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PETROLEUM REFINING

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MATERIALS AND EQUIPMENT

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Pierre Trambouze

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P. Trambouze

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PETROLEUM REFINING

**4 MATERIALS
AND
EQUIPMENT**

FROM THE SAME PUBLISHER

Petroleum Refining

1. Crude Oil, Petroleum Products, Process Flowsheets
J. P. WAUQUIER, Ed.
 2. Separation Processes
J. P. WAUQUIER, Ed.
 3. Conversion Processes (to be published in 2000)
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Introducing the Collection

"PETROLEUM REFINING"

The collection **"Petroleum Refining"** includes five volumes covering the following aspects of the technology involved in the oil refining industry:

- Crude oil. Petroleum products. Process flowsheets.
- Separation processes.
- Conversion processes.
- Materials and equipment.
- Refinery operation and management.

The collection is designed for the engineers and technicians who will be operating the refineries of the twenty-first century. Two types of problems will have to be solved at the same time: increasingly severe product specifications and, even more importantly, protecting our air and water from pollution. It will provide operational people in the field with an understanding of the fundamentals of oil refining as well as an overview of the specific technology they will be using.

The collection was written by a group of eminent specialists whose names will be found at the beginning of each volume. We would like to thank them all for being so dynamic and enthusiastic in their work on this project.

Michel VERWAERDE

Institut Français du Pétrole

Foreword

Volume 4 in the collection "Petroleum Refining" is devoted to the main equipment found in a refinery or a petrochemical complex. As such, it is a logical sequel to the first three volumes that have already been published.

Distillation operations, which are crucial in oil refining, obviously rely mainly on separation techniques. However, they also require the use of heat transfer equipment which provides the heat energy needed for all these separations. Moreover, reaction techniques are central to all the refining processes which convert molecular species in crude oil so as to obtain products with constantly adapted and improved properties to meet market demand.

One of the features of the oil industry is that it implements liquids and gases almost exclusively. In order to carry these phases at every stage of their processing, specific equipment such as pumps, compressors, turbines and ejectors is required. In addition, a highly complex piping system makes the connections among the different pieces of equipment, in order to constitute the end products by blending and dispatch them to consumption nodes.

A refinery is thus a very complex technical facility and its profitability can be ensured only by strict and constant control of all the component parts, to guarantee product quality, operational safety and environmental protection. These aims are attained by measurement, control and supervision techniques, which are now of vital importance in all petroleum and petrochemical complexes.

Since there are numerous and varied pieces of equipment involved, they have been grouped in type categories having similar functions. In this connection, the classification of chemical engineering unit operations has been used and the following will be examined successively:

1. Equipment for separating the components of a mixture, either by mass transfer between phases (gas-liquid or liquid-liquid) or by physical separation

of multiphase systems such as gas-liquid, liquid-liquid, gas-solid and liquid-solid mixtures.

2. Equipment for achieving heat transfers, such as furnaces and heat exchangers.

3. Equipment called reactors where chemical reactions take place.

4. Equipment used to accomplish the mechanical operations of fluid transport (pumps, compressors) or mixing.

5. Equipment in charge of controlling all the above-mentioned operations by measuring physical or physicochemical variables with sensors and using the measurements in control and management systems. These measurements allow operations to be optimized as illustrated by the last chapter, devoted to energy optimization in the units.

Due to the diversity of all this equipment, it was necessary to call on authors from a variety of sectors (engineering companies, construction, operations, process engineering), each having a specific approach. As a result, the chapters in this volume were not drafted according to a uniform blueprint, but present the diversified viewpoints of the engineers in the profession instead.

Nomenclature

Because of the diversity of equipment and systems described in this volume, it is difficult to observe a single nomenclature. Nevertheless, to the extent possible an attempt is made to comply with the nomenclature recommendations given in the previous volumes. Any deviation from this rule is the result of a deliberate choice, either to conform to the usage in the profession or to avoid any ambiguity in the meaning of symbols. In all cases each use of a new symbol in a chapter is associated with a definition. A definition may sometimes not be systematically repeated for classical variables in order to save space. In this instance the reader will find the definition of the relevant symbol in the list below.

The same holds true for units. The SI system is generally employed except when the specifications in use in the profession involve particular units, usually from the US/British systems.

In addition to the basic units in the SI system, i.e. m, kg, s, mol and K, the multiples and sub-multiples of these basic units and derived or compound units are also used.

