

Contents

Part 1 Hydrate Prediction and Prevention	1
<i>Objectives</i>	1
<i>Overview</i>	2
Dew Point	2
Dew Point Depression	2
Why Dehydrate?	2
<i>Water Content of Gas</i>	3
Introduction	3
Partial Pressure and Fugacity	3
Empirical Plots	4
Sour Gas Correlations	6
Weighted-Average Method	6
Sharma Correlation	6
SRK Sour Gas Correlation	6
Effect of Nitrogen and Heavy Ends	7
Example 1-1: Calculation of Water Content in a Sour Gas Stream	11
Applications	12
Amount of Water Condensed	12
<i>Gas Hydrates</i>	12
What Are Gas Hydrates?	12
Why Is Hydrate Control Necessary?	13
What Conditions Are Necessary to Promote Hydrate Formation?	13
How Do We Prevent or Control Hydrates?	13
<i>Prediction of Operating Temperature and Pressure</i>	13
Wellhead Conditions	13
Flowline Conditions	14
Calculation of Temperature and Pressure at the Wellhead	14
Calculation of Flowline Downstream Temperature	14
<i>Temperature Drop Determination</i>	15
Overview	15
Temperature Drop Correlation	17
Example 1-2: Determine the Temperature Drop across a Choke	17
<i>Hydrate Prediction Correlations</i>	19
Overview	19
Vapor-Solid Equilibrium Constants	19
Pressure-Temperature Curves	19
Equations of State Calculations	19
Vapor-Solid Equilibrium Constants	19

Example 1-3: Determination of Hydrate Formation Temperature Using Vapor-Solid Constants	22
Pressure-Temperature Curves	24
Example 1-4: Determine the Hydrate Formation Temperature Using Pressure-Temperature Correlations	25
<i>Hydrate Prevention</i>	25
Overview	25
Adding Heat	26
Temperature Control	26
Indirect Heaters	26
Overview	26
Wellhead Heater Description	27
High-Pressure Flowline	27
Expansion Loop	27
Long-Nose Heater Choke	27
Heater Bypass Valve	27
Heater Coil	30
Pressure Relief Valve	30
Heater Flame Arrestor	30
Flowline Heaters	30
System Optimization	30
Heater Sizing	31
Downhole Regulators	31
Chemical Injection	32
Overview	32
Methanol Injection Considerations	32
Methanol Injection System Description	34
Glycol Injection Considerations	34
Glycol Injection and Recovery System Description	34
Nozzle Design	37
Glycol Selection	37
Dow Chemical Company Guidelines	38
Injection Requirement Categories	39
Low Pressure–High Volume	39
High Pressure–Low Volume	40
High Pressure–High Volume	40
Single versus Two-Step Injection Considerations	41
Single-Step Injection	41
Two-Step Injection	41
Chemical Injection System	42
Overview	42
Single-Point Chemical Injection	42
Disadvantages	42
Multi-Point Chemical Injection	42
Advantages	42
Disadvantages	42
Metering Pump Considerations	42
Diaphragm Pumps	43
Advantages	43

Disadvantages	43
Plunger Pumps	43
Advantages	43
Disadvantages	43
Comparison of Hydrate Prevention Methods	43
Overview	43
Heaters	44
Chemical Injection	44
Downhole Regulators	44
Summary of Hydrate Prevention Methods	45
<i>Hydrate Inhibition</i>	45
Hammerschmidt Equation	45
Determination of Total Inhibitor Required	47
Procedure for Determining Inhibitor Requirements	47
Example 1-5: Determining the Amount of Methanol Required in a Wet Gas Stream	47
<i>Exercises</i>	52

