

# Encyclopedia of Chemical Processing and Design

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**46**

Executive Editor **John J. McKetta**

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# Encyclopedia of Chemical Processing and Design

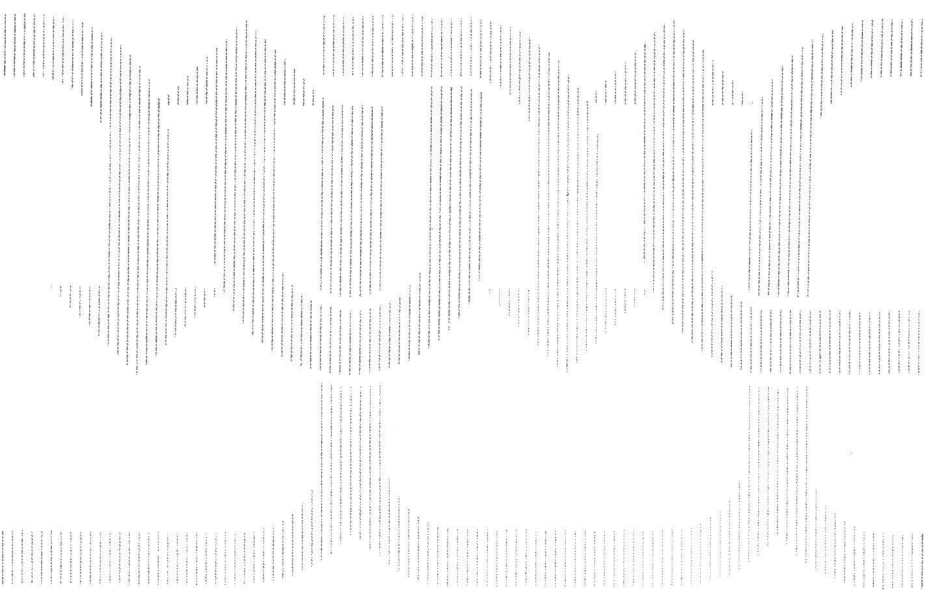
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## 46      Pumps, Bypass to Reboilers

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**ION GHEJAN**

Department of Chemical Engineering  
Institute of Petroleum, Gas, and  
Geology  
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M. W. Kellogg Company  
Houston, Texas

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Vice President and Manager  
Process Department  
Stone and Webster Engineering Corp.  
Boston, Massachusetts



# Contributors to Volume 46

---

- Jozsef M. Berty** Professor, Chemical Engineering Department, The University of Akron, Akron, Ohio: *Reaction Engineering*
- Philip G. Blakey** Argon Product Manager, Airco Industrial Gases, Murray Hill, New Jersey: *Purging, Blanketing and Transfer; Rare Gas Separation and Purification*
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- J. B. Cropley, Ph.D.** Corporate Research Fellow, Union Carbide Corporation, South Charleston, West Virginia: *Reaction Kinetics, Heuristic Approach; Reactors, Recycle, Systematic Errors*
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- Dale J. Herron** President, Bepex Corporation, Minneapolis, Minnesota: *Purge Vessels, Selection*
- Y. W. Huang** Department of Chemical Engineering, Kansas State University, Manhattan, Kansas: *Reasoning in Design, Heuristics*
- Roger P. Kirchen, Ph.D.** Research Associate, Syncrude Canada Ltd., Edmonton Research Center, Edmonton, Canada: *Reactors, Fouling Reduction*

