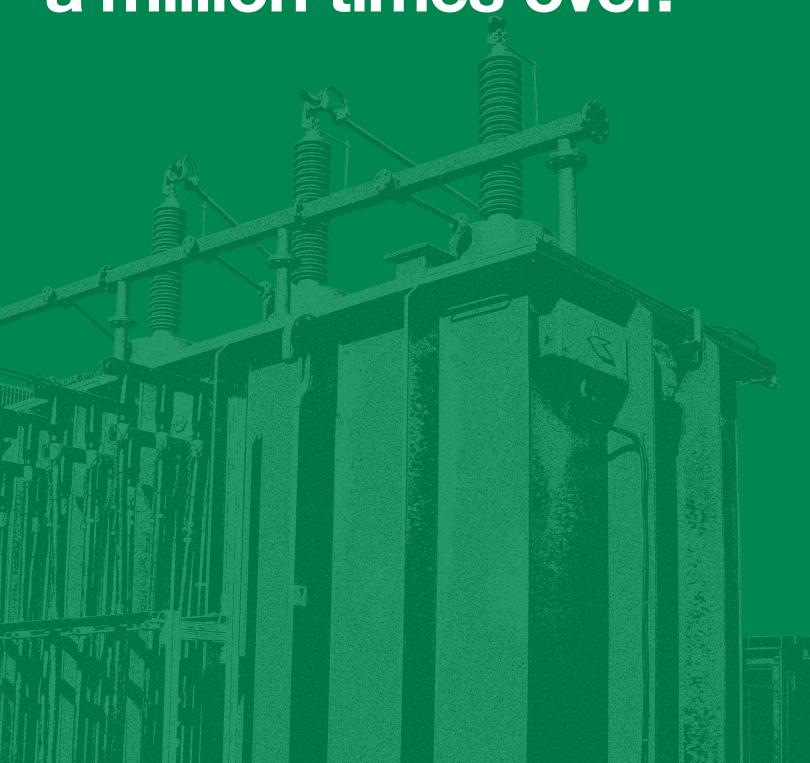




# Envirotemp FR3 fluid. Trusted worldwide a million times over.





With over one 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 help improve transformer performance reliably and safely.

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 without sacrificing reliability.
- Extend transformer insulation and asset life.
- Optimize load capacity.
- Significantly improve fire safety.
- Enhance their environmental footprint and sustainable supply chain initiatives.

# Improve performance with life extension and loading 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 10 times the water saturation level of mineral oil. This results in extending the insulation life 5-8 times longer than mineral oil.



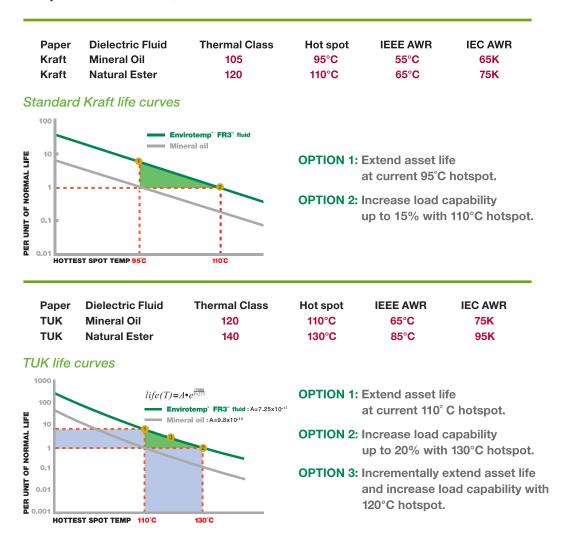
Insulation aging study comparing thermally upgraded paper using FR3 fluid vs. mineral oil.

- 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 loading profiles 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.



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# 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 smaller transformer designs, your supply chain just got a whole lot more sustainable.

- Smaller, 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	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	255
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	-1823
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)	D445	ISO 3104			
100 °C			≤15	≤15	7.7 - 8.3
40 °C			≤50	≤50	32 - 34
0 °C			≤500		190
Visual Examination	D1524	IEC 61099 9.2	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		≥20		28
2mm gap	D1816		≥35		48-75
2.5mm gap		IEC 60156		≥35	73
Gassing Tendency (mm/min)	D2300		≤0		-79
Dissipation Factor					
25°C (%)	D924		≤0.20		0.010 - 0.15
90°C (tanδ)		IEC 60247		≤0.05	0.02
100°C (%)	D924		≤4.0		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
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 (tan δ)		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.
- Biodegrades in less than 28 days.
- Contains no petroleum, halogens, silicones or sulfurs.
- Recyclable.























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