

This document contains the tutorial questions for the 15-credit Offshore Process Engineering course delivered at the University of Aberdeen.

The recommended questions you should solve for each week are:

- Tutorial 1 Phase Behaviour: Q. 1 to Q. 7.
- Tutorial 2 Single Phase Fluid Flow: Q. 10 to Q. 20.
- Tutorial 3 Separation: Q. 23
- Tutorial 4 Produced Water: Q. 24 to Q. 26.
- Tutorial 5 Compression: Q. 27 to Q. 29.
- Tutorial 6 Gas Treatment: Q. 32 to Q. 35.
- Tutorial 7 Multi-phase: Q. 39 to Q. 43.
- Tutorial 8 Hydrates: Q. 45 to Q. 47.
- Tutorial 9 Energy Efficiency: Q. 48 to Q. 57.
- Tutorial 10 Water Injection: Q. 60 to Q. 61.

All other questions are provided for additional practice (and many are past exam questions) and should help you to explore all aspects of the course.

Fully worked solutions are available but you should attempt the problems without the solutions, it's the only way to find out what you don't know!

Where marks are given, these are indicative of the *relative* weighting each part of a question might have. Please note, the number of questions in an exam (and exam durations) have changed over the years, so the overall marks for a question may now be different to what is reported here.

When answering questions, state any assumptions and reference any information sourced from literature.

1 1: Phase behavior and physical properties

Question 1

Calculate the molar volume of carbon dioxide at 400 K and 50 bara:

- using the Peng-Robinson equation of state [598 cm³ mol⁻¹]
- assuming the ideal gas law [665 cm³ mol⁻¹]

Repeat the calculations at 293 K and 1 bara. Source the required value from literature and compare with your calculation.

[24215 cm³ mol⁻¹, 24361 cm³ mol⁻¹]

[Question end]

Question 2

Calculate the saturation pressure for ethane at 293 K using the SRK equation of state. Compare with published information. [38 bara]

[Question end]

Question 3

Given the following hydrocarbon composition calculate the dew and bubble point curves from 1 bara to 100 bara. Use the Wilson expression to generate your K values.

$$K_i = \frac{P_{Ci}}{P} e^{[5.37(1+\omega_i)(1-T_{Ci}/T)]} \quad (1)$$

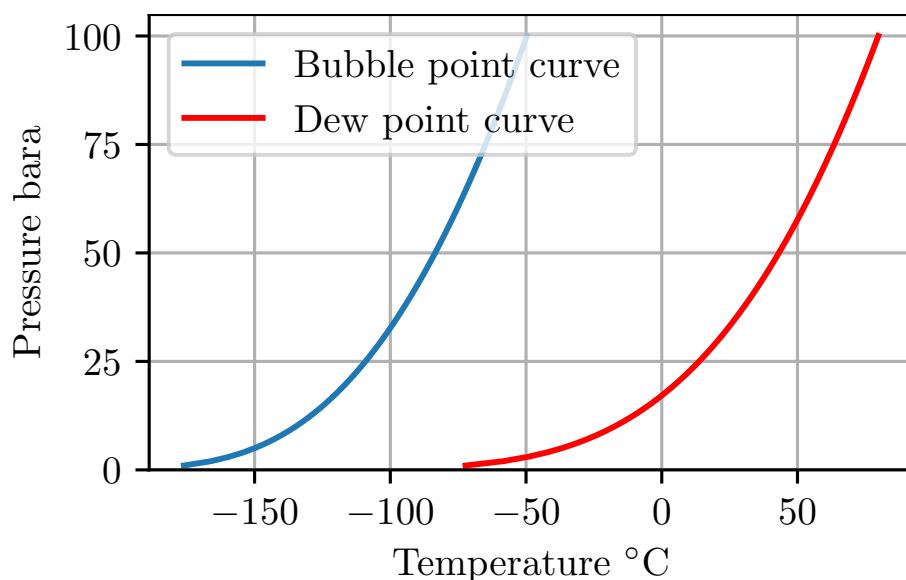
where P is the absolute pressure, P_{Ci} is the critical pressure of component i in the same units as P , T is the absolute temperature, T_{Ci} is the critical temperature of component i in the same units as T , and ω_i is the acentric factor of component i .

Component	Mol fraction
Methane	0.65
Ethane	0.15
Propane	0.1
i-Butane	0.05
n-Butane	0.05

Use the following properties:

Component	P_C bara	T_C °C	T_C K	Acentric factor
Methane	46.39	-82.45	190.55	0.0115
Ethane	48.83	32.28	305.28	0.0986
Propane	42.55	96.75	369.75	0.1524
i-Butane	36.46	134.9	407.9	0.1848
n-Butane	37.95	152	425	0.201

Answer:

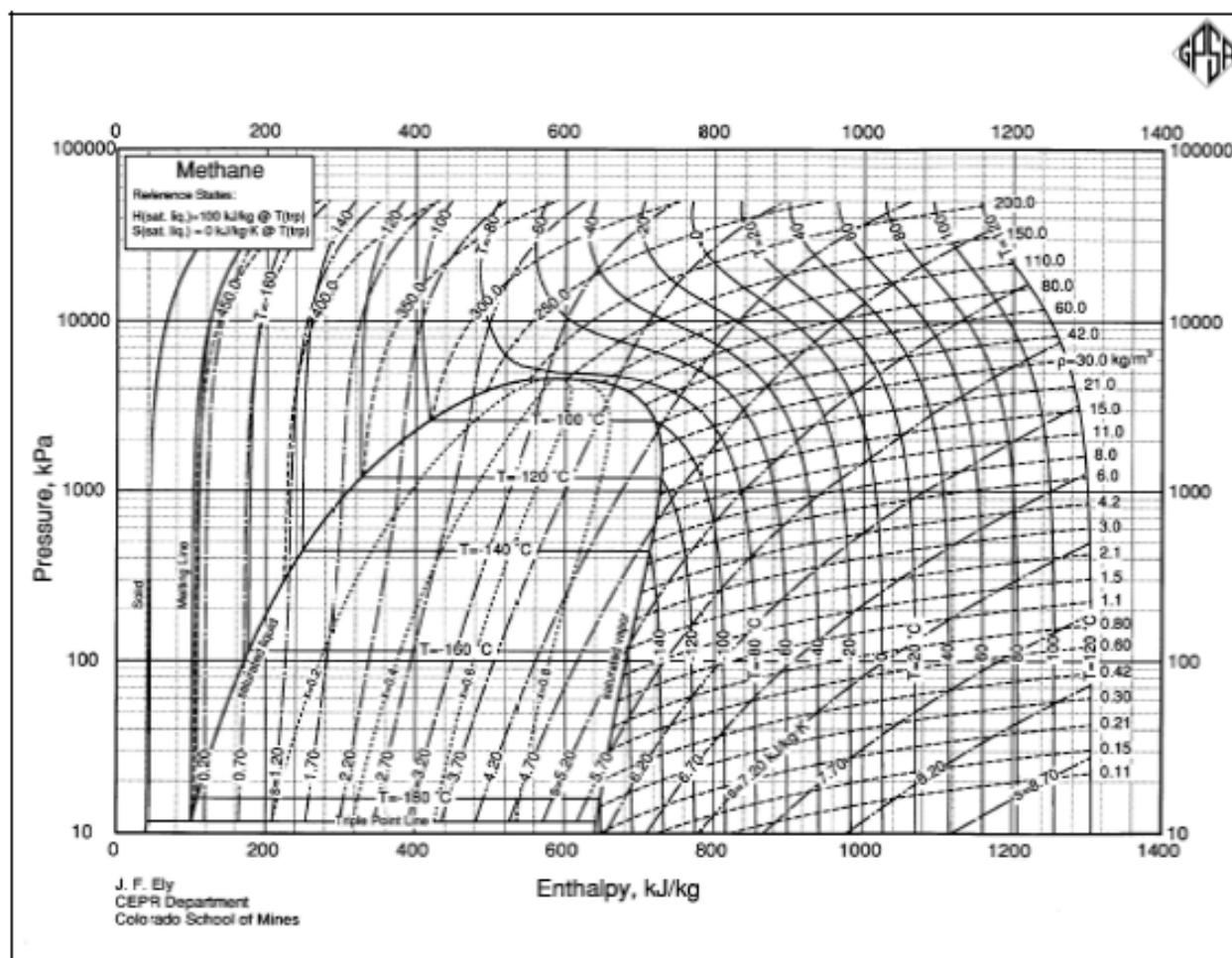


[Question end]

Question 4

Methane is expanded across a choke valve from 100 bara and 20 °C to 1 bara. Using the attached Mollier chart calculate the downstream temperature. [-26 °C]

As the pipeline fills with methane the back pressure increases. Calculate the choke downstream temperature at back pressures of 10 and 25 bara. [-20 °C, -18 °C]



[Question end]

Question 5

Calculate the gas density for the following mixture at 139.4 bara and 331 K.

Component	Mol fraction
N ₂	0.0046
CO ₂	0.0030
H ₂ S	0.1438
Methane	0.8414
Ethane	0.0059
Propane	0.0008
i-Butane	0.0003
n-Butane	0.0002

State your data sources. [120 kg m⁻³]

[Question end]

Question 6

Past exam question

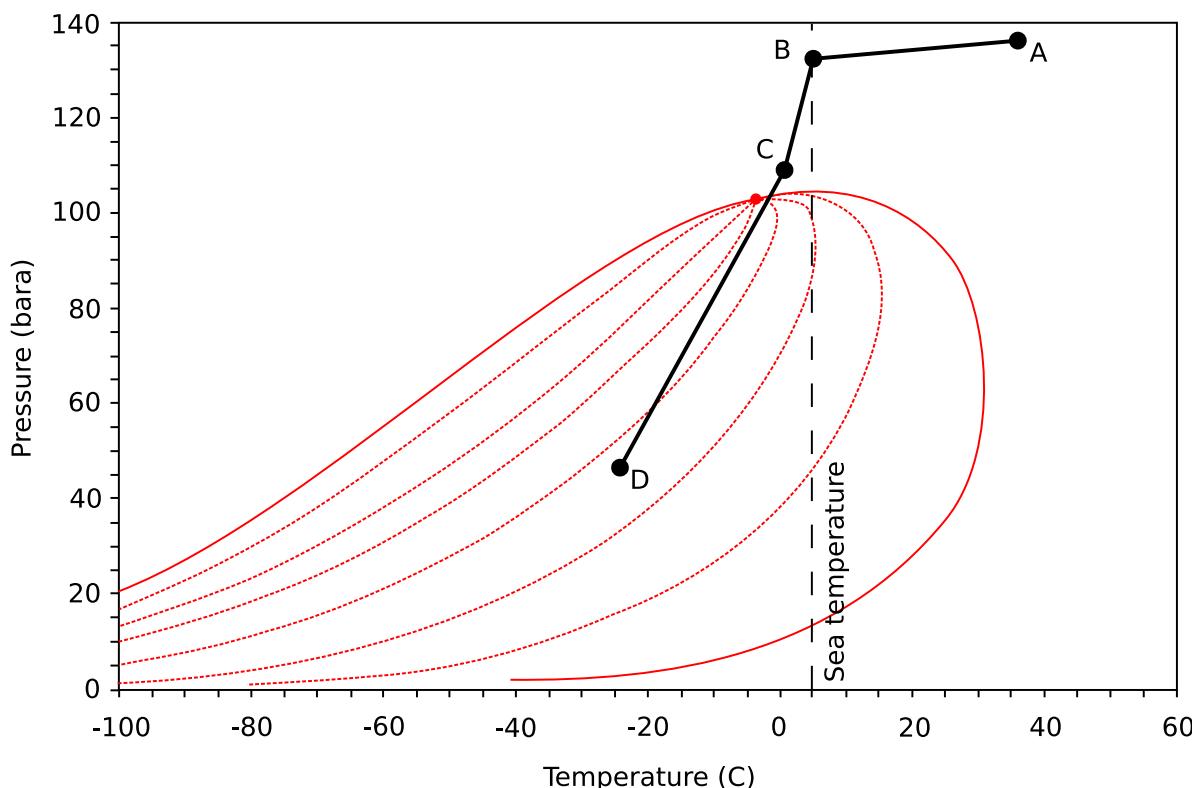


Figure 1: The phase diagram for well-fluids produced offshore (point A) and the pressure-temperature path of the subsea pipeline ($A \rightarrow C$) and initial treatment at ($C \rightarrow D$) the processing plant.

Consider a subsea well. The wellhead temperature and pressure are indicated by point A on the figure above. The gas processing terminal, which is some distance away, receives the fluids at the conditions indicated by point C.

- Describe what might be occurring to cause the condition change $A \rightarrow B$. Note that the relative pressure drop is small. [5 marks]
- Describe what might be occurring between points $B \rightarrow C$. In particular describe why the fluid is colder than the surrounding sea water. [5 marks]
- Comment on the location of point C. Why is the subsea pipeline exit operated and designed at those conditions? Explain using key properties of the phase diagram. [5 marks]
- Upon arrival to the processing plant, the process $C \rightarrow D$ is carried out. Explain why this is performed and how the process might be carried out, particularly if energy use is to be minimized. [5 marks]

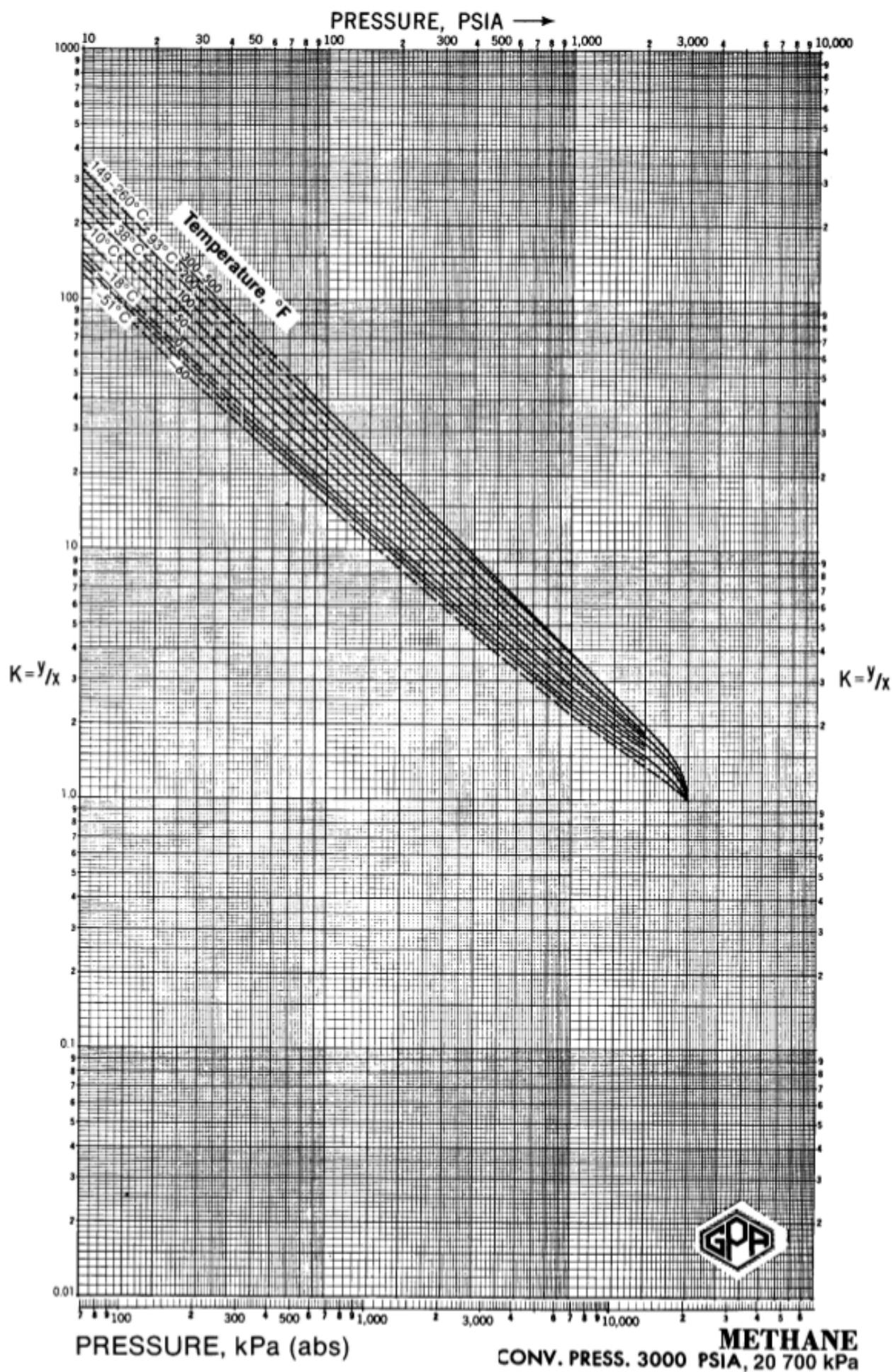
[Question total: 20 marks]

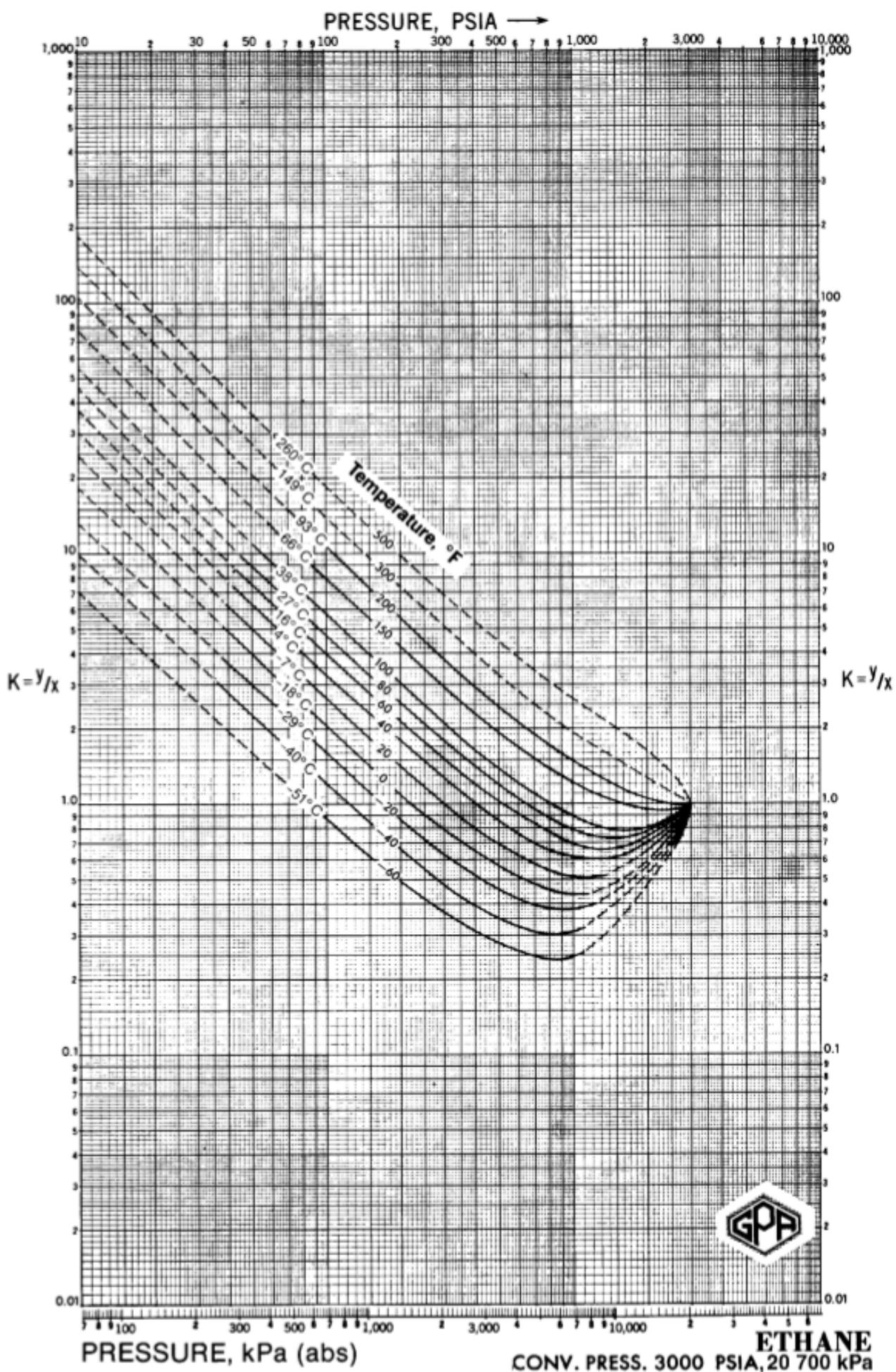
Question 7

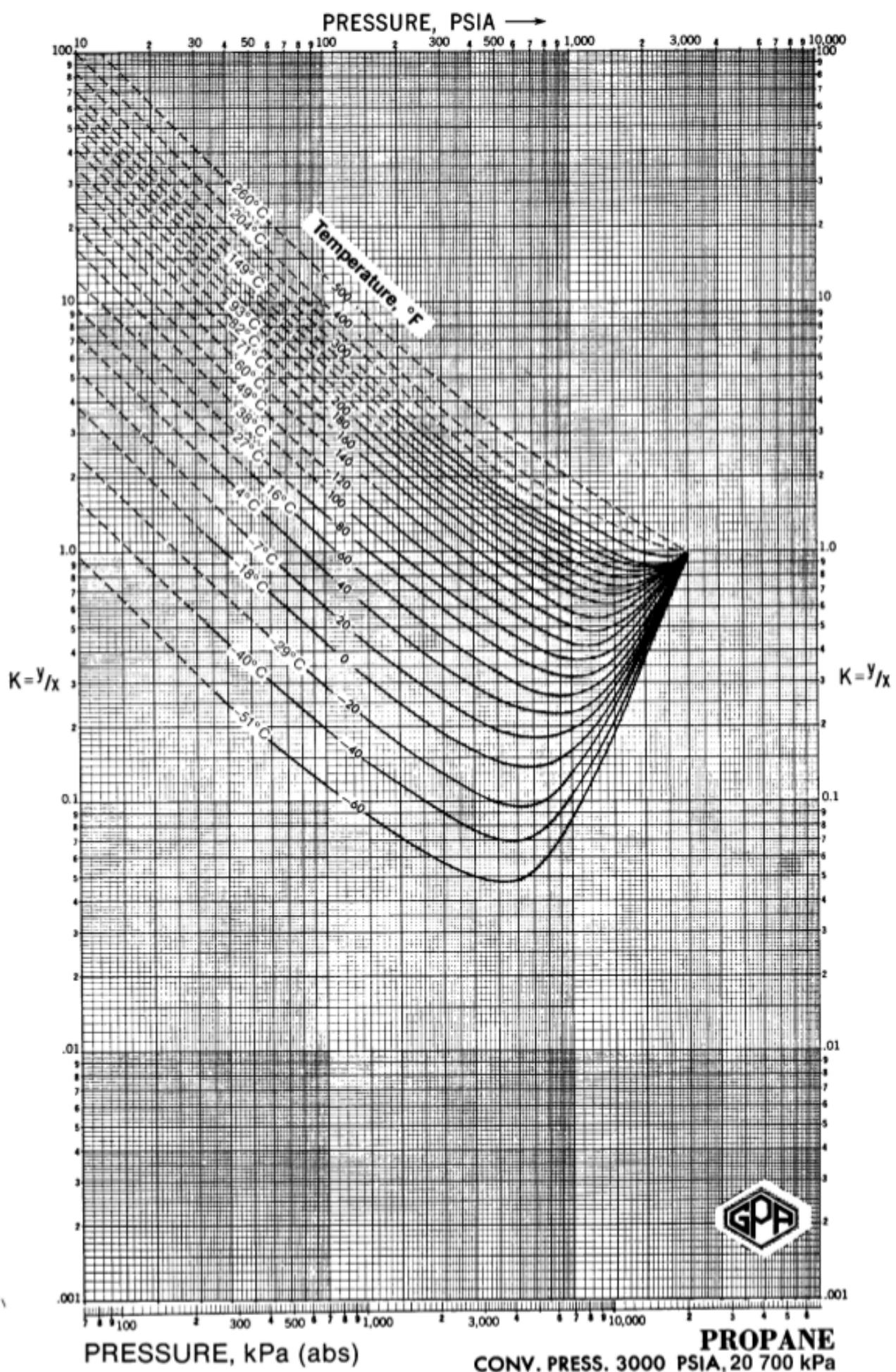
The following mixture flows in a subsea pipeline. The inlet temperature and pressure of the pipeline are 150°F and 1000 psia the outlet conditions are 100°F and 200 psia. Calculate the vapour liquid ratio at the pipeline inlet and outlet using the attached K value charts.

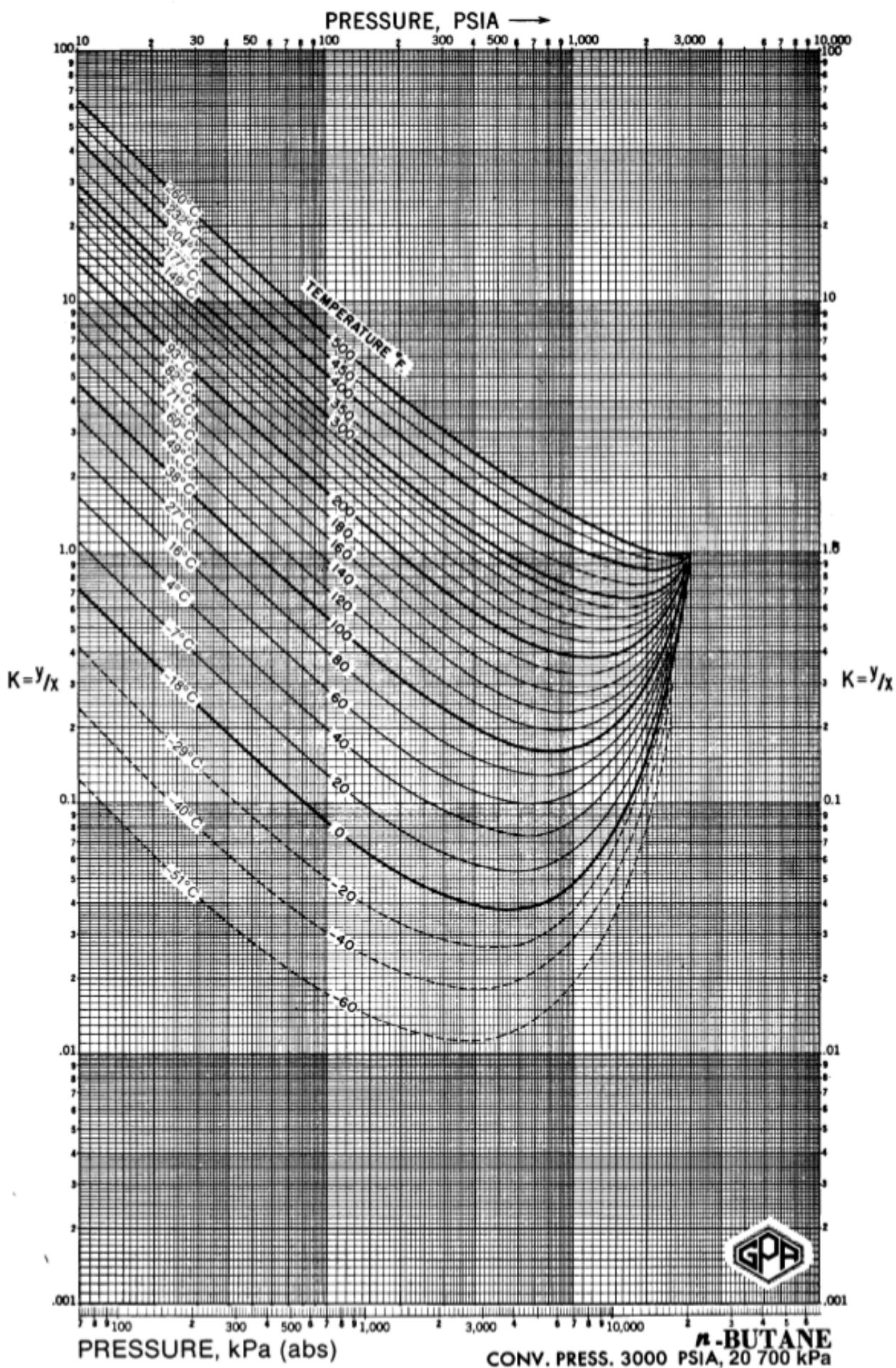
[Inlet V=0.14, L=0.86, Outlet V=0.67, L=0.33]

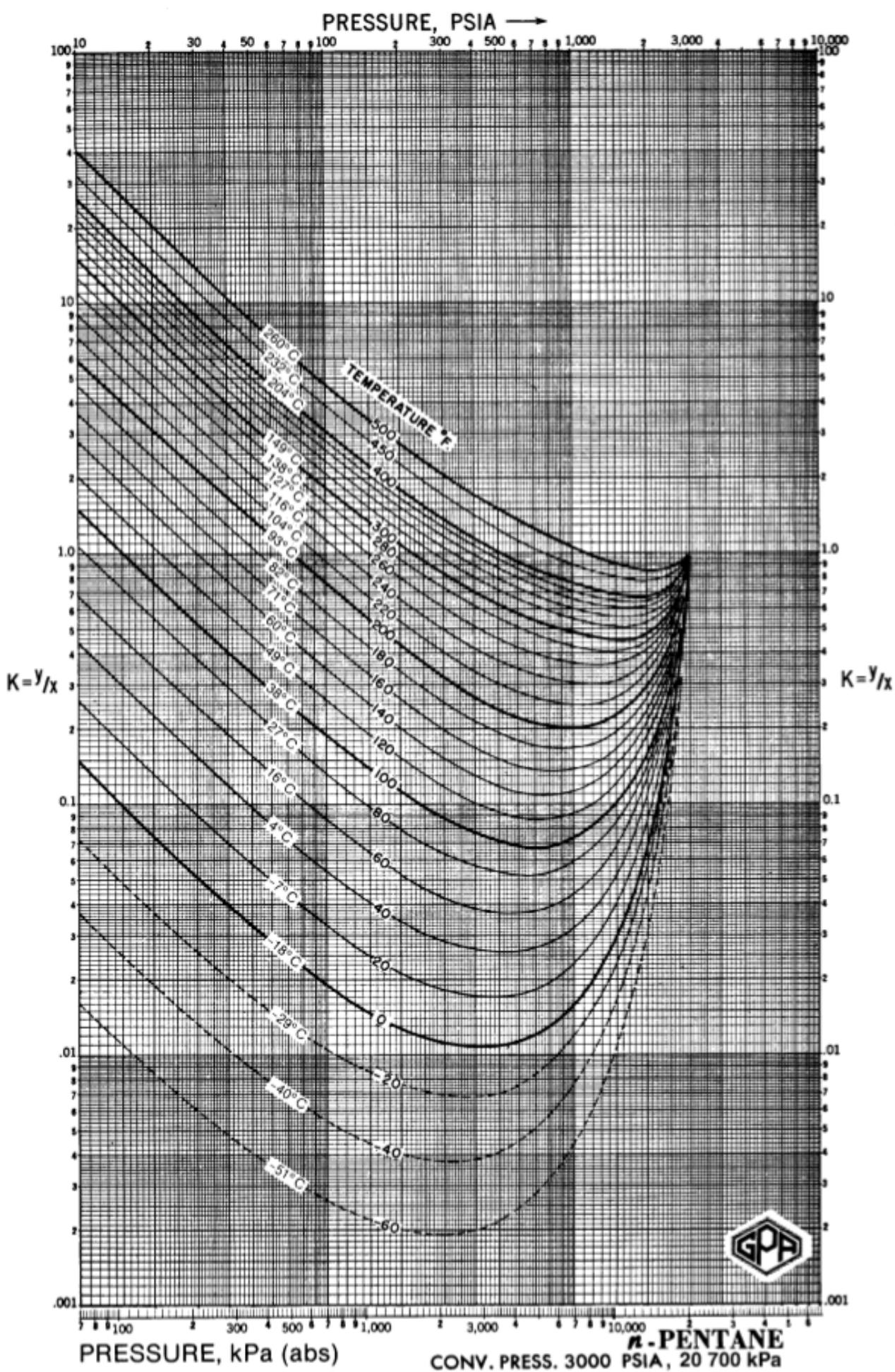
Component	Mol fraction
Methane	0.2
Ethane	0.3
Propane	0.15
n-Butane	0.1
n-Pentane	0.1
n-Octane	0.15