Part 2 Dehydration Considerations 55

Overview	55
Adsorption	56
Process Overview	56
Principles of Adsorption	56
Process Reversal	57
Mass Transfer Zone (MTZ)	57
Principles of Operation	58
Introduction	58
System Components	59
Drying/Reactivation Cycle	60
Performance	63
Advantages	63
Disadvantages	63
Effect of Process Variables	64
Quality on Inlet Gas	64
Temperature	65
General Considerations	65
Maximum Temperature	66
Pressure	66
Cycle Time	67
Gas Velocities	67
Source of Regeneration Gas	70
Direction of Gas Flow	71
Desiccant Selection	72
Molecular Sieves	73
Silica Gel and Alumina	73
Silica Gel	74
Desirable Characteristics of Solid Desiccants	74
Effect of Regeneration Gas on Outlet Gas Quality	74
Pressure Drop Considerations	75

Example 2-1: Determination of Pressure Drop through a Dry Bed Desiccant Dehydration Tower	77
Equipment	78
Inlet Gas Cleaning Equipment	78
Adsorber Tower	78
General Considerations	78
Insufficient Gas Distribution	79
Inadequate Insulation	80
Improper Bed Supports	81
Pressurization	82
Regeneration Gas Exchangers, Heaters, and Coolers	83
Regeneration Gas Separator	84
Control Valves	84
Expander Plant Molecular Sieve Applications	85
<i>Desiccant Performance</i>	86
General Conditions	86
Moisture Analyzer	86
Effect of Contaminants in Inlet Feed Stream	86
Effect of Regeneration Gases Rich in Heavy Hydrocarbons	87
Effect of Methanol in the Inlet Gas Stream	87
Useful Life	87
Effect of Insufficient Reactivation	87
Effect of High Reactivation Temperature	88
Areas Requiring Engineering Attention	88
Example 2-2: Preliminary Solid Bed Desiccant Design	88
<i>Absorption</i>	93
Process Overview	93
Principles of Absorption	93
Absorption and Stripping	93
Raoult and Dalton's Laws	94
Glycol-Water Equilibrium	95
<i>Glycol Dehydration</i>	96
Principles of Operation	96
Introduction	96
Gas System	96
Inlet Scrubber/Microfiber Filter Separator	96
Glycol Gas Contactor	97
Glycol System	101
Glycol Gas Heat Exchanger	101
Glycol Gas Contactor	102
Reflux Condenser	103
Glycol-Glycol Preheater	103
Gas-Glycol-Condensate Separator	103
Microfiber Filter	104
Charcoal (Carbon) Filter	105
Glycol-Glycol Heat Exchanger	105
Still Column	105
Reconcentrator	107

Stripping Gas	108
Effect of Operating Variables	109
General Considerations	109
Glycol Selection	109
Ethylene Glycol (EG)	110
Diethylene Glycol (DEG)	110
Triethylene Glycol (TEG)	110
Tetraethylene Glycol (TTEG)	110
Inlet Gas Temperature	110
Lean Glycol Temperature	111
Glycol Reconcentrator Temperature	111
Temperature at Top of Still Column	112
Contactor Pressure	113
Reconcentrator Pressure	113
Contractor Pressure	114
Glycol Concentration	114
Glycol Circulation Rate	116
Number of Absorber Trays	118
<i>System Design</i>	119
Sizing Considerations	119
Inlet Microfiber Filter Separator	120
Glycol Gas Contactor	121
Contactor Diameter	123
Tray Design	125
Bubble Cap Trays	125
Valve or Flapper Trays	126
Perforated (Sieve) Trays	127
Structured (Matrix) Packing	127
Tray Spacing	127
Number of Trays	128
Downcomers	128
Glycol Circulation Rate	129
Lean Glycol Concentration	133
Glycol-Glycol Preheater	133
Glycol-Gas Cooler	134
Glycol-Glycol Heat Exchanger	134
Gas-Glycol-Condensate Separator	134
Reconcentrator	134
Heat Duty	135
Fire Tube Sizing	135
Reflux Condenser	136
Stripping Still Column	136
Diameter Size	137
Packing	138
Amount of Stripping Gas	138
Filters	140
Microfiber	140
Activated Charcoal (Carbon)	140
Glycol Pumps	140

