

Treating difficult feed gases to lng plants

treating difficult feed gases to LNG plants is a critical process in the liquefied natural gas (LNG) industry, ensuring that raw natural gas is refined to meet the stringent specifications required for liquefaction and transportation. Feed gases often contain impurities and components that can hinder the liquefaction process, damage equipment, or reduce product quality. Addressing these challenges effectively requires a comprehensive understanding of the composition of the feed gas, the specific impurities involved, and the most suitable treatment technologies. In this article, we explore the methods and best practices for treating difficult feed gases to LNG plants, covering the fundamental principles, common impurities, treatment techniques, and innovations in the field.

Understanding Difficult Feed Gases in LNG Production

Feed gases from natural sources are rarely pure. They contain various impurities that can complicate the liquefaction process. Difficult feed gases are characterized by the presence of components such as CO₂, H₂S, mercaptans, water vapor, heavy hydrocarbons, and other contaminants that require specialized attention.

Common Impurities in Feed Gases

Carbon Dioxide (CO₂): Can cause freezing issues, corrosion, and reduce LNG quality.

Hydrogen Sulfide (H₂S): Toxic and corrosive; needs removal to prevent equipment damage.

Water Vapor: Promotes hydrate formation and corrosion.

Heavy Hydrocarbons (C₅+): Can cause freezing and operational issues during liquefaction.

Mercaptans and Other Sulfur Compounds: Cause odor issues and corrosion.

Nitrogen: Dilutes the methane content, reducing energy value.

Challenges Posed by Difficult Feed Gases

Handling such impurities requires careful process design to prevent operational disruptions, equipment corrosion, and substandard LNG production. Moreover, the treatment must be cost-effective, reliable, and adaptable to varying feed gas compositions.

Key Treatment Technologies for Difficult Feed Gases

Treating challenging feed gases involves multiple integrated processes designed to remove specific impurities efficiently. The choice of treatment technology depends on the composition of the feed gas, operational constraints, environmental regulations, and economic considerations.

1. Acid Gas Removal (CO₂ and H₂S)

Removing acid gases is typically the first step in feed gas treatment, as their presence can cause severe operational issues.

Amine Gas Treating: The most common method, using aqueous solutions of amines (e.g., MEA, DEA, MDEA) to selectively absorb CO₂ and H₂S.

Physical Solvent Processes: Such as Selexol or Rectisol, suitable for high CO₂ concentrations, offering high absorption capacity and ease of regeneration.

Solid Scavengers: Using solid sorbents like zinc oxide for H₂S removal, especially in smaller or remote facilities.

2. Water and Hydrocarbon Removal

Water vapor and heavy hydrocarbons must be efficiently removed to prevent hydrate formation and freezing.

Dehydration Units: Typically employing glycol dehydration (using TEG ? triethylene glycol) to reduce water content to very low levels (< 1 ppm).

Cryogenic Condensation: Utilizing cooling to liquefy and remove heavier hydrocarbons.

Adsorption: Using molecular sieves for dehydration and removal of traces of hydrocarbons.

3. Heavy Hydrocarbon (C₅+) Removal

Heavy hydrocarbons can cause freezing issues during liquefaction.

Cryogenic Fractionation: Separates C₅+ components at low temperatures.

Adsorptive Technologies: Such as activated carbon beds, to adsorb heavier hydrocarbons.

4. Nitrogen Removal

Nitrogen dilutes the methane content, reducing energy

density. Cryogenic Nitrogen Rejection: Uses distillation at low temperatures to separate nitrogen from methane. Membrane Separation: Employs selective permeable membranes for nitrogen extraction, especially suitable for high N_2 concentrations. Pressure Swing Adsorption (PSA): A process that can selectively adsorb nitrogen, though less common for large-scale LNG feed gas treatment.

Design Considerations for Treating Difficult Feed Gases

Effective treatment of difficult feed gases demands careful planning and engineering, considering the specific composition and flow rates.

Feed Gas Composition Analysis

Conduct thorough compositional analysis to determine impurity levels. Monitor variations over time to adapt treatment processes accordingly.

Process Integration and Optimization

Combine multiple treatment steps to maximize efficiency. Optimize regeneration cycles for absorbents and sorbents. Incorporate real-time monitoring to adjust operational parameters dynamically.

Environmental and Safety Regulations

Ensure treatment processes comply with local environmental standards. Implement safety measures for handling toxic and flammable gases like H_2S .

Cost and Operational Efficiency

Balance capital expenditures with operational costs. Consider energy consumption, especially for cryogenic and compression units.

Innovations and Future Trends in Feed Gas Treatment

The field of feed gas treatment is continuously evolving, driven by technological advances and environmental considerations.

Membrane Technologies

Increasing use of polymer and ceramic membranes for selective separation of nitrogen and other inert gases. Advantages include modularity, lower energy consumption, and ease of scalability.

Advanced Adsorbents

Development of novel adsorbents with higher capacity and selectivity for impurities such as H_2S and CO_2 . Use of metal-organic frameworks (MOFs) for targeted impurity removal.

Integration with Carbon Capture

Combining acid gas removal with carbon capture techniques to reduce greenhouse gas emissions. Facilitates compliance with stricter environmental regulations.

Automation and Digitalization

Employing sensors and AI-driven control systems for real-time process optimization. Enhances reliability and reduces operational costs.

Best Practices for Treating Difficult Feed Gases to LNG Plants

Comprehensive Feed Gas Characterization: Always start with detailed analysis to select appropriate treatment technologies.

Tailored Treatment Solutions: Customize processes based on specific impurity levels and variability.

Regular Maintenance and Monitoring: Ensure equipment operates within design parameters and detect issues early.

Environmental Compliance: Incorporate emission control and waste management strategies.

Staff Training: Equip personnel with knowledge on handling hazardous impurities safely.

Conclusion

Treating difficult feed gases to LNG plants is a complex but essential task that directly influences the efficiency, safety, and environmental footprint of LNG production. By understanding the nature of impurities and deploying the right combination of treatment technologies—ranging from amine scrubbing to cryogenic separation—industry operators can ensure high-quality LNG output while minimizing operational risks and costs. Advancements in membrane technology, adsorbent materials, and process automation promise to further improve treatment efficacy and sustainability. As the demand for clean and efficient energy grows, refining the treatment of challenging feed gases remains a vital component of the LNG industry's evolution.

Keywords: LNG feed gas treatment, acid gas removal, CO_2 removal, H_2S scrubbing, dehydration, heavy hydrocarbons, nitrogen rejection, cryogenic separation, membrane technology, process optimization.

Treating Difficult Feed Gases to LNG Plants: An Expert Overview

In the rapidly evolving landscape of liquefied natural gas (LNG) production, the quality of feed gases plays a pivotal role in ensuring efficient, safe, and cost-effective operations. As LNG plants increasingly process diverse and challenging feed gases—often containing a complex mixture of contaminants—understanding how to effectively treat these difficult feed streams becomes essential. This article delves into the intricacies of treating challenging feed gases for LNG production, offering a comprehensive, expert-oriented overview of the technologies, processes, and best practices involved.

Understanding the Challenges of Difficult Feed Gases in LNG Production

The feed gas entering an LNG plant is typically a mixture of hydrocarbon gases, predominantly methane, along with various impurities. While standard feed gases are manageable with established treatment processes, difficult feed gases present unique challenges due to their composition and impurity levels.

Common Contaminants in Difficult Feed Gases

- Carbon Dioxide (CO₂):** Causes freezing and solid formation during liquefaction, risking blockages.
- Mercury (Hg):** Can alloy with aluminum heat exchangers, leading to corrosion and equipment failure.
- Sulfur Compounds (H₂S, COS):** Corrosive gases that can damage equipment and pose environmental concerns.
- Heavy Hydrocarbons (C₅+):** Can cause freezing issues and reduce LNG yield.
- Water Vapor:** Leads to hydrate formation and freezing problems.
- Nitrogen (N₂):** Dilutes methane content, reducing LNG calorific value.
- Particulates and Acid Gases:** Can cause fouling and corrosion.

The complexity and variability of these impurities make the treatment process more challenging compared to standard feed gases.

Key Strategies for Treating Difficult Feed Gases

Treating challenging feed gases involves a combination of advanced separation technologies, chemical treatments, and process optimization. The primary goal is to meet the stringent specifications for LNG production—particularly low levels of CO₂, N₂, and mercury—while maintaining high operational efficiency.

Pre-Treatment Considerations

Pre-treatment is critical to protect downstream processing units such as cryogenic exchangers and to ensure the overall integrity of the plant. This involves:

- Filtration:** Removal of particulates and solids.
- Dehydration:** Using glycol dehydration units to eliminate water vapor, preventing hydrate formation.
- Contaminant Specific Removal:** Targeted removal of specific impurities like mercury and sulfur gases.

Effective pre-treatment ensures that the gas entering cryogenic processing is stable and within tolerable impurity levels.

