

FIGURES	vi
TABLES	viii
FOREWORD	ix
ACKNOWLEDGMENTS	xi
ABOUT THE AUTHORS	xiii
<b>CHAPTER 1. Fundamentals</b>	<b>1</b>
<b>Fluid Properties</b>	<b>1</b>
Temperature	2
Pressure	3
Gravity and Miscibility	3
Solubility	4
<b>The Ideal Gas Law</b>	<b>4</b>
Liquid Phase	5
Vapor Pressure	5
Boiling Point and Freezing Point	6
Hydrates	7
Comparing Physical Properties	8
Composition	10
Heat Energy	10
Heating Value	12
Combustion	12
Flammability	13
Applications	13
Flow Diagrams	14
References	21
<b>CHAPTER 2. Feed Gas Receiving and Condensate Stabilization</b>	<b>23</b>
Treating and Processing	23
Design Basis and Specifications for Treatment Units	26
Feed Gas Basis	26
Product Specifications	27
Equipment Selection and Design	28
Pig Receivers	28
Slug Catchers	30
Condensate Stabilizers	32
Condensate Stabilizer Reboilers	32
Stabilizer Overhead Compressors	32
Gas and Liquid Heaters	32
References	33
<b>CHAPTER 3. Dew-Point Control and Refrigeration Systems</b>	<b>35</b>
Process Descriptions	35
Cost Estimate	35
Silica Gel Process	36
Glycol/Propane System	37
Glycol/J-T Valve Cooling Process	38
Comparison of Dew-Point Processes	40
Unit Specifications	40
The Refrigeration System	41
Economizers	42
Chillers	44
Possible Problems	44
Multiple-Stage Refrigeration	46
References	50

# Table of Contents

CHAPTER 4.	Hydrocarbon Treating	51
	Gas-Treating Processes	51
	Chemical Reaction	51
	Amine-Based Solvents	52
	Nonamine-Based Processes	57
	Physical Absorption Processes	58
	Selexol®	59
	Propylene Carbonate Process	59
	Rectisol® Process	60
	Mixed Chemical/Physical Absorption	60
	Sulfinol® Process	60
	Adsorption on a Solid	61
	Molecular Sieve Process	61
	Activated Carbon Process	62
	Membrane Processes	62
	General Operating Considerations for Gas Treating	65
	Inlet Separation	65
	Foaming	65
	Filtration	65
	Corrosion	65
	References	66
CHAPTER 5.	Sulfur Recovery and Claus Off-Gas Treating	67
	Sulfur Recovery	67
	Thermal Process	67
	Catalytic Recovery	68
	Claus Off-Gas Treating	70
	SCOT Process	70
	References	72
CHAPTER 6.	Dehydration and Mercury Removal	73
	Dehydration	73
	Inhibitor Injection	76
	Dehydration Methods	80
	Liquid Desiccants	80
	Solid Desiccants	84
	Design Issues	88
	Mercury Removal Unit (MRU)	90
	Design Basis and Specifications	92
	Design Considerations	94
	Equipment Selection and Design	95
	Case Study	95
	References	96
CHAPTER 7.	NGL Recovery—Lean-Oil Absorption	97
	Lean-Oil Absorption	98
	The Recovery System	98
	Absorption	99
	Why Absorbers Work	99
	Presaturation	100
	Potential Problems	102
	The Rejection System	104
	Hot Rich-Oil Flash Tank	104
	Rich-Oil Demethanizer	105
	Possible Problems	107
	The Separation System	108
	The Still	108
	Oil Purification	109
	Possible Problems	110
	References	111