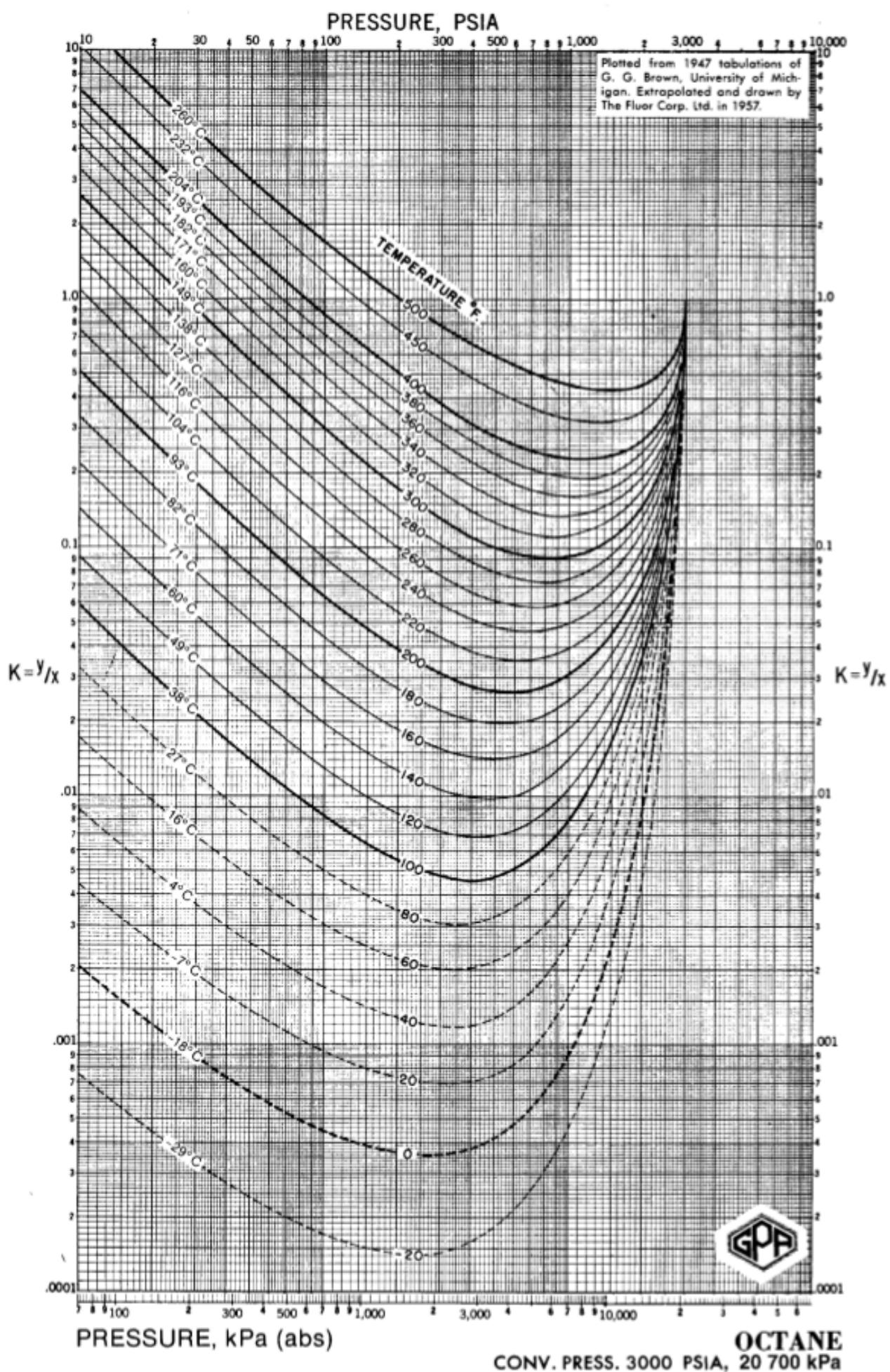












[Question end]

Question 8

1: Phase behaviour

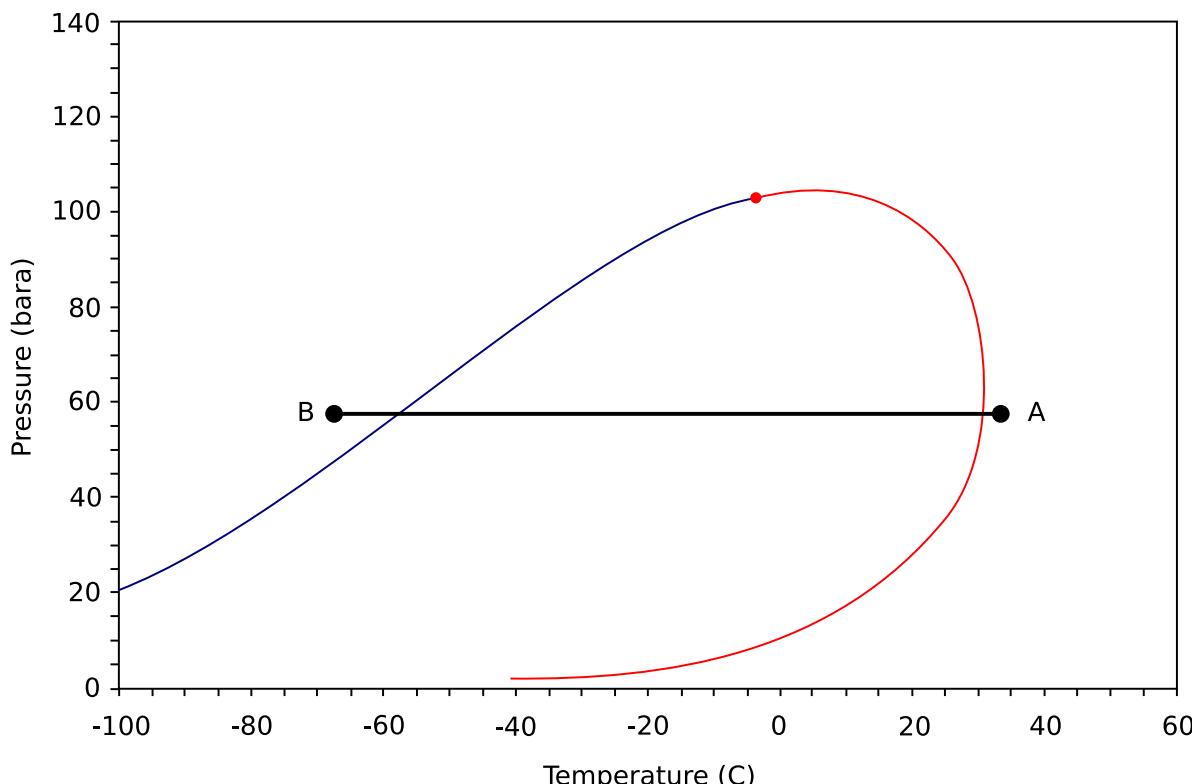
- a) Sketch a typical mixed hydrocarbon gas phase envelope. Indicate the cricondenbar. What is the significance of the Cricondenbar for the operation of gas pipeline systems? **[5 marks]**
- b) An oil/gas separator is operating at 85°C and 2.3 bara producing an oil with a True Vapour Pressure (TVP) of 0.94 bara. Why is TVP an important specification? If water is introduced with the hydrocarbons, what will happen to the TVP if the separator pressure and temperature remain unchanged? **[8 marks]**
- c) A subsea gas pipeline transports gas to a shore terminal. The seabed temperature is 4°C. The pipeline is being operated at a much higher gas throughput than normal and it is noted that the gas arrival temperature at the shore terminal is -2°C. What effect would explain a gas temperature lower than ambient temperature? **[5 marks]**
- d) A natural gas has a calorific value of 40 MJ Nm⁻³. If the CO₂ concentration of the gas is increased from 0 to 5% calculate the new calorific value. **[2 marks]**

[Question total: 20 marks]

Question 9

1: Phase behaviour

- a) The following *T-p* plot is the phase envelope for a mixed hydrocarbon fluid. Describe the phase transitions moving from point A to B. **[3 marks]**



- b) The dew point of a mixed hydrocarbon gas can be calculated using the following expression:

$$\sum_i \frac{y_i}{K_i} = 1.0$$

Describe the term K_i and how a typical K value chart such as that given in Fig. 2 may be used to calculate the dew point temperature at a fixed pressure of a multi-component mixture where the mole fractions are known. [6 marks]

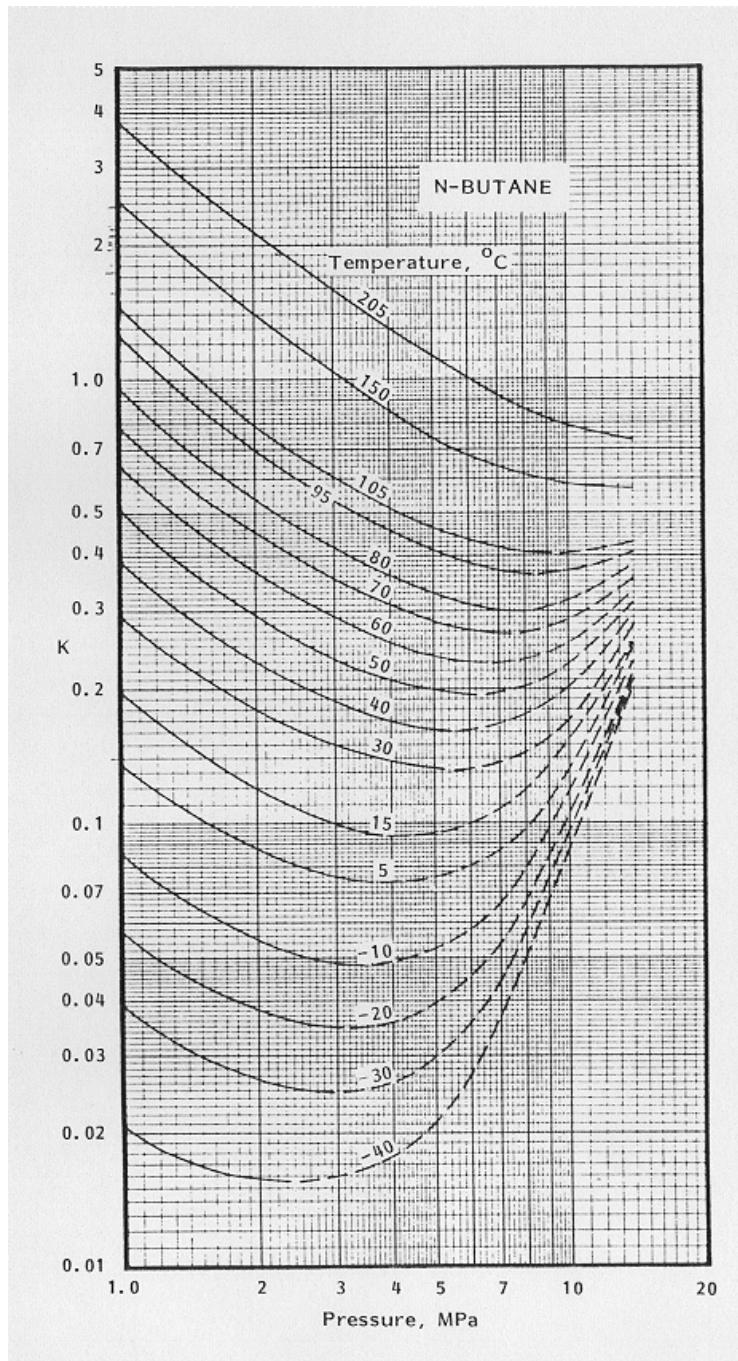


Figure 2: K-value chart for *n*-butane.

- c) A final stage oil and gas separator is operating at 70 °C and 1.5 bara producing a crude oil product with a True Vapour Pressure (TVP) of 0.85 bara at 37.8 °C. Explain what will happen to the TVP of the crude if:

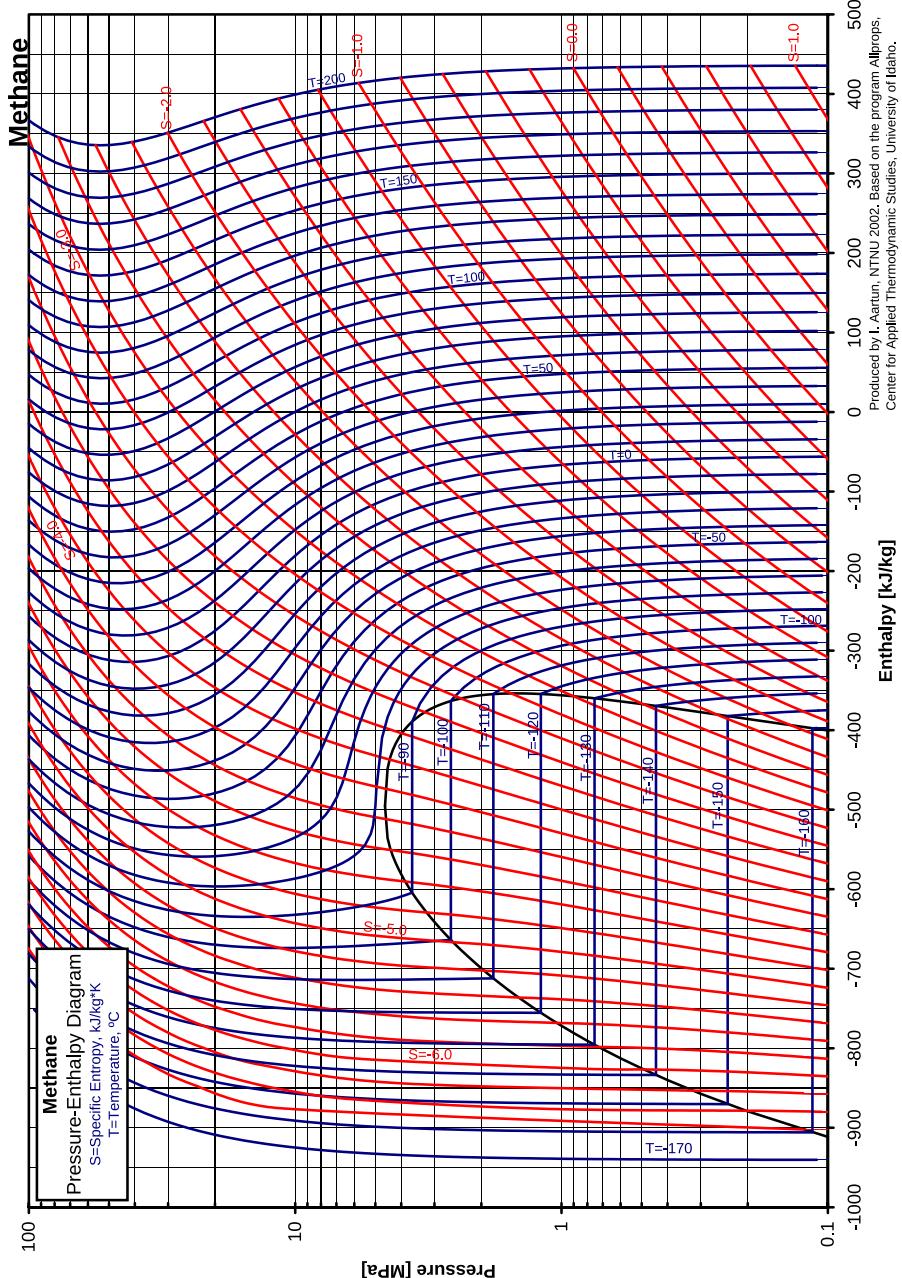
- the separator temperature reduces and the pressure is held constant.
- the separator pressure reduces and the temperature is held constant. **[4 marks]**

d) Methane is expanded across a blowdown valve from 500 bara and 20 °C to 1.5 bara. Discuss the thermodynamics of the expansion process. Using the enclosed Mollier chart in Fig. 3 calculate the downstream temperature. **[3 marks]**

e) A process simulation uses Peng-Robinson to determine the phase behaviour in the three-phase separator at a light crude offshore installation. Water is present in the received fluids, comment on the suitability/limitations of the results/model. **[4 marks]**

[Question total: 20 marks]

If you use this graph, you must attach it to your exam booklet using the provided tag.
Student ID:



[Question end]

Question 11

A 160 km long subsea gas pipeline has an internal diameter of 333 mm. The inlet pressure is 90 bara and the outlet pressure is 20 bara. The pipeline flows isothermally at 4 °C. The gas consists of 75 % methane, 21 % ethane and 4 % propane. The gas compressibility is 0.85. Calculate the flowrate of gas in $\text{sm}^3 \text{ day}^{-1}$. The pipeline efficiency is 1. Compare the Weymouth and Panhandle A equations.

[3.13 million $\text{sm}^3 \text{ day}^{-1}$ Weymouth, 4.18 million $\text{sm}^3 \text{ day}^{-1}$ Panhandle A]

[Question end]

Question 12

If the gas entered the pipeline at 60 °C and cooled to 4 °C, outline how you would calculate the pressure drop in the pipeline if the gas flowrate was fixed.

[Question end]

Question 13

A square edged orifice of 50 mm diameter is installed in a 102.5 mm inside diameter pipe having a mercury manometer connected between the pipe taps. Find the flowrate of water when the mercury deflection is 110 mm. [395.3 litre min^{-1}]

[Question end]

Question 14

Using the following expression for frictional pressure drop

$$\frac{dp}{dl} = \frac{f\rho V^2}{2d} \quad (2)$$

and the ideal gas law develop an expression that takes the same form as the Panhandle A equation.

[Question end]

Question 15

The pressure at the top of a static gas filled riser is 20 bara, the temperature is 10 °C, the gas molecular weight is 22 g mol^{-1} , the compressibility at 20 bara is 0.88. The riser is 1000 m long, what is the pressure at the riser base? [22.2 bara]

[Question end]

Question 16

What is the riser base pressure if the riser from Q. 15 is full of oil with an sg of 0.825? [100.9 bara]

Repeat the calculation for a 600 m oil and 400 m gas filled riser. [69.4 bara]

[Question end]

Question 17

Water is flowing through a convergent divergent nozzle. Given the following information, calculate the pressure at the nozzle throat. Nozzle inlet pressure and temperature - 10 bara and 15 °C, inlet piping and nozzle diameter - 125 mm and 25 mm. The water flowrate is 1 m³ min⁻¹. Neglect frictional pressure drop. [4.245 bara]

[Question end]

Question 18

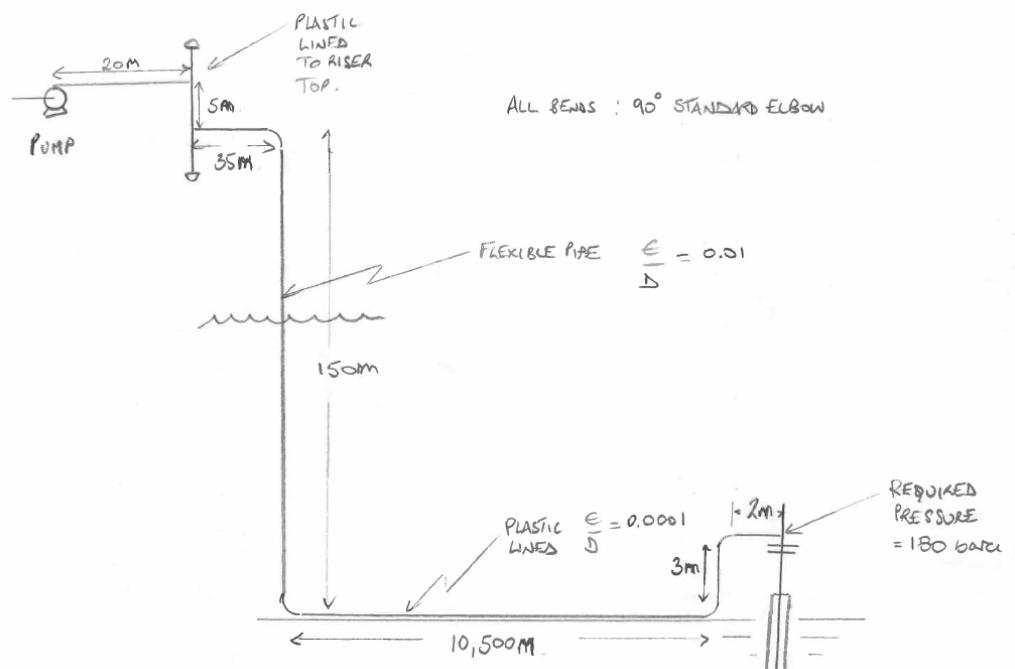
Calculate the speed of sound in air at 15 °C. [340 m s⁻¹]

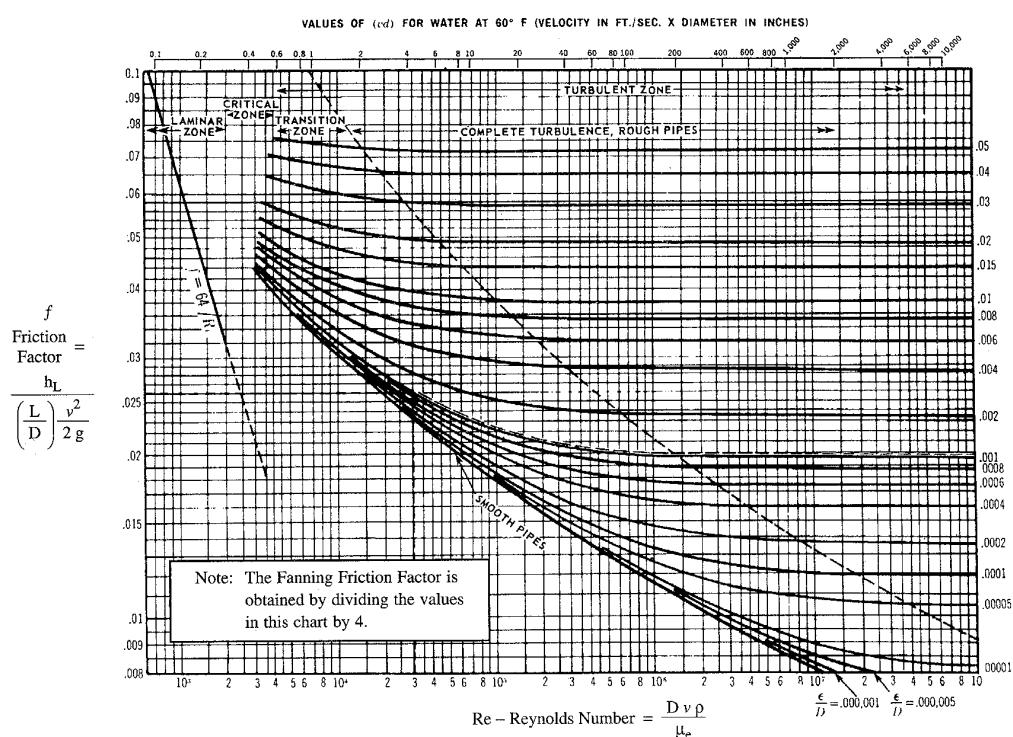
Calculate the speed of sound in water. [1466 m s⁻¹]

[Question end]

Question 19

A plastic lined, subsea water injection flowline is required to deliver 80,000 bbl day⁻¹ of treated sea water to a subsea manifold at a pressure of 180 bara and temperature of 10 °C. The water pipeline route is as shown. The topsides piping is also plastic lined but the riser is flexible pipe. The pipe ID is 10.75 inch throughout. Calculate the required water injection pump discharge pressure. 6.29 bbl = 1 m³. Viscosity and density of sea water at 10 °C is 1.31 cP and 1020 kg m⁻³ respectively. [185.0 bara]



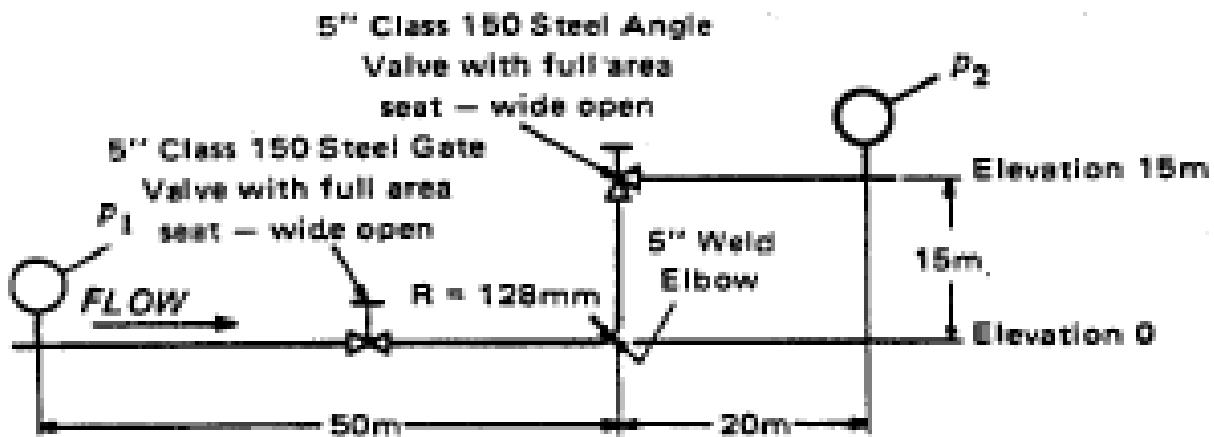


Description				Equivalent Length in Pipe Diameters (L/D)
Globe Valves	Stem perpendicular to run	No Obstruction Wing or Pin guided disc	100% Open 100% Open	340 450
	Y-pattern	Stem 60° from run of pipe Stem 45° from run of pipe	100% Open 100% Open	175 145
Angle Valves		No Obstruction Wing or Pin guided disc	100% Open 100% Open	145 200
Gate Valves	Wedge Disc Double Disc, Plug Disc		100% Open 75% Open 50% Open 25% Open	13 35 160 900
	Pulp Stock		100% Open 75% Open 50% Open 25% Open	17 50 260 1200
Conduit PipeLine Gate Ball and Plug Valves			100% Open	3
Check Valves	Conventional Swing Clearway Swing Globe Lift or Stop; Stem Perpendicular to Run or Y-pattern Angle lift or Stop In-Line Ball			135 50 same as globe same as globe 150
Foot Valves with Strainer		Poppet lift-type disc Leather-hinger disc		420 75
Butterfly Valves (8-inch and larger)				40
Cocks	Straight-through	Rectangular plug port area equal to 100% of pipe area		18
	Three-way	Rectangular plug port area equal to 80% of pipe area	Straight through Through branch	44 140
Fittings	90° Standard Elbow 45° Standard Elbow 90° Long Radius Elbow			30 16 20
	90° Street Elbow 45° Street Elbow Square Corner Elbow			50 26 57
	Standard Tee	Flow through run Flow through branch		20 60
	Close Pattern Return Bend			50

[Question end]

Question 20

For the following piping system has an oil flow rate of 2300 l min^{-1} , pipe diameter of 128.2 mm, liquid density of 899 kg m^{-3} and viscosity of 450 cP. Calculate the pressure difference $p_1 - p_2$. The fully turbulent friction factor f_T is 0.016. For the fittings (valves/components) $\beta=1$. [3.65 bar]



APPENDIX A

CRANE PHYSICAL PROPERTIES OF FLUIDS AND FLOW CHARACTERISTICS OF VALVES, FITTINGS AND PIPE A - 27

"K" FACTOR TABLE – SHEET 2 of 4

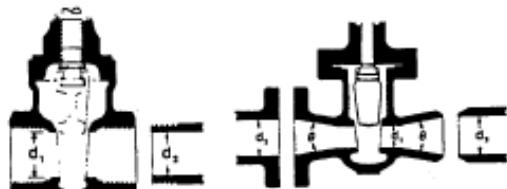
Representative Resistance Coefficients (K) for Valves and Fittings

(for formulas and friction data, see page A-26)

("K" is based on use of schedule pipe as listed on page 2-10)

GATE VALVES

Wedge Disc, Double Disc, or Plug Type



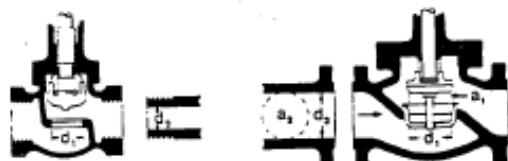
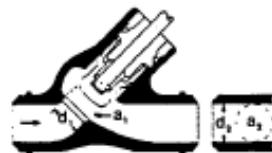
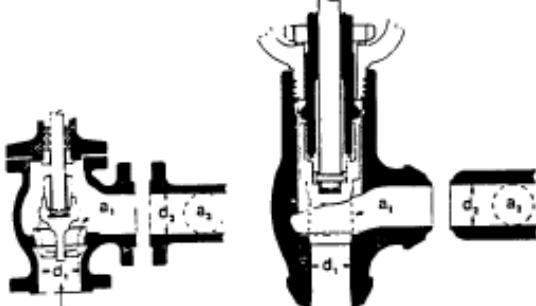
If: $\beta = 1, \theta = 0 \dots K_1 = 8 f_T$
 $\beta < 1 \text{ and } \theta < 45^\circ \dots K_1 = \text{Formula 5}$
 $\beta < 1 \text{ and } 45^\circ < \theta < 180^\circ \dots K_1 = \text{Formula 6}$