Advanced Gas Separation Technologies

Achieving the desired purity levels in LNG production, especially from difficult feed gases, demands sophisticated separation technologies:

- Acid Gas Removal (AGR) Units**
- Amine Scrubbing:** The most common method for CO₂ and H₂S removal. Special solvents (e.g., methyl diethanolamine) are used to absorb acid gases selectively.
- Physical Solvent Systems:** Such as Selexol or Rectisol, which operate at low temperatures and are effective for high CO₂/H₂S concentrations.
- Mercury Removal Systems**
- Activated Carbon Beds:** Mercury adsorbs onto activated carbon, often impregnated with sulfur or other agents.
- Gold-Enhanced Sorbents:** Some systems use gold-based sorbents that form amalgams with mercury, offering high capacity and specificity.
- Temperature Swing Adsorption (TSA):** For regenerating sorbent beds.
- Nitrogen Rejection Units**
- Membrane Separation:** Polymer or ceramic membranes that

selectively permeate N_2 , reducing its concentration. Cryogenic N_2 Rejection: Low-temperature distillation techniques for high N_2 removal efficiency. Heavy Hydrocarbon Removal Cryogenic Fractionation: To separate C_5+ hydrocarbons. Absorption and Adsorption: Using activated carbons or other absorbents to remove heavy hydrocarbons and other condensates. Optimizing the Treatment Process for Difficult Feed Gases Given the complexity of difficult feed gases, optimization involves balancing multiple factors. Process Integration: Combining treatment units to minimize energy consumption and footprint. Material Selection: Using corrosion-resistant alloys and materials compatible with aggressive contaminants. Monitoring and Control: Real-time sensors for impurity levels, enabling dynamic process adjustments. Redundancy and Flexibility: Designing systems capable of handling feed gas variability. Case Study: Handling Mercury and CO_2 in a Challenging Feed Gas Stream Consider an LNG plant processing a feed gas with elevated mercury and CO_2 levels. The treatment strategy includes: Pre-Dehydration: Using glycol dehydration to remove bulk water. Mercury Removal: Passing the gas through activated carbon beds designed for mercury capture, with periodic regeneration. Acid Gas Removal: Employing a Selexol system capable of handling high CO_2 concentrations, ensuring downstream freezing issues are mitigated. N_2 Rejection: Utilizing membrane technology for N_2 reduction, optimizing the methane content. Final Polishing: Additional filtration and adsorbents to remove residual contaminants before liquefaction. This integrated approach ensures the feed gas meets LNG specifications, minimizes operational risks, and maximizes plant throughput. Emerging Technologies and Best Practices As feed gases become more complex, new solutions and best practices are emerging: Hybrid Separation Systems: Combining membrane, cryogenic, and chemical removal methods for tailored impurity removal. Solid Adsorbent Innovations: Development of advanced sorbents with higher capacity and selectivity for mercury and other contaminants. Process Automation: Enhanced control systems for real-time monitoring and adaptive process adjustments. Environmental Compliance: Technologies designed to minimize emissions and waste, aligning with stricter environmental standards. Best practices include thorough feed gas analysis, proactive maintenance, and continuous process optimization. Conclusion: Achieving Efficient Treatment for Difficult Feed Gases Treating difficult feed gases to LNG plants is a complex but manageable challenge that requires a comprehensive understanding of gas composition, advanced separation technologies, and robust process design. Success hinges on proactive pre-treatment, the deployment of specialized removal systems, and ongoing optimization. By adopting innovative solutions and integrating best practices, LNG producers can ensure high-quality feed gases, safeguard their equipment, and achieve operational efficiency, paving the way for sustainable growth in the global LNG market. Whether dealing with high levels of mercury, CO_2 , nitrogen, or heavy hydrocarbons, the key lies in tailoring treatment strategies to the specific impurity profile, leveraging technological advancements, and maintaining rigorous monitoring protocols. As the industry continues to evolve, so too must the approaches to treating these challenging feed gases, keeping LNG plants competitive, compliant, and efficient in an increasingly demanding market.

QuestionAnswer

What are the primary challenges in treating difficult feed gases for LNG plants?

The main challenges include removing impurities such as sulfur compounds, CO₂, heavy hydrocarbons, and trace contaminants that can cause corrosion, catalyst poisoning, or operational issues in LNG processing.

Which purification technologies are most effective for treating challenging feed gases?

Common technologies include amine gas treating for CO₂ and H₂S removal, cryogenic separation for heavy hydrocarbons, adsorption methods like pressure swing adsorption (PSA), and membrane separation for specific contaminants.

How does high CO₂ content in feed gases impact LNG production, and how is it treated?

High CO₂ levels can reduce liquefaction efficiency and cause operational problems. Treatment involves amine absorption or membrane separation to reduce CO₂ to acceptable levels before liquefaction.

What role does sulfur removal play in treating difficult feed gases?

Sulfur compounds can cause corrosion and environmental issues. Technologies like scavengers, amine treating, or catalytic oxidation are employed to remove sulfur to meet safety and environmental standards.

How are heavy hydrocarbons managed in challenging feed gases for LNG plants?

Heavy hydrocarbons are typically removed via cryogenic fractionation or adsorption processes to prevent freezing issues and ensure smooth liquefaction operation.

What are the environmental considerations when treating difficult feed gases for LNG production?

Treatment processes must minimize emissions of contaminants, prevent environmental pollution, and comply with regulations through effective removal of sulfur, CO₂, and other hazardous substances.

How does membrane technology compare to amine treating for impurity removal in feed gases?

Membrane technology offers energy-efficient, compact solutions suitable for specific contaminants, while amine treating is more established for bulk CO₂ and H₂S removal, especially in high impurity

scenarios.

What innovations are emerging in the treatment of difficult feed gases for LNG plants?

Emerging innovations include hybrid membrane-amine systems, advanced adsorbents, process intensification techniques, and real-time monitoring to improve efficiency and reduce costs.

How does feed gas composition variability affect the treatment process design in LNG plants?

Variability requires flexible treatment systems capable of adapting to changing impurity levels, often involving modular or staged treatment units to ensure consistent LNG quality.

What are the best practices for ensuring reliable treatment of difficult feed gases in LNG operations?

Best practices include thorough feed gas analysis, proper process design with redundancies, regular maintenance, real-time monitoring of impurities, and adopting advanced treatment technologies tailored to specific feed compositions.

Related keywords: gas processing, dehydration, acid gas removal, sulfur removal, mercaptan removal, cryogenic distillation, membrane separation, adsorption technologies, impurity removal, LNG plant optimization

Ammonia flash separation

Ammonia Flash Separation: An Essential Technique in Industrial Gas Purification Ammonia flash separation is a critical process utilized in various industrial applications to efficiently separate ammonia from mixtures containing other gases or liquids. This technique is especially vital in the production, storage, and transportation of ammonia, ensuring safety, purity, and process efficiency. By leveraging the principles of rapid vaporization and phase change under controlled conditions, ammonia flash separation enables industries to achieve high separation efficiency with minimal energy consumption. Understanding the fundamentals, operational parameters, applications, and safety considerations of this process is essential for engineers, operators, and decision-makers involved in chemical processing and gas handling.

What is Ammonia Flash Separation? Ammonia flash separation is a physical separation process where a mixture containing ammonia is subjected to sudden pressure reduction or heating, causing a rapid vaporization of ammonia. The term "flash" refers to the quick transition from liquid to vapor phase, resulting in the separation of ammonia from other components based on differences in volatility and phase behavior. This process is typically

employed in situations where ammonia needs to be separated from: Liquid or vapor mixtures
Aqueous solutions containing ammonia
Gas streams with ammonia impurities
The objective is to achieve a high-purity ammonia stream while minimizing energy input and maximizing throughput.

Principles of Ammonia Flash Separation

Thermodynamics and Phase Behavior

The core principle behind ammonia flash separation is the phase change driven by thermodynamic conditions, primarily pressure and temperature. When the pressure on a liquid ammonia mixture is suddenly decreased, the ammonia reaches its boiling point at the new pressure, leading to rapid vaporization.

Key aspects include:

- Vapor-Liquid Equilibrium (VLE):** Understanding the VLE curve of ammonia-water or ammonia-inert mixtures helps determine optimal operation points.
- Boiling Point at Different Pressures:** Ammonia has a boiling point of -33.34°C at atmospheric pressure, but this can vary with pressure, influencing the separation process.
- Latent Heat of Vaporization:** The energy required for vaporization impacts energy consumption and design considerations.

Rapid Pressure Drop (Flash) Phenomenon

The process involves:

- Preconditioning:** The mixture is heated or pressurized to a specific point.
- Expansion/Pressure Reduction:** The mixture passes through a pressure-reducing device such as a flash tank or pressure vessel.
- Vaporization:** The sudden drop in pressure causes ammonia to vaporize rapidly.
- Separation:** The vapor phase (rich in ammonia) is separated from the remaining liquid phase, which is depleted of ammonia. This rapid phase change exploits differences in volatility and affinity for phase change, enabling effective separation.

Types of Ammonia Flash Separation Equipment

Various equipment configurations are used to implement ammonia flash separation, each suited to specific operational needs:

- Flash Tanks**
Description: Vertical or horizontal vessels where pressure is suddenly reduced.
Operation: Mixture enters at high pressure, then undergoes a controlled pressure drop, leading to vaporization.
Advantages: Simple design, effective for large flow rates.
- Flash Drums**
Similar to flash tanks but often equipped with internal baffles or trays to improve separation quality.
- Turbo Expanders**
Description: Devices that expand high-pressure ammonia gases to produce cooling and vaporization.
Application: Used in cryogenic processes or when high efficiency is required.

Membrane or Other Advanced Separation Technologies

Complementary methods that may be integrated with flash separation for enhanced purity.

Operational Parameters Influencing Ammonia Flash Separation

Achieving optimal separation efficiency depends on carefully controlling several operational parameters:

- Pressure Control:** Precise regulation of inlet pressure to ensure the ammonia reaches its vaporization point. Typical pressure drops range from several bar to atmospheric or below, depending on process requirements.
- Temperature Management:** Pre-heating of the mixture increases vaporization efficiency. Maintaining temperatures below ammonia's critical point ($\sim 132.4^{\circ}\text{C}$) to prevent supercritical conditions.
- Flow Rate and Residence Time:** Adequate residence time in the flash vessel ensures complete vaporization. Flow rates must be balanced to prevent carryover or incomplete separation.