- Miguel Larocca** Process Engineer, Faculty of Engineering Science, The University of Western Ontario, London, Ontario, Canada: *Reactors, Particle Size Calculation*
- Béla G. Lipták, MME, P.E.** President of Lipták Associates P.E., Stamford, Connecticut: *Reactors, Controlling and Optimizing*
- Edward A. Margus** Vanion Pump & Equipment Corporation, Hillside, New Jersey: *Pumps, Plastic, Selection of*
- K. M. Ng, Ph.D.** Professor, Chemical Engineering Department, University of Massachusetts, Amherst, Massachusetts: *Reactors, Trickle-bed*
- Joyce A. Ober** Physical Scientist, U.S. Bureau of Mines, Washington, D.C.: *Quartz Crystal Supply-Demand Relationships*
- Gary Orlando** Airco Industrial Gases, Murray Hill, New Jersey: *Purging, Blanketing and Transfer*
- Vivek N. Parulekar** Principal Process Engineer, Koch Industries Technology and Engineering, Wichita, Kansas: *Reactive Distillation*
- R. P. Patel** Fertilizernage, Baroda, India: *Quenching Oils, Reclamation of*
- Ven Pinjala** Technical Manager, Koch Engineering Company, Inc., Wichita, Kansas: *Reactive Distillation*
- Blanchard L. Pritchard, Jr., P.E.** Quality Quest, Dallas, Texas: *Quality Management*
- P. A. Ramachandran** Professor, Department of Chemical Engineering, Washington University in St. Louis, St. Louis, Missouri: *Reactors, Three-Phase Slurry*
- James M. Ramey** Consultant, Environmental Health Sciences, Horseshoe Bay, Texas: *Quality Control*
- Emerson C. Sanford, Ph.D.** Research Associate, Syncrude Canada Ltd., Edmonton Research Center, Edmonton, Canada: *Reactors, Fouling Reduction*
- G. C. Shah** Senior Process Engineer, American Hoechst Corporation, Houston, Texas: *Reactors, Cycle Optimizing*
- David W. Smith** R.F.E. Industries, Perth Amboy, New Jersey: *Reactions, Runaway*
- Irving Taylor, P.E.** Consultant after retirement from Bechtel Corporation, San Francisco, California: *Pumps, Bypass*
- A. G. Telpande** Chemical Engineering Department, Faculty of Technology & Engineering, Maharaja Sayajirao University of Baroda, Baroda, India: *Quenching Oils, Reclamation of*
- Sorab R. Vatcha, Ph.D., P.E.** Senior Research Fellow and Project Leader, Catalytica, Inc., Mountain View, California: *Reaction Order Estimation*
- Stanley M. Walas** Professor of Chemical and Petroleum Engineering, University of Kansas, Lawrence, Kansas: *Reactors and Chemical Kinetics*
- Thomas A. Walton, B.Sc., PEng.** Quality Specialist, Newbridge Networks Corporation, Kanata, Ontario, Canada: *Pumps and Compressors, Efficiency Monitoring*
- S. Yedidiah** Consultant, West Orange, New Jersey: *Pumps, Efficiency; Pumps, Testing Pitfalls; Pumps, Unusual Problems*
- Adam Zanker, Ch.E., M.Sc.** Senior Research Engineer, Oil Refineries, Ltd., Haifa, Israel: *Reactor Conversion Efficiencies*