Glycol-Gas Powered Pump	140
Electric Driven Positive Displacement Piston/ Plunger Pump	141
Still Emissions	141
<i>Mercury Considerations</i>	143
Mercury	143
Treatment	143
<i>Special Glycol Dehydration Systems</i>	144
General Considerations	144
Drizo (wt.-2) Process	144
Process Description	145
Applications	146
Cold Finger Condenser Process	146
Process Description	147
Application	149
<i>Systems Utilizing Glycol-Gas Powered Pumps</i>	149
<i>Systems Utilizing Electric Driven Pumps</i>	149
Example 2-3: Glycol Dehydration	151
<i>Nonregenerable Dehydrator</i>	157
Overview	157
Calcium Chloride Unit	157
Principles of Operation	158
Advantages	158
Disadvantages	158
Operating Problems	159
Design Considerations	159
<i>Physical Properties of Common Glycols</i>	160
Part 3 Glycol Maintenance, Care, and Troubleshooting	169
<i>Preventive Maintenance</i>	169
Scheduled Preventive Maintenance	169
Five Steps to a Successful Preventive Maintenance Program	169
Record-Keeping	169
Mechanical Maintenance	170
Glycol Care	170
Corrosion Control	170
Communication	171
Record-Keeping	172
Mechanical Maintenance	173
Glycol Care	177
General Considerations	177
Smell the Sample	178
Corrosion Control	179
Overview	179
General Considerations	179
Oxidation	180
Sour Corrosion	180
Sweet Corrosion	180
Prevention and Control Programs	181

General Considerations	181
pH Buffers	181
Plating Inhibitors	182
Communication	182
General Considerations	183
Oxidation	183
Thermal Decomposition	184
pH Control	184
Salt Contamination	185
Salt Deposits	185
Hydrocarbons	186
Sludge	186
Foaming	187
General Considerations	187
Defoamers	188
<i>Analysis and Control of Glycol</i>	188
General Considerations	188
Visual Inspection	188
Chemical Analysis	189
Chemical Analysis Interpretation	190
pH	190
Sludge	191
Hydrocarbons	191
Water Content	192
Suspended Solids	193
Residue	194
Chlorides	194
Iron	195
Foaming	195
General Considerations	195
Foam Test	196
Acceptable Limits	197
Specific Gravity	197
Glycol Composition	197
<i>Troubleshooting</i>	198
General Considerations	198
High Dew Points	199
Insufficient Glycol Circulation	199
Insufficient Reconcentration	199
Operating Conditions Different from Design	200
Low Flow Rate	200
Absorber Tray Damage	200
Breakdown or Contamination of Glycol	200
Glycol Loss from the Contactor	200
Foaming	200
Plugged or Dirty Trays	200
Excessive Velocity	201
Interrupted Liquid Seal on the Trays (Gas Surge)	201
Cold Glycol (Cold Gas)	201
Leaks	201

Accumulation in Integral Scrubber	201
Glycol Loss from the Reconcentrator	202
Leaks	202
Bad Glycol Relief Valve	202
Exiting the Still Column	202
Vaporization	202
Glycol Loss—Glycol Hydrocarbon Separator	202
Improper Control Operation	202
Leaks	203
Accumulation in Oil Bucket (Bucket-and-Weir)	203
Glycol Loss—Miscellaneous	203
Leaks	203
Poor Quality or Contamination Replacement Glycol	203
Three-Step Approach to Troubleshooting	203
Timeframe	203
List Changes	203
Investigate	204
Glycol System Cleaning	204
General Considerations	204
Cleaning Techniques to Avoid	204
<i>Eliminating Operating Problems</i>	205
General Considerations	205
Inlet Scrubber/Microfiber Filter Separator	205
Absorber	209
Glycol-Gas Heat Exchanger	213
Lean Glycol Storage Tank or Accumulator	214
Stripper or Still Column	215
Reboiler	220
Stripping Gas	226
Circulating Pump	227
Flash Tank or Glycol-Gas Separator	231
Gas Blanket	232
Reclaimer	232
<i>Improving Glycol Filtration</i>	232
General Considerations	232
<i>Use of Carbon Purification</i>	236
General Considerations	236
<i>References</i>	239
<i>Index</i>	241