Phase Equilibrium Considerations

Understanding the mixture composition and VLE behavior ensures the process operates within optimal parameters.

Applications of Ammonia Flash Separation

This process finds extensive use across multiple industries:

- Ammonia Production Plants:** Separation of ammonia from synthesis gases or unreacted feedstock.
- Purification of ammonia:** before storage or further processing.
- Refrigeration and Cooling Systems:** Ammonia is widely used as a refrigerant; flash separation helps recover ammonia from refrigeration cycle condensates.
- Fertilizer**

Manufacturing Purification of ammonia streams used in fertilizer synthesis. Gas Processing and Treating Removal of ammonia impurities from natural gas or other hydrocarbon streams. Environmental Control Recovery of ammonia from waste streams to prevent emissions and pollution. Advantages of Ammonia Flash Separation Implementing ammonia flash separation offers several benefits: High Separation Efficiency: Rapid phase change enables effective separation of ammonia. Energy Efficiency: When properly designed, the process consumes less energy compared to distillation. Simplicity of Equipment: Flash tanks and vessels are straightforward to operate and maintain. Cost-Effectiveness: Lower capital and operational costs compared to more complex separation methods. Environmental Benefits: Facilitates ammonia recovery, reducing emissions and environmental impact. Challenges and Safety Considerations While advantageous, ammonia flash separation also involves certain challenges and safety concerns: Handling of Toxic and Flammable Gases Ammonia is toxic, corrosive, and flammable. Proper safety protocols are essential. Equipment must be designed to prevent leaks and accidental releases. Corrosion and Material Compatibility Ammonia can cause corrosion; materials like stainless steel are preferred. Pressure and Temperature Control Precise control is necessary to prevent over-pressurization or unintended phase changes. Emergency Preparedness Adequate ventilation, leak detection, and emergency shutdown systems are crucial. Design and Optimization of Ammonia Flash Separation Systems Designing an effective ammonia flash separation system involves: Process Simulation: Using thermodynamic models to predict phase behavior. Equipment Selection: Choosing suitable vessels, pressure regulators, and control instrumentation. Operational Flexibility: Allowing adjustments for feed variability. Monitoring and Control: Implementing sensors for pressure, temperature, and flow to maintain optimal conditions. Optimization strategies include: Adjusting pressure drops for maximum vaporization without causing equipment stress. Pre-heating mixtures to improve vaporization efficiency. Incorporating internal baffles or trays for better phase separation. Future Trends and Innovations in Ammonia Flash Separation Research and development efforts focus on: Enhanced Materials: Development of corrosion-resistant, lightweight materials for safety and durability. Process Integration: Combining flash separation with other purification steps for higher purity. Energy Recovery: Utilizing waste heat or expanding energy-efficient devices like turbo expanders. Automation and Control: Advanced control systems for real-time optimization and safety. Conclusion Ammonia flash separation stands as a vital process in the chemical and industrial sectors, enabling efficient, safe, and cost-effective separation of ammonia from complex mixtures. By understanding the thermodynamics, equipment choices, operational parameters, and safety considerations, industries can optimize this process to meet their purity, efficiency, and environmental goals. As technology advances, innovations in equipment design, process control, and safety will continue to enhance the effectiveness of ammonia flash separation, solidifying its role in modern chemical processing and gas handling systems. Proper implementation and ongoing optimization are key to harnessing the full potential of this essential separation technique.

Ammonia Flash Separation: An In-Depth Guide to Efficient Separation Processes Ammonia flash

separation is a critical process in chemical engineering, particularly within industries such as fertilizer manufacturing, refrigeration, and chemical synthesis. This technique involves the rapid vaporization of ammonia from a liquid mixture under reduced pressure, enabling efficient separation of ammonia from other components. Understanding the principles, equipment, and optimization strategies behind ammonia flash separation is essential for engineers and plant operators aiming to maximize efficiency, safety, and product purity.

What Is Ammonia Flash Separation?

Ammonia flash separation refers to the process where liquid ammonia, often mixed with water or other impurities, is subjected to a sudden reduction in pressure (or an increase in temperature), causing a portion of the ammonia to vaporize instantly. This rapid vaporization, called "flashing", separates ammonia from the liquid phase, allowing it to be collected as a vapor and subsequently condensed or further processed. This process is favored for its simplicity, low energy consumption, and ability to quickly remove ammonia from mixtures. It is especially useful in situations where a high purity of ammonia vapor is desired or where downstream processes require ammonia in vapor form.

Principles of Ammonia Flash Separation

Thermodynamics Behind Flash Separation

The foundation of flash separation lies in the principles of phase equilibrium and thermodynamics. When a liquid mixture is suddenly depressurized, its vapor pressure exceeds the system pressure, causing part of the liquid to vaporize. The degree of vaporization depends on temperature, pressure, and the composition of the mixture. Ammonia's high vapor pressure at ambient or slightly elevated temperatures makes it particularly suitable for flash separation.

Key Factors Influencing Flash Separation

Pressure Drop: The magnitude of the pressure reduction determines how much ammonia vaporizes.
Temperature: Higher temperatures increase vapor pressure and enhance vaporization.
Composition of the Feed: The initial concentration of ammonia in the mixture influences the separation efficiency.
Flow Rate: The rate at which the mixture is fed into the flash vessel impacts residence time and separation quality.

Equipment Used in Ammonia Flash Separation

Flash Tanks (Vessels)

The core component for ammonia flash separation is the flash tank or flash vessel. It is designed to:

- Withstand the pressure and temperature conditions.
- Facilitate rapid phase change.
- Enable easy separation of vapor and liquid phases.

Design Considerations for Flash Tanks

Material Compatibility: Use corrosion-resistant materials like carbon steel, stainless steel, or specialized alloys due to ammonia's corrosive nature.
Size and Capacity: Sized based on feed flow rates and desired separation efficiency.
Internal Features: Baffles or distributor plates improve phase contact and separation.

Auxiliary Equipment

Condensers: To condense ammonia vapor into liquid form for collection or reuse.
Reboilers: Sometimes integrated to supply heat for maintaining optimal vaporization.
Pressure Control Devices: Valves and regulators to precisely manage depressurization.

The Process of Ammonia Flash Separation

Step-by-Step Overview

Feed Preparation The mixture containing ammonia is prepared, ensuring it is within specified parameters for temperature and pressure.
Depressurization The feed is introduced into the flash tank through pressure-reducing valves, causing a sudden drop in pressure.
Vaporization (Flashing) Under the new conditions, part of the ammonia vaporizes rapidly, separating from the liquid phase.
Separation The vapor and liquid phases are allowed to stratify naturally, aided by the vessel's design.
Collection and Processing The ammonia vapor is drawn off from the top, often condensed into high-purity liquid ammonia, while the residual liquid (rich in water or impurities) is drained from the

bottom. Advantages of Flash Separation Rapid and energy-efficient compared to distillation. Minimal equipment requirements. Suitable for continuous processing. High throughput with proper design. Optimization Strategies for Ammonia Flash Separation Controlling Operating Conditions Pressure Adjustment: Fine-tuning the pressure drop to maximize vaporization without causing excessive carryover or entrainment. Temperature Management: Maintaining optimal feed temperature to improve separation efficiency. Flow Rate Regulation: Ensuring steady feed rates for consistent operation. Equipment Design Improvements Enhanced Vessel Design: Incorporating internal baffles or demisters to reduce entrainment. Use of Multiple Stages: Cascading flash tanks for improved purity and recovery rates. Integration with Condensation Units: To recover ammonia vapor efficiently. Process Monitoring and Control Real-time Sensors: For pressure, temperature, and flow rate. Automated Control Systems: To adjust parameters dynamically, ensuring optimal separation. Safety and Environmental Considerations Ammonia is a hazardous chemical with significant health and environmental risks. Proper safety protocols must underpin all flash separation operations: Leak Prevention: Use of high-quality seals and regular maintenance. Proper Ventilation: To prevent ammonia accumulation. Emergency Relief Systems: To handle overpressure scenarios. Environmental Controls: Scrubbers or scrubber systems to treat vented gases and prevent environmental release. Applications of Ammonia Flash Separation Fertilizer Production: Recovering ammonia from process streams. Refrigeration Systems: Separating ammonia for reuse or disposal. Chemical Manufacturing: Purifying ammonia for downstream chemical reactions. Gas Purification: Removing impurities from ammonia gas streams. Conclusion Ammonia flash separation is a vital technique in the chemical processing industry, combining thermodynamic principles with practical engineering to efficiently and safely isolate ammonia vapor from mixtures. When carefully designed, operated, and optimized, flash separation vessels can significantly enhance process performance, reduce energy consumption, and improve product purity. As industries strive for safer and more sustainable operations, understanding and leveraging the principles of ammonia flash separation becomes increasingly important. By focusing on key factors such as pressure control, equipment design, and process monitoring, engineers can tailor flash separation processes to meet specific operational needs. Whether in large-scale fertilizer plants or smaller chemical facilities, mastering ammonia flash separation is essential for achieving high efficiency and safety standards in ammonia handling and processing.

Question Answer

What is ammonia flash separation and how does it work?