SWING CHECK VALVES



$K = 100 f_T$ $K = 50 f_T$
Minimum pipe velocity (mps) for full disc lift
 $= 45\sqrt{V}$ $= 75\sqrt{V} \text{ except}$
U/L listed = $120\sqrt{V}$

GLOBE AND ANGLE VALVES

If: $\beta = 1 \dots K_1 = 340 f_T$ If: $\beta = 1 \dots K_1 = 55 f_T$ If: $\beta = 1 \dots K_1 = 150 f_T$ If: $\beta = 1 \dots K_1 = 55 f_T$ All globe and angle valves,
whether reduced seat or throttled,If: $\beta < 1 \dots K_1 = \text{Formula 7}$

LIFT CHECK VALVES



If: $\beta = 1 \dots K_1 = 600 f_T$
 $\beta < 1 \dots K_1 = \text{Formula 7}$

Minimum pipe velocity (mps) for full disc lift
 $= 50\beta^2 \sqrt{V}$



If: $\beta = 1 \dots K_1 = 55 f_T$
 $\beta < 1 \dots K_1 = \text{Formula 7}$

Minimum pipe velocity (mps) for full disc lift
 $= 170\beta^2 \sqrt{V}$

TILTING DISC CHECK VALVES



Sizes	$\alpha = 5^\circ$	$\alpha = 15^\circ$
50 mm (2") to 200 mm (8")	$40 f_T$	$120 f_T$
250 mm (10") to 350 mm (14")	$30 f_T$	$90 f_T$
400 mm (16") to 1200 mm (48")	$20 f_T$	$60 f_T$
Minimum pipe velocity (mps) for full disc lift =	$100\sqrt{V}$	$40\sqrt{V}$

Note. mps = metres per second

APPENDIX A

CRANE PHYSICAL PROPERTIES OF FLUIDS AND FLOW CHARACTERISTICS OF VALVES, FITTINGS AND PIPE A - 29

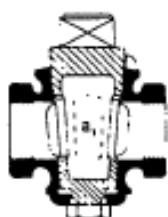
"K" FACTOR TABLE – SHEET 4 of 4

Representative Resistance Coefficients (K) for Valves and Fittings

(for formulas and friction data, see page A-26)
 ("K" is based on use of schedule pipe as listed on page 2-10)

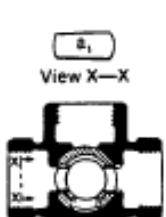
PLUG VALVES AND COCKS

Straight-Way

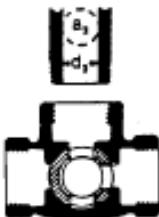


If: $\beta = 1$,
 $K_1 = 18 f_T$

3-Way



If: $\beta = 1$,
 $K_1 = 30 f_T$



If: $\beta = 1$,
 $K_1 = 90 f_T$

If: $\beta < 1$ $K_1 = \text{Formula 6}$

STANDARD ELBOWS

90°



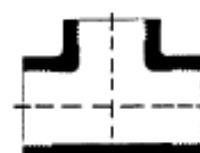
$K = 30 f_T$

45°



$K = 16 f_T$

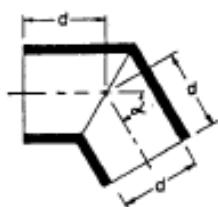
STANDARD TEES



Flow thru run $K = 20 f_T$

Flow thru branch $K = 60 f_T$

MITRE BENDS



α	K
0°	$2 f_T$
15°	$4 f_T$
30°	$8 f_T$
45°	$15 f_T$
60°	$25 f_T$
75°	$40 f_T$
90°	$60 f_T$

90° PIPE BENDS AND

FLANGED OR BUTT-WELDING 90° ELBOWS

$1.5 = r/d = 14 \text{ ft} = \text{Standard}$



r/d	K	r/d	K
1	$20 f_T$	8	$24 f_T$
1.5	$14 f_T$	10	$30 f_T$
2	$12 f_T$	12	$34 f_T$
3	$12 f_T$	14	$38 f_T$
4	$14 f_T$	16	$42 f_T$
6	$17 f_T$	20	$50 f_T$

The resistance coefficient, K_B , for pipe bends other than 90° may be determined as follows:

$$K_B = (n - 1) \left(0.25 \pi f_T \frac{r}{d} + 0.5 K \right) + K$$

n = number of 90° bends

K = resistance coefficient for one 90° bend (per table)

$$K_B = 31 (0.25 \pi \times 0.013 \times 3 + 0.5 \times 0.156) + 0.156$$

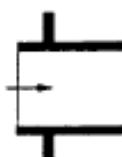
CLOSE PATTERN RETURN BENDS



$K = 50 f_T$

PIPE ENTRANCE

Inward Projecting

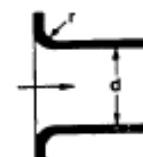


$K = 0.78$

r/d	K
0.00*	0.5
0.02	0.28
0.04	0.24
0.06	0.15
0.10	0.09
0.15 & up	0.04

*Sharp-edged

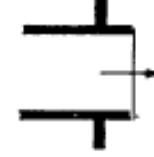
Flush



For K ,
see table

PIPE EXIT

Projecting



$K = 1.0$

Sharp-Edged



$K = 1.0$

Rounded



$K = 1.0$

"K" FACTOR TABLE – SHEET 1 of 4														
Representative Resistance Coefficients (K) for Valves and Fittings														
("K" is based on use of schedule pipe as listed on page 2-10)														
PIPE FRICTION DATA FOR CLEAN COMMERCIAL STEEL PIPE WITH FLOW IN ZONE OF COMPLETE TURBULENCE														
Nominal Size	mm in.	15 ½	20 ¾	25 1	32 1¼	40 1½	50 2	65, 80 2½, 3	100 4	125 5	150 6	200, 250 8, 10	300-400 12-16	450-600 18-24
Friction Factor (f_T)		.027	.025	.023	.022	.021	.019	.018	.017	.016	.015	.014	.013	.012

NB MOODY FRICTION FACTOR

[Question end]

Question 21

Past exam question

- a) For a centrifugal compressor describe the condition known as surge. [4 marks]
- b) Describe the concept of equivalent length as used in piping system pressure drop calculations. [2 marks]
- c) A polymer gel (density $\rho = 1000 \text{ kg m}^{-3}$ and viscosity $\mu = 0.01 \text{ Pa s}$) injection system is sketched below which has an inner diameter of 0.1 m. A volumetric flow of 10,000 barrel day $^{-1}$ is required. This is supplied to each well separately in sequence, so consider the two flow paths separately and at the full flowrate of 10,000 barrel day $^{-1}$. Calculate the pressure drops required to each well-head (B and C) assuming the pipe walls are smooth. Additional required information is available in Table 1 of the datasheet. [10 marks]

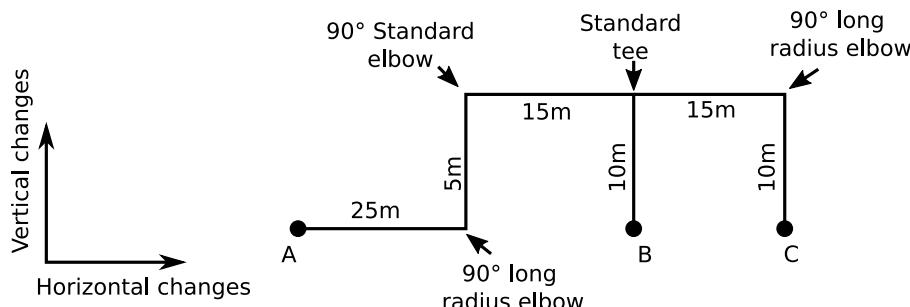


Figure 4: The flow diagram for the water injection system, and the pipeline. Please note the difference between vertical height changes and horizontal distance changes.

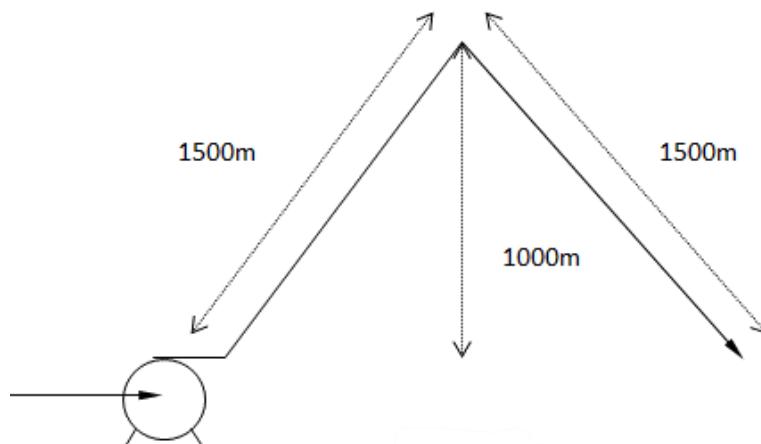
- d) What equipment is required to maintain the required flowrate to each well? [4 marks]

[Question total: 20 marks]

Question 22

2: Single-phase fluid flow

The figure below shows a simplified route for an oil pipeline.



The oil has a specific gravity of 0.82. The inlet temperature to the pipeline is 30°C and it can be assumed that there is a 1°C temperature drop every 150 m. The True Vapour Pressure of the oil is 1000, 1200 and 1500 kPa at 10, 20 and 30°C respectively. At design conditions the total frictional pressure drop across the whole pipeline length is 500 kPa. You may ignore any pressure loss from fittings such as elbows or joints.

- Calculate the minimum pump discharge pressure to avoid vapour evolution from the oil. State any assumptions. **[6 marks]**
- Sketch the pipeline pressure-temperature profile with respect to a typical oil phase envelope. Indicate the P,T conditions at the pipeline inlet, apex and pipeline outlet. **[4 marks]**
- Explain the concept of equivalent length as used in the calculation of pressure drop in a piping system. **[4 marks]**
- The formula for single phase frictional pressure drop in a pipe is given by:

$$\Delta P_f = \frac{\rho f L v^2}{2 D}$$

where f is the Moody friction factor (proportional to $f \propto Re^{-0.25}$), L is the pipe length, v is the fluid velocity, D is the internal pipe diameter, ΔP_f is the frictional pressure loss, and ρ is the fluid density. An incompressible fluid is flowing in a horizontal section of pipe and the measured pressure drop is 2 bar.

- Calculate the pressure drop if the volumetric flow is halved. **[3 marks]**
- Calculate the pressure drop if the volumetric flow remains the same but the pipe diameter is halved instead. **[3 marks]**

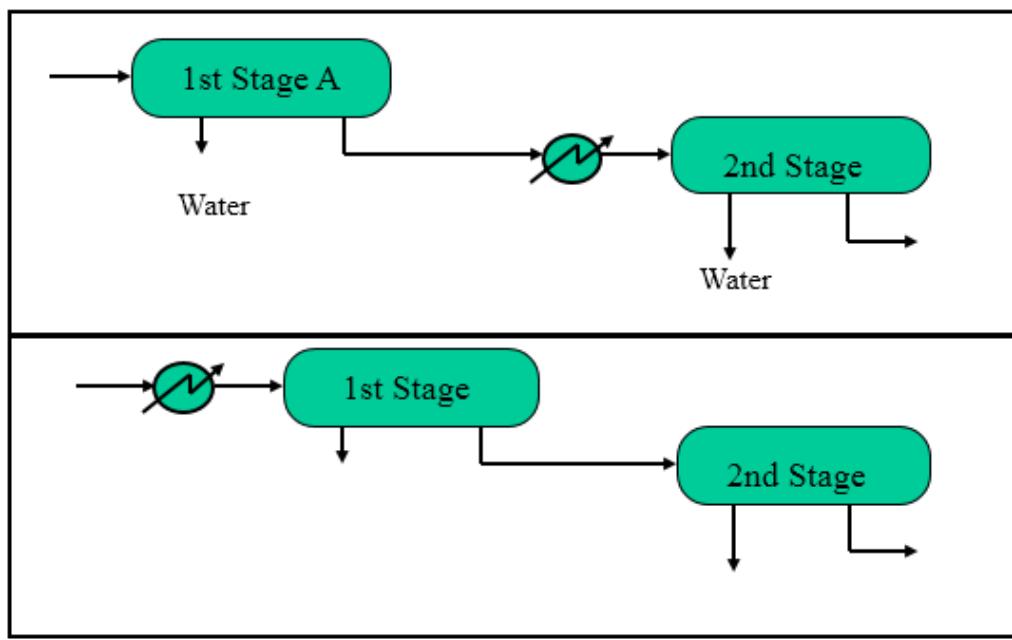
[Question total: 20 marks]

3 3: Separator

Question 23

Prepare a conceptual design for an oil/gas/water separation train handling a relatively low API crude - 22 API. Previous experience of low API crudes in the North Sea indicates that oil-water separation can be difficult, especially if stable emulsions are formed. In order to understand some of the oil-water separation characteristics of this crude, you have commissioned a series of lab tests at varying water cuts and temperatures. The results are attached.

Consider the following arrangements. Identify the issues / benefits associated with the two options and select your preferred option.



Carry out basic separator sizing based on residence times inferred from the lab tests. Vessel weights are required for costing and dimensions are required for plant layout. Additionally, calculate the heat exchanger duty for the scheme. Identify requirement for an electrostatic coalescer and if required prepare a size and weight. Develop a control system and an equipment list for your selected arrangement.

Use the following guidelines and information:

- Typical L/D ratios for oil-water separation is ≈ 3 .
- Normal liquid level in separators is 50 %.
- Arrival temperature of fluids is 50 °C.
- Arrival pressure is 10 bara.
- Gas / oil ratio in first stage is 60 sm³ / m³ oil and the gas molecular weight is 20.
- Gas / oil ratio in first stage is 10 sm³ / m³ oil and the gas molecular weight is 35.
- 2nd stage separator operating pressure is to be determined to produce required oil TVP.

Operating and design pressure

The following is typical guidance used by process design companies.

Typical design pressures are as follows:

Operating pressure barg	Design Pressure barg
0-10	MOP + 1 bar
10-35	MOP + 10 %
35-70	MOP + 3.5 bar
> 70	MOP + 5 %

MOP = Maximum Operating Pressure

Design temperatures

Maximum design temperature = max. operating temperature + 15 °C

Minimum design temperature = min. operating temperature - 5 °C (or minimum ambient temperature)

Consideration for the min. design temperature must take into account any depressurisation that may occur during an emergency or shutdown situations.

Note that it is a conceptual design which means an accuracy of ±30 %.

Production data

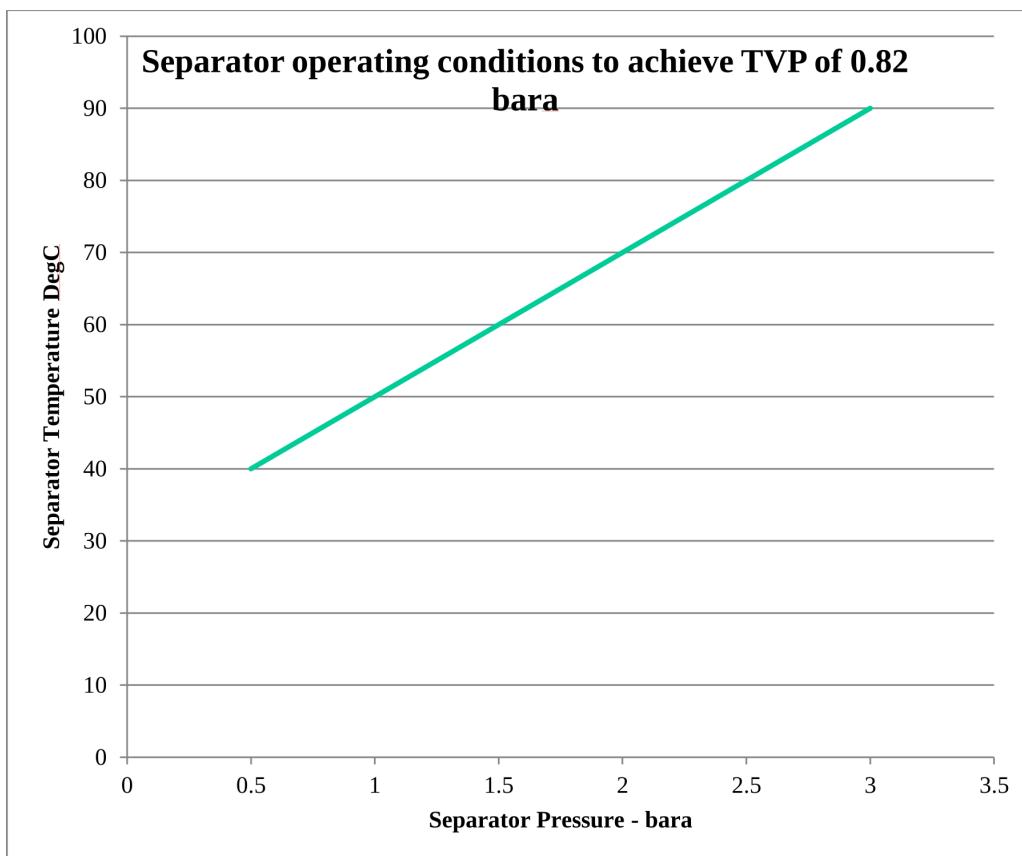
	Flowrate bpd	Specific gravity	Specific heat capacity kJ kg ⁻¹ K ⁻¹
Oil	89,000	0.83	2.1
Water	60,000	1.025	4.2

Oil specification

TVP = 0.82 bar at 37.8 °C

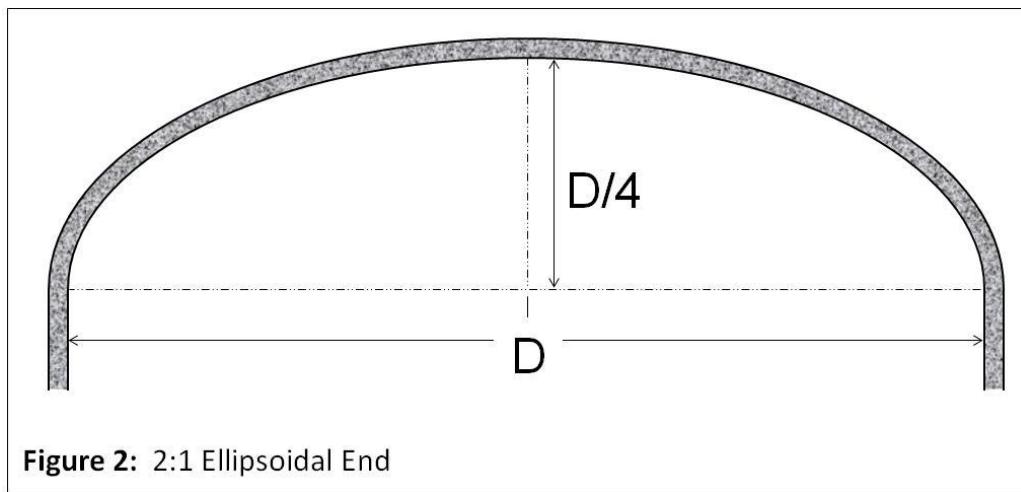
BS&W = 0.5 % v/v

TVP characteristics:



Volume of a vessel with a 2:1 ellipsoidal dished ends is given by the following expression:

$$V = \frac{\pi D^3}{12} + \frac{\pi D^2 L}{4} \quad (3)$$



Additional equations

The wall thickness is given by

$$t = \frac{PD}{20(SE - 0.06P)} \quad (4)$$

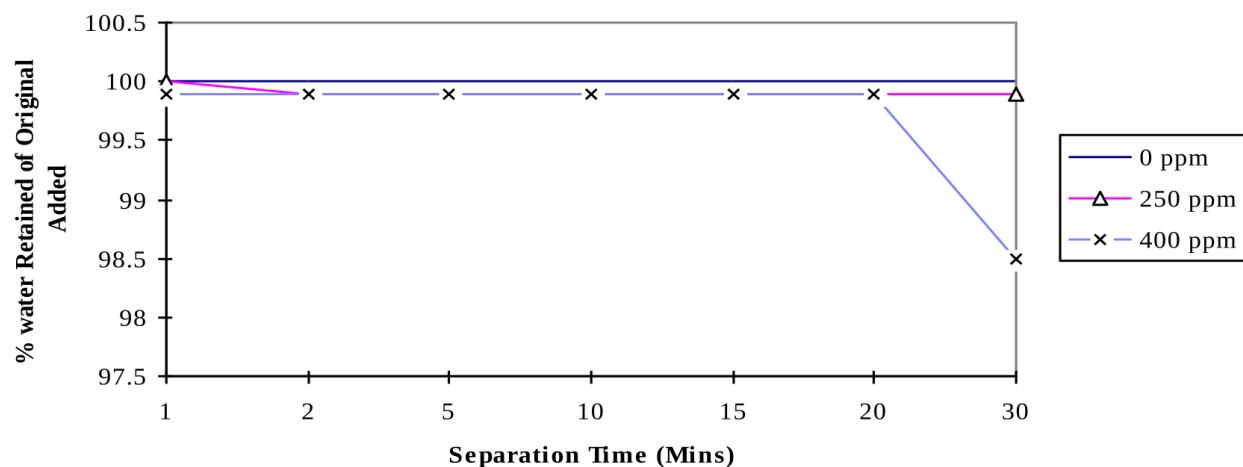
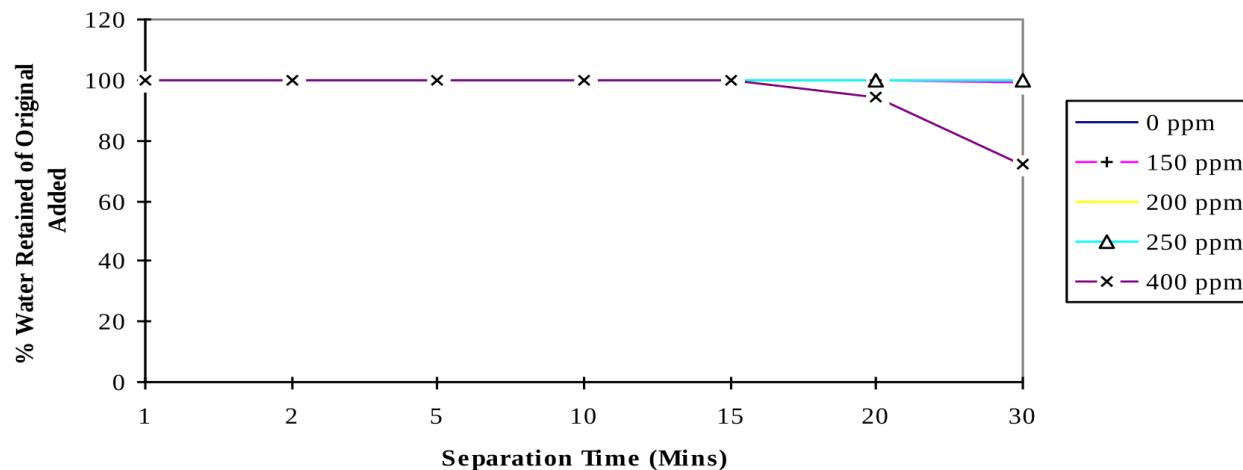
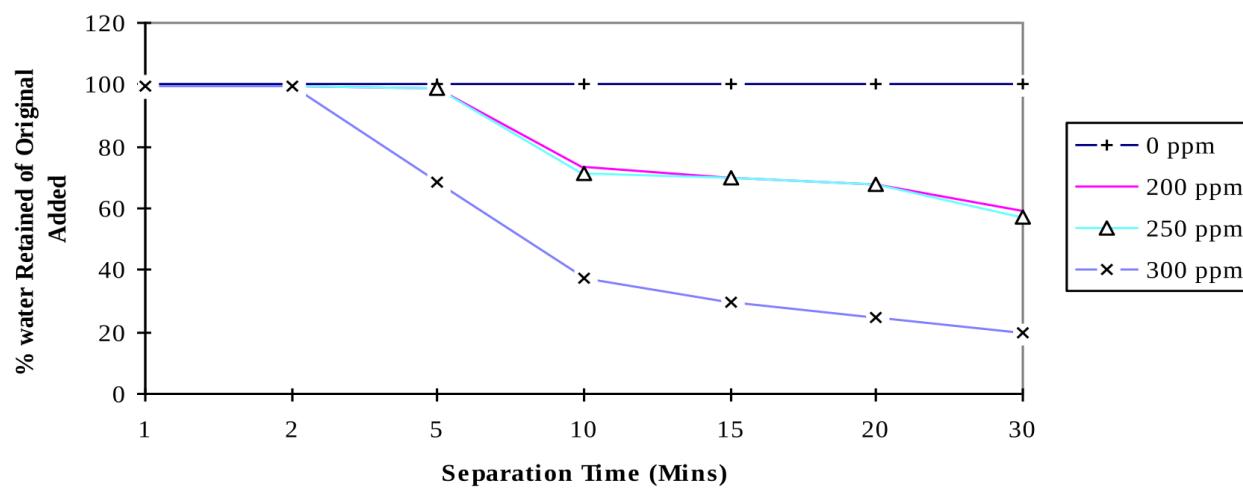
where t is the wall thickness in m, P is the design pressure in bara, S is the allowable stress in N mm⁻² (normally 155 N mm⁻² for carbon steel), E is the joint efficiency (assume $E = 1$), and D is the diameter in m.

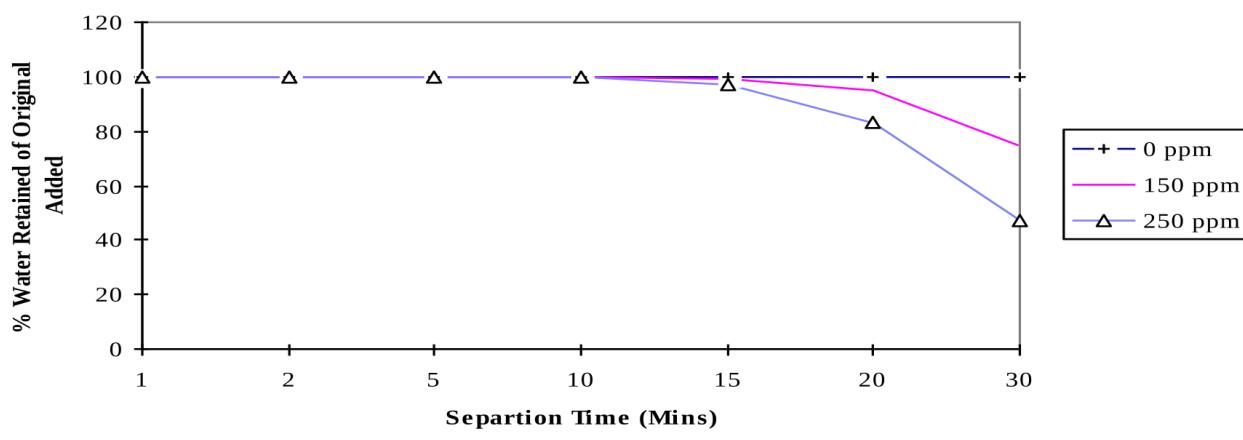
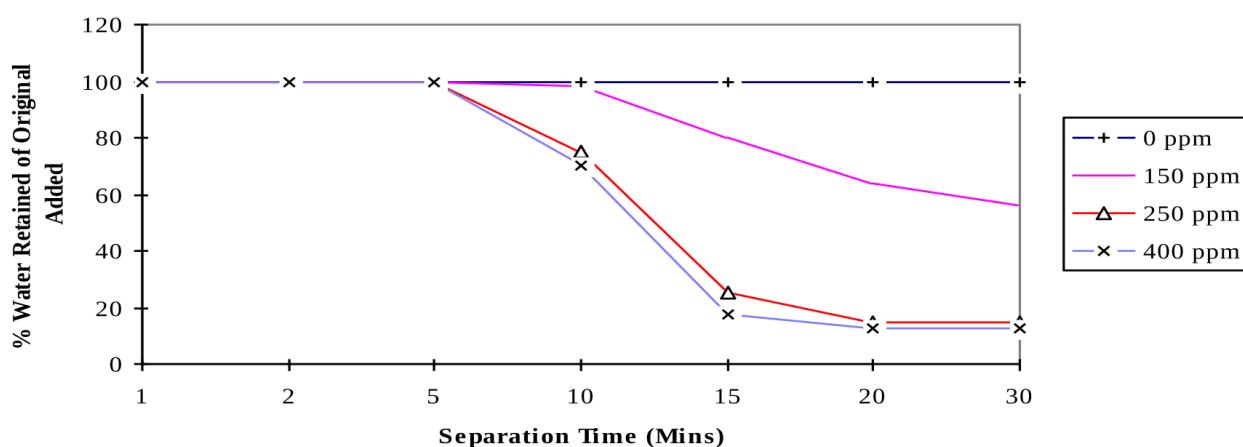
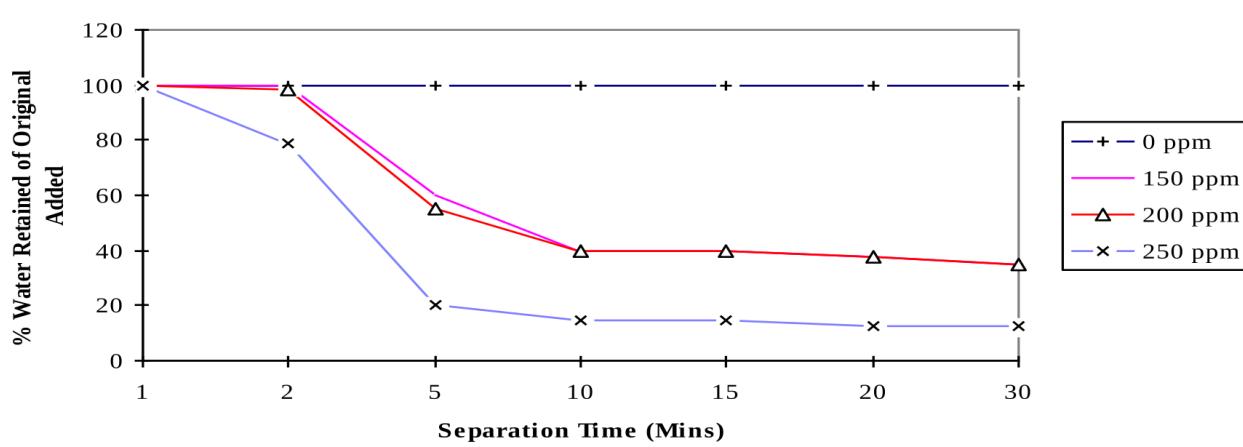
The surface area is given by