Symbols

A	interfacial area per unit of volume	m^2/m^3
C_p	molar heat capacity at constant pressure	$\text{J}/(\text{mol}\cdot\text{K})$
C	with a number n : hydrocarbon whose number of carbon atoms is equal to n	
C	concentration	kmol/m^3
d, D	diameter	m
$\mathcal{D}$	diffusion coefficient	m^2/s

E	overall efficiency in number of stages	—
E_m	Murphree efficiency	—
G	gas superficial mass flow rate	$\text{kg/m}^2\cdot\text{s}$
h, H	height	m
k	mass transfer coefficient	m/s
K	overall mass transfer coefficient	m/s
l, L	width, length	m
L	liquid superficial mass flow rate	$\text{kg/m}^2\cdot\text{s}$
m	weight	kg
M	molecular weight	kg/kmol
P	pressure	Pa
Q	volume flow rate	m^3/s
r	radius	m
R	ideal gas constant	$= 8.31 \text{ J}/(\text{mol K})$
Re	Reynolds number ($= u d \rho / \mu$)	—
S	surface or cross-sectional area	m^2
Sc	Schmidt number ($= \mu / \rho \cdot \mathcal{D}$)	—
Sh	Sherwood number ($= k d / \mathcal{D}$)	—
t	time	s
T	absolute temperature	K
u, U	velocity	m/s
V	volume	m^3
V	superficial velocity ($= Q/S$)	m/s
We	Weber number ($= \rho d u^2 / \sigma$)	—
x	mole fraction (in the liquid phase)	—
y	mole fraction (in the vapor phase)	—
z	mole fraction	—
Z	compressibility factor	—

Greek letters

α, ω	angle	(rad ou °)
ε	volume void fraction	—
ε_i	volume fraction occupied by phase i	—
θ	contact or residence time	s
λ	thermal conductivity	$\text{W}/(\text{m}\cdot\text{K})$
μ	dynamic (or absolute) viscosity	$\text{Pa}\cdot\text{s}$
ν	kinematic viscosity	m^2/s
ρ	density	kg/m^3
σ	interfacial tension	N/m

Subscripts and superscripts

A, B, i	relative to compound A, B, i	1, 2	relative to phase 1 or 2
P	at constant pressure	G, L, V, i	relative to the gas, liquid, vapor or i phase
p	relative to the particle (grain or drop)		

Functional symbols

d	"derivative" operator	$\exp$	exponential
∂	"partial differential" operator	$\log$	base 10 logarithm
Σ	"sum" operator	$\ln$	Napierian logarithm
Δ	"difference" operator	$\approx$	approximately equal to
$\int$	"integral" operator	$\neq$	different from

Abbreviations and acronyms

API	American Petroleum Institute	HTU	Height of a Transfer Unit
ASTM	American Society for Testing and Materials	IFP	Institut français du pétrole
ASVAHL	Association pour la valorisation des huiles lourdes (Association for upgrading heavy oils)	LPG	Liquefied Petroleum Gases
FCC	Fluid Catalytic Cracking	MTBE	Methyltertiobutylether
HDS	Hydrodesulfurization	RDC	Rotating Disc Contactor
HETP	Height Equivalent to a Theoretical Plate	VR	Vacuum residue
HF	Hydrofluoric acid	TEMA	Tubular Exchanger Manufacturers Association
		UOP	Union Oil Products
		VGO	Vacuum Gas Oil

Contents

Foreword	IX
Nomenclature	XXI

PART ONE Separation Technologies

Chapter 1 Gas-Liquid Contactors for Distillation: Plate Columns

1.1 General Characteristics of a Plate	4
1.1.1 Handling Liquid and Vapor Streams	4
1.1.2 Hydraulic Behavior of a Plate. Operating Zones	7
1.2 Types of Plates or Trays	12
1.2.1 Bubble Cap Plate	13
1.2.2 Sieve Plate with Downcomer	13
1.2.3 Valve Plate	14
1.2.4 Plates without Downcomers	15
1.2.5 Comparison of Plate Technologies	17
1.3 Correlations for Plate Sizing	18
1.3.1 Flooding Due to the Gas Phase. Choosing the Column Diameter	18
1.3.2 Determining Plate Spacing	20
1.3.3 Nature of the Gas-Liquid Mixture on the Active Zone	21
1.3.4 Downcomer Cross-Section	22

1.3.5 Weirs, Downcomers.....	23
1.3.6 Liquid Gradient on the Plate.....	26
1.3.7 Vapor Pressure Drop	28
1.3.8 Entrainment.....	30
1.3.9 Weeping.....	30
1.3.10 Efficiency	31
1.4 Calculating Plate Dimensions	33
1.5 Other Parts of a Column	36
1.6 Comparison of Different Types of Plates	40
References	40

Chapter 2 Gas-Liquid Contactors for Distillation: Packed Columns

2.1 Different Types of Packing.....	43
2.1.1 Random Packings	44
2.1.2 Structured Packings	47
2.1.3 Grids	47
2.2 Fluid Flow in Packings	51
2.2.1 Pressure Drop	51
2.2.2 Capacity	54
2.2.3 Hold Up	58
2.2.4 Minimum Liquid Irrigation Flow Rate	59
2.3 Packing Efficiency	60
2.3.1 Estimating HETPs	62
2.3.2 Estimating HTUs	65
2.4 Phase Distribution	66
2.5 Calculating a Packed Column.....	72
2.5.1 Principle of the Method	72
2.5.2 Example of Sizing a Packed Column	75
2.6 Packing or Plates?.....	77
References	80