Ammonia flash separation is a process used to quickly separate ammonia vapor from liquid ammonia by reducing pressure or increasing temperature, causing the ammonia to vaporize rapidly and be separated from the liquid phase.

What are the main applications of ammonia flash separation in industry?

It is primarily used in the production and purification of ammonia in fertilizer manufacturing, refrigeration systems, and chemical processing plants to efficiently recover ammonia vapors and improve process efficiency.

What are the key factors affecting the efficiency of ammonia flash separation?

Factors include pressure and temperature conditions, the initial ammonia concentration, system design, and the rate of depressurization, all of which influence the vaporization rate and separation effectiveness.

What safety considerations should be taken into account during ammonia flash separation?

Proper ventilation, leak detection, pressure control, and protective equipment are essential due to ammonia's toxicity and corrosiveness. Ensuring equipment is designed to withstand pressure changes is also critical.

How can process optimization improve ammonia flash separation efficiency?

Optimizing parameters like pressure drop rate, temperature, and system design, along with continuous monitoring, can enhance vapor-liquid separation, reduce energy consumption, and increase purity.

Are there any recent technological advancements in ammonia flash separation methods?

Recent developments include the integration of advanced sensors for real-time monitoring, automation for better control, and improved condenser and separator designs to boost separation efficiency and safety.

Related keywords: ammonia distillation, flash evaporation, ammonia separation, process engineering, vapor-liquid separation, ammonia recovery, thermodynamic separation, industrial separation processes, pressure swing absorption, ammonia purification

Heat exchangers deaerator and feedwater tank

heat exchangers deaerator and feedwater tank are essential components in thermal power plants,

industrial processes, and various heating systems. Their primary function is to ensure the efficient removal of dissolved gases, such as oxygen and carbon dioxide, from feedwater, thereby preventing corrosion and enhancing system longevity. These devices work together within a complex network of equipment to optimize heat transfer, maintain water quality, and ensure reliable operation of steam generation systems. Understanding the design, operation, and maintenance of heat exchangers, deaerators, and feedwater tanks is critical for engineers, plant operators, and maintenance personnel committed to maximizing efficiency and minimizing downtime.

Understanding Heat Exchangers: The Heart of Thermal Efficiency

What Are Heat Exchangers?

Heat exchangers are devices designed to transfer heat between two or more fluids without mixing them. They are fundamental to many industrial processes where heat needs to be conserved or transferred efficiently. In power plants, heat exchangers preheat feedwater before it enters the boiler, thereby improving overall thermal efficiency.

Types of Heat Exchangers Used in Power Plants

Shell and Tube Heat Exchangers:

The most common type, featuring a series of tubes inside a shell, ideal for high-pressure applications.

Plate Heat Exchangers:

Comprise multiple thin plates, providing high heat transfer efficiency in compact designs.

Air Cooled Heat Exchangers:

Use air to cool the fluids, suitable where water is scarce.

Role of Heat Exchangers in Power Plants

Preheating feedwater

Condensing steam from turbines

Recovering waste heat

Improving overall plant efficiency

Deaerators: Removing Dissolved Gases for Corrosion Prevention

What Is a Deaerator?

A deaerator is a specialized device that removes dissolved gases, mainly oxygen and carbon dioxide, from feedwater. These gases can cause corrosion in boiler tubes and other system components if not adequately eliminated.

Types of Deaerators

Tray Deaerators:

Use a series of trays to contact feedwater with steam, facilitating gas removal.

Spray Deaerators:

Employ spray nozzles to create fine water droplets, increasing contact surface with steam.

Combination Deaerators:

Incorporate features of both tray and spray types for optimized performance.

Working Principle of a Deaerator

Preheating:

Feedwater is heated using low-pressure steam, raising its temperature close to saturation.

Gas Removal:

Elevated temperature reduces the solubility of gases, which are then expelled with venting steam.

Storage and Supply:

The deaerated feedwater is stored in a tank and supplied to the boiler feedwater system.

Importance of Deaerators in Power Plants

Minimize oxygen and carbon dioxide levels

Prevent corrosion of boiler and piping systems

Extend equipment lifespan

Improve efficiency by maintaining water quality

Feedwater Tanks: Storage and Quality Control

What Is a Feedwater Tank?

A feedwater tank, also known as a surge tank or deaerated water tank, stores preheated, deaerated feedwater before it is pumped into the boiler. It acts as a buffer to accommodate fluctuations in demand and ensures continuous operation.

Design Features of Feedwater Tanks

Adequate capacity to meet plant demand

Insulation to maintain water temperature

Venting systems to release gases

Level controls and alarms for safety

Functions of Feedwater Tanks

Store deaerated water

Allow for mixing of water to ensure uniform temperature and quality

Provide a space for water treatment chemicals to be added

Serve as a safety barrier against sudden demand changes

Operational Considerations

Maintaining proper water level to avoid dry firing

Ensuring effective deaeration and filtration

Regular cleaning and maintenance to prevent fouling and corrosion

Integration of Heat Exchangers, Deaerators, and Feedwater Tanks in Power Plants

System Workflow Overview

Feedwater Heating: Raw water passes through heat exchangers,

where it absorbs heat from various processes.

Deaeration Process: The heated water flows into the deaerator, where dissolved gases are removed.

Storage and Buffering: The deaerated water is stored in the feedwater tank, ready for pumping.

Boiler Feed: Pumped into the boiler for steam generation, completing the cycle.

Benefits of Proper Integration

- Enhanced thermal efficiency
- Reduced corrosion and maintenance costs
- Improved system reliability
- Longer operational lifespan of equipment

Design Considerations for Heat Exchangers, Deaerators, and Feedwater Tanks

Key Factors in Design

- Material selection based on corrosion resistance and thermal conductivity
- Capacity sizing aligned with plant demand
- Pressure ratings to withstand operating conditions
- Ease of maintenance and cleaning
- Safety features, including venting and level controls

Common Challenges and Solutions

Scaling and Fouling: Use of anti-fouling coatings and regular cleaning

Corrosion: Material selection and water treatment

Venting Efficiency: Proper vent design to ensure complete gas removal

Temperature Control: Accurate sensors and control systems

Maintenance and Troubleshooting

Regular Inspection Tips

- Check for leaks, corrosion, and fouling
- Verify venting and drainage systems
- Monitor water quality parameters
- Ensure all controls and safety devices function correctly

Common Issues and Fixes

- Decreased gas removal efficiency: Clean or replace spray nozzles or trays
- Corrosion signs: Improve water treatment and material selection
- Temperature fluctuations: Calibrate sensors and control systems
- Leaks or structural damage: Conduct timely repairs and inspections

Environmental and Efficiency Benefits

Environmental Advantages

- Reduced oxygen and carbon dioxide emissions due to minimized corrosion products
- Lower water consumption by optimizing heat recovery
- Decreased chemical usage through improved water quality

Efficiency Improvements

- Enhanced heat transfer through well-maintained heat exchangers
- Reduced fuel consumption by preheating feedwater
- Longer equipment lifespan reduces replacement and downtime costs

Conclusion

Understanding the roles and interplay of heat exchangers, deaerators, and feedwater tanks is vital for optimizing power plant performance and longevity. Proper design, operation, and maintenance of these components not only improve thermal efficiency but also significantly reduce corrosion-related failures, leading to safer and more economical operations. As industries continue to seek sustainable and efficient energy solutions, investing in high-quality heat exchangers, advanced deaerator systems, and robust feedwater tanks remains a strategic priority for plant operators worldwide. This comprehensive overview provides insights into the critical components that uphold the efficiency and safety of thermal power systems. Whether you are designing a new plant or maintaining existing facilities, understanding these systems' nuances ensures optimal performance and longevity.

Heat Exchangers, Deaerators, and Feedwater Tanks: An In-Depth Technical Exploration

Introduction to Heat Exchangers, Deaerators, and Feedwater Tanks

In the realm of thermal power plants, process industries, and large-scale heating systems, the seamless integration of various components ensures operational efficiency, safety, and longevity. Among these critical components, heat exchangers, deaerators, and feedwater tanks play pivotal roles. While each performs distinct functions, their combined operation sustains optimal heat transfer, reduces corrosion, and

guarantees a reliable supply of high-quality feedwater. This review delves into each component's technical intricacies, operational principles, design considerations, and integration strategies, providing a comprehensive understanding vital for engineers, operators, and maintenance personnel.

Heat Exchangers: Fundamentals, Types, and Applications

Definition and Purpose

A heat exchanger is a device designed to transfer heat between two or more fluids without mixing them. This process is fundamental in various industrial applications, including power generation, chemical processing, HVAC systems, and refrigeration. Its primary aim is to optimize energy utilization, improve process efficiency, and minimize waste heat.

Operational Principles

The core principle involves conduction and convection: Hot fluid transfers heat through the exchanger's surface. The heat is then absorbed by the cooler fluid. The efficiency depends on temperature difference, flow arrangement, and heat transfer surface area.

Types of Heat Exchangers

The selection hinges on process requirements, flow rates, pressure, temperature, and fouling tendencies. Common types include:

Shell and Tube Heat Exchangers

Construction: Comprise a series of tubes enclosed within a cylindrical shell.

Advantages: High pressure capability, ease of maintenance, adaptable to large capacities.

Applications: Power plant feedwater heating, oil refineries.

Plate Heat Exchangers

Construction: Consist of multiple thin, corrugated plates assembled in parallel.

Advantages: Compact, high heat transfer efficiency, easy to clean.

Applications: HVAC systems, food processing.

Air Coolers

Function: Transfer heat from process fluids to ambient air.