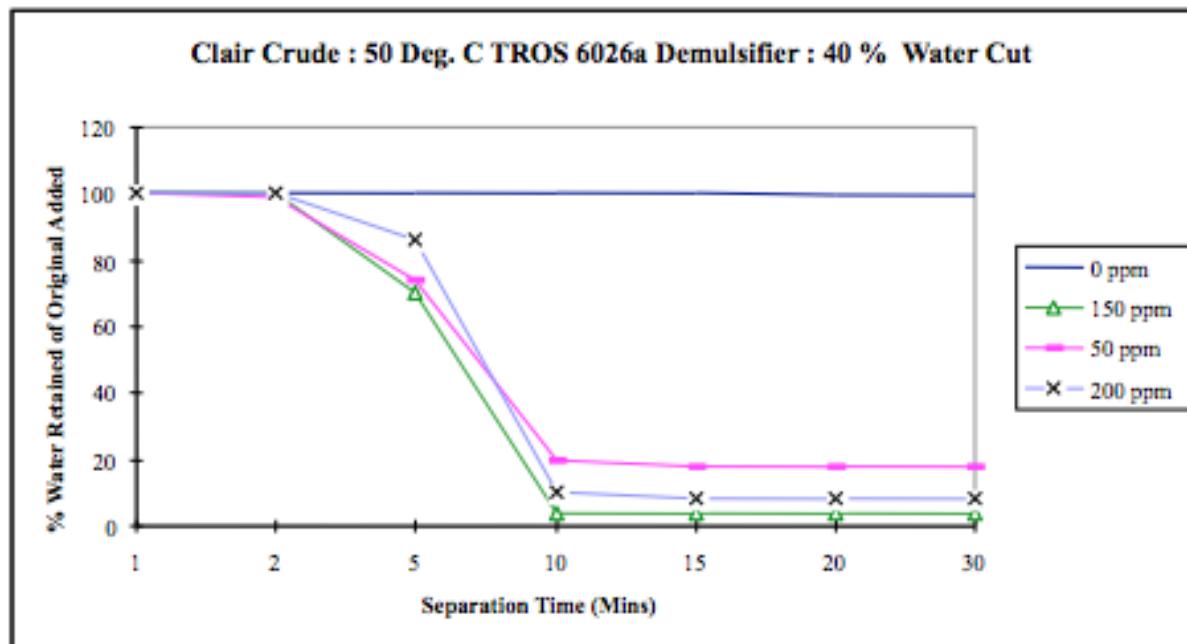
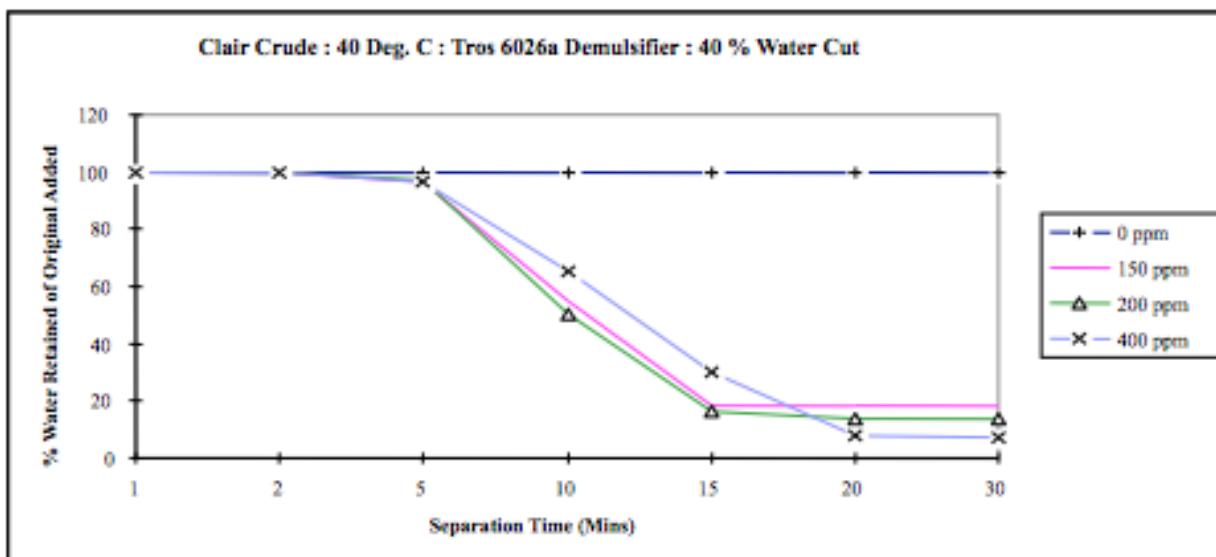
$$A = \pi DL + 0.8\pi D^2 \quad (5)$$

The vessel weight is given by

$$W(\text{kg}) = 8000At \quad (6)$$

Bottle tests**Clair Crude : 40 Deg. C : TROS 6026a Demulsifier : 10% Water Cut****Clair Crude : 50 Deg. C : TROS 6026a Demulsifier : 10 % Water Cut****Clair Crude : 90 Deg. C : TROS 6026a Demulsifier : 10% Water Cut**

Clair Crude : 40 Deg. C : TROS 6026a Demulsifier : 20% Water Cut**Clair Crude : 50 Deg. C : TROS 6026a Demulsifier : 20 % Water Cut****Clair Crude : 90 Deg. C : TROS 6026a Demulsifier : 20% Water Cut**



Equipment list

An equipment list will include a table showing:

- Equipment tag number e.g. V101
- A tag descriptor e.g. HP separator
- Number off - $1 \times 100\%$, $2 \times 50\%$ etc.
- Capacity per item
- Materials of construction
- Operating and design conditions

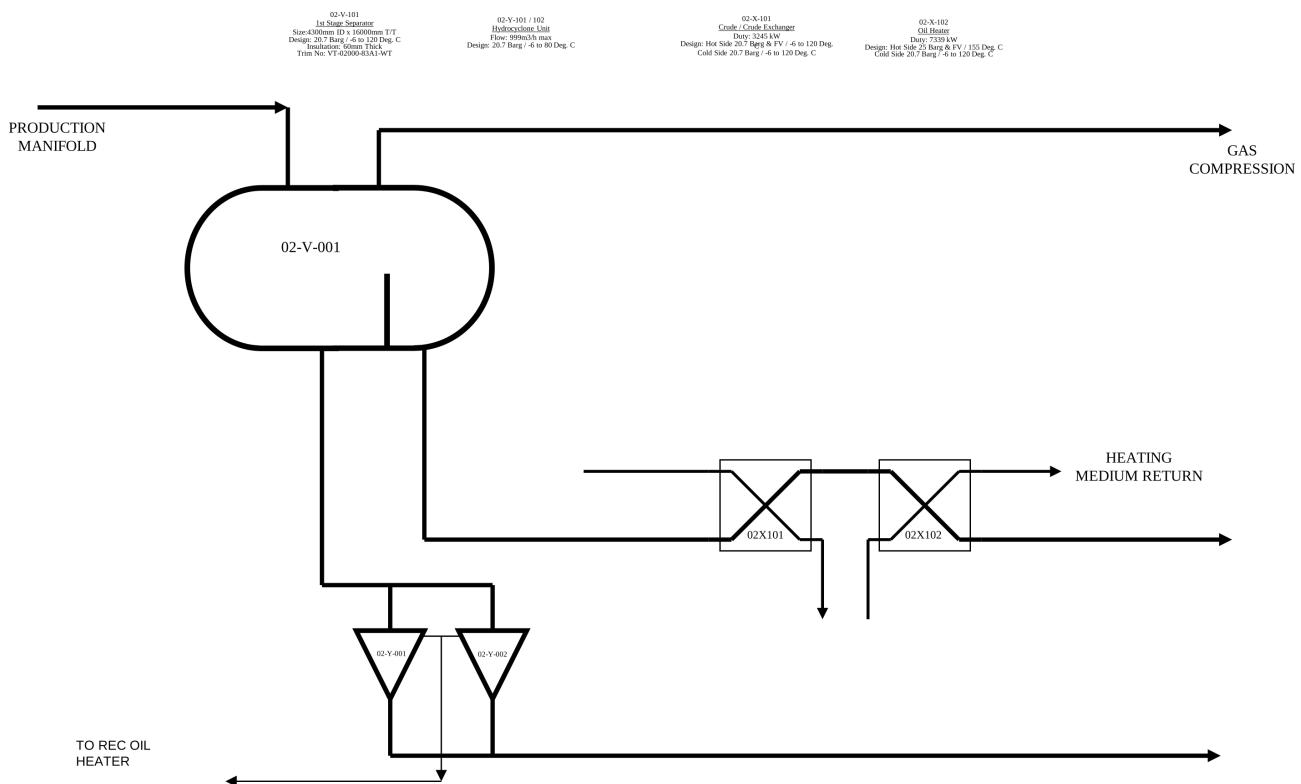
- Electrical load
- Size
- Dry weight
- Operating weight

[Question end]

4 4: Produced water

Question 24

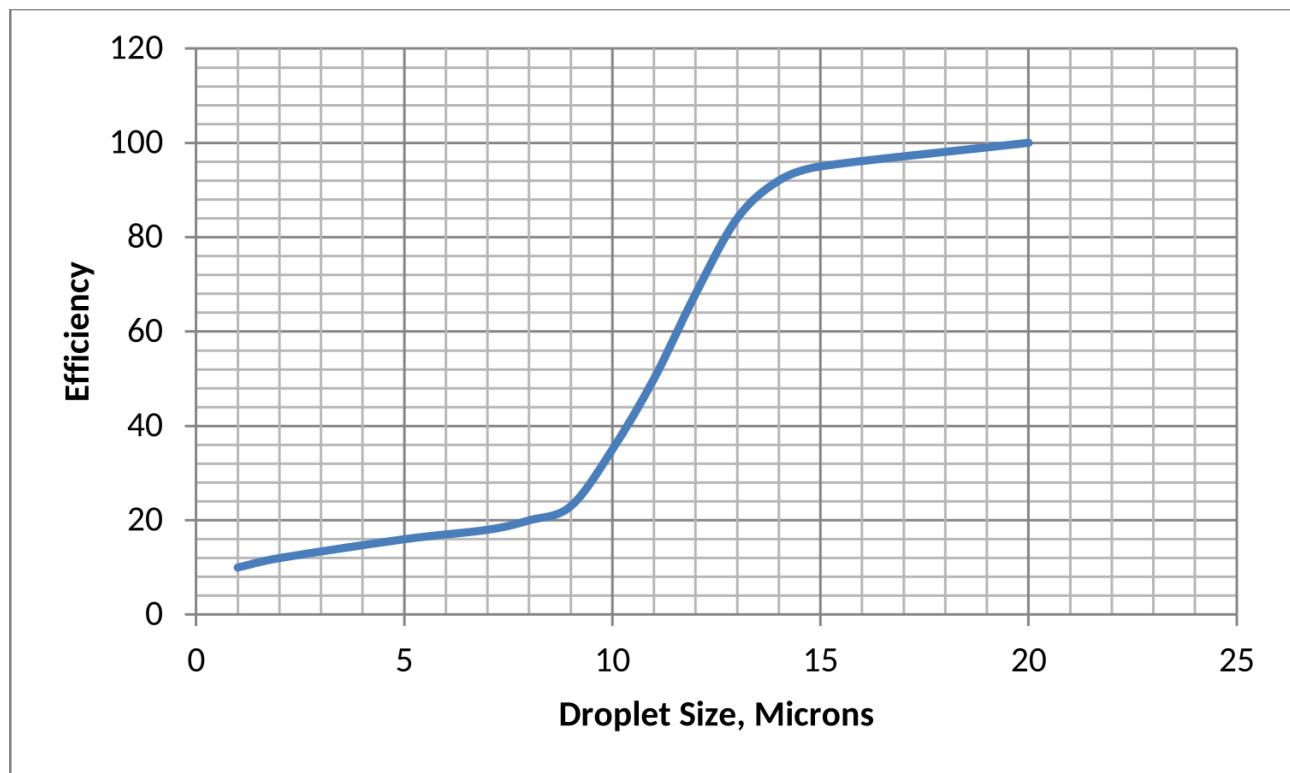
Use the attached PFD of a bare three phase separator and associated hydrocyclone and develop this into a preliminary P&ID. Firstly consider the control system, then the alarm and trips, followed by the safety valves. Finally add in the pipework and valves required for maintenance.



[Question end]

Question 25

A hydrocyclone treating oil in water has the following oil removal characteristics.



The inlet oil concentration is 200 ppm by volume and the oil droplet size distribution entering the hydrocyclone is as follows:

Oil droplet size (micron)	Volume %
< 1	2
2	3
5	4
7	6
8	8
9	8
10	8
11	8
12	9
13	9
14	9
15	10
> 20	16

- Calculate the predicted outlet oil in water concentration. Will this oil concentration be acceptable for overboard disposal?
- Repeat the calculation for the following distribution

Oil droplet size micron	Volume %
< 1	0.5
2	0.5
5	3
7	3
8	4
9	5
10	6
11	10
12	12
13	12
14	12
15	14
> 20	18

[Question end]

Question 26

Review the attached paper. Identify data which could be used to access the accuracy of suitable phase behaviour models. Use this information to investigate the accuracy of a range of phase behaviour models contained within ASPEN HYSYS, UNISIM etc. Identify an appropriate phase behaviour model.

Mutual Solubilities of Benzene and Water

Equilibria in the Two Phase Liquid-Liquid Region

WILLIAM H. THOMPSON and J. ROBERT SNYDER
The Pennsylvania State University, University Park, Pa.

The mutual solubilities in the liquid-liquid benzene-water system were studied from 100 to 460° F. at pressures of 1000 and 5000 p.s.i.g. The densities of the saturated liquid phases were also obtained. The phase-contacting apparatus consisted of an insulated high pressure cell with provisions for heating, pressurizing, sampling, and temperature and pressure measurements. The liquid-liquid system under study was contained in the cell by a moveable piston. Measurement of the piston motion provided data for calculation of density. To avoid emulsification problems, the equilibrium cell was not agitated, which resulted in the use of a lengthy equilibration period (24 hours). The solubility results are generally in good agreement with results that are available from other studies at different pressure and temperature conditions. The densities of the saturated phases are almost identical to pure solvent densities at low temperatures, but differ appreciably at high temperatures where the high solubilities have a strong influence on density.

ALTHOUGH a substantial amount of benzene-water mutual solubility data is available in the literature (1, 3-7, 10-13, 15, 16, 19-22), most of the data are limited to moderate temperatures and pressures, and many of the results are conflicting. This study (23) was undertaken to obtain liquid-liquid mutual solubility data at higher temperatures and pressures (up to 460° F. and 5000 p.s.i.g.), and to lay groundwork for subsequent solubility studies up to the critical solution conditions for the benzene-water system.

APPARATUS

The phase-contacting equipment consisted of a high-pressure cylinder fitted with a moveable piston for confining the benzene-water mixtures, and auxiliaries for sampling, pressure and thermal regulation, and for pressure, volume, and temperature measurement. The assembly is shown diagrammatically in Figure 1 while detailed information is available (23).

Nitrogen was hydraulically compressed in vessel I by fluid supplied from air-driven pump E. The pressure on the nitrogen was transmitted to distilled water (S) and in turn to the piston in equilibrium cell X. Water was employed for pressurizing cell X to avoid the possibility for trace contamination. Pressures were indicated on gages J and U and recorded via pressure transducer V. All gages were calibrated by dead-weight test gage and were accurate to about 25 p.s.i.

Since the equilibrium cell X was a smooth-bore cylinder, differential volumes could be calculated from measurements of the piston movement during sampling. Such measurements were gained from linear-variable-differential transformer Y (18) and machinists gage Z. The volume of a sample was measured to within 0.03 cc. The discharged sample was collected in chilled flask DD and weighed by analytical balance.

MATERIALS

The benzene used in this study was the pure grade (99 mole per cent minimum-purity) supplied by Phillips Petroleum Co. Several samples were analyzed by standard gas chromatographic procedures and found to be essentially

pure, since no other peaks appeared at maximum chromatograph sensitivity. Accordingly, the benzene was not further purified. The water was taken from the laboratory distilled water supply and redistilled in the absence of carbon dioxide in a simple batch still. Both materials were dispensed as required in the investigation from sealed vessels in which a nitrogen atmosphere was maintained.

PROCEDURE

For charging, the equilibrium cell was removed from the phase-contacting equipment, and both closures and the piston were removed. After cleaning the parts and inserting the piston, about 70-ml. each of water and benzene were withdrawn from storage and poured into the sample end of the cell so it was slightly overfilled and some liquid was forced out when the closure was screwed on. The other (pressurizing) end of the cell was filled with distilled water and closed. The charged cell was then installed in the phase-contacting equipment.

After filling surge cell S with distilled water and pressurizing the system to about 200 p.s.i. with nitrogen, the connections on tee W were slightly loosened to bleed out air and leave a continuous water couple between the water-surge cell S and the equilibrium-cell piston. Also, a portion of the charge was bled through the sampling valve to purge gases from the sampling lines.

With the equilibrium cell in the horizontal position, the system was pressurized by admitting nitrogen from cylinder K, and compressing the nitrogen by pumping oil into the system with pump E. During the heating period, the expansion of the cell charge was followed with the volume-measuring equipment to assure free piston motion. In some cases, nitrogen was vented from the system to relieve the pressure increase caused by the charge expansion.

After reaching the operating temperature and pressure, the cell normally remained in the horizontal position without agitation for a minimum of 24 hours. The cell assembly was then gently rotated into the vertical position and normally remained in this position for three hours to assure complete phase separation. With the sampling line and sample flask attached, valve AA was opened slightly and samples were drawn off at a rate less than 3-ml. per minute. The pressure on the piston was held constant

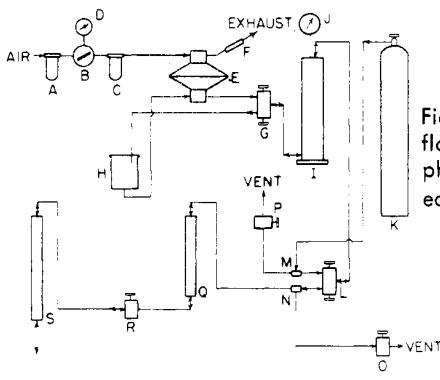


Figure 1. Simplified flow diagram of the phase-contacting equipment

Legend

- A = air filter
- B = air diaphragm valve
- C = air lubricator
- D = air pressure gage, 0–160 p.s.i.
- E = sprague pump
- F = muffler
- G = double valve for hydraulic fluid
- H = hydraulic fluid reservoir
- I = high pressure cell
- J = nitrogen pressure gage, 0–10,000 p.s.i.
- K = nitrogen cylinder
- L = double valve for nitrogen
- M, N = tee
- O, P = let-down valve
- Q = high pressure nitrogen surge cell
- R = valve
- S = high pressure water surge cell
- T = cross
- U = water pressure gage, 0–10,000 p.s.i.
- V = pressure transducer, 0–5,000 p.s.i.
- W = tee
- X = equilibrium cell
- Y = linear variable differential transformer, LVDT
- Z = vernier height gage
- AA = sampling valve
- BB = tee
- CC = thermocouple
- DD = sampling flask

by pump E. With the low sampling rate, enough cooling occurred in the sampling line that very little liquid was flash-vaporized in the Kjeldahl flask, and this small amount was effectively condensed in the bulb of the flask.

A sample of about 20-ml. was taken from both of the liquid phases in each experiment, and the upper, middle (interfacial), and lower portions of the charge were discarded. At the beginning and end of each sample, the vernier height gage reading was taken with the LVDT centered over its core. The difference between these values (the sample displacement) was converted with a calibration factor to give the volume that the sample occupied under the operating conditions.

After the cell charge had been completely withdrawn, valve AA was opened with full pressure on the piston to assure that the seal between the piston and the cell was intact.

ANALYSIS

The benzene-rich phase was analyzed for water by the Fischer method (8) using a potentiometric end-point (2). The sample, which had become heterogeneous after reducing the temperature from the higher equilibrium

value, was made homogeneous by adding a weighed amount of standard water-in-methanol solution. A weighed portion of the liquid was analyzed, and the solubility was calculated with an allowance for the water added in the methanol standard solution.

The water-rich phase was analyzed for benzene by slowly vaporizing the sample into a purified air stream, passing the vapors over copper oxide at 1450–1500° F., absorbing the resulting carbon dioxide in a known volume of standard sodium hydroxide solution, and determining the amount of sodium hydroxide that was not used to react with the carbon dioxide. The determination of unreacted sodium hydroxide was made by titrating with standard hydrochloric acid after precipitating the carbonates with excess barium chloride.

For both phases, the filled and empty sample flasks were weighed on an analytical balance to give the total sample weight by difference. Phase densities were then calculated using the sample volumes determined earlier.

Calibration of Cell Volume. The volume of the cell was calibrated by charging the cell with pure degassed water, and drawing off samples at various temperatures and pressures. The piston displacement for each sample was obtained by the difference between the height gage readings. After smoothing the experimental results to even temperature, the corresponding volumes were calculated from the weights of the water samples using specific volume data from Keenan and Keyes (14). In this way, conversion factors (cc. per linear inch of cell) for use in determining sample volumes were obtained that are functions of both temperature and pressure.

Equilibration. This work differs from almost all previous high-temperature solubility studies in that no agitation was used to help establish equilibrium rapidly. Here, agitation was avoided to preclude emulsion formation which could become a problem in subsequent work at temperatures nearer the critical solution temperature. In this study, the solute diffused through a solvent layer that remained stagnant after the initial heating period was completed. However, during the equilibration period, the cell was horizontal to provide a maximum interfacial area and minimum diffusive distance.

The approach to equilibrium in 24 hours for the dilute solutions was calculated for 100° F. using Fick's law and estimated (24) diffusivities. The boundary conditions used in the diffusion equation were: the solvent is uniformly saturated with solute after an infinitely long contact period; the solvent is always saturated with solute at the interface; the initial solute concentration in the solvent is zero; and the concentration gradient is always zero at the cell wall furthest from the interface. At 100° F., the diffusivity of benzene in water was taken as 6×10^{-5} ft.² per hr; and that of water in benzene, 3×10^{-4} . A rectangular cross-section was chosen to simplify the calculations. It was found that the approach to equilibrium in 24 hours was more than 99.9 per cent for the water diffusing into the benzene, and about 92 per cent for the benzene in water. This predicted approach to equilibrium for benzene in water would be unacceptable if it did not represent the limiting minimum approach. However, in practice, such factors as thermal agitation during heating and enhanced diffusivities at elevated temperatures result in considerably higher rates of mass transfer.

A series of experiments was performed at 100° F. which verified that equilibrium was established in 24 hours. The results for benzene dissolved in water are illustrated in Figure 2, and a similar pattern was found for water dissolved in benzene.

EXPERIMENTAL RESULTS

The experimental solubility and density results of this study are listed in Table I, and the smoothed results in

Table II. As indicated by asterisks, some data were discarded. Most of these poor results accumulated in the early developmental stages of the study due to poor sampling equipment and techniques. After reducing the sampling line volume and decreasing the sampling rate, both phases were successfully sampled without entraining a portion of the other liquid phase.

The solubility data are plotted on Figures 3 and 4. The water solubility line passes through all the experimental points for 1000 p.s.i.g., as does the benzene solubility curve at 5000 p.s.i.g. Although the points for water solubility at 5000 p.s.i.g. are scattered slightly, a line is well-defined. At 400° F., the line begins curving sharply as the critical solution temperature is approached. The worst data were obtained for the water phase at 1000 p.s.i.g. Since most of the 340 and 400° F. points were known to be high as a result of difficulties with irregularly high analytical blanks, the curve was drawn below them. The 5000 p.s.i.g. behavior was influential when drawing the 1000 p.s.i.g. curve.

Compared with solubility, the density data are scattered. However, although the results appear worse on the expanded scales of Figures 5 and 6, the average deviation of the points from the curve is less than one per cent of the density. In view of the secondary nature of these data, the reproducibility is considered satisfactory.

COMPARISON OF SOLUBILITY RESULTS

Both liquid phases of the benzene-water system have been extensively studied at low temperatures by other investigators, and results at higher temperatures are available for the water phase. The results of this study are compared with the literature data in Figures 3 and 4.

In the benzene phase, the logarithm of solubility was found to be linear with reciprocal temperature which is typical for the solubility of water in hydrocarbons. An increase in pressure results in a uniform decrease in solubility such that the 5000 p.s.i.g. isobar is below and about parallel to the 1000 p.s.i.g. isobar. By extrapolation, the atmospheric pressure isobar should be parallel to this work, but at higher solubilities. This is in agreement with the results of Stavely, Jeffes, and Moy (20). The solubilities of Groschuff (10) and Hill (12) are also higher and almost parallel. Although the other data that are shown in Figure 3 do not correspond exactly, the over-all agreement of the results of this study with those of others is considered excellent for the benzene phase.

Typical temperature behavior for hydrocarbons was also observed in the water phase, where a 4000-p.s.i. pressure increase was found to cause a large increase in solubility. A proportionate change should be observed between this 1000-p.s.i.g. work and the low pressure work of others, but the change is very small. Nevertheless, if the two

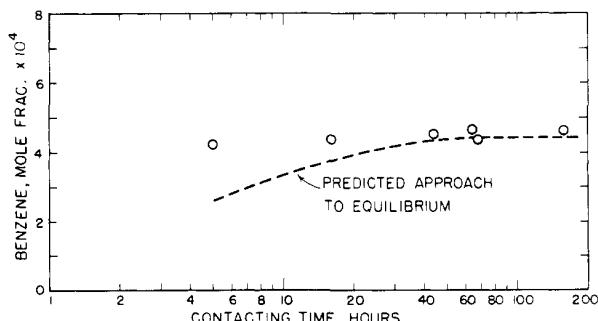


Figure 2. Benzene dissolved in water at 100° F. and 1000 p.s.i.g. as a function of contacting time

Table I. Experimental Solubility and Density Results

Temp., °F.	Benzene Phase		Water Phase	
	Water concn., mole frac. × 10 ⁴	Density, g./cc.	Benzene concn., mole frac. × 10 ⁴	Density, g./cc.
1000 P.S.I.G.				
100.3	48.7	0.865	4.34	0.993
100.1	46.6	0.861	4.54	0.992
99.9	41.6	0.856	4.33	0.994
99.9	41.8	0.858	4.61	0.991
101.5	43.3	0.859
101.0	42.1	0.856	4.60	0.992
160.3	124	0.816	6.63	0.975
219.0	274	0.779	8.56	0.952
218.0	9.84	0.941
280.0	558.	0.761	*	0.913
280.3	14.3	0.920
281.0	18.6	0.922
340.0	1000	0.673	44.2†	0.859
339.3	*	0.686	42.7†	0.905
339.3	...	0.680	41.6†	0.854
340.3	46.5†	0.879
341.0	36.0†	0.878
397.3	1770	0.641
396.3	85.3	0.815
399.7	*	0.575	81.0	0.830
398.0	...	0.582	94.2†	0.838
399.0	72.6	0.837
5000 P.S.I.G.				
100.3	38.1	0.885	5.61	1.005
161.0	105	0.848	*	0.988
159.7	*	0.851	8.95	0.987
160.3	110	0.850
219.7	*	0.812	14.1	0.966
220.7	263	0.820	...	0.961
279.3	505	0.781	22.8	0.922
339.3	959	0.753	43.1	0.897
400.7	1530	0.713	98.3	0.867
460.7	4320	0.660	265	0.787
459.7	4600	0.664	248	0.790

* = No analysis was performed. † = Discarded data. ‡ = Results known to be high due to a high analytical blank.

100° F. points from this study were very slightly higher, the agreement with other low-temperature data would be excellent.

The high-temperature solubility results of Jaeger (13) required conversions and corrections for comparison with the solubilities from this study. In his pioneer work, Jaeger analyzed by simply measuring the volumes which separated after cooling the samples to room temperature. Accordingly room-temperature density data were used to convert the solubility results from the reported volumetric units. In addition, since Jaeger incorrectly assumed that the solubility of benzene in water at room temperature was negligible, 4×10^{-4} mole fraction units were added to each experimental solubility.

Since the pressure for the work of Jaeger increased with temperature, the results should converge on this work until intersection occurs with the 1000-p.s.i.g. curve at about 460° F. This behavior is not observed. Jaeger's results are lower than the results of this work for all temperatures. However, Jaeger's results for the xylenes are almost identically low when compared with the data of Pryor and Jentoft (17). Similar departures are observed in comparing the toluene data with that of Bohon and Claussen (6). Apparently, the 10-minute equilibration period used by Jaeger did not produce an equilibrium system.

The two isobars that were plotted in Figure 4 from the smoothed results of Kudchadker and McKetta (15) do not agree with this work or the work of others. These two isobars (for 60 and 450 p.s.i.a) indicate very unusual tem-

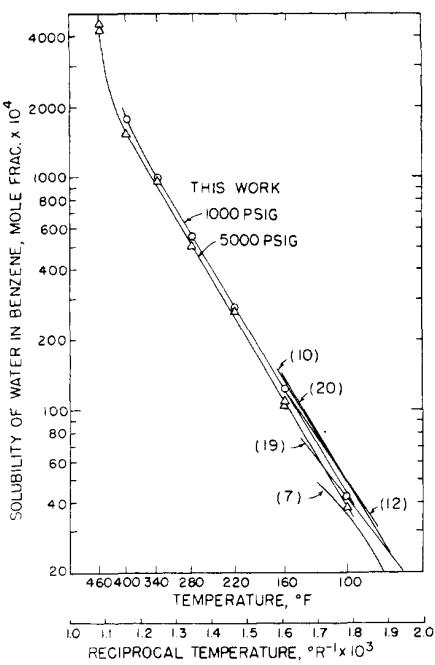


Figure 3. Solubility of water in benzene
The following work of others was performed at one atmosphere pressure or less: Clifford (7), Groschuff (10), Hill (12), Rosenbaum and Walton (19), and Stavely, Jeffes, and Moy (20).