Chapter 3 Solvent Extraction Equipment

3.1 General Hydrodynamic Features of Liquid-Liquid Systems.....	81
--	----

3.2	Different Types of Extractors	84
3.2.1	Extractors without Outside Energy Contribution	85
3.2.2	Extractors with Outside Energy Contribution	92
3.3	Conclusion	102
	References	103

Chapter 4 Techniques for Physical Separation of Phases

4.1	Separation of Two Fluid Phases	105
4.1.1	Gas-Liquid Separation	105
4.1.2	Liquid-Liquid Separation	112
4.2	Gas-Solid Separation	121
4.2.1	Cyclones	122
4.3	Liquid-Solid Separation	139
4.3.1	Filtration	139
4.3.2	Separation Using Centrifugal Force	148
4.4	Conclusion	155
	References	155

PART TWO

Heat Transfer Technologies

Chapter 5 Process Furnaces

5.1	Furnace Functions	159
5.2	Description of a Furnace	160
5.3	Different Types of Furnaces	165
5.4	Furnace Thermal Efficiency	171
5.5	Component Parts of a Furnace	171
5.5.1	Tube Bundles	171
5.5.2	Tube Coil Supports	173
5.5.3	Furnace Wall Lining	174
5.5.4	Burners	175
5.5.5	Air Heater	179
5.5.6	Sweepers	183

5.6	Designing a Furnace.....	183
5.6.1	Determining Heat Exchange Surfaces	184
5.6.2	Fluid Dynamics in a Furnace	214
5.6.3	Mechanical Design of Structures	221
5.6.4	Control of Operating Furnaces	221
	References	222

Chapter 6 Heat Exchangers

	Introduction	223
6.1	Heat Exchanger Functions	224
6.1.1	The Cooling Function	224
6.1.2	The Heating Function	224
6.1.3	The Condensation Function	224
6.1.4	The Vaporization Function	225
6.2	Operating Principle.....	225
6.2.1	Surface Exchangers	225
6.2.2	Direct Contact Heat Exchangers (or Mixing Heat Exchangers)	226
6.3	Technological Construction Principles and Circulation Modes ...	227
6.3.1	Cocurrent (or Parallel Currents) and Counter-Current Circulation	227
6.3.2	Circulation Associating Cocurrent and Counter-Current	229
6.3.3	Cross-Flow Circulation	231
6.4	Parameters Influencing Exchanger Performance	232
6.4.1	Quality of Local Transfer	233
6.4.2	Circulation Modes	253
6.5	Critical Points in Selecting Heat Exchanger Type and Technological Design.....	264
6.5.1	Operating Conditions	264
6.5.2	Mechanical Resistance Conditions	265
6.5.3	Maintenance Conditions	266
6.5.4	Reliability in Performance and Mechanical Resistance ..	267
6.5.5	Economic Requirements	267
6.5.6	Availability of Calculation Methods to Predict Performance	267
6.6	Shell-and-Tube Exchangers.....	268
6.6.1	Types of Construction	269
6.6.2	The Shell	290

6.6.3	The Tube Bundle	290
6.6.4	Materials	302
6.6.5	Tube-Side and Shell-Side Circulation Circuits.....	302
6.6.6	Cost Estimation.....	305
6.7	Other Tubular Exchangers	305
6.7.1	Double Pipe or Coaxial Exchangers. Multi-Hairpin Exchangers	305
6.7.2	Heaters	315
6.7.3	In-Line Exchangers	319
6.7.4	Bayonet Exchangers.....	319
6.7.5	Helical Wound Coil Tube Heat Exchangers.....	321
6.8	Compact Non-Tubular Exchangers	323
6.8.1	Plate and Frame Exchangers.....	324
6.8.2	Brazed Plate Exchangers	328
6.8.3	Welded Plate Exchangers	329
6.8.4	Plate-Fin Exchangers	335
6.8.5	Printed Circuit Heat Exchangers (PCHE)	343
6.8.6	Circular Plate Exchangers	345
6.8.7	Spiral Plate Exchangers	346
6.9	Air-Cooled Exchangers	349
6.9.1	The Tube Bundles.....	349
6.9.2	Ventilation Systems	361
6.9.3	Plenum Chambers between Fans and Bundles	364
6.9.4	Structures	366
6.9.5	Air Cooled Exchanger Layout and Installation.....	366
6.9.6	Special Devices	369
6.9.7	Estimating Costs	373
6.9.8	Uses	373
6.10	Direct Contact Exchangers	375
6.10.1	Gas Coolers.....	375
6.10.2	Condensers.....	376
6.11	Conclusion	378
	Appendixes	379
A6.1	Conversion Table.....	379
A6.2	Thermal Conductivity of Materials	380
A6.3	Characteristics of Exchanger Tubes	381
A6.4	Heat Exchanger Types	383
	References.....	387