

TABLE 1 RECOMMENDED ABMA & ASME BOILER WATER LIMITS

	DRUM OPERATING PRESSURE (PSIG)							
	0-300	301-450	451-600	601-750	751-900	901-1000	1001-1500	1501-2000
STEAM								
TDS max (ppm)	0.2-1.0	0.2-1.0	0.2-1.0	0.1-0.5	0.1-0.5	0.1-0.5	0.1	0.1
BOILER WATER								
TDS max (ppm)	700-3500	600-3000	500-2500	200-1000	150-750	125-625	100	50
ALK max (ppm)	350	300	250	200	150	100	Not specified	Not specified
TSS max (ppm)	15	10	8	3	2	1	1	n / a
Conductivity max (µmho/cm)	1100-5400	900-4600	800-3800	300-1500	200-1200	200-1000	150	80
Silica max (ppm SiO ₂)	150	90	40	30	20	8	2	1

ABMA-American Boiler Manufacturer's Association
 ASME-American Society of Mechanical Engineers