Usage: Power plant condensers, petrochemical plants.

Adiabatic and Double Pipe Heat Exchangers

Suitability: Small-scale, low-pressure applications or where space constraints exist.

Design Considerations

Designing an effective heat exchanger involves balancing several parameters:

- Heat transfer area:** Ensures sufficient heat exchange capacity.
- Flow arrangement:** Counter-flow, parallel-flow, or cross-flow configurations impact heat transfer efficiency.
- Material selection:** Must withstand operating temperatures, pressures, and corrosive environments (e.g., stainless steel, carbon steel, copper alloys).
- Fouling and scaling:** Regular maintenance and material choice mitigate fouling, which hampers heat transfer.
- Pressure drop:** Minimized to reduce pumping costs while maintaining desired flow rates.

Operational Challenges and Maintenance

Fouling reduces heat transfer efficiency and increases energy consumption. Corrosion can lead to leaks and structural failure. Regular cleaning, inspection, and tube integrity testing are crucial. Use of corrosion inhibitors and proper water treatment prolongs lifespan.

Deaerators: Eliminating Dissolved Gases for System Integrity

Introduction and Purpose

A deaerator is a device designed to remove dissolved gases—primarily oxygen and carbon dioxide—from feedwater. The presence of these gases accelerates corrosion in boilers and associated piping, leading to reduced component lifespan and increased maintenance costs. Hence, deaerators are vital for ensuring water quality and operational reliability.

Operational Principles

Deaerators operate on the principle of: Heating water to promote gas release. Reducing partial pressure of gases through vacuum or steam stripping. Using venting systems to remove gases. Typically, the process involves: Preheating feedwater to near-boiling temperatures. Applying a vacuum or introducing steam to strip gases. Venting the liberated gases to the atmosphere.

Types of Deaerators

Spray-Type Deaerators

Design: Use spray nozzles to distribute water into a steam atmosphere.

Advantages: Effective in removing oxygen and carbon dioxide, compact size.

Application: Small to medium-sized power plants.

Tray-Type Deaerators

Design:

Feature multiple trays where water cascades over and contacts steam. Advantages: Higher efficiency, larger capacity. Application: Large power plants. Vacuum Deaerators Design: Use vacuum to lower partial pressure, aiding gas removal. Advantages: Effective at lower temperatures, minimal water loss. Application: Critical systems requiring high purity. Design Considerations Heating Surface Area: Sufficient to ensure water reaches the desired temperature for gas removal. Steam Quality and Quantity: Adequate steam supply ensures effective stripping. Vent System Design: To safely vent gases without environmental or safety hazards. Material Compatibility: Use corrosion-resistant materials, considering operating temperature and pressure. Capacity and Size: Match with system demands to prevent over- or under-sizing. Operational Challenges and Best Practices Corrosion Control: Proper oxygen removal minimizes corrosion. Water Chemistry: Maintain appropriate pH and chemical dosing for corrosion inhibition. Regular Inspection: Check for leaks, corrosion, and proper vent operation. Steam Quality: Use clean, dry steam to prevent contamination and fouling. Feedwater Tanks: Storage and Quality Maintenance Role and Significance A feedwater tank serves as a reservoir for storing preheated, treated water before it enters the boiler. It acts as a buffer, helps in maintaining a steady supply, and allows for chemical treatment and deaeration processes to occur. Proper design and operation of feedwater tanks are essential for consistent boiler performance. Design Features Material Selection: Typically carbon steel or stainless steel, considering corrosiveness and temperature. Capacity: Sized based on boiler capacity, startup/shutdown cycles, and operational demands. Level Control: Automated systems maintain water levels to prevent overflow or dry running. Temperature Control: Usually integrated with deaerators or heaters to ensure water is at the correct temperature. Accessibility: For inspection, cleaning, chemical dosing, and maintenance. Operational Considerations Water Treatment: Chemical dosing (e.g., oxygen scavengers, pH adjusters) occurs within or prior to the tank. Preheating: Often, feedwater is preheated to improve efficiency and reduce thermal shock to the boiler. Water Level Management: Critical for preventing boiler damage; includes high-level alarms and automatic shutoffs. Fouling Prevention: Regular cleaning and proper chemical treatment prevent sludge and scaling. Integration with Deaerators and Heat Exchangers The feedwater tank is typically located downstream of the deaerator, ensuring gases are removed before storage. It supplies preheated, deaerated water to the boiler feed pump, which then circulates it through heat exchangers or superheaters as required. Operational Challenges and Maintenance Corrosion Prevention: Use of corrosion inhibitors and maintaining appropriate water chemistry. Fouling and Sedimentation: Regular cleaning and water treatment. Level Control Failures: Regular calibration and maintenance of sensors and control systems. Leak Prevention: Routine inspection of tank integrity, valves, and connections. Integration and System Optimization Holistic Operation Strategy The efficiency of power plants and industrial systems depends on the optimal integration of heat exchangers, deaerators, and feedwater tanks: Sequential Heat Recovery: Heat exchangers preheat feedwater, reducing fuel consumption. Gas Removal Efficiency: Deaerators ensure feedwater is free of oxygen, preventing corrosion. Water Quality Control: Feedwater tanks provide a controlled environment for chemical treatment and storage. Automation and Control: Integration of sensors, PLCs, and control valves ensures seamless operation and safety. Energy and Cost Considerations Proper design minimizes energy losses, reduces chemical consumption, and extends equipment lifespan. Regular

maintenance and monitoring prevent costly failures and downtime. Upgrading to more efficient heat exchangers or deaerators can yield long-term savings. Environmental and Safety Aspects Safe venting of gases in deaerators prevents environmental pollution. Use of corrosion-resistant materials reduces leak risks. Proper handling and disposal of chemical treatments and waste gases adhere to environmental regulations. Conclusion The heat exchangers, deaerators, and feedwater tanks form a vital subsystem within thermal and process industries, ensuring efficient heat transfer, high-quality feedwater, and system longevity. Their design

QuestionAnswer

What is the primary function of a heat exchanger in a power plant?

The primary function of a heat exchanger in a power plant is to transfer heat between two fluids, typically to recover waste heat and improve overall efficiency of the system.

How does a deaerator contribute to the efficiency of a steam boiler system?

A deaerator removes dissolved gases like oxygen and carbon dioxide from feedwater, preventing corrosion in the boiler and enhancing system longevity and efficiency.

What are the key differences between a deaerator and a feedwater tank?

A deaerator removes dissolved gases from feedwater, while a feedwater tank stores and supplies water to the boiler system, often acting as a buffer and mixing point.

Why are heat exchangers important in industrial processes beyond power plants?

Heat exchangers are vital in industries like chemical processing, HVAC, and refrigeration for energy conservation, process optimization, and reducing operational costs.

What maintenance practices are essential for ensuring the longevity of deaerators?

Regular inspections for corrosion, proper operation of sprays and vents, and routine cleaning of deaerator components are essential for maintaining its efficiency and lifespan.

Can a feedwater tank also function as a deaerator in some systems?

Yes, in some systems, the feedwater tank incorporates deaeration features, combining both functions to save space and improve water quality before entering the boiler.

What are the common types of heat exchangers used in modern industrial applications?

Common types include shell and tube, plate, and air-cooled heat exchangers, each suited for different capacities, temperatures, and operational environments.

Related keywords: heat exchangers, deaerator, feedwater tank, boiler feedwater system, deaeration process, water treatment, thermal efficiency, condensate return, steam drum, preheating

Afbc boiler operation procedure

Understanding the AFBC Boiler Operation Procedure AFBC boiler operation procedure is a critical aspect of ensuring efficient, safe, and reliable power generation or process heating in thermal power plants, waste-to-energy facilities, and industries utilizing fluidized bed combustion technology. Atmospheric Fluidized Bed Combustion (AFBC) boilers are designed to burn solid fuels such as coal, biomass, or waste materials with high efficiency and low emissions. Proper operation procedures are essential to maximize performance, minimize environmental impact, and ensure safety for personnel and equipment. This comprehensive guide covers the detailed steps involved in operating an AFBC boiler, including startup, normal operation, and shutdown procedures, along with safety considerations and troubleshooting tips.

Overview of AFBC Boiler Components Before diving into the operation procedures, it's important to understand the main components of an AFBC boiler:

- Fluidized Bed Reactor:** The core area where fuel combustion occurs within a bed of inert particles, such as sand.
- Air Distribution Plate:** Distributes primary air evenly to fluidize the bed.
- Primary Air Fan:** Supplies air necessary for fluidization.
- Secondary Air Supply:** Provides additional air for complete combustion.
- Fuel Feed System:** Introduces solid fuel into the combustion chamber.
- Ash Removal System:** Collects and removes ash produced during combustion.
- Economizer and Air Preheater:** Preheat air and economize flue gases to improve efficiency.
- Flue Gas Treatment System:** Removes pollutants from exhaust gases, including scrubbers and electrostatic precipitators.

Understanding these components helps in executing the correct procedures and troubleshooting effectively.

Pre-Operation Checks Proper preparation before starting the boiler ensures safety and optimal operation.

Inspection and Safety Checks Verify that all safety devices and alarms are functional. Check for any visible leaks in flue gas paths or water circuits. Ensure that all instrumentation, gauges, and control panels are operational. Confirm that ash removal and fuel feeding systems are clean and unobstructed. Review recent maintenance logs and ensure scheduled inspections are completed.

Fuel and Water Supply Verification Confirm that the fuel supply (coal, biomass, waste) is available and properly stored. Check the water level in the boiler drum and ensure feedwater pumps are functioning. Test water treatment systems for proper operation to

prevent scale and corrosion.