# Conversion to SI Units

To convert from	To	Multiply by
acre	square meter (m <sup>2</sup> )	$4.046 \times 10^3$
angstrom	meter (m)	$1.0 \times 10^{-10}$
are	square meter (m <sup>2</sup> )	$1.0 \times 10^2$
atmosphere	newton/square meter (N/m <sup>2</sup> )	$1.013 \times 10^5$
bar	newton/square meter (N/m <sup>2</sup> )	$1.0 \times 10^5$
barrel (42 gallon)	cubic meter (m <sup>3</sup> )	0.159
Btu (International Steam Table)	joule (J)	$1.055 \times 10^3$
Btu (mean)	joule (J)	$1.056 \times 10^3$
Btu (thermochemical)	joule (J)	$1.054 \times 10^3$
bushel	cubic meter (m <sup>3</sup> )	$3.52 \times 10^{-2}$
calorie (International Steam Table)	joule (J)	4.187
calorie (mean)	joule (J)	4.190
calorie (thermochemical)	joule (J)	4.184
centimeter of mercury	newton/square meter (N/m <sup>2</sup> )	$1.333 \times 10^3$
centimeter of water	newton/square meter (N/m <sup>2</sup> )	98.06
cubit	meter (m)	0.457
degree (angle)	radian (rad)	$1.745 \times 10^{-2}$
denier (international)	kilogram/meter (kg/m)	$1.0 \times 10^{-7}$
dram (avoirdupois)	kilogram (kg)	$1.772 \times 10^{-3}$
dram (troy)	kilogram (kg)	$3.888 \times 10^{-3}$
dram (U.S. fluid)	cubic meter (m <sup>3</sup> )	$3.697 \times 10^{-6}$
dyne	newton (N)	$1.0 \times 10^{-5}$
electron volt	joule (J)	$1.60 \times 10^{-19}$
erg	joule (J)	$1.0 \times 10^{-7}$
fluid ounce (U.S.)	cubic meter (m <sup>3</sup> )	$2.96 \times 10^{-5}$
foot	meter (m)	0.305
furlong	meter (m)	$2.01 \times 10^2$
gallon (U.S. dry)	cubic meter (m <sup>3</sup> )	$4.404 \times 10^{-3}$
gallon (U.S. liquid)	cubic meter (m <sup>3</sup> )	$3.785 \times 10^{-3}$
gill (U.S.)	cubic meter (m <sup>3</sup> )	$1.183 \times 10^{-4}$
grain	kilogram (kg)	$6.48 \times 10^{-5}$
gram	kilogram (kg)	$1.0 \times 10^{-3}$
horsepower	watt (W)	$7.457 \times 10^2$
horsepower (boiler)	watt (W)	$9.81 \times 10^3$
horsepower (electric)	watt (W)	$7.46 \times 10^2$
hundred weight (long)	kilogram (kg)	50.80
hundred weight (short)	kilogram (kg)	45.36
inch	meter (m)	$2.54 \times 10^{-2}$
inch mercury	newton/square meter (N/m <sup>2</sup> )	$3.386 \times 10^3$
inch water	newton/square meter (N/m <sup>2</sup> )	$2.49 \times 10^2$
kilogram force	newton (N)	9.806

To convert from	To	Multiply by
kip	newton (N)	$4.45 \times 10^3$
knot (international)	meter/second (m/s)	0.5144
league (British nautical)	meter (m)	$5.559 \times 10^3$
league (statute)	meter (m)	$4.83 \times 10^3$
light year	meter (m)	$9.46 \times 10^{15}$
liter	cubic meter (m <sup>3</sup> )	0.001
micron	meter (m)	$1.0 \times 10^{-6}$
mil	meter (m)	$2.54 \times 10^{-6}$
mile (U.S. nautical)	meter (m)	$1.852 \times 10^3$
mile (U.S. statute)	meter (m)	$1.609 \times 10^3$
millibar	newton/square meter (N/m <sup>2</sup> )	100.0
millimeter mercury	newton/square meter (N/m <sup>2</sup> )	$1.333 \times 10^2$
oersted	ampere/meter (A/m)	79.58
ounce force (avoirdupois)	newton (N)	0.278
ounce mass (avoirdupois)	kilogram (kg)	$2.835 \times 10^{-2}$
ounce mass (troy)	kilogram (kg)	$3.11 \times 10^{-2}$
ounce (U.S. fluid)	cubic meter (m <sup>3</sup> )	$2.96 \times 10^{-5}$
pascal	newton/square meter (N/m <sup>2</sup> )	1.0
peck (U.S.)	cubic meter (m <sup>3</sup> )	$8.81 \times 10^{-3}$
pennyweight	kilogram (kg)	$1.555 \times 10^{-3}$
pint (U.S. dry)	cubic meter (m <sup>3</sup> )	$5.506 \times 10^{-4}$
pint (U.S. liquid)	cubic meter (m <sup>3</sup> )	$4.732 \times 10^{-4}$
poise	newton second/square meter (N · s/m <sup>2</sup> )	0.10
pound force (avoirdupois)	newton (N)	4.448
pound mass (avoirdupois)	kilogram (kg)	0.4536
pound mass (troy)	kilogram (kg)	0.373
poundal	newton (N)	0.138
quart (U.S. dry)	cubic meter (m <sup>3</sup> )	$1.10 \times 10^{-3}$
quart (U.S. liquid)	cubic meter (m <sup>3</sup> )	$9.46 \times 10^{-4}$
rod	meter (m)	5.03
roentgen	coulomb/kilogram (c/kg)	$2.579 \times 10^{-4}$
second (angle)	radian (rad)	$4.85 \times 10^{-6}$
section	square meter (m <sup>2</sup> )	$2.59 \times 10^6$
slug	kilogram (kg)	14.59
span	meter (m)	0.229
stoke	square meter/second (m <sup>2</sup> /s)	$1.0 \times 10^{-4}$
ton (long)	kilogram (kg)	$1.016 \times 10^3$
ton (metric)	kilogram (kg)	$1.0 \times 10^3$
ton (short, 2000 pounds)	kilogram (kg)	$9.072 \times 10^2$
torr	newton/square meter (N/m <sup>2</sup> )	$1.333 \times 10^2$
yard	meter (m)	0.914