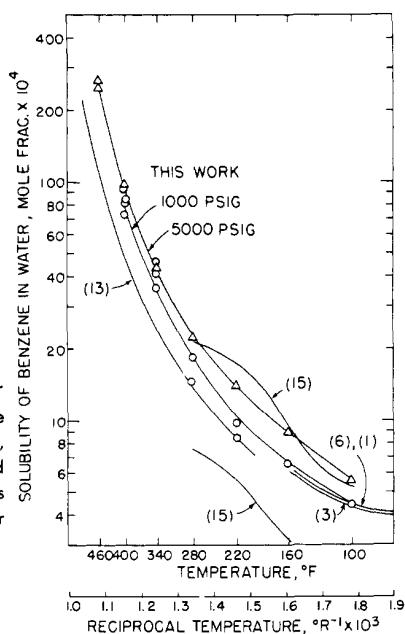


Figure 4. Solubility of benzene in water
The following work of others was performed at the vapor pressure of the system: Alexander (1), Arnold et al. (3), Bohon and Claussen (6), and Jaeger (13). Two curves are shown for the results of Kudchadker and McKetta (15), the upper for 450 p.s.i.a., and the lower, 60 p.s.i.a.

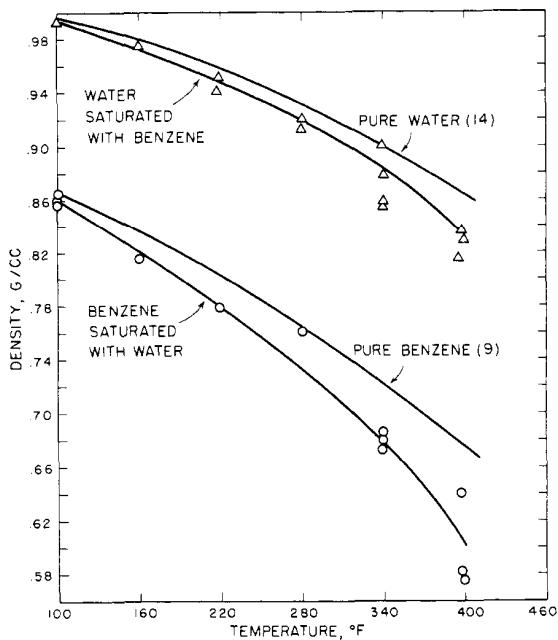


Figure 5. Density of the saturated liquid phases at 1000 p.s.i.g.

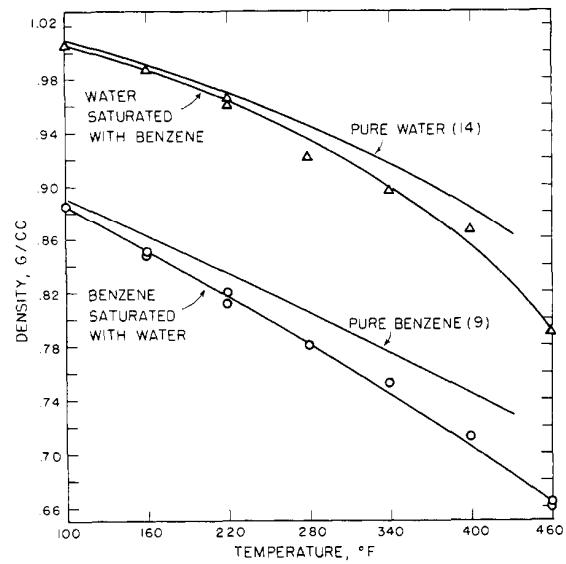


Figure 6. Density of the saturated liquid phases at 5000 p.s.i.g.

Table II. Experimental Solubility and Density Results

Temp., °F.	Benzene Phase			Water Phase				
	Mole frac. × 10 ⁴	Wt. frac. × 10 ⁴	Moles/liter	Density, g./cc.	Mole frac. × 10 ⁴	Wt. frac. × 10 ⁴	Moles/liter	Density, g./cc.
1000 P.S.I.G.								
100	42.3	9.78	0.0467	0.860	4.46	19.3	0.0246	0.993
160	121	28.2	0.129	0.821	6.65	28.8	0.0360	0.972
220	274	64.5	0.279	0.779	10.1	43.6	0.0530	0.948
280	558	134	0.544	0.732	18.6	80.1	0.0942	0.919
340	1000	250	0.944	0.679	36.0	154	0.174	0.881
400	1780	475	1.58	0.601	82.0	346	0.369	0.831
5000 P.S.I.G.								
100	38.1	8.80	0.0432	0.885	5.61	24.3	0.312	1.005
160	106	24.6	0.116	0.851	9.05	39.2	0.495	0.987
220	245	57.5	0.261	0.817	14.1	60.8	0.0751	0.965
280	500	120	0.520	0.781	22.8	98.0	0.117	0.935
340	905	224	0.927	0.745	43.0	184	0.211	0.899
400	1620	445	1.74	0.706	98.0	411	0.449	0.855
460	4500	1590	5.83	0.663	255	1020	1.03	0.791

perature behavior as well as a very strong influence of pressure on solubility. The smoothed atmospheric pressure results were so low that they could not be plotted on Figure 4.

The density results are compared with data for the pure solvents in Figures 5 and 6. As shown, at low temperatures, the small amount of dissolved solute causes a small decrease in solvent density. As temperature increases, solubility increases, and the density departure becomes larger.

ACKNOWLEDGMENT

Acknowledgment is made to the donors of the Petroleum Research Fund, administered by the American Chemical Society, for support of this research.

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Kinematic Viscosity of Liquid Rubidium from 67° to 688° C.

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The kinematic viscosity of pure rubidium was measured from 67° to 688° C. in an all-metal capillary viscometer. The calibration of the apparatus without the use of a reference fluid is described, and experimental results are compared with low-temperature data for rubidium and with data for potassium and sodium. The correlated kinematic viscosity of rubidium, in centistokes, may be expressed in terms of temperature, in degrees Kelvin, as: $\log (\mu/\rho) = 250/T - 1.15$.

THE ANTICIPATED USE of alkali metals as working fluids, heat transfer media, and lubricants in high-temperature energy-conversion systems has spurred considerable research on the thermophysical properties of these fluids. However, there are still many areas in which reliable data are meager or lacking. Experimental measurement of liquid alkali-metal viscosity is in progress in several laboratories, and new experimental data have been reported recently for potassium (17). The viscosities of cesium, potassium, sodium, and lithium have been measured at temperatures as high as 1150° C. (for potassium) by damped torsional oscillation methods (1, 2, 8, 9, 17), and that of sodium has been determined to 600° C. by capillary viscometry (4, 5). On the other hand, the experimental viscosity of rubidium has not been reported for temperatures above 220° C.

As part of an Air Force sponsored research program on the influence of contaminants in liquid alkali-metal systems, an all-metal capillary viscometer has been developed in this laboratory. Extensive viscosity measurements have been made on pure rubidium from 67° to 688° C., and it is the purpose of this paper to present the resulting experimental kinematic viscosity data.

EXPERIMENTAL APPARATUS AND MATERIALS

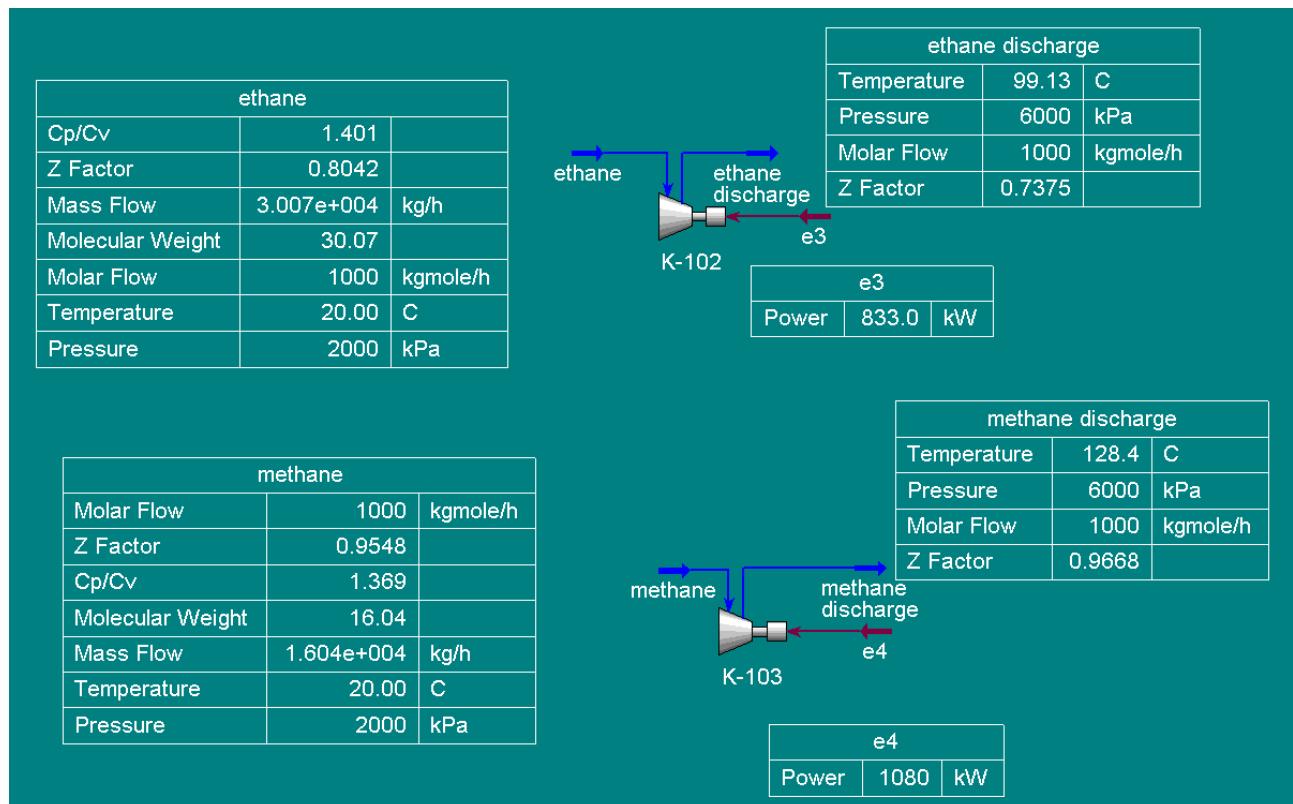
Rubidium Samples. Two batches of pure rubidium were obtained commercially for use in this program. Cesium represented the major impurity in each batch, being present to the extent of 0.4 and 0.02 wt. per cent, respectively. The rubidium was analyzed for trace metal constituents by emission spectroscopy; for alkali metals

[Question end]

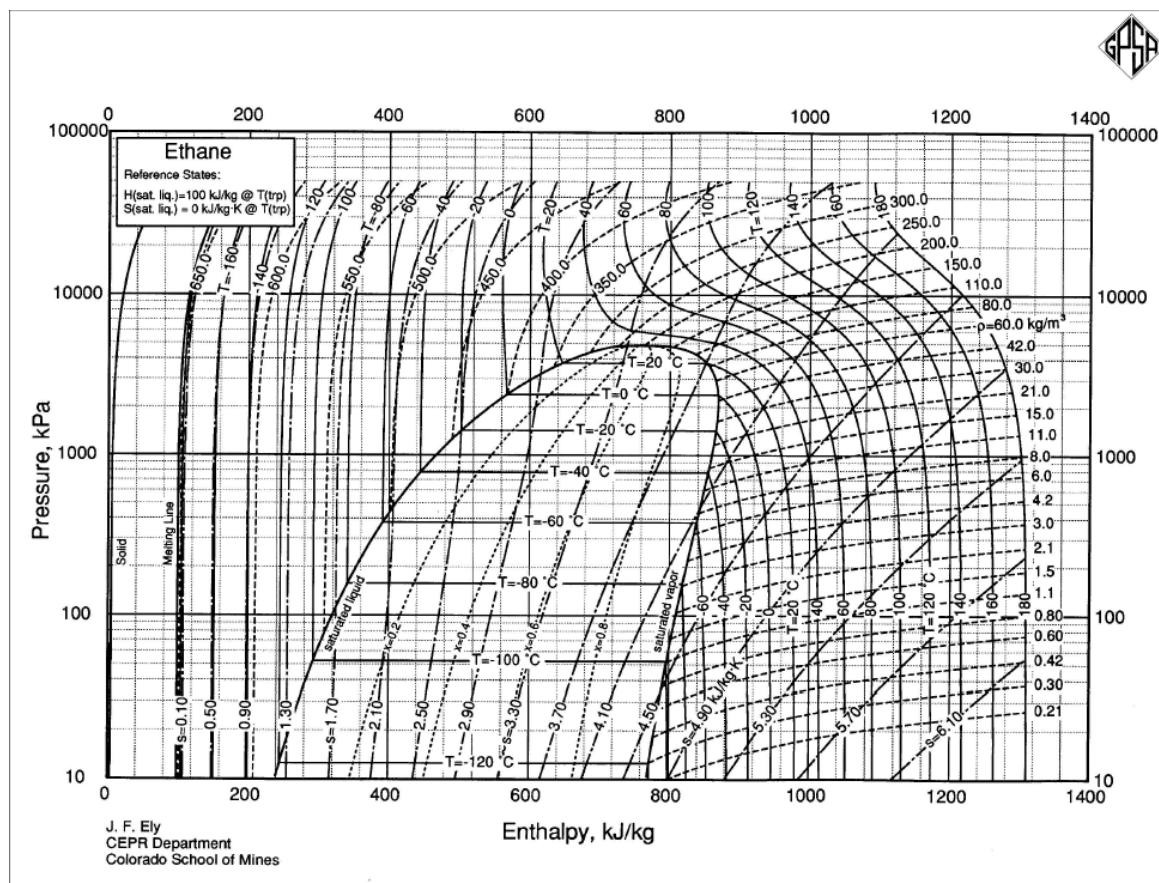
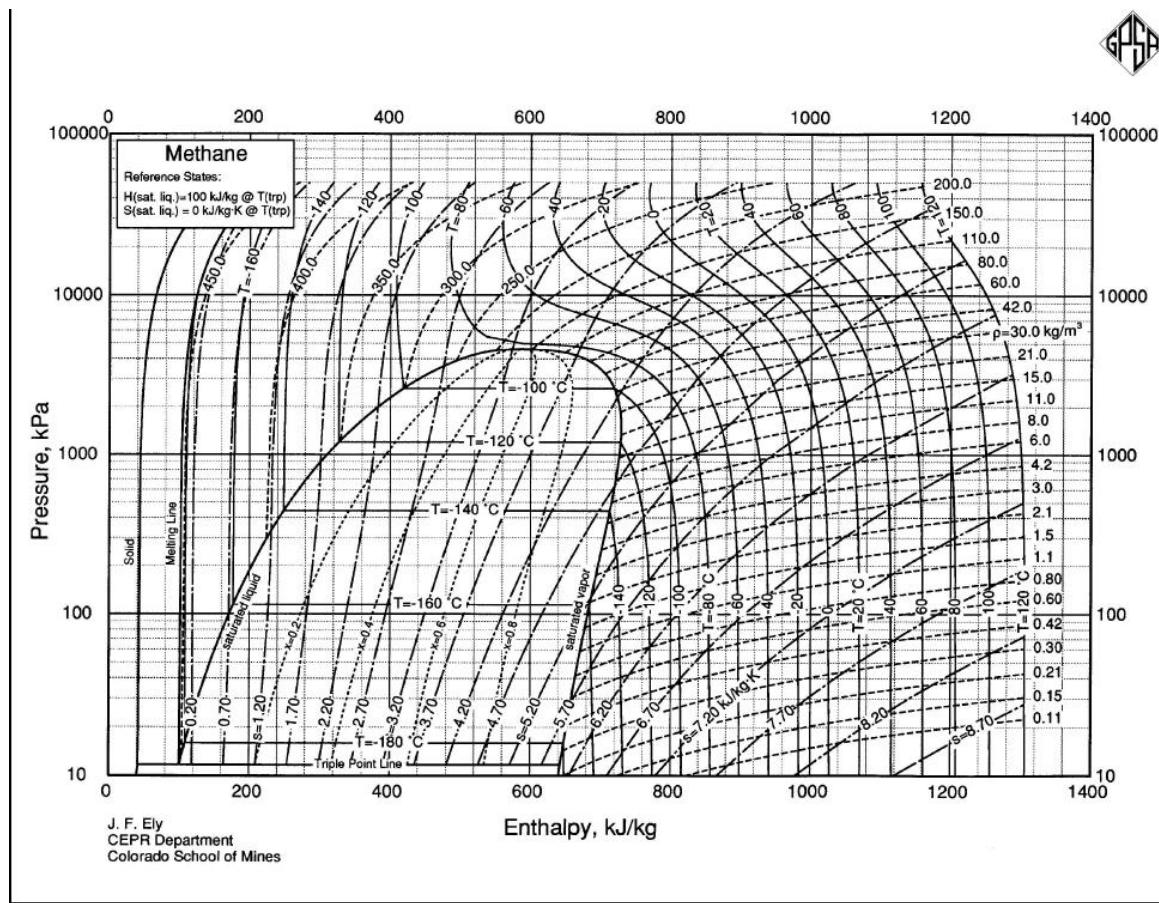
5 5: Gas compression

Question 27

The following simulation has been run on UNISIM. Represented are two compressors, one handling 100 % ethane and the other 100% methane. The polytropic efficiency is 77.5% for both compressors.



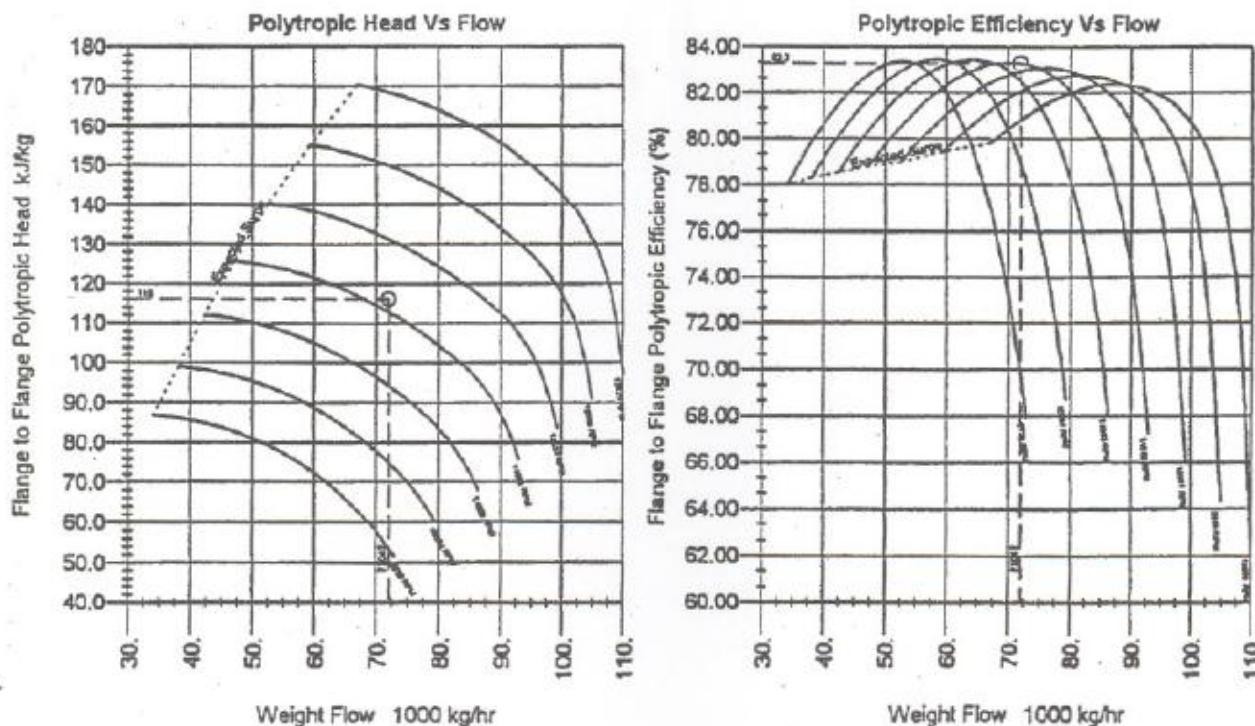
- Build the same model in UNISIM, ASPEN HYSYS etc.
- Compare the UNISIM predicted power and the compressor outlet temperature with that using the polytropic head approach given in the lecture notes. Do not use the UNISIM C_p/C_V - source the values from literature.
- If the methane compressor outlet temperature rises to 160 °C, what efficiency change would have caused this?
- Predict the power requirements using the attached Mollier charts. Show the compressor path.



[Question end]

Question 28

A compressor has the following performance curves.



- Using the polytropic head expression, what will be the discharge pressure for the following conditions:
 - Suction pressure = 10 bara
 - Suction temperature = 30 °C
 - Molecular weight = 22.6
 - Z = 0.97
 - $C_p/C_V = 1.25$

Use the design point shown on the curves.

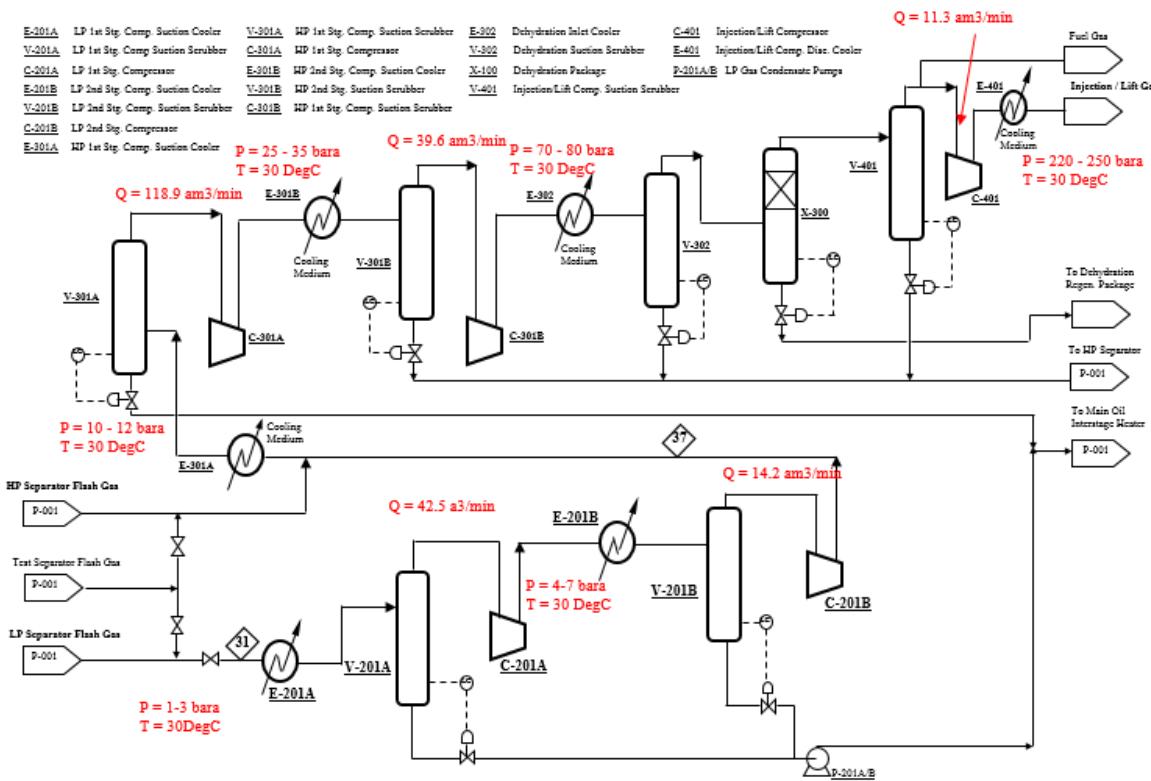
- How could you reduce the power requirement (enthalpy change) for the same fluid with the same compression ratio?
- Using the variable you have identified to reduce the enthalpy change, what new value would you change it to in order to reduce the enthalpy change by 5 %?

[Question end]

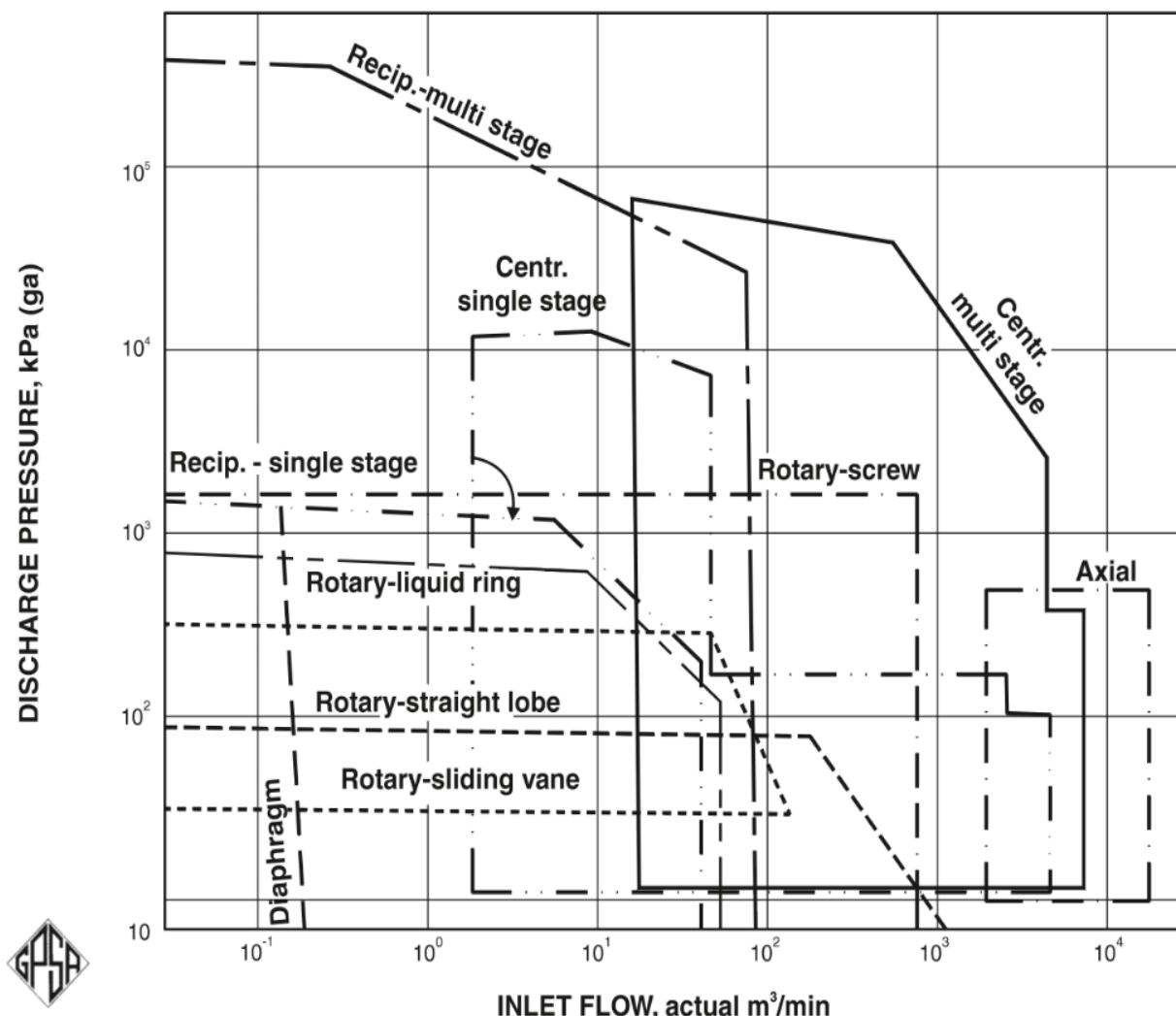
Question 29

The attached PFD shows a compression train.

Gas Plant PFD



Overlaid on to it are the compressor inlet flow rates as well as the compressor outlet conditions. Use this information and the compressor selection map to identify compressor types for the various duties.



[Question end]

Question 30

5: Gas compression

- Name and briefly describe four types of compressors including a description of their operating principles. [8 marks]
- Sketch a typical head flow characteristic for a centrifugal compressor. Indicate the effect of varying the compressor speed and the surge limit. [4 marks]
- A centrifugal gas compressor is operating with the following inlet and outlet conditions:
 - Inlet pressure, $p_1 = 10$ bara.
 - Outlet pressure, $p_2 = 30$ bara.
 - Inlet temperature, $T_1 = 30^\circ\text{C}$.
 - Outlet temperature, $T_2 = 110^\circ\text{C}$.

After a process upset the compressor achieves the same outlet pressure but the outlet temperature of the compressor is seen to rise by 5°C. It is suspected that the machine is losing polytropic efficiency. Calculate the percentage change in the compressor efficiency from before to after the upset.