Initial System Checks

Ensure the boiler is cool and depressurized before any startup. Confirm that all valves, dampers, and controls are in their correct positions. Check the condition of the refractory lining and bed material.

Startup Procedure for AFBC Boiler

Starting an AFBC boiler involves a systematic approach to safely bring the system from cold to operational state.

Step 1: Pre-Heating and Drying Turn on the auxiliary equipment, including fans, pumps, and control systems. Warm up the water/steam circuit gradually to prevent thermal stresses. Ensure the bed material is dry; if not, initiate drying cycles.

Step 2: Bed Preparation Confirm that the bed material (sand or inert particles) is evenly distributed. Ensure the bed is free from any foreign materials or blockages. Adjust the air distribution to ensure proper fluidization during startup.

Step 3: Ignition and Initial Combustion Open the primary air damper gradually to start fluidizing the bed. Introduce a small amount of fuel manually or via the fuel feeder. Ignite the fuel using an automatic igniter or pilot flame. Monitor temperature and pressure to ensure safe ignition.

Step 4: Normalizing Combustion Gradually increase fuel feed rate while maintaining stable bed temperature. Adjust primary and secondary air supplies for efficient combustion. Monitor flue gases for proper oxygen levels and emissions. Keep an eye on bed temperature, pressure, and other critical parameters.

Step 5: Steady-State Operation Once stable combustion is achieved, optimize air and fuel ratios. Ensure all safety alarms and instrumentation are functioning correctly. Record baseline operational data for future reference.

Normal Operation Procedures

During normal operation, maintaining optimal conditions is vital for efficiency and safety.

Operational Monitoring

Continuously monitor parameters such as bed temperature, pressure, oxygen, and flue gases. Check ash removal systems for blockages or accumulation. Ensure fuel feed rates match desired load conditions. Regularly inspect water levels and boiler drum conditions.

Control System Management

Use the control panel to make necessary adjustments in fuel and air supply. Maintain proper bed temperature (typically 850°C to 950°C). Adjust secondary air to ensure complete combustion and reduce emissions. Use automated control systems for precise regulation.

Pollution Control and Emissions Monitoring

Continuously analyze flue gases for SO_x, NO_x, CO, and particulate matter. Operate electrostatic precipitators or baghouses effectively. Adjust combustion parameters to minimize emissions within permissible limits.

Routine Maintenance During Operation

Schedule periodic inspection of ash removal and bed material replenishment. Check for unusual vibrations or noises indicating equipment issues. Maintain lubrication of moving parts as per manufacturer specifications.

Shutdown Procedure for AFBC Boiler

Proper shutdown procedures prolong equipment life and ensure safety.

Step 1: Reduce Load Gradually decrease fuel feed rate smoothly to avoid thermal shocks. Adjust air supply to maintain stable combustion until flame extinguishes.

Step 2: Cease Fuel Feeding Turn off the fuel supply system once the load is minimized. Ensure all residual fuel is consumed or safely disposed of.

Step 3: Cool Down Reduce combustion air gradually to allow the bed and boiler to cool naturally. Keep the ash removal system operational during cooling to prevent ash buildup. Avoid sudden cooling to prevent thermal stresses and damage.

Step 4: Close Air and Fuel Supplies Shut down primary and secondary air dampers carefully. Turn off auxiliary systems like fans, feedwater pumps, and ash conveyors.

Step 5: Inspection and Maintenance Post-Shutdown Inspect the entire system for wear and damage. Clean the bed material and ash removal components. Record operational data and any irregularities observed.

Safety Precautions and Best Practices

Ensuring safety during AFBC boiler

operation is paramount. Always wear appropriate PPE (Personal Protective Equipment). Regularly train personnel on emergency procedures. Use safety interlocks and alarms to prevent unsafe conditions. Avoid abrupt changes in operational parameters. Maintain clear and accessible control room and safety signage. Conduct periodic safety audits and drills.

Troubleshooting Common Issues in AFBC Boilers

Understanding common problems helps in quick resolution.

Uneven Bed Temperature: Check for bed material distribution; verify air flow uniformity.

High Flue Gas Emissions: Adjust combustion air and fuel feed; inspect for incomplete combustion.

Ash Buildup or Blockages: Increase ash removal frequency; inspect ash handling equipment.

Unstable Combustion: Ensure proper ignition procedures; verify fuel quality.

Vibration or Noise: Examine mechanical parts; check for imbalance or wear.

Conclusion

The afbc boiler operation procedure is a well-defined process that requires careful attention to detail, safety, and efficiency. From startup to shutdown, each step must be performed systematically, considering the specific characteristics of the boiler and fuel used. Proper training, continuous monitoring, and adherence to safety standards are essential to optimize performance and extend the lifespan of the equipment. By following the detailed procedures outlined above, operators can ensure that the AFBC boiler functions effectively, providing reliable energy while minimizing environmental impact. Regular maintenance, vigilant monitoring, and prompt troubleshooting further enhance operational stability, making AFBC technology a sustainable choice for various industrial applications.

AFBC boiler operation procedure is a critical aspect of ensuring efficient, safe, and reliable power generation in thermal plants. Fluidized Bed Combustion (FBC) boilers, particularly those employing Atmospheric Fluidized Bed Combustion (AFBC) technology, are widely used in industries due to their ability to burn a variety of fuels with low emissions and high efficiency. Proper operation procedures are essential to optimize performance, prevent accidents, and prolong equipment lifespan. This guide provides a comprehensive overview of the step-by-step AFBC boiler operation procedure, highlighting key safety considerations, operational checks, and maintenance practices.

Understanding AFBC Boilers

Before diving into the operation procedure, it's crucial to understand what an AFBC boiler is and how it functions. AFBC boiler utilizes a bed of inert material (like sand) through which air is blown to suspend and circulate fuel particles, promoting uniform combustion at atmospheric pressure. The process involves:

- Combustion of fuel in a fluidized state
- Low NO_x and SO_x emissions
- Capability to burn low-grade and waste fuels
- Reduced ash handling and pollution

Pre-Start Checks and Preparations

Safety Precautions

Ensure all safety devices, such as pressure relief valves and interlocks, are in place and functional. Confirm that all personnel involved are trained and equipped with appropriate PPE (Personal Protective Equipment). Verify that emergency shutdown procedures are understood and accessible.

Inspection of Equipment and Components

Fuel Supply System: Check fuel supply line for leaks, blockages, or damage. Confirm fuel quality and quantity.

Air Supply System: Inspect air fans, dampers, and ductwork for obstructions or leaks.

Water Level and Feedwater System: Ensure the water level in the boiler drum is within specified limits; check feedwater pumps and valves.

Instrumentation and

Controls: Verify that all gauges, sensors, and control panels are operational and calibrated. Ash and Bed Material: Confirm proper bed material level and that ash handling systems are ready. Cleaning and Maintenance Remove any accumulated ash or debris from the furnace, air preheater, and flue gas ductwork. Check for corrosion or damage on refractory linings and other critical parts. Startup Procedure for AFBC Boiler Initial Checks Confirm that all safety interlocks are engaged. Ensure that the water level is at the prescribed start-up level. Verify that fuel and air supply systems are ready and free of obstructions. Check that ash removal systems are operational. Lighting Up the Furnace Open the fuel valves gradually, ensuring a controlled flow. Start the fuel firing with a pilot flame or igniter system, if available. Turn on the primary air fan to establish a fluidized bed. Establishing Fluidization Gradually increase the air flow to achieve proper fluidization of the bed. Observe the bed for uniform bubbling and circulation; irregularities indicate issues with air distribution. Adjust dampers and fans to maintain stable fluidization. Bed Material and Combustion Optimization Confirm that bed temperature is within the optimal range (generally 850°C-900°C). Fine-tune fuel feed rate to sustain steady combustion without causing bed agglomeration or cold spots. Adjust excess air to ensure complete combustion while minimizing excess oxygen. Monitoring and Control Continuously monitor parameters such as bed temperature, pressure, flue gas composition, and ash discharge. Use control systems to maintain stable operation, adjusting fuel feed and air flow as necessary. Check for abnormal vibrations, noises, or emissions. Normal Operation Procedures Continuous Monitoring Keep an eye on key parameters: Bed temperature Furnace pressure Flue gas temperature Oxygen and CO levels Ash removal rate Record data at regular intervals to detect trends. Adjustments During Operation Increase or decrease fuel input to maintain desired bed temperature. Modulate air supply for optimal combustion and emissions control. Manage ash removal systems to prevent bed material depletion or accumulation. Emissions Control Ensure that emission levels (NO_x, SO_x, particulate matter) are within permissible limits. Use electrostatic precipitators or bag filters for particulate removal. Adjust combustion parameters if emissions exceed standards. Safety Checks Regularly inspect for abnormal vibrations, leaks, or unusual sounds. Monitor safety devices like pressure relief valves. Keep communication lines open among operators. Shutdown Procedure Gradual Reduction Slowly decrease fuel feed to allow the bed temperature to decline gradually. Turn off the primary air fan once combustion stabilizes at low levels. Cooling Down the System Stop fuel supply completely. Maintain air flow for a short period to purge combustible gases. Allow the bed and boiler to cool naturally under controlled conditions. System Inspection and Maintenance Remove accumulated ash and bed material residues. Inspect refractory linings, burners, and other critical parts for damage. Record operational data and note any irregularities for future reference. Post-Operation Checks and Maintenance Ensure all valves are closed and systems are secured. Perform routine cleaning of soot and ash deposits. Check instrumentation calibration and replace faulty sensors. Schedule preventive maintenance based on operation hours and observed wear. Safety and Troubleshooting Tips Always adhere to safety protocols, including lockout/tagout procedures. If abnormal vibrations or noises occur, shut down the boiler and investigate. Address emissions issues promptly to prevent environmental violations. Regularly train personnel on operation updates and emergency procedures. Conclusion The afbc boiler operation procedure

demands meticulous attention to detail, adherence to safety standards, and continuous monitoring to ensure optimal performance. Proper startup, operation, and shutdown protocols help prevent accidents, reduce emissions, and extend equipment life. With diligent operational practices and routine maintenance, AFBC boilers can deliver reliable and efficient power generation, making them a vital component in modern thermal plants.