## Bringing Costs up to Date

Cost escalation via inflation bears critically on estimates of plant costs. Historical costs of process plants are updated by means of an escalation factor. Several published cost indexes are widely used in the chemical process industries:

Nelson-Farrar Cost Indexes (*Oil and Gas J.*), quarterly  
 Marshall and Swift (M&S) Equipment Cost Index, updated monthly  
 CE Plant Cost Index (*Chemical Engineering*), updated monthly  
 ENR Construction Cost Index (*Engineering News-Record*), updated weekly

All these indexes were developed with various elements, such as material availability and labor productivity, taken into account. However, the proportion allotted to each element differs with each index. The differences in overall results of each index are due to uneven price changes for each element. In other words, the total escalation derived by each index will vary because different bases are used. The engineer should become familiar with each index and its limitations before using it.

Table 1 compares the CE Plant Index with the M&S Equipment Cost

**TABLE 1** *Chemical Engineering and Marshall and Swift Plant and Equipment Cost Indexes since 1950*

Year	CE Index	M&S Index	Year	CE Index	M&S Index
1950	73.9	167.9	1971	132.3	321.3
1951	80.4	180.3	1972	137.2	332.0
1952	81.3	180.5	1973	144.1	344.1
1953	84.7	182.5	1974	165.4	398.4
1954	86.1	184.6	1975	182.4	444.3
1955	88.3	190.6	1976	192.1	472.1
1956	93.9	208.8	1977	204.1	505.4
1957	98.5	225.1	1978	218.8	545.3
1958	99.7	229.2	1979	238.7	599.4
1959	101.8	234.5	1980	261.2	659.6
1960	102.0	237.7	1981	297.0	721.3
1961	101.5	237.2	1982	314.0	745.6
1962	102.0	238.5	1983	316.9	760.8
1963	102.4	239.2	1984	322.7	780.4
1964	103.3	241.8	1985	325.3	789.6
1965	104.2	244.9	1986	318.4	797.6
1966	107.2	252.5	1987	323.8	813.6
1967	109.7	262.9	1988	342.5	852.0
1968	113.6	273.1	1989	355.4	895.1
1969	119.0	285.0	1990	357.6	915.1
1970	125.7	303.3	1991	361.3	930.6
			1992	358.2	943.1