The compression relationship is as follows;

$$T_2 = T_1 \left(\frac{p_2}{p_1} \right)^{\frac{n-1}{n}} \quad \frac{n-1}{n} = \frac{k-1}{k \eta_{poly}}$$

where k is the ratio of specific heats for the gas and η_{poly} is the compressor polytropic efficiency. [8 marks]

[Question total: 20 marks]

6 6: Gas treatment

Question 31

- a) **3: Separators** Stokes law is given by,

$$V_{settle} = \frac{d^2(\rho_w - \rho_o)g}{18\mu}$$

For a system with water droplets separating from a continuous oil phase, name the variables in the equation. [2 marks]

- b) **3: Separators**

An oil, gas, water separator is producing an oil product which meets the required water specification. The oil density is 750 kg m^{-3} and its viscosity is 1 cp while the water density is 1000 kg m^{-3} . As a result of introducing a new oilfield, the oil density and viscosity increase to 850 kg m^{-3} and 1.5 cp respectively. Assuming the droplet size distribution of water in oil stays the same, what percentage change would be required to the oil residence time to achieve the same water specification? [5 marks]

- c) **4: Produced Water**

A hydrocyclone is used to remove oil droplets from a continuous water phase. Describe the operating principles of a hydrocyclone. [6 marks]

- d) **5: Gas Compression**

In order to obtain increased discharge pressure from a centrifugal compressor it has been proposed to run the machine at reduced throughput. Why would a reduced throughput result in an increased discharge pressure? What machine characteristic would you check before agreeing to conduct a reduced throughput trial? Why is this characteristic a concern? [3 marks]

- e) **6: Gas Treatment - refrigeration**

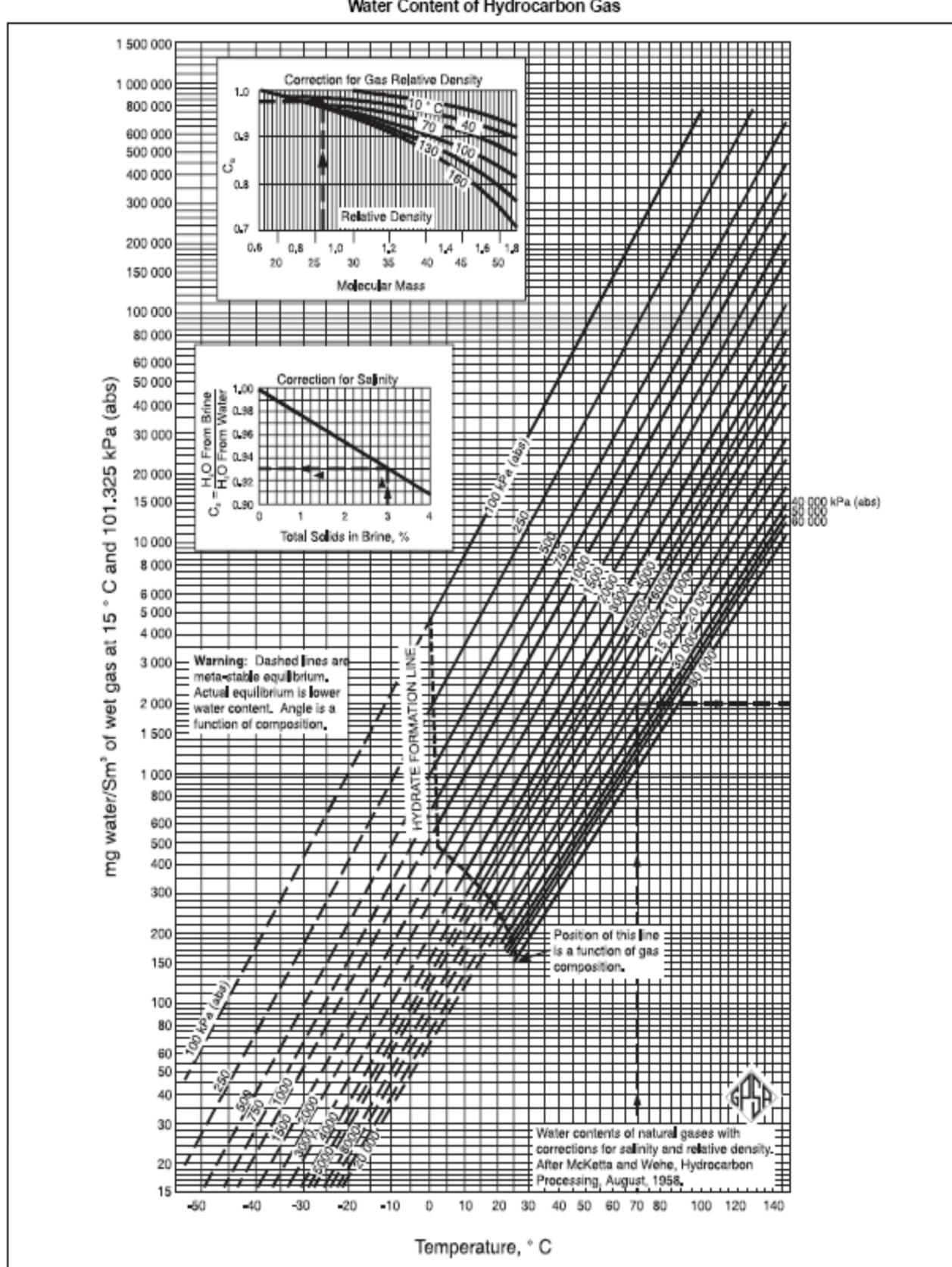
In order to recover additional hydrocarbon liquids from a gas stream, a refrigeration plant is often utilised to cool the fluid below that possible by air or cooling water. Describe a typical refrigeration cycle. A sketch may help. [4 marks]

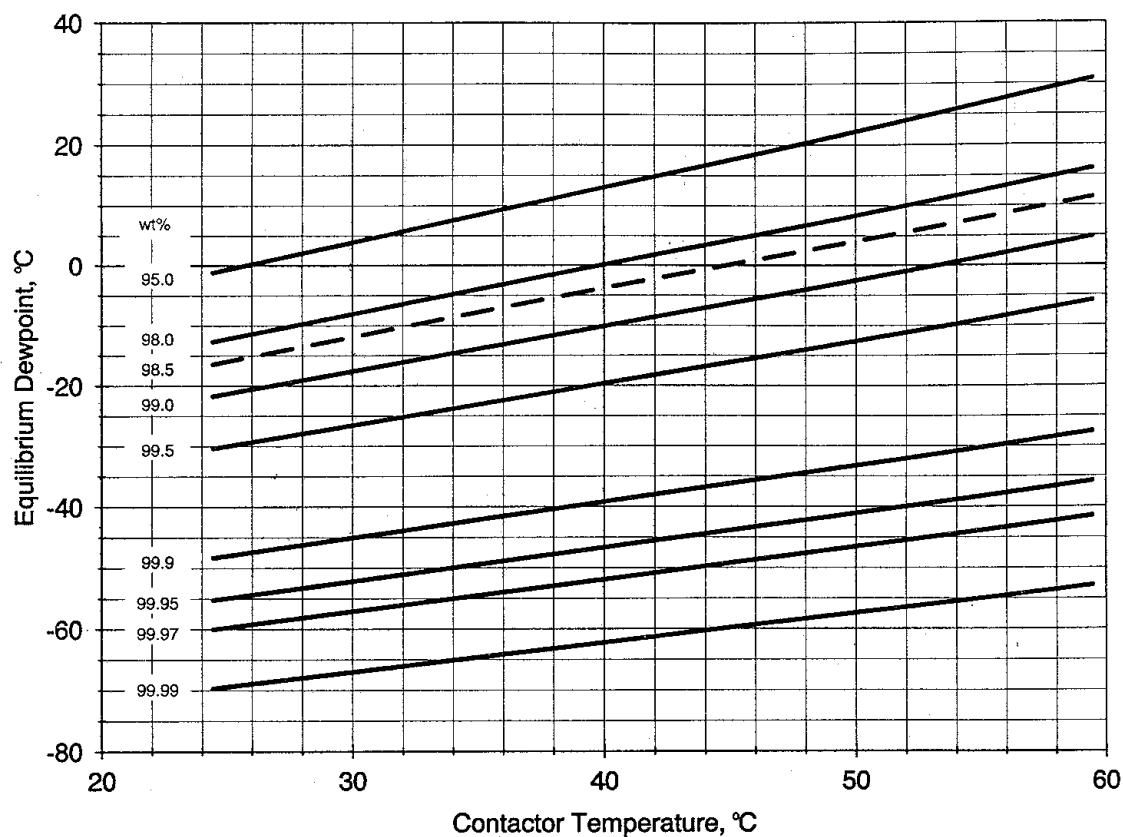
[Question total: 20 marks]

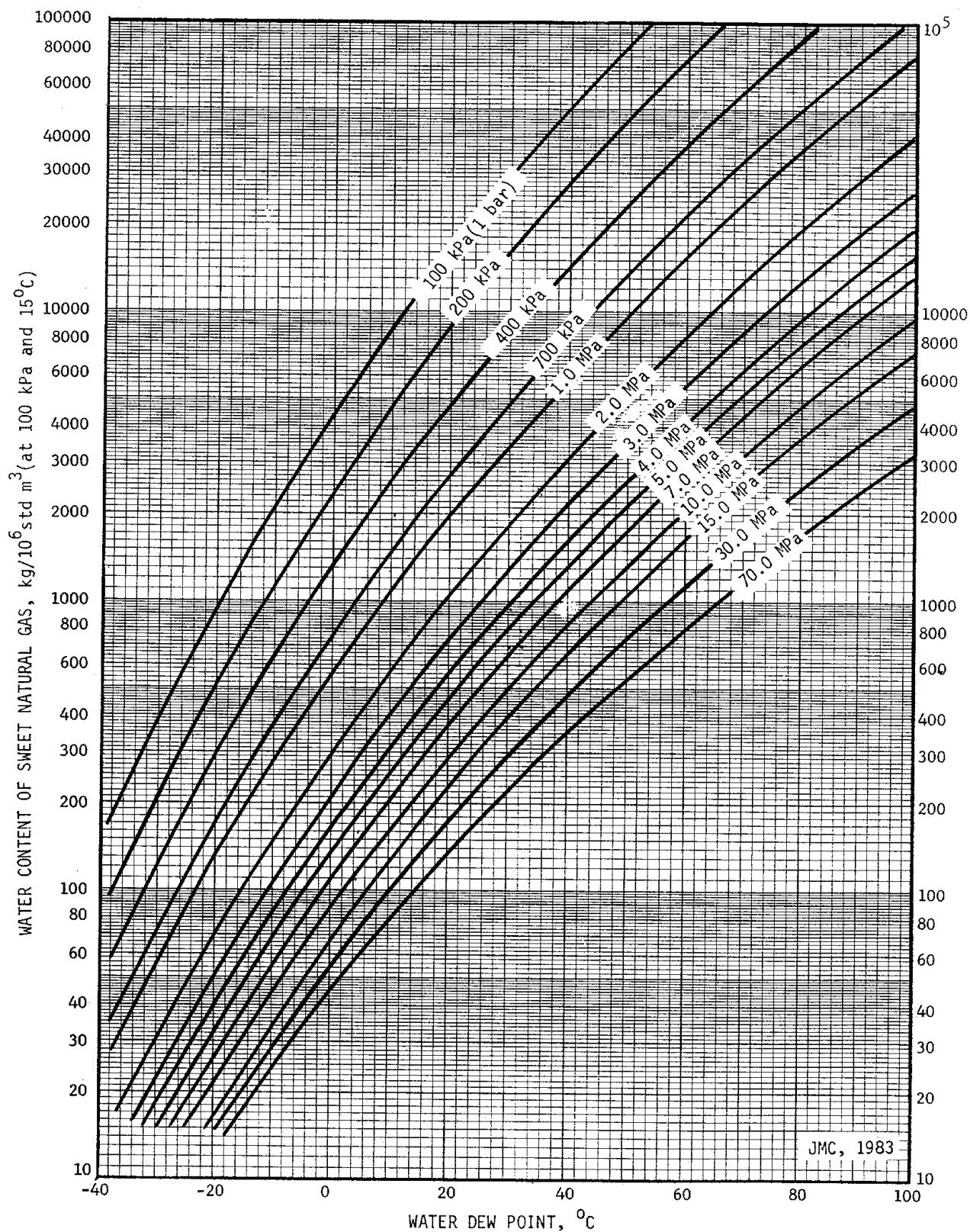
Question 32

Water saturated methane gas enters a tri-ethylene glycol counter-flow absorber at 30 °C and 50 bara. The duty of the absorber is to dry the gas to a specification of 100 mg H₂O sm⁻³. The flowrate of the gas is 5×10^6 sm³ day⁻¹. Calculate the number of theoretical and actual plates required to achieve the above duty. Use the enclosed water saturation and glycol-water dewpoint equilibrium charts for your calculations. Use the guidance for lean glycol rate and concentration in the lecture notes.

Assume that the column pressure drop is negligible and that the column operates isothermally. Plate efficiencies can be taken as 50 %. Assume a TEG density of 1110 kg m⁻³.



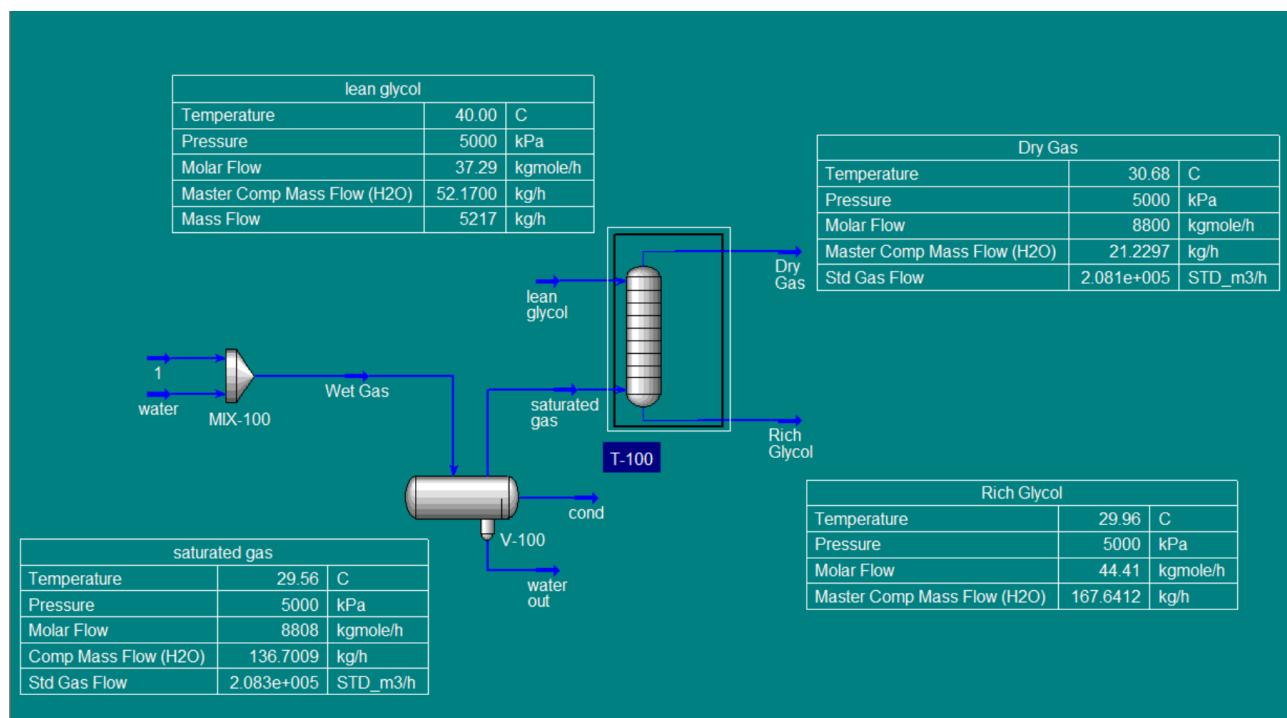




[Question end]

Question 33

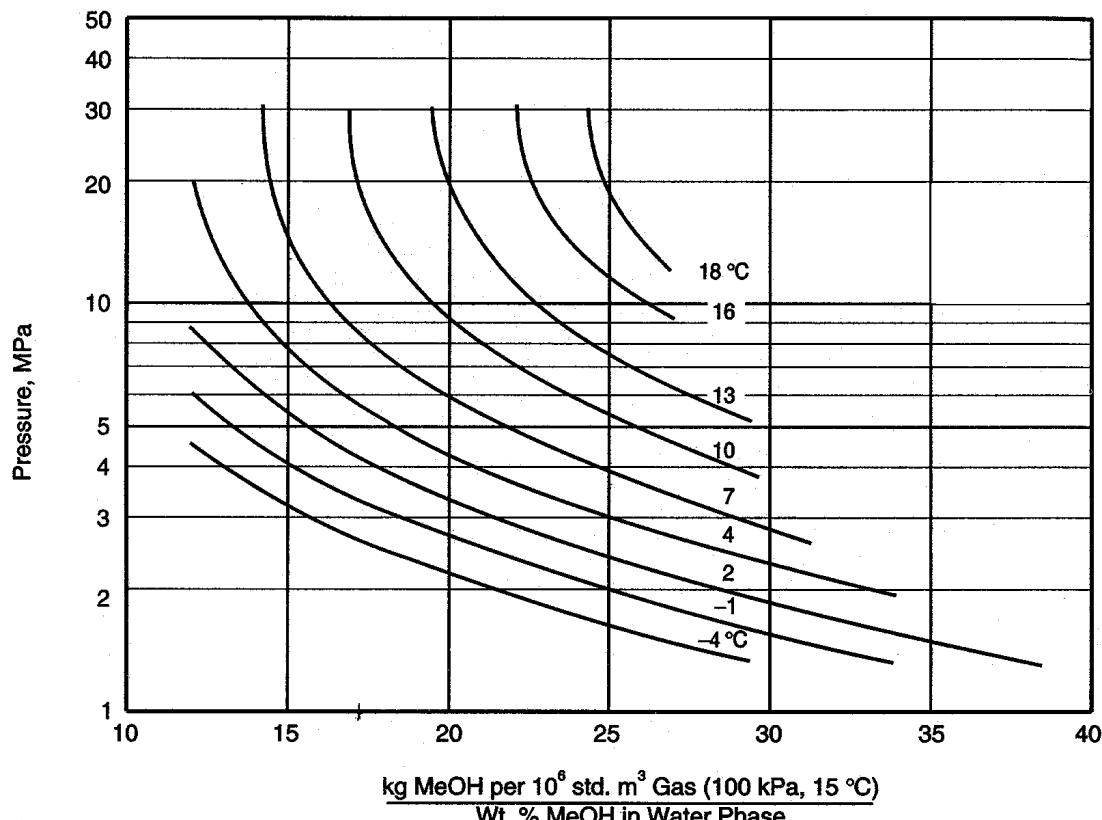
Build a glycol model on UNISIM, ASPEN HYSYS, etc. with the following conditions and compare the answers.



[Question end]

Question 34

10 MMscfd ($2.83 \times 10^5 \text{ std m}^3 \text{ day}^{-1}$) of natural gas ($\gamma = 0.65$) having a hydrate formation temperature of 17°C cools to 4.4°C in a buried pipeline (pressure is 8 MPa). To avoid hydrate formation, how much methanol ($\rho = 800 \text{ kg m}^{-3}$, MW = 32) must be added if the gas enters the line saturated with water at 30°C .

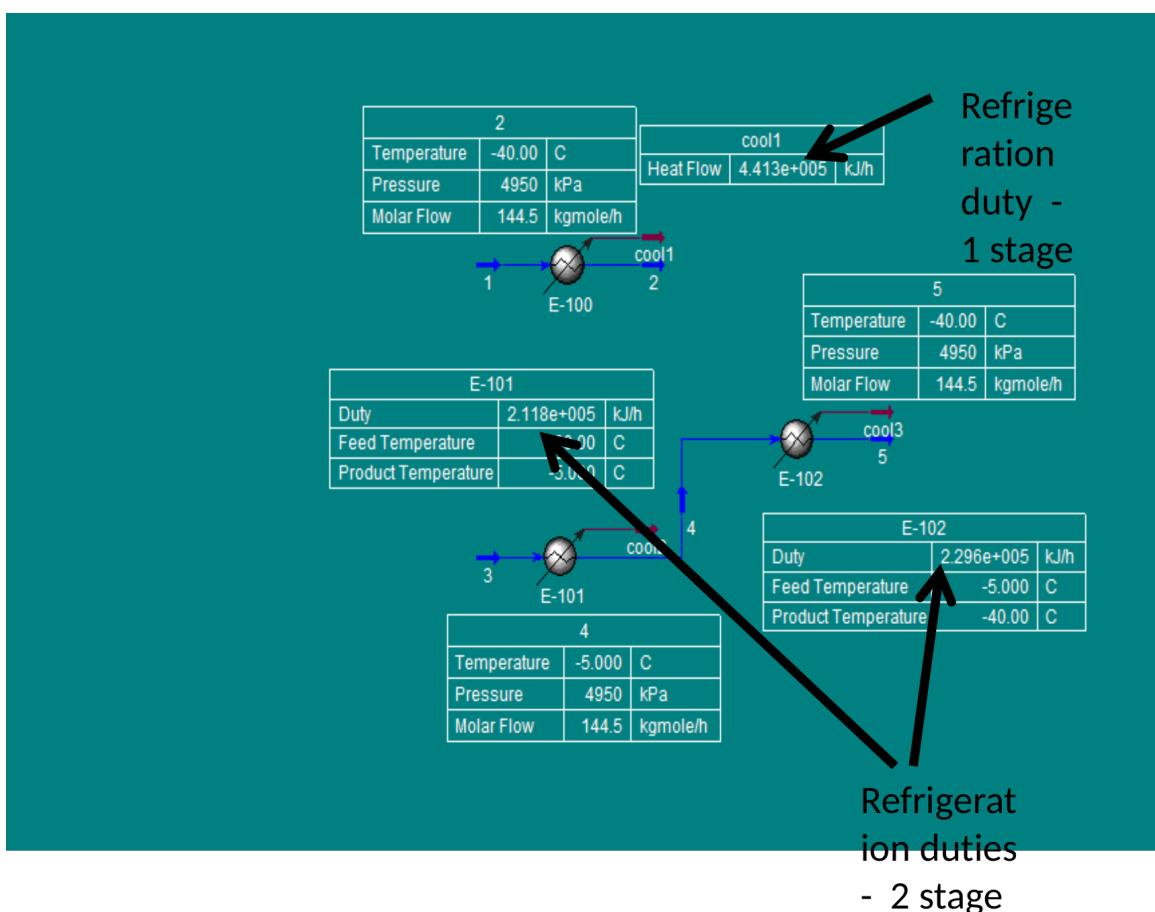


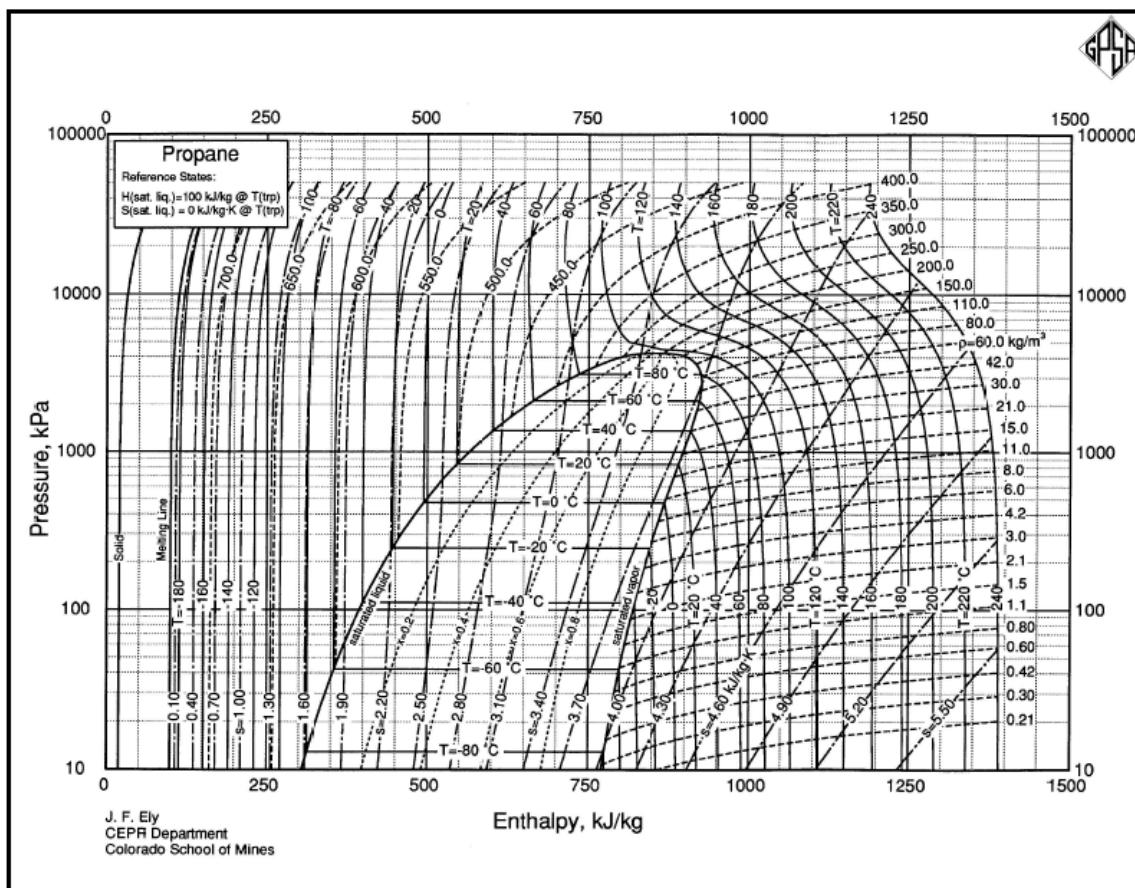
[Question end]

Question 35

Use the attached Mollier chart to compare the compressor power requirements and condenser duty of one and two stage refrigeration processes. The refrigerant is propane. The cooling duties are shown in the attached UNISIM output. Use the following assumptions:

- 5 °C approach between refrigerant and process gas outlet
- 5 °C approach to the condensing medium which is air at 20 °C.
- Polytropic efficiency of propane compressor is 80 %.





[Question end]

Question 36

Past exam question

- a) A process gas is to be cooled from 20°C to -35°C using a refrigeration plant. The refrigerant is propane. Using the attached Mollier chart (see Fig. 5) for propane estimate the compressor energy savings between a one and a two stage refrigeration system. Assume air is available at 25°C for condensation. State any other assumptions. Enclose your Mollier chart including your student number with the returned exam booklet.

[14 marks]

- b) State and explain six factors in deciding whether to use a one or two stage refrigeration system.

[6 marks]

[Question total: 20 marks]

If you use this graph, you must attach it to your exam booklet using the provided tag.
 Student ID:

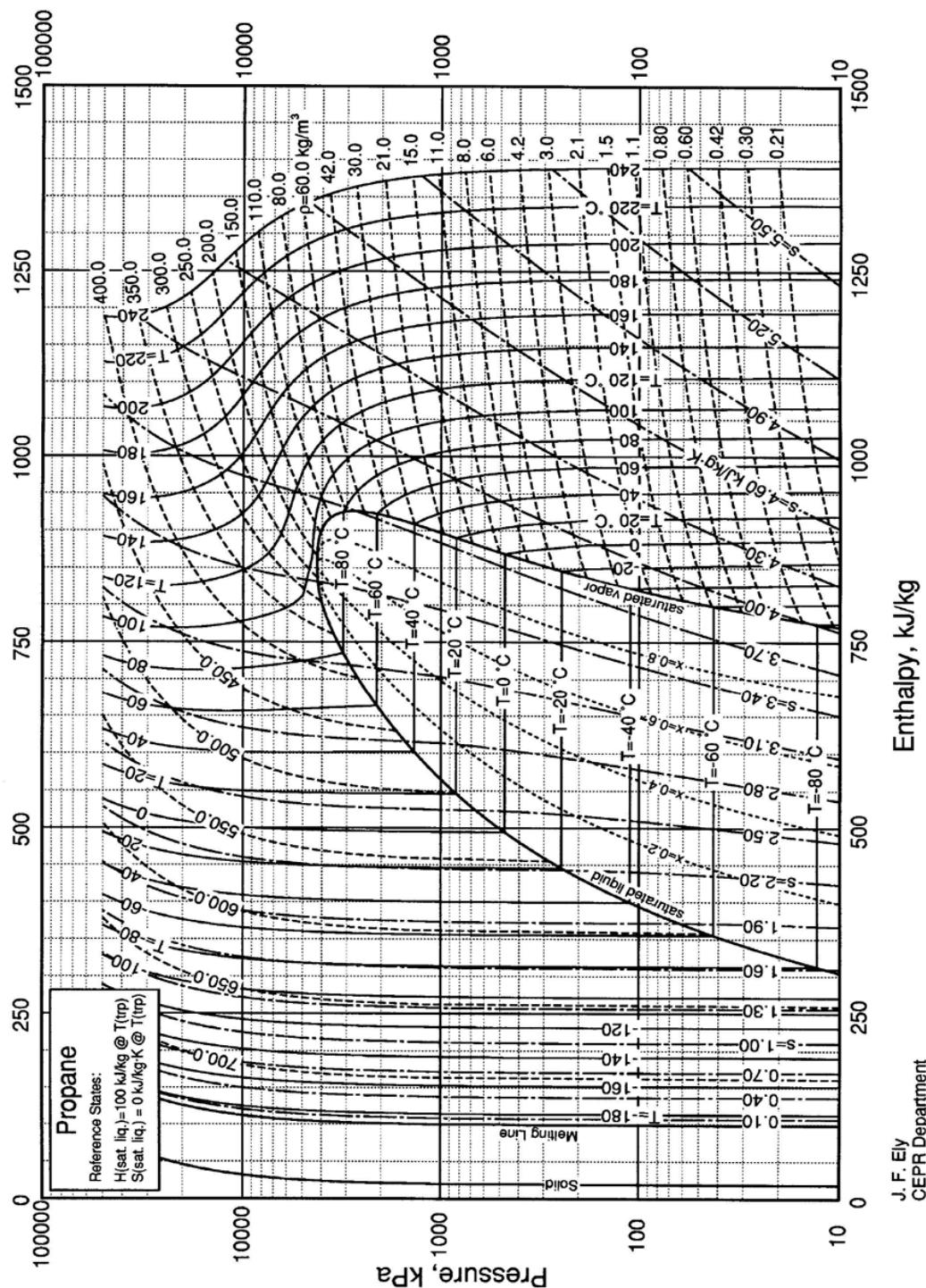


Figure 5: A Mollier chart for propane.

Question 37**Past exam question**

- a) Describe hydrates and the main conditions necessary for hydrate formation. Why is hydrate formation a concern for transportation and process systems? [4 marks]
- b) Hydrate formation can be calculated using K charts, an example of which is given in Fig. 6.