QuestionAnswer

What are the initial steps to start an AFBC boiler safely?

Begin by checking all safety devices, ensuring fuel and water supply are adequate, verifying control panel settings, and gradually igniting the startup burner following the manufacturer's operating procedure.

How is the fuel fed into the AFBC boiler during operation?

Fuel is fed continuously or intermittently via a feeder system controlled by the automation system, ensuring proper combustion and maintaining the desired temperature and bed level.

What are the key parameters to monitor during AFBC boiler operation?

Monitor parameters such as bed temperature, flue gas temperature, pressure, oxygen levels, and fuel feed rate to ensure efficient and safe boiler operation.

How is the bed temperature maintained in an AFBC boiler?

Bed temperature is maintained by adjusting the fuel and air feed rates, controlling the combustion process, and using feedback from temperature sensors to optimize combustion conditions.

What are common issues faced during AFBC boiler operation and their remedies?

Common issues include uneven bed temperature, ash buildup, or excessive emissions. Remedies involve adjusting fuel feed, cleaning ash systematically, and optimizing combustion air distribution.

What safety precautions should be followed during AFBC boiler operation?

Operators should wear protective gear, regularly inspect safety valves and devices, avoid sudden changes in fuel or air supply, and follow standard operating procedures to prevent accidents.

How is the ash removal process managed in an AFBC boiler?

Ash is removed via an ash discharge system, typically after cooling, using conveyors or hoppers, with continuous monitoring to prevent ash buildup and ensure smooth operation.

What is the shutdown procedure for an AFBC boiler?

Gradually reduce fuel feed, turn off the air supply, allow the bed to cool down safely, then disconnect auxiliary systems, and perform routine inspection and cleaning after shutdown.

Related keywords: AFBC boiler, fluidized bed combustion, boiler startup procedure, boiler shutdown procedure, boiler safety protocols, AFBC boiler maintenance, combustion process, boiler control system, ash removal process, boiler operation guidelines

Flow diagram lummus ethylene technology

Flow Diagram Lummus Ethylene Technology Ethylene is one of the most vital building blocks in the petrochemical industry, serving as a precursor for plastics, solvents, and other chemical products. The production process of ethylene has evolved over the decades, with Lummus Technology standing out as a leader in providing advanced, efficient, and environmentally friendly ethylene manufacturing solutions. The flow diagram of Lummus ethylene technology offers a comprehensive overview of the process, highlighting key stages, innovations, and operational efficiencies that make it a preferred choice for ethylene producers worldwide. This article delves into the detailed flow diagram of Lummus ethylene technology, exploring each step of the process, the underlying principles, and the technological advantages. Whether you're a process engineer, plant manager, or industry enthusiast, understanding this flow diagram is essential for grasping how modern ethylene production is optimized for maximum yield and sustainability.

Overview of Lummus Ethylene Technology Lummus Technology specializes in designing and licensing ethylene production processes that combine efficiency with environmental compliance. Their ethylene technology primarily revolves around steam cracking, a method that converts hydrocarbons into ethylene and other valuable byproducts. The core features of Lummus ethylene technology include:

- Advanced furnace designs for high throughput and energy efficiency
- Improved feedstock flexibility, accommodating naphtha, ethane, LPG, and other hydrocarbons
- Innovative quenching and cooling systems to optimize product yields
- Integrated recovery units for byproduct separation and purification
- Emphasis on reducing emissions and energy consumption

The flow diagram encapsulates these features, illustrating how raw hydrocarbons are transformed into high-purity ethylene.

Basic Flow Diagram of Lummus Ethylene Process The typical flow diagram for Lummus

ethylene technology comprises several interconnected units, each performing specific functions:

- Feedstock Preparation** Selection and pre-treatment of hydrocarbon feedstock
- Removal of impurities** to prevent catalyst poisoning and furnace fouling
- Steam Cracking Furnace** Main reactor where hydrocarbons are thermally cracked
- Utilizes high-temperature furnaces** with advanced thermal management
- Operates at temperatures** ranging from 850°C to 950°C
- Quenching and Cooling** Rapid cooling of cracked gases to halt further reactions
- Use of water or oil quench systems**
- Primary Fractionation** Separation of cracked gases into light and heavy fractions
- Recovery of ethylene, ethane, propylene, and other hydrocarbons**
- Ethylene Purification** Compression and purification processes
- Use of distillation columns** to achieve high-purity ethylene
- Byproduct Recovery** Extraction of valuable byproducts such as benzene, toluene, and pyrolysis gasoline
- Utilization of absorption and extraction units**
- Utilities and Off-Gas Handling** Management of combustion gases, steam, and other utilities
- Emission control systems** ensuring environmental compliance

Each of these units is interconnected, forming a continuous flow process that maximizes ethylene yield while minimizing waste and energy consumption.

Detailed Breakdown of Each Unit in the Flow Diagram

- Feedstock Preparation** Before entering the cracking furnace, feedstock must be conditioned to ensure efficient cracking and prevent operational issues.
- Hydrocarbon Feedstock Selection:** Naphtha, ethane, LPG, or other hydrocarbons are chosen based on availability and desired product slate.
- Pre-treatment:** Removal of sulfur compounds, nitrogen compounds, and other impurities through hydrotreating or adsorption processes.
- Preheating:** Slight heating to optimize cracking conditions.
- Steam Cracking Furnace** This is the heart of the process, where thermal cracking occurs.
- Furnace Design:** Lummus furnaces utilize advanced refractory materials and thermal management to ensure uniform temperature distribution.
- Cracking Reaction:** Hydrocarbons are broken down into smaller molecules, primarily ethylene, at high temperatures.
- Residence Time:** Carefully controlled to optimize yields and minimize byproduct formation.
- Quenching and Cooling** Rapid cooling is vital to "freeze" the cracked gases and prevent secondary reactions.
- Quench System:** Water or oil quench systems cool gases immediately post-reaction.
- Heat Recovery:** Waste heat is recovered for other plant utilities, improving overall efficiency.
- Primary Fractionation** Separation of cracked gases into individual components.
- High-Pressure Columns:** Separate light gases such as methane and ethane.
- Light Gas Separation:** Ethylene, ethane, propane, and butanes are separated for further purification.
- Ethylene Purification** Purifies ethylene to meet product specifications.
- Compression:** Raising pressure to facilitate distillation.
- Distillation Columns:** Multiple stages to remove impurities like acetylene, methane, and other contaminants.
- Final Ethylene Product:** Achieved with high purity, ready for downstream applications.
- Byproduct Recovery** Maximizes value by capturing other chemicals.
- Benzene and Toluene:** Separated via extraction and distillation.
- Pyrolysis Gasoline:** Recovered for use as blending component or fuel.
- Other Byproducts:** Such as C4 and C5 cuts for further processing.
- Utilities and Off-Gas Handling** Ensures environmentally compliant operation.
- Off-Gas Treatment:** Catalytic oxidation or absorption to reduce emissions.
- Fuel Gas Preparation:** Off-gases used as fuel for furnaces and other utilities.
- Steam and Power Generation:** Using waste heat to generate electricity or process steam.

Technological Innovations in Lummus Ethylene Technology Lummus has incorporated several technological advancements into their ethylene process flow diagram to enhance efficiency and sustainability:

- Advanced Furnace**

Design Improved refractory materials for longer operational life Enhanced thermal management systems to reduce fuel consumption Modular furnace configurations for flexible capacity adjustments Feedstock Flexibility Ability to process various hydrocarbons with minimal modifications Optimization algorithms for feedstock selection based on market conditions Energy Recovery and Integration Heat exchangers for preheating feedstock using waste heat Integration with power plants to utilize excess energy Environmental Compliance Low-emission burners and catalytic afterburners Systems for capturing and treating volatile organic compounds (VOCs)

Advantages of Lummus Ethylene Technology Implementing Lummus ethylene technology offers numerous benefits:

- High Ethylene Yield:** Optimized cracking conditions ensure maximum conversion rates.
- Operational Flexibility:** Capable of processing different feedstocks and adjusting to market demands.
- Energy Efficiency:** Advanced heat integration reduces fuel consumption and greenhouse gas emissions.
- Product Purity:** High-quality ethylene suitable for downstream polymerization and chemical manufacturing.
- Environmental Sustainability:** Reduced emissions and waste through innovative process design.

Conclusion The flow diagram of Lummus ethylene technology encapsulates a sophisticated, integrated process designed to maximize efficiency, yield, and environmental compliance. From feedstock preparation to the final high-purity ethylene product, each unit operation is optimized through technological innovations and process control strategies. As the demand for ethylene continues to grow, Lummus's advanced process solutions stand out as reliable, flexible, and sustainable options for petrochemical producers worldwide. Understanding this flow diagram enables industry professionals to better appreciate the complexities and efficiencies of modern ethylene production, guiding improvements, troubleshooting, and strategic planning for future plant upgrades or new installations.