**TABLE 2** Nelson-Farrar Inflation Refinery Construction Indexes since 1946  
(1946 = 100)

Date	Materials Component	Labor Component	Miscellaneous Equipment	Nelson-Farrar Inflation Index
1946	100.0	100.0	100.0	100.0
1947	122.4	113.5	114.2	117.0
1948	139.5	128.0	122.1	132.5
1949	143.6	137.1	121.6	139.7
1950	149.5	144.0	126.2	146.2
1951	164.0	152.5	145.0	157.2
1952	164.3	163.1	153.1	163.6
1953	172.4	174.2	158.8	173.5
1954	174.6	183.3	160.7	179.8
1955	176.1	189.6	161.5	184.2
1956	190.4	198.2	180.5	195.3
1957	201.9	208.6	192.1	205.9
1958	204.1	220.4	192.4	213.9
1959	207.8	231.6	196.1	222.1
1960	207.6	241.9	200.0	228.1
1961	207.7	249.4	199.5	232.7
1962	205.9	258.8	198.8	237.6
1963	206.3	268.4	201.4	243.6
1964	209.6	280.5	206.8	252.1
1965	212.0	294.4	211.6	261.4
1966	216.2	310.9	220.9	273.0
1967	219.7	331.3	226.1	286.7
1968	224.1	357.4	228.8	304.1
1969	234.9	391.8	239.3	329.0
1970	250.5	441.1	254.3	364.9
1971	265.2	499.9	268.7	406.0
1972	277.8	545.6	278.0	438.5
1973	292.3	585.2	291.4	468.0
1974	373.3	623.6	361.8	522.7
1975	421.0	678.5	415.9	575.5
1976	445.2	729.4	423.8	615.7
1977	471.3	774.1	438.2	653.0
1978	516.7	824.1	474.1	701.1
1979	573.1	879.0	515.4	756.6
1980	629.2	951.9	578.1	822.8
1981	693.2	1044.2	647.9	903.8
1982	707.6	1154.2	622.8	976.9
1983	712.4	1234.8	656.8	1025.8
1984	735.3	1278.1	665.6	1061.0
1985	739.6	1297.6	673.4	1074.4
1986	730.0	1330.0	684.4	1089.9
1987	748.9	1370.0	703.1	1121.5
1988	802.8	1405.6	732.5	1164.5
1989	829.2	1440.4	769.9	1195.9
1990	832.8	1487.7	797.5	1225.7
1991	832.3	1533.3	827.5	1252.9
1992	824.6	1579.2	837.6	1277.3

Index. Table 2 shows the Nelson-Farrar Inflation Petroleum Refinery Construction Indexes since 1946. It is recommended that the CE Index be used for updating total plant costs and the M&S Index or Nelson-Farrar Index for updating equipment costs. The Nelson-Farrar Indexes are better suited for petroleum refinery materials, labor, equipment, and general refinery inflation.

Since

$$C_B = C_A(B/A)^n \quad (1)$$

Here,  $A$  = the size of units for which the cost is known, expressed in terms of capacity, throughput, or volume;  $B$  = the size of unit for which a cost is required, expressed in the units of  $A$ ;  $n = 0.6$  (i.e., the six-tenths exponent);  $C_A$  = actual cost of unit  $A$ ; and  $C_B$  = the cost of  $B$  being sought for the same time period as cost  $C_A$ .

To approximate a current cost, multiply the old cost by the ratio of the current index value to the index at the date of the old cost:

$$C_B = C_A I_B / I_A \quad (2)$$

Here,  $C_A$  = old cost;  $I_B$  = current index value; and  $I_A$  = index value at the date of old cost.

Combining Eqs. (1) and (2),

$$C_B = C_A(B/A)^n(I_B/I_A) \quad (3)$$

For example, if the total investment cost of plant  $A$  was \$25,000,000 for 200-million-lb/yr capacity in 1974, find the cost of plant  $B$  at a throughput of 300 million lb/yr on the same basis for 1986. Let the sizing exponent,  $n$ , be equal to 0.6.

From Table 1, the CE Index for 1986 was 318.4, and for 1974 it was 165.4. Via Eq. (3),

$$\begin{aligned} C_B &= C_A(B/A)^n(I_B/I_A) \\ &= 25.0(300/200)^{0.6}(318.4/165.4) \\ &= \$61,200,000 \end{aligned}$$

JOHN J. McKETTA



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