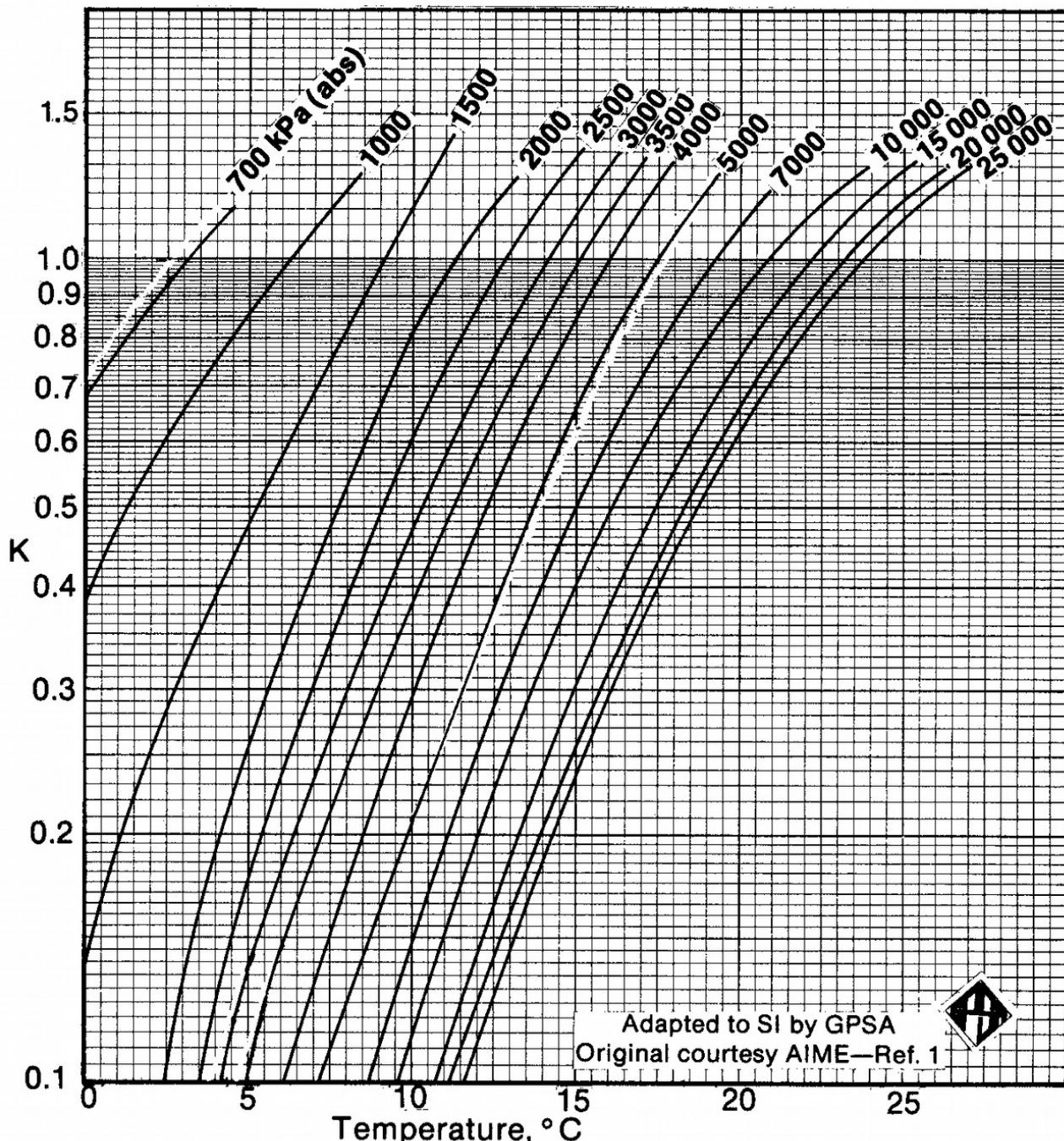


Figure 6: Hydrate K-value chart for ethane.

Explain how these charts could be used to calculate the hydrate formation pressure at a given temperature for a known mixture of methane, ethane, propane and nitrogen. No chart is available for nitrogen.

You should note the following relationship for the dewpoint of a hydrocarbon mixture.

$$\sum_{i=1}^{i=N_s} \left(\frac{y_i}{K_{vs,i}} \right) = 1$$

where y_i is the mole fraction of species i and $K_{vs,i}$ is the equilibrium ratio between the gaseous/vapour fraction and the solid hydrate for each component. [6 marks]

- c) To prevent hydrate formation a $2366 \text{ Sm}^3 \text{ h}^{-1}$ gas stream is to be dehydrated using a TEG contactor. The gas enters the dehydrator saturated at 80 bar and 30°C and lean TEG is available at 99% purity. Calculate the exit gas water concentration and the flowrate of TEG required assuming 0.04 m^3 per kg water removed is required. A safety factor of 10°C is also required.

Equilibrium data are available in Fig. 7 and 8. [8 marks]

- d) What TEG purity would be required to dehydrate the gas to 20 mg Sm^{-3} ? [2 marks]

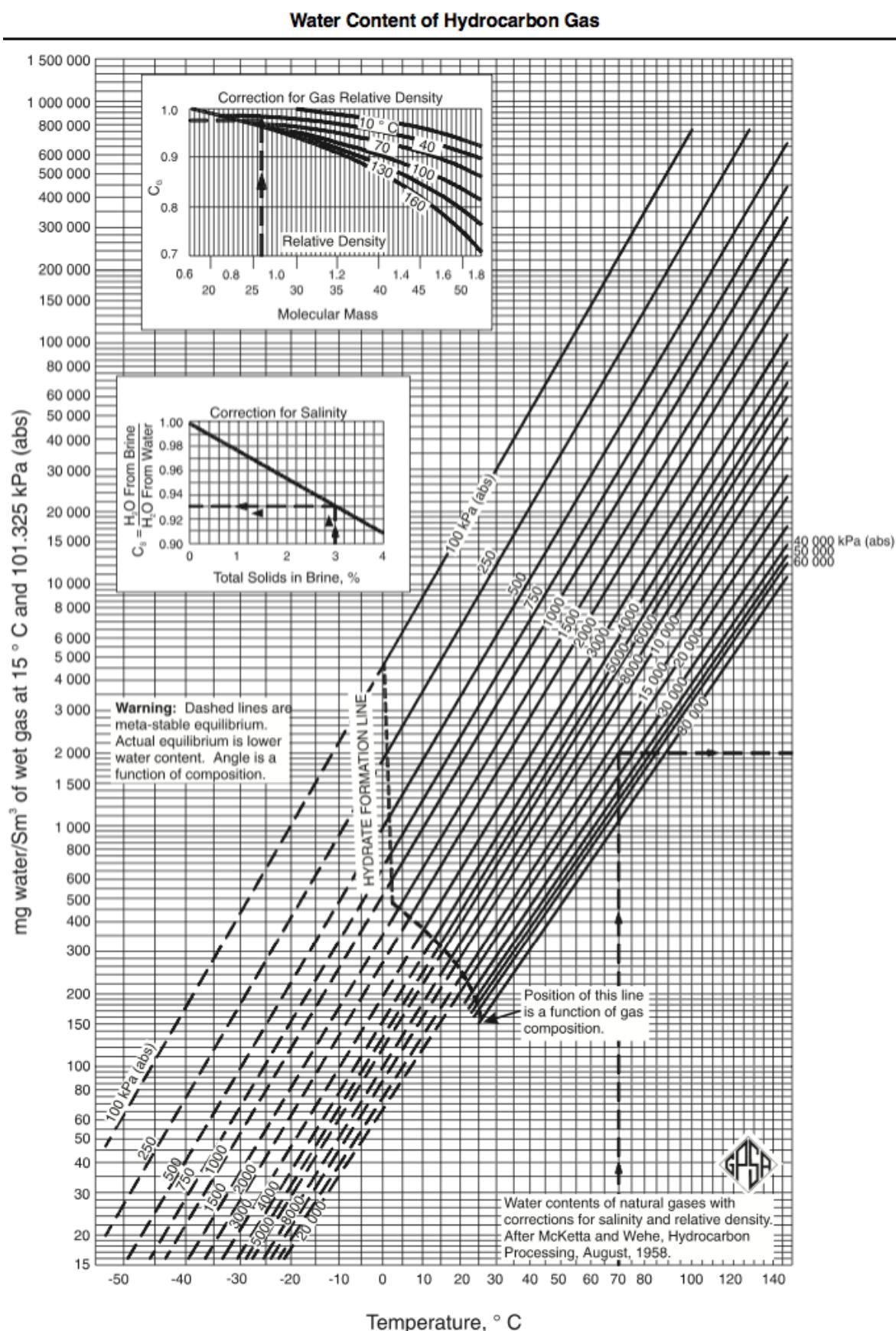


Figure 7: Equilibrium chart for wet natural gas including corrections for water salinity and relative molecular weight/density.

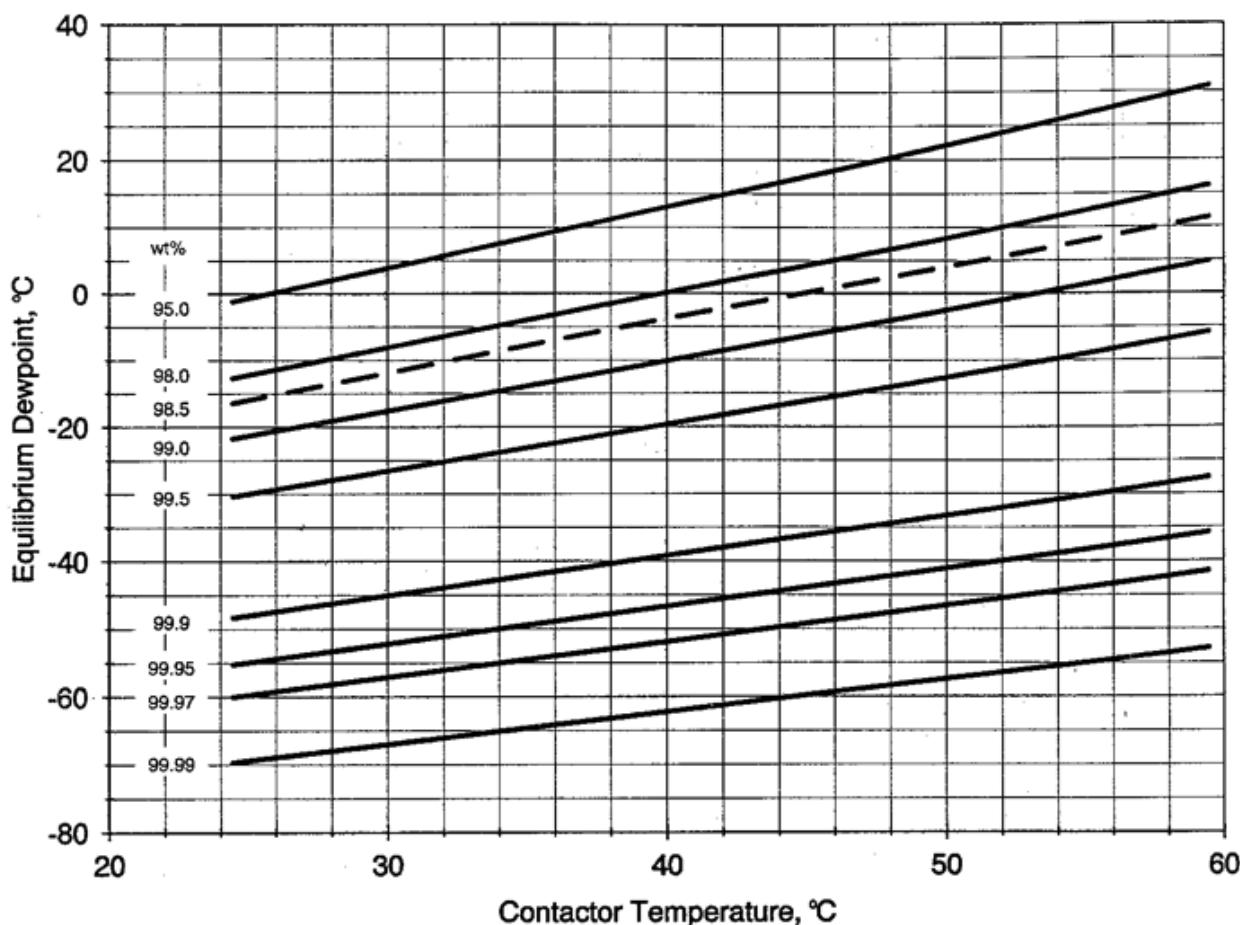


Figure 8: Equilibrium correction chart for wet natural gas over TEG solutions.

[Question total: 20 marks]

Question 38

6: Gas treatment

- Water is to be removed from a process gas prior to pipeline entry. The pipeline entry specification is 20 mg water/ Sm^3 gas. A glycol absorption unit is available with a lean glycol content of 1.5 wt% water. The absorber pressure and temperature is 50 bara and 35°C, respectively. Will the glycol absorber be capable of achieving the pipeline entry specification? Use the enclosed glycol equilibrium (Fig. 9) and water saturation (Fig. 10) charts and explain your reasoning. **[8 marks]**
- Describe the key aspects of the molecular sieve process used for gas drying. **[6 marks]**
- A molecular sieve dehydration unit is operating at 40 bara and 30°C. The unit is required to produce a product natural gas with a water dewpoint of minus 20°C. The gas entering the unit is water saturated and the flowrate is $2 \times 10^6 \text{ sm}^3/\text{day}$. How much water is the unit required to remove? You will need the data in Fig. 10. **[3 marks]**
- The export gas from the above molecular sieve later enters a cold plant operating at 150 bara and minus 15°C. Comment on the suitability of the molecular sieve treated gas for the cold plant operation. **[3 marks]**

[Question total: 20 marks]

If you use this graph, you must attach it to your exam booklet using the provided tag.
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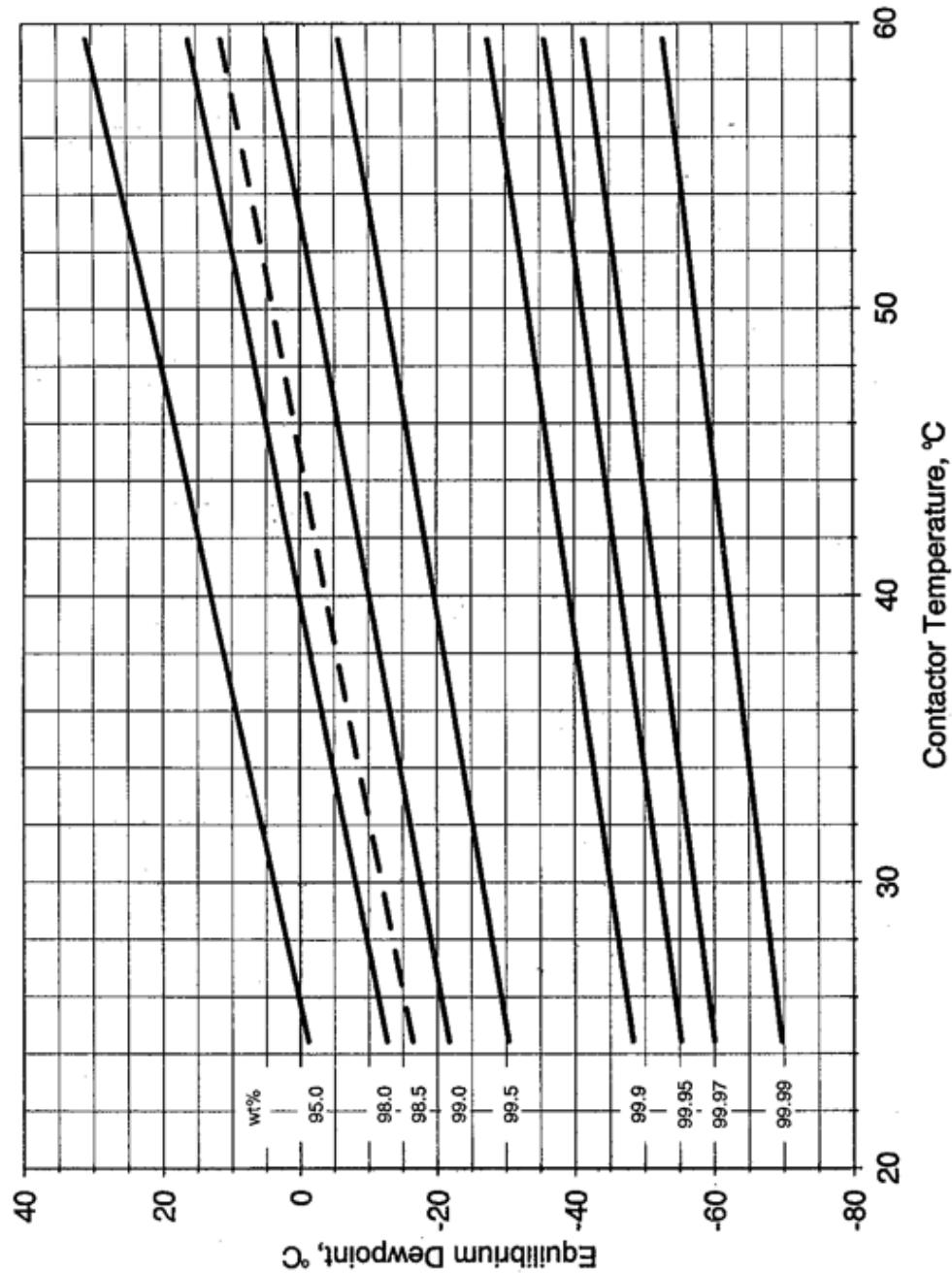


Figure 9: A TEG equilibrium chart.

If you use this graph, you must attach it to your exam booklet using the provided tag.
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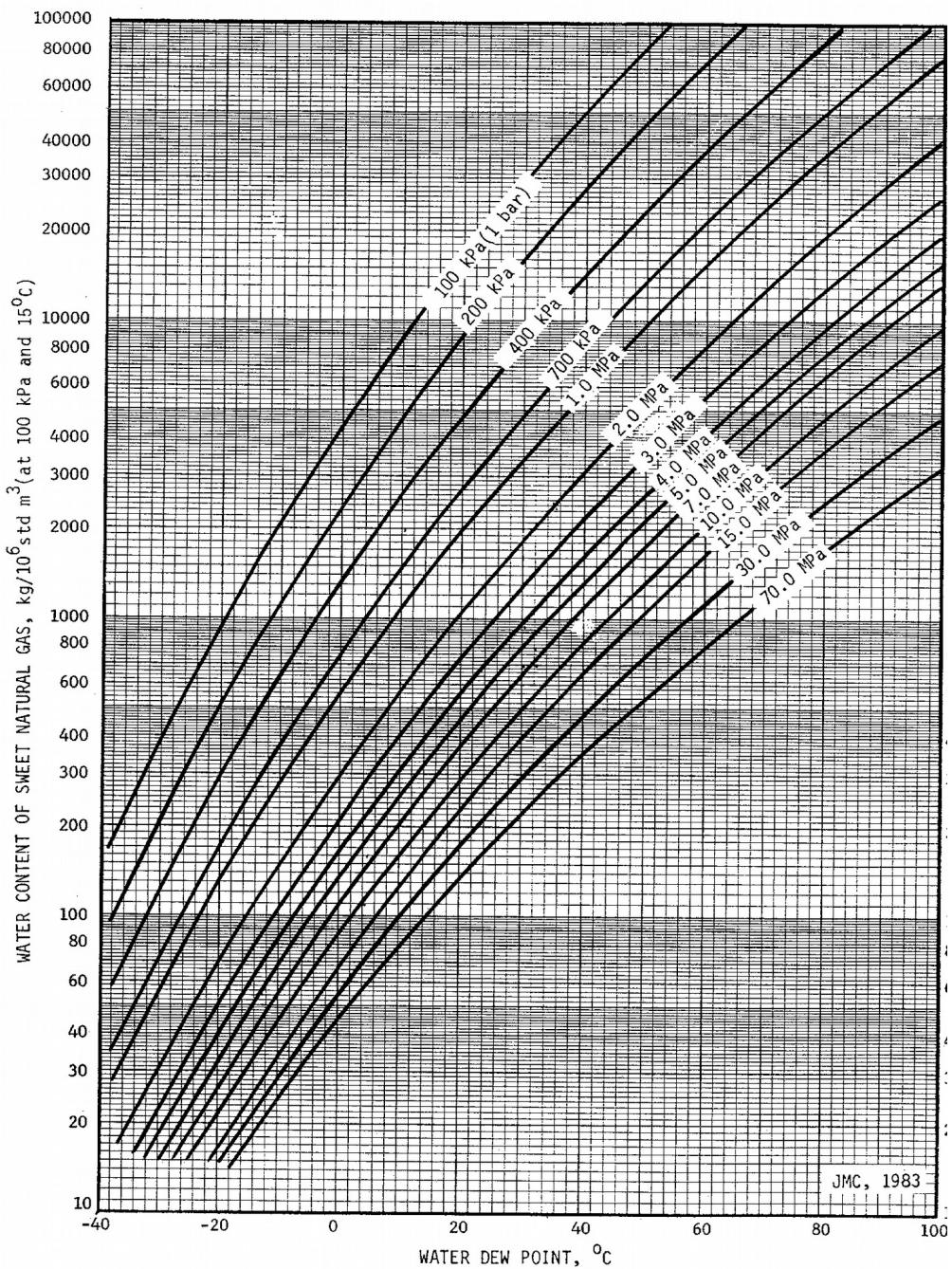


Figure 10: Sweet-gas/water dew point graph.

7 7: Flow assurance (Multi-phase flow)

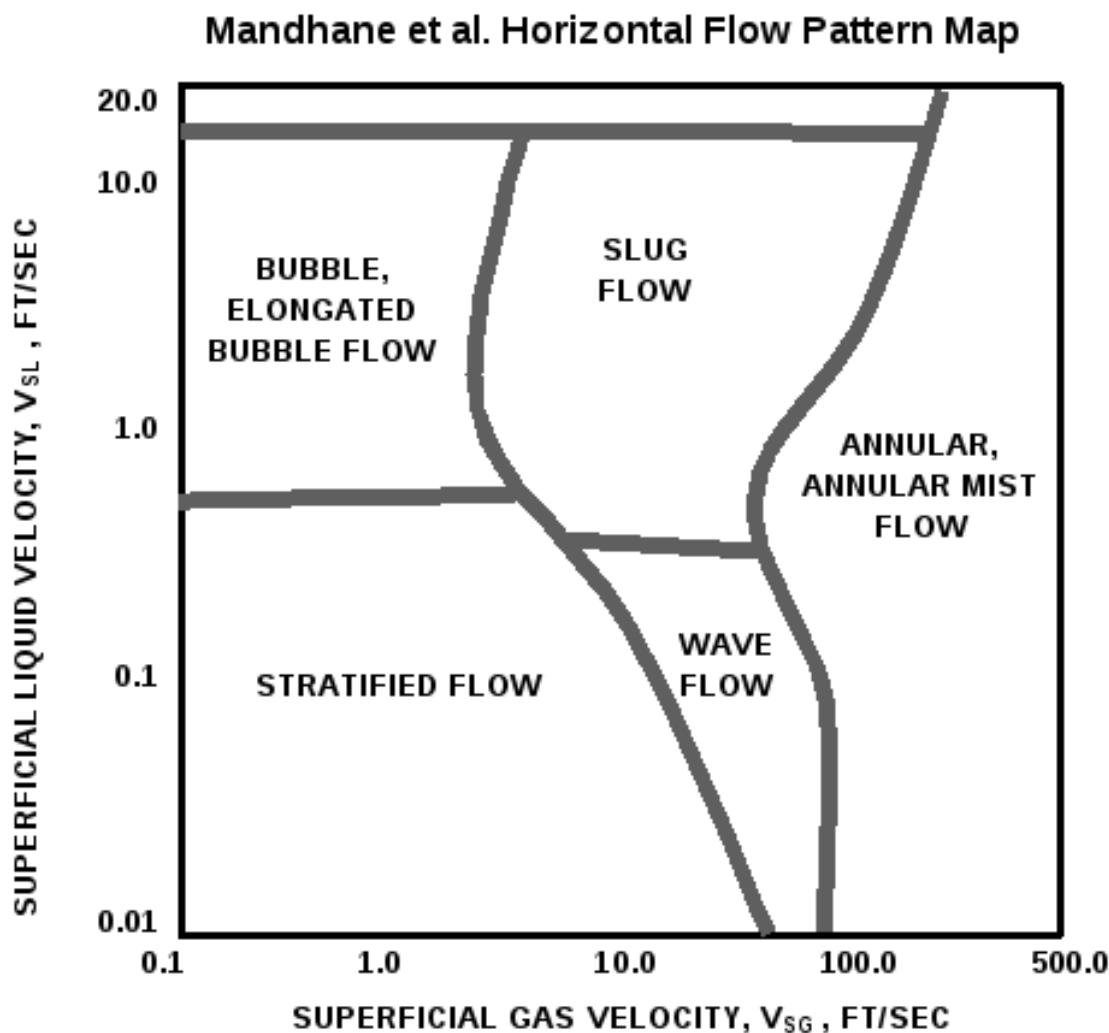
Question 39

Two phase flow is present in a pipeline with the following conditions:

- Pipeline diameter = 0.381 m
- Gas volume flow = 0.835 m³ s⁻¹

- Liquid volume flow = $0.0369 \text{ m}^3 \text{ s}^{-1}$

Using the attached Mandhane flow map, predict the expected flow pattern. [slug]

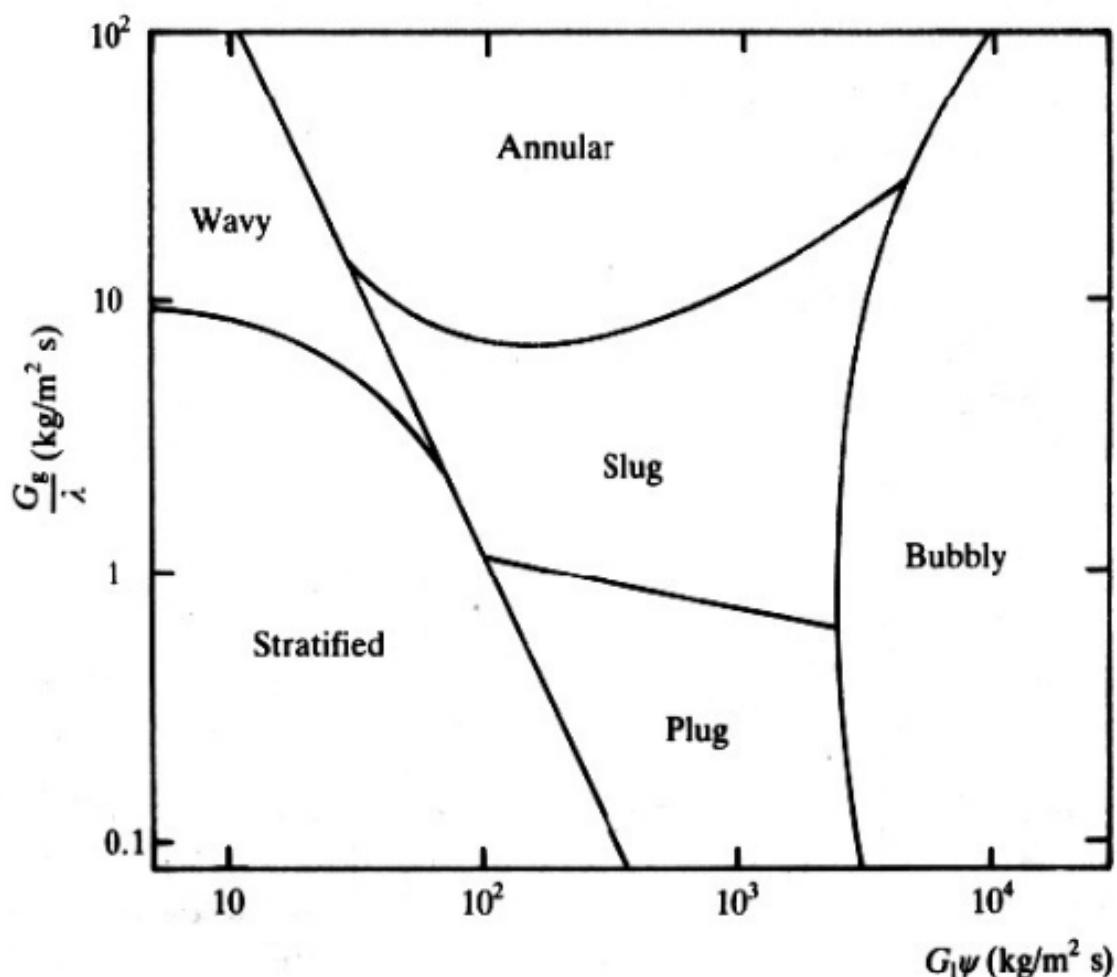


[Question end]

Question 40

Using the Baker flow pattern map evaluate the most likely flow pattern occurring in a 2.54 cm i.d. horizontal pipe when the system pressure is 30 bar, 70 bar, and 170 bar, the gas mass quality x is 1 %, 10 %, and 50 %, and the mass velocity G is $500 \text{ kg m}^{-2} \text{ s}^{-1}$, and $2000 \text{ kg m}^{-2} \text{ s}^{-1}$. Fluid properties are:

- Liquid density = $817, 741, 556 \text{ kg m}^{-3}$ for 30, 70, 170 bara respectively
- Gas density = $15, 35.6, 119.3 \text{ kg m}^{-3}$ for 30, 70, 170 bara respectively
- Liquid viscosity = 0.00014 Pa s
- Gas viscosity = 0.0000169 Pa s
- Water surface tension = $0.029835, 0.017633, 0.0032375 \text{ N m}^{-1}$ for 30, 70, 170 bara respectively



[Question end]

Question 41

- Repeat the Eaton hold-up calculation in the lecture notes but use a 250 mm pipe diameter. All relevant parameters are given below:
 - Pipeline internal diameter $D = 250$ mm
 - Liquid viscosity $\mu_L = 0.02$ Pa s
 - Liquid flowrate $Q_L = 17$ m³ hr⁻¹
 - Vapour flowrate $Q_G = 425$ m³ hr⁻¹
 - Liquid density $\rho_L = 880$ kg m⁻³
 - Gas density $\rho_G = 20.8$ kg m⁻³
 - Surface tension $\sigma = 1.5 \times 10^{-6}$ N m⁻¹
 - Inlet pressure $P_{in} = 2800$ kPa
 - Outlet pressure $P_{out} = 2400$ kPa
 - $P_b = 101.6$ kPa
- The pipeline is 50 km long, calculate the total liquid hold-up in m³.

- The pipeline terminates with a slugcatcher to capture liquids when the pipe is sphered. The liquid capacity of the slugcatcher is 50 m³. How frequently will the line require spherding to remain within the liquid capacity?

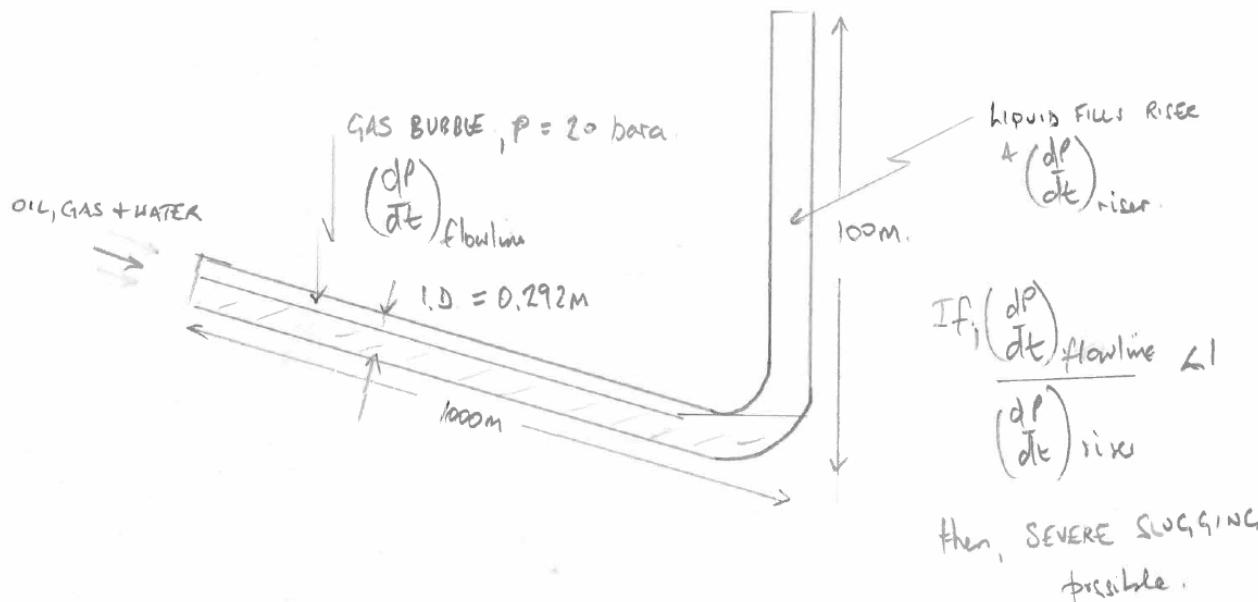
[Question end]

Question 42

A downward sloping 1000 m pipeline with an internal diameter of 0.292 m joins a 100 m long vertical pipe (riser) of the same diameter. The pipeline contains oil, gas, and water flowing at an average pressure of 20 bara. The flow rates are:

- Oil = 0.009 m³ s⁻¹
- Water = 0.009 m³ s⁻¹
- Gas = 0.041 m³ s⁻¹

The oil and water densities are 800 and 1000 kg m⁻³ respectively. Determine if the system of pipeline and riser will be prone to severe slugging at the given flow conditions.