Flow Diagram Lummus Ethylene Technology: An In-Depth Exploration The global petrochemical industry stands as a cornerstone of modern manufacturing, enabling the production of plastics, solvents, and a myriad of chemical products essential to daily life. Among the vital processes within this sector, the production of ethylene—a fundamental building block for the creation of polymers such as polyethylene and ethylene oxide—remains a focal point of technological innovation and operational excellence. A pivotal aspect of this production process is the utilization of Flow Diagram Lummus Ethylene Technology, a sophisticated approach that combines advanced process design with cutting-edge engineering to optimize efficiency, safety, and environmental performance. This comprehensive article aims to provide an investigative and detailed review of the Flow Diagram Lummus Ethylene Technology, exploring its technical foundations, operational intricacies, recent advancements, and the strategic considerations that underpin its deployment across global petrochemical complexes.

Understanding Ethylene Production and the Role of Flow Diagrams

The Significance of Ethylene in the Petrochemical Industry Ethylene (C_2H_4) is arguably the most produced organic compound worldwide, serving as a precursor to a vast array of chemicals and materials. Its production volume surpasses that of many other chemicals, driven by demand in packaging, automotive, construction, and healthcare sectors. The primary methods of ethylene

production include steam cracking, catalytic cracking, and other specialized processes. Why Flow Diagrams Matter in Ethylene Technology Flow diagrams serve as the blueprint for chemical plants, illustrating the sequence and interconnection of equipment, streams, and control systems. They are crucial for:

- Design Optimization:** Ensuring the process operates at maximum efficiency.
- Operational Control:** Facilitating startup, shutdown, and troubleshooting.
- Safety and Compliance:** Clearly mapping safety zones and emergency pathways.
- Scalability and Flexibility:** Allowing for process modifications and capacity expansions.

In the context of Lummus ethylene technology, detailed flow diagrams are instrumental in translating complex chemical reactions into manageable, safe, and efficient industrial operations.

Overview of Lummus Ethylene Technology

Historical Background and Industry Position

Lummus Technology, a leading engineering and licensor in the chemical process industry, has pioneered numerous innovations in hydrocarbon processing. Their ethylene technology, originally developed in the mid-20th century, has evolved through decades of research, adaptation, and integration of environmental standards. The company's licensing covers a broad spectrum from traditional steam cracking to advanced, energy-efficient configurations.

Core Principles of Lummus Ethylene Processes

Lummus ethylene technology is distinguished by:

- Optimized Reactor Design:** Ensuring maximum ethylene yield with minimal by-products.
- Energy Efficiency:** Incorporating heat recovery and process intensification.
- Environmental Compliance:** Reducing emissions and effluents.
- Modularity and Flexibility:** Facilitating various feedstocks and capacities.

The technology is typically implemented via detailed process flow diagrams that serve as operational guides and design references.

Flow Diagram Components of Lummus Ethylene Technology

A typical flow diagram for Lummus ethylene technology encompasses several interconnected units. Each component plays a vital role in converting hydrocarbons into high-purity ethylene.

- Feedstock Preparation**
 - Hydrocarbon Feedstocks:** Naphtha, ethane, propane, or other light hydrocarbons.
 - Pre-treatment Units:** Removal of sulfur compounds, heavy metals, and other contaminants.
 - Heaters and Pre-Reactors:** Initial heating to prepare for cracking.
- Cracking Furnace**
 - Reactor Tubes:** Usually fired with fuel gas, operating at high temperatures (~750-900°C).
 - Temperature Control:** Critical for optimizing ethylene yield and minimizing by-products.
 - Residence Time:** Carefully calibrated to balance conversion efficiency and thermal cracking severity.
- Quenching and Gas Recovery**
 - Rapid Quench System:** Cools hot gases to prevent secondary reactions.
 - Washers and Scrubbers:** Remove coke precursors, sulfur compounds, and other impurities.
 - Condensers and Absorbers:** Recover valuable by-products such as benzene, toluene, and C₂+ hydrocarbons.
- Fractionation and Product Separation**
 - Distillation Columns:** Separate ethylene from other hydrocarbons.
 - Compression and Purification Units:** Achieve desired ethylene purity levels (typically >99%).
- Utilities and Auxiliary Systems**
 - Energy Recovery Systems:** Use of heat exchangers to improve overall plant efficiency.
 - Control Systems:** Advanced automation for process stability and safety.

Technical Innovations and Process Optimization

Enhanced Reactor Designs

Lummus has developed proprietary reactor configurations incorporating:

- Catalytic Reactions:** Integration of selective catalysts to improve yields.
- Advanced Materials:** Use of refractory and corrosion-resistant materials to withstand harsh conditions.
- Modular Reactors:** Enabling easier maintenance and capacity scaling.

Energy Efficiency Strategies

- Heat Integration:** Utilization of hot streams to preheat feedstocks.
- Heat Recovery Steam Generators:** Generating steam for process

needs, reducing external energy consumption. **Process Intensification:** Combining multiple process steps to reduce footprint and energy use. **Environmental Management Enhancements** **Emission Control:** Incorporation of oxidizers and scrubbers to reduce NO_x, SO_x, and VOC emissions. **Coke Management:** Improved coking prevention and removal systems. **Water Conservation:** Closed-loop water systems and wastewater treatment. **Recent Developments and Future Trends** **Integration of Digital Technologies** The adoption of digital twins, real-time monitoring, and advanced control algorithms has enhanced process reliability and minimized downtime. **Transition to Sustainable Feedstocks** Emerging trends involve utilizing ethane derived from shale gas and exploring bio-based hydrocarbons to reduce carbon footprint. **Energy Transition and Decarbonization** Lummus and industry stakeholders are investing in: **Carbon Capture and Storage (CCS):** To mitigate greenhouse gas emissions. **Renewable Energy Integration:** Powering process units with renewable electricity. **Process Electrification:** Replacing fossil-fuel-fired heaters with electric alternatives. **Modular and Small-Scale Ethylene Production** Development of modular plants designed to serve local markets, reduce capital investment, and enhance flexibility. **Strategic Considerations for Deployment** **Site Selection and Feedstock Availability** Optimal site planning involves proximity to hydrocarbon sources, access to utilities, and logistical considerations. **Capacity Planning and Scalability** Designing flow diagrams to accommodate future expansion or process upgrades without significant reengineering. **Regulatory and Environmental Compliance** Adapting process design to meet evolving standards, including emissions limits and safety regulations. **Economic Analysis** Assessing capital expenditure, operational costs, and potential return on investment to determine project viability. **Conclusion: The Significance of Flow Diagram Lummus Ethylene Technology** The detailed and sophisticated flow diagrams underpinning Lummus ethylene technology exemplify the intersection of chemical engineering innovation and practical plant design. By meticulously mapping each process step—from feedstock pretreatment to product purification—these diagrams facilitate optimized operations, safety, and environmental compliance. As the industry progresses toward more sustainable and energy-efficient practices, the adaptability and robustness of Lummus ethylene process flow diagrams will remain central to innovation. Their role in enabling complex chemical transformations, integrating new technologies, and scaling operations underscores their importance in shaping the future of ethylene production. In essence, the investigative review of Flow Diagram Lummus Ethylene Technology reveals a dynamic landscape where engineering excellence drives efficiency, sustainability, and economic competitiveness in the petrochemical sector.

QuestionAnswer

What is the primary purpose of the Lummus Ethylene Technology flow diagram?

The primary purpose of the Lummus Ethylene Technology flow diagram is to illustrate the process of converting hydrocarbons, typically naphtha or ethane, into ethylene through steam cracking,

highlighting key process steps, equipment, and flow paths.

How does the Lummus Ethylene Technology flow diagram ensure process efficiency?

It optimizes process parameters, heat integration, and equipment placement, allowing operators to monitor and control reaction conditions effectively, thereby maximizing ethylene yield and minimizing energy consumption.

What are the key components depicted in the Lummus Ethylene Technology flow diagram?

Key components include feed preheat exchangers, steam crackers, quenching systems, fractionation columns, and product separation units, all interconnected to facilitate efficient ethylene production.

Can the Lummus Ethylene Technology flow diagram be customized for different feedstocks?

Yes, the flow diagram can be adapted for various feedstocks such as naphtha, ethane, or LPG, with modifications to equipment and process conditions to optimize ethylene output.

What role does heat integration play in the Lummus Ethylene Technology flow diagram?

Heat integration helps recover and reuse heat within the process, reducing energy consumption, improving process economics, and maintaining optimal reaction temperatures in the steam cracking process.

How does the flow diagram facilitate troubleshooting and process optimization?

By providing a clear visualization of process flows and key parameters, the diagram allows engineers to identify bottlenecks, monitor system performance, and implement targeted improvements efficiently.

Are safety considerations represented in the Lummus Ethylene Technology flow diagram?

Yes, safety features such as relief valves, emergency shutdown systems, and process monitoring points are integrated into the diagram to ensure safe operation and compliance with industry standards.

What advancements in Lummus Ethylene Technology are reflected in the latest flow diagrams?

Latest flow diagrams incorporate innovations like advanced heat recovery systems, improved catalyst handling, and enhanced automation controls to boost efficiency, safety, and environmental

compliance.

Related keywords: ethylene process, Lummus technology, flow diagram, petrochemical engineering, ethylene production, process simulation, process flowchart, chemical engineering, ethylene plant design, Lummus process