CHAPTER 8.	NGL Recovery—Cryogenic	113
	Typical Applications	115
	Turboexpander Process	115
	Propane-Recovery Process	120
	Ethane-Recovery Process	121
	Turboexpanders	122
	Cryogenics	127
	References	130
CHAPTER 9.	Fractionation and Liquid Treating	131
	Fractionation	131
	Packed Columns	134
	NGL Fractionation Plants	134
	Deethanizer (DeC <sub>2</sub> ) Column	136
	Depropanizer (DeC <sub>3</sub> ) Column	137
	Debutanizer (DeC <sub>4</sub> ) Column	137
	Deisobutanizer (DIB) or Butane Splitter Column	137
	Product Specifications	138
	Monitoring Fractionation Plant Operation	139
	Possible Operating Problems	140
	NGL Product Treating	141
	Liquid—Liquid Treating	141
	Liquid—Solid Treating	143
	References	143
CHAPTER 10.	Nitrogen Rejection Unit (NRU)	145
	Nitrogen Rejection	145
	NRU Process Selection	145
	Pressure Swing Adsorption (PSA)	145
	Cryogenic Absorption	145
	Membranes	146
	Cryogenic Distillation	146
	Cryogenic NRU Processes	146
	Pretreatment	147
	Chilling	148
	Cryogenic Distillation	148
	Recompression	148
	NRU Processes	149
	References	152
APPENDIX.	Figure and Table Credits	153
GLOSSARY		159
INDEX		183

# Figures

1.1	Fluid molecules can be compared to marbles in a glass jar.	2
1.2	Comparison of different temperature measurement scales	2
1.3	Molecules escape and return to the liquid phase in a closed vessel.	5
1.4	Vapor pressure depends on the temperature of the liquid in a closed vessel.	5
1.5	Vapor pressure compared to the boiling temperature of liquid in a closed vessel	6
1.6	Hydrate plug in pipe	7
1.7	Vapor pressures of various hydrocarbons	9
1.8	Principles of sensible and latent heat	11
1.9	Light molecules vaporize and heavy molecules concentrate in a liquid.	14
1.10	Flow diagram symbols	15
1.11	Simple separation system for light and heavy fluid components	16
1.12	Simple separation system with reboiler	17
1.13	Simple separation system with reboiler and condenser	17
1.14	A series separation system	18
1.15	Bubble-cap tray for separation tower	19
1.16	Bubble-cap trays in tower	19
1.17	A tower separation system diagram	20
2.1	Gas processing plant	23
2.2	The functional units inside a gas processing plant	24
2.3	A typical feed gas receiving system	24
2.4	Diagram of a typical condensate stabilization system	25
2.5	Various types of pigs used for pipeline cleaning	29
2.6	A typical pig receiver system	29
2.7	Pig launcher/receiver	29
2.8	Finger-type slug catcher	30
2.9	Slug catcher being transported	31
2.10	Vertical slug catcher vessel	31
2.11	Horizontal slug catcher vessel	31
2.12	Pipe-fitting-type slug catcher	31
3.1	Diagram of a silica gel process	36
3.2	Glycol and propane refrigeration process	37
3.3	Glycol/J-T valve cooling process	39
3.4	A typical plant refrigeration system	41
3.5	Two different layouts of simple-staged separation process	42
3.6	Diagram of a refrigeration system using staged separation	43
3.7	Gas turbine-driven propane refrigeration compressor in a natural gas plant	43
3.8	Chiller diagram	44
3.9	Graph used to determine amount of ethane in propane	45
3.10	Graph used to determine amount of butane in propane	45
3.11	A two-stage refrigeration system	46
3.12	A three-stage refrigeration system	47
3.13	Diagram of a cascade refrigeration system with ethane and propane	48
3.14	Two-stage propane refrigeration system	49
4.1	Diagram of a typical aqueous amine treating plant	52
4.2	Schematic diagram of the Shell-Paques™ process	57
4.3	XTO Shell-Paques™ gas treating plant in Texas	58
4.4	Diagram of a typical physical solvent process	59