[Question end]

Question 43

Given the following information for a horizontal multi-phase pipeline, calculate the expected pressure loss in bara using the Homogeneous Flow Model.

Liq density	860	kg m ⁻³
Gas density	25	kg m ⁻³
Liq viscosity	0.0013	kg m ⁻¹ s ⁻¹
Gas viscosity	0.000012	kg m ⁻¹ s ⁻¹
Mass flow rate	50	kg s ⁻¹
Pipe i.d.	0.2	m
Pipe length	1000	m
Vapour quality	0.03	Mass fraction

[Question end]

Question 44**7: Flow assurance**

- a) Oil production from a vertical riser is enhanced by injecting gas at the riser base. A series of tests is conducted where the injected gas rate is varied. The oil production trend observed indicates an optimal gas rate which maximises oil production. If gas rates are reduced from the optimal gas rate, oil production drops, similarly if gas rates are increased above the optimal rate, oil production drops. Explain this observation and clearly state any assumptions you make. [6 marks]
- b) Liquid and gas are flowing in a horizontal pipeline with inner diameter of 38.1 cm. The liquid rate is $0.0369 \text{ m}^3 \text{ s}^{-1}$. Using the Mandhane flow map in Fig. 11, calculate the gas rate in $\text{m}^3 \text{ s}^{-1}$ where there will be a transition from slug to annular flow. [4 marks]

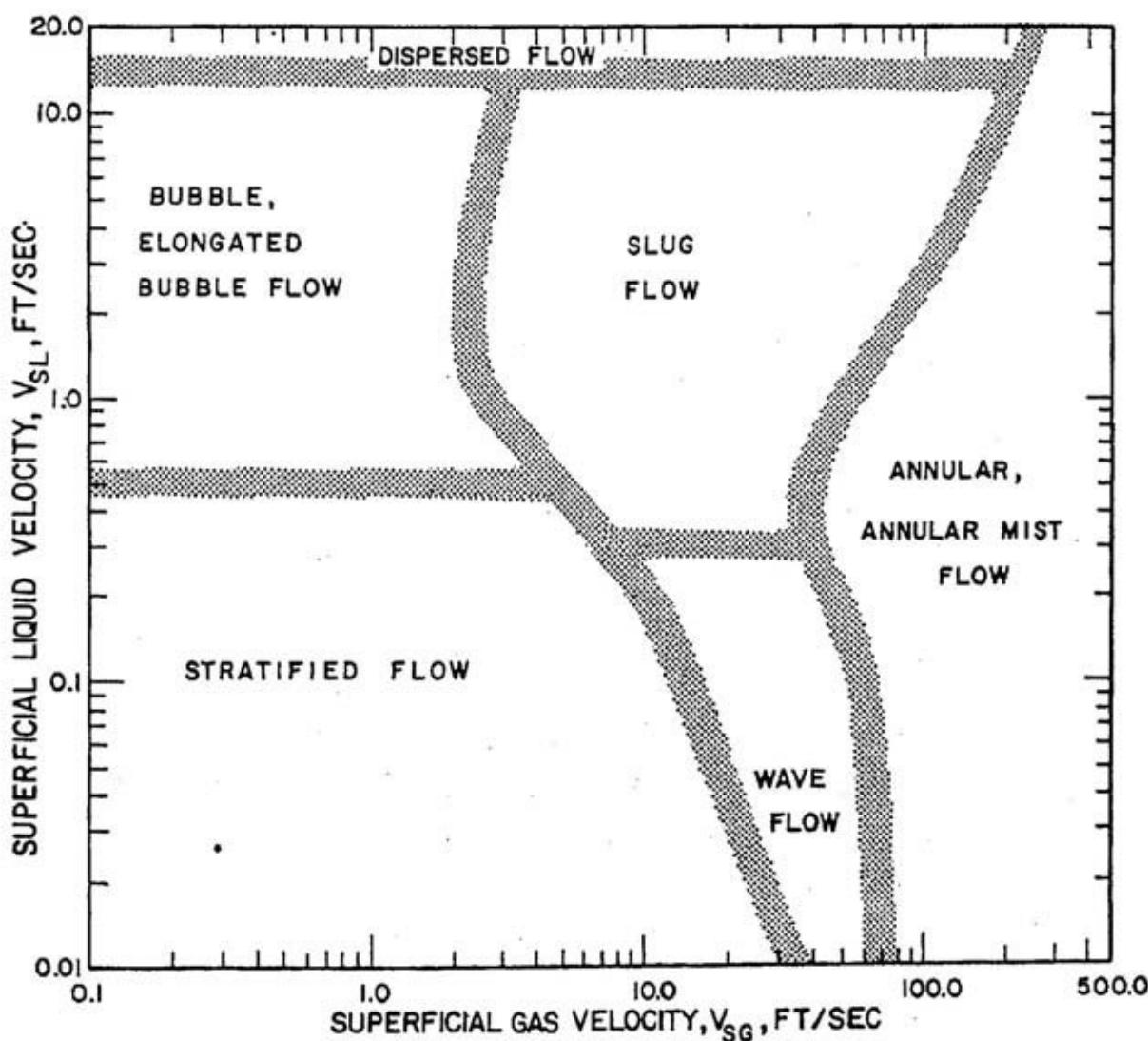


Figure 11: The Mandhane horizontal flow pattern map.

- c) What is a hydrate and what are the conditions required for their formation?

[2 marks]

- d) A pipeline is flowing with a light hydrocarbon gas and water. Given the following information, calculate the distance from the pipeline inlet to the point where hydrates will form. [8 marks]

- The hydrate formation temperature for the pipeline is 15°C .
- Pipeline Overall Heat Transfer Coefficient (OHTC), $U = 5 \text{ W m}^{-2} \text{ }^{\circ}\text{C}^{-1}$ (based on pipe outer diameter).
- Pipeline inside diameter, $D_i = 0.2 \text{ m}$.
- Pipeline wall thickness, $W_t = 0.02 \text{ m}$.
- Gas/water mixture specific heat, $C_p = 2.8 \text{ kJ kg}^{-1} \text{ }^{\circ}\text{C}^{-1}$.
- Gas/water mixture mass flow rate, $m = 10 \text{ kg s}^{-1}$.
- Ambient temperature, $T_a = 4^{\circ}\text{C}$.
- Pipeline inlet temperature, $T_i = 50^{\circ}\text{C}$.
- You should use a log-mean temperature difference, $\Delta T_{lm} = (\Delta T_A - \Delta T_B) / \ln \left(\frac{\Delta T_A}{\Delta T_B} \right)$ where A and B denote opposite ends of the exchanger/pipeline, when calculating the heat flux.

[Question total: 20 marks]

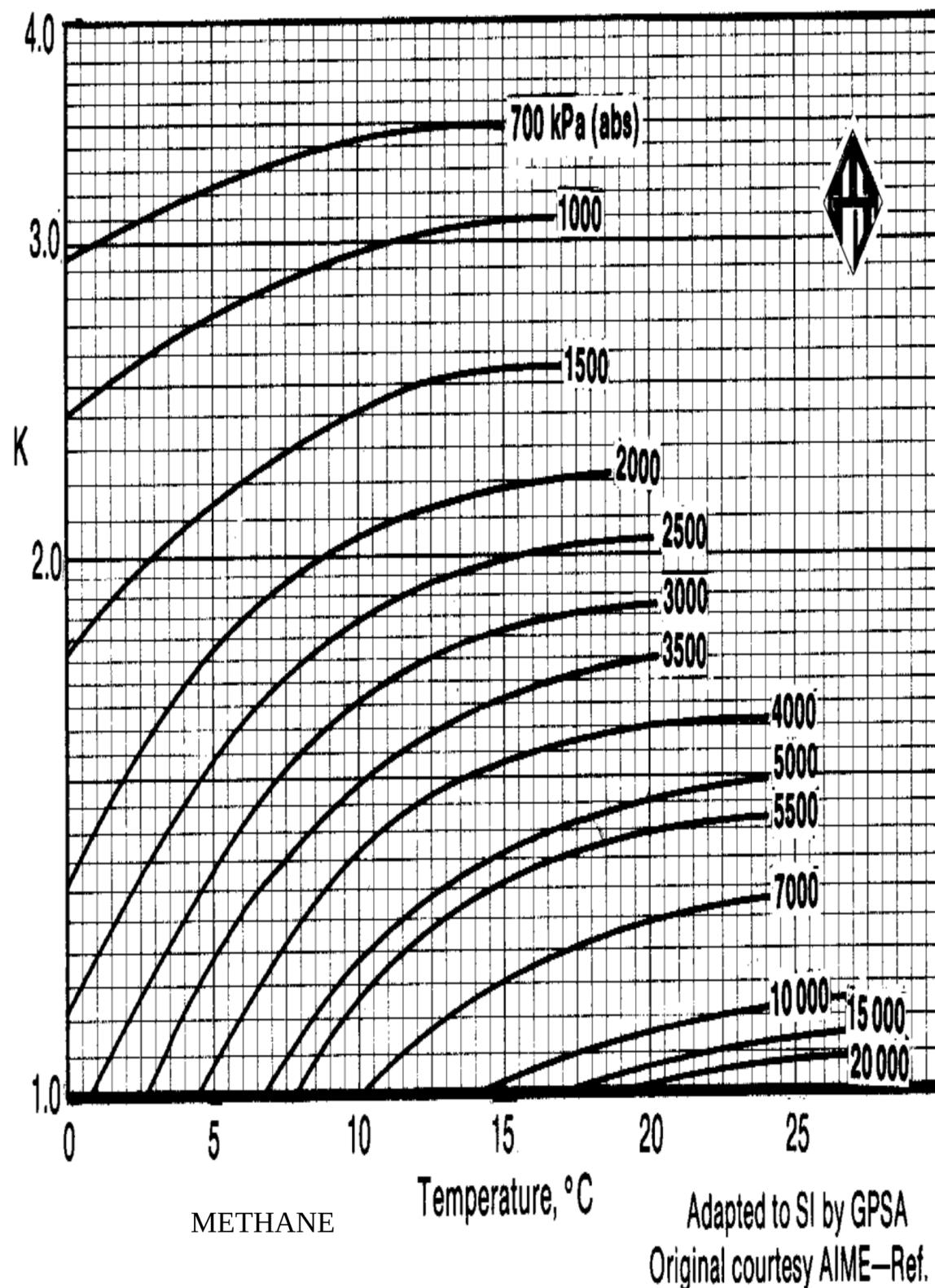
8 8: Hydrates, wax, and erosion

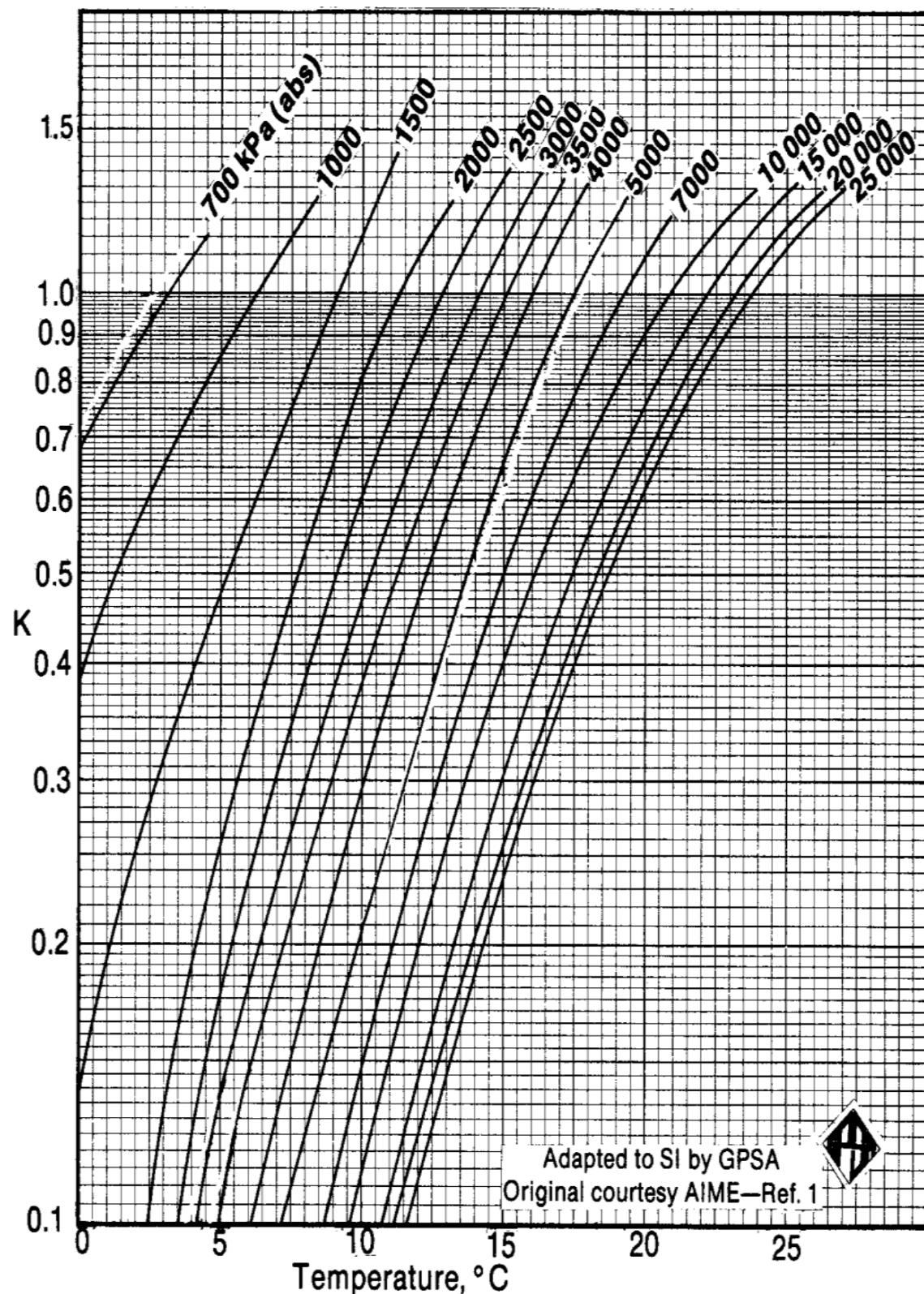
Question 45

The following mixture is flowing in a subsea pipeline.

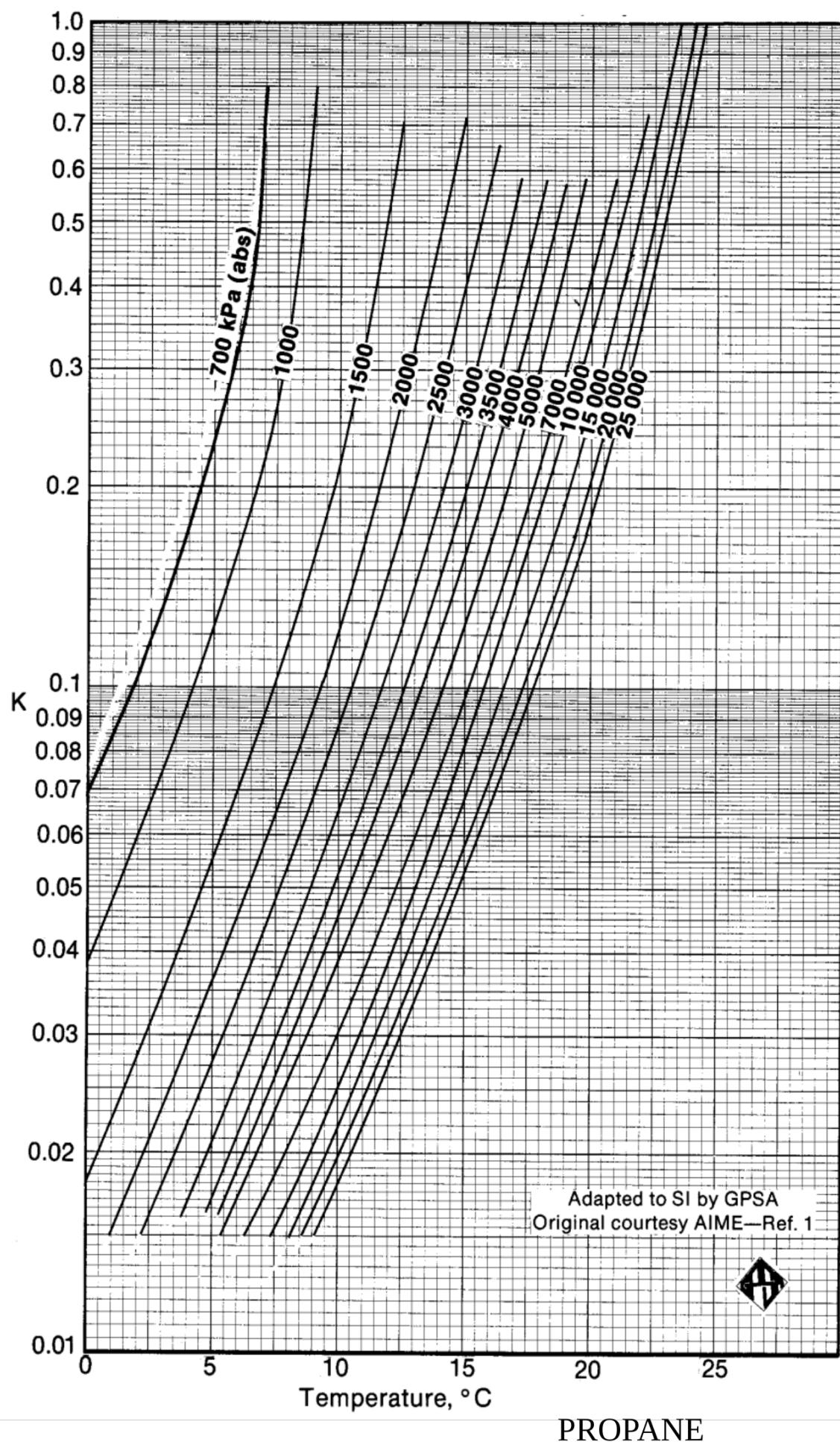
Component	Mol fraction
Methane	0.6
Ethane	0.3
Propane	0.1

Calculate the hydrate formation temperature for a pipeline pressure of 40 bara. Use the K value figures and compare with the GPSA charts.

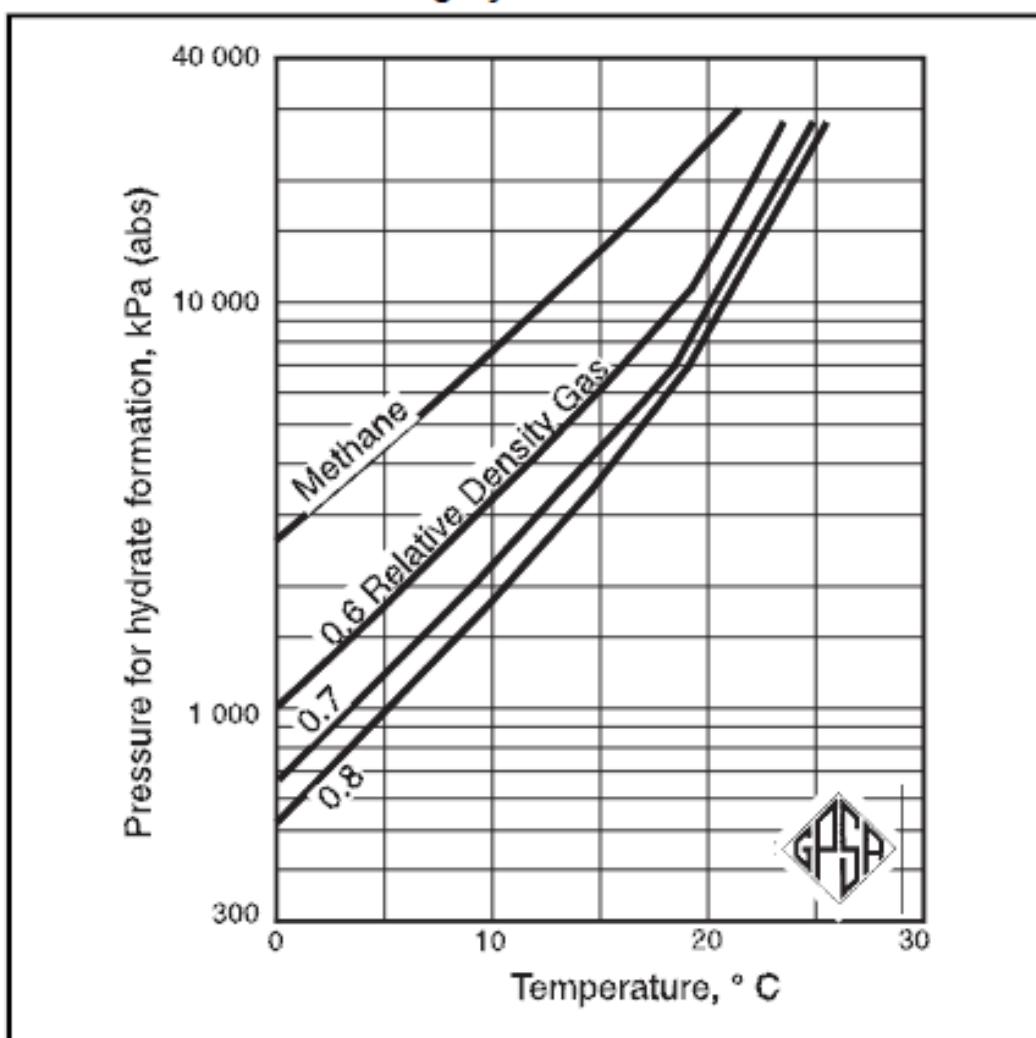




ETHANE



**Pressure-Temperature Curves for
Predicting Hydrate Formation**



[Question end]

Question 46

The hydrate formation temperature of a hydrocarbon and water mixture flowing in a subsea pipeline has been measured at 18 °C. The pipeline conditions are:

- Pipeline length $L = 15 \text{ km}$
- Pipe inner diameter $D = 0.292 \text{ m}$
- Pipe wall thickness = 0.0127 m
- Mass flowrate $m = 15 \text{ kg s}^{-1}$
- Inlet temperature $T_1 = 70 \text{ }^\circ\text{C}$
- Sea temperature $T_{\text{out}} = 4 \text{ }^\circ\text{C}$
- Fluid specific heat $C_p = 1745 \text{ J kg}^{-1} \text{ K}^{-1}$

What is the minimum level of insulation (U value) that would be required to ensure that the pipeline contents will not enter hydrate forming conditions?

[Question end]

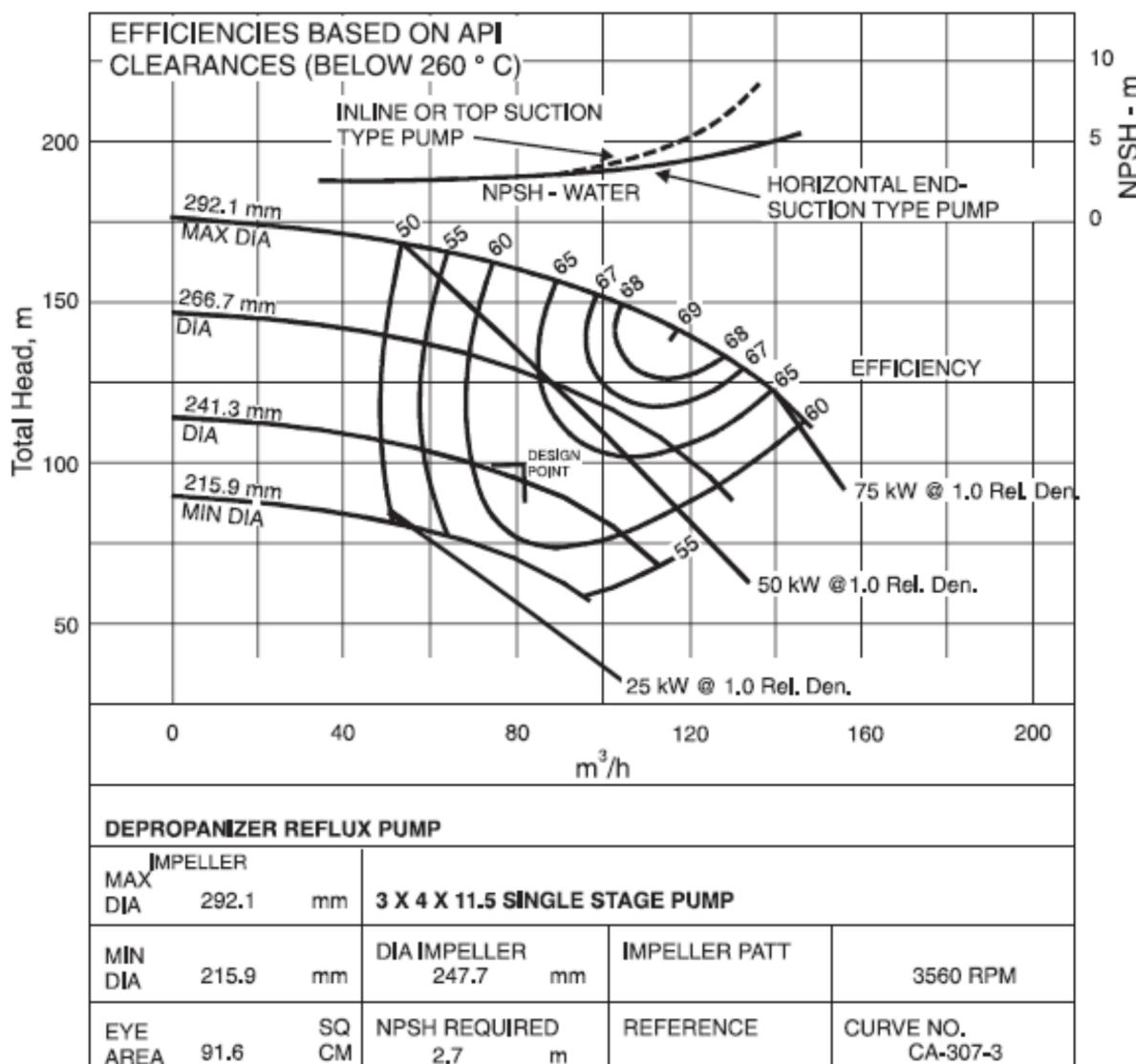
Question 47

Calculate the time taken for a subsea pipeline to cool to hydrate forming conditions after flow is stopped. Consider two sections of the pipe, one gas filled and the other mainly liquid filled. Each section of the pipe is 10 m long. The pipe ID and OD are 0.17 m and 0.2 m respectively. Assume the pipe OHTC is $1.5 \text{ W m}^{-2} \text{ K}^{-1}$. The specific heat C_p of the gas and the liquid is $3100 \text{ J kg}^{-1} \text{ K}^{-1}$. The gas density is 90 kg m^{-3} and the liquid density is 840 kg m^{-3} . The initial temperature is 70°C and the surrounding sea temperature is 4°C . The hydrate forming temperature is 15°C .

[Question end]

9 9: Energy efficiency**Question 48**

Verify the affinity laws using the following pump characteristic. The duty is water and the pump has a 215.9 mm impeller. The flow rate is $80 \text{ m}^3 \text{ hr}^{-1}$. The impeller is changed to 266.7 mm. Calculate the new head using the affinity laws and check against values in the figure. Similarly for power.



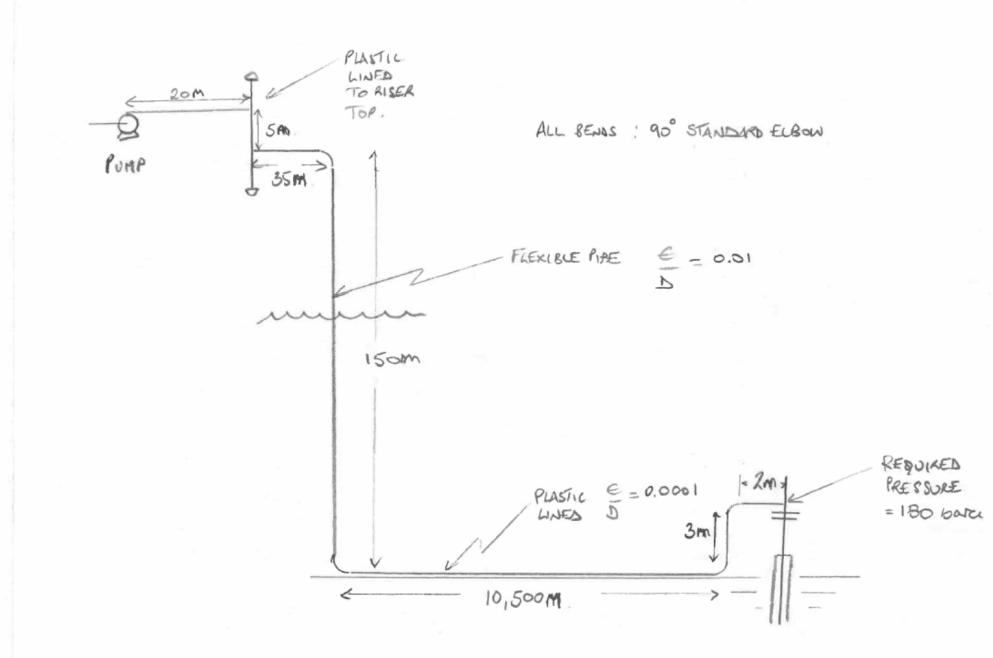
[Question end]**Question 49**