4.5	An integrated natural gas desulfurization plant	61
4.6	UOP's spiral wound membrane element	62
4.7	Element being inserted into the casing	63
4.8	A hollow-fiber membrane element	63
4.9	A membrane skid for the removal of CO <sub>2</sub> from natural gas	64
5.1	Species of elemental S in equilibrium at different temperatures	68
5.2	Three-stage modified Claus sulfur-recovery unit	69
5.3	A small, package-type, two-stage Claus plant that sends tail gas to an incinerator	69
5.4	Diagram of the Shell Claus Off-Gas Treating process (SCOT)	71
5.5	SCOT process plant	71
6.1	Water content of natural gas varies.	74
6.2	Pressure-temperature curves for predicting hydrate formation	75
6.3	Physical properties of selected glycols and methanol	76
6.4	A typical EG injection system	77
6.5	Freezing temperatures of ethylene glycol-water mixtures	78
6.6	Glycol reboiler temperatures	78
6.7	Hydrate depression versus minimum withdrawal concentration of ethylene glycol	79
6.8a	TEG dehydration unit	81
6.8b	Glycol regeneration unit designed to regenerate TEG for natural gas dehydration on an offshore oil and gas production platform	81
6.9	Effect of stripping gas on TEG concentration	82
6.10	Glycol regeneration processes	82
6.11	Equilibrium water dew points with various concentrations of TEG	83
6.12	TEG reboiler temperatures	84
6.13	Typical desiccant properties	85
6.14	Dry-bed dehydration unit schematic	86
6.15	Diagram of an adsorption tower	87
6.16	Mass transfer zone for water solid bed adsorption scheme	87
6.17	Horizontal filter separator	89
6.18	Mercury removal flow diagram	91
7.1	Oil absorption plant systems	98
7.2	Lean-oil-to-inlet-gas ratio	100
7.3	A typical low-pressure presaturation system using vapors from rich-oil demethanizer (ROD)	101
7.4	Accumulator	101
7.5	A residue gas scrubber diagram	102
7.6	Differential pressure indicators	103
7.7	Hot rich-oil flash tank used for methane rejection	104
7.8	Diagram of a ROD	105
7.9	Graph of demethanizer bottom temperature versus lean-oil-to-product ratio	106
7.10	Typical bottom temperature adjustments	107
7.11	The ROD reboiler is heated with hot lean oil in the bottom of the still.	107
7.12	Diagram of a dry still	108
7.13	An oil-reclaiming system design	109
7.14	A distillation test graph showing lean-oil quality	110
7.15	Losses due to poor quality of lean-oil initial boiling point	111
8.1	Lean-oil absorption process and cryogenic process	113
8.2	Pressure and temperature to recover 60% ethane	114
8.3	Pressure-temperature diagram for the turboexpander process	116

8.4	Diagram of a plant using a turboexpander process	117
8.5	Methane-ethane binary	118
8.6	Schematic of gas plant processing	119
8.7	Deethanizer overhead recycle process	120
8.8	Residue gas recycle process	121
8.9	A 3.5 turboexpander-compressor used to process offshore gas from the Gulf of Mexico	122
8.10	Efficiency of turboexpansion cooling	123
8.11	A radial-reaction turbine showing nozzle blades	123
8.12	Turboexpander	124
8.13	Wheel shaft	125
8.14	Active magnetic bearings for typical ABM turboexpanders	126
8.15	Core of an aluminum plate	127
8.16	Corrugated fin flow patterns	128
8.17	Cores of plate-fin heat exchanger (PFHE)	128
8.18	Components of a brazed aluminum heat exchanger	129
9.1	Diagram of a fractionation column	132
9.2	Flow through vapor passages	133
9.3	Various types of random packing	134
9.4	Tower with various packing materials including structured packing	135
9.5	Example of a four-column fractionation plant	135
9.6	Example of a fractionation plant used to produce three products	136
9.7	Fractionation plant	139
9.8	Schematic of a regenerable caustic process	142
10.1	Simplified block flow schematic for a nitrogen rejection facility	146
10.2	A single-column distillation unit	149
10.3	Double-column distillation process	150
10.4	Prefractionation scheme	151
10.5	Typical natural gas nitrogen phase	152

## Tables

1.1	Physical Properties of Hydrocarbons Involved in Gas Processing	8
1.2	Physical Properties of Other Compounds Used in Gas Processing	9
1.3	Calculating Mole Percent	10
2.1	Typical Gas Feeds	27
4.1	Approximate Guidelines for Several Commercial Gas Processes	55
4.2	Physical Properties of Gas Treating Chemicals	56
9.1	Product Specifications for a Southern Louisiana Fractionation Plant	138
10.1	Components with Allowable Concentrations in a Cryogenic N <sub>2</sub> Rejection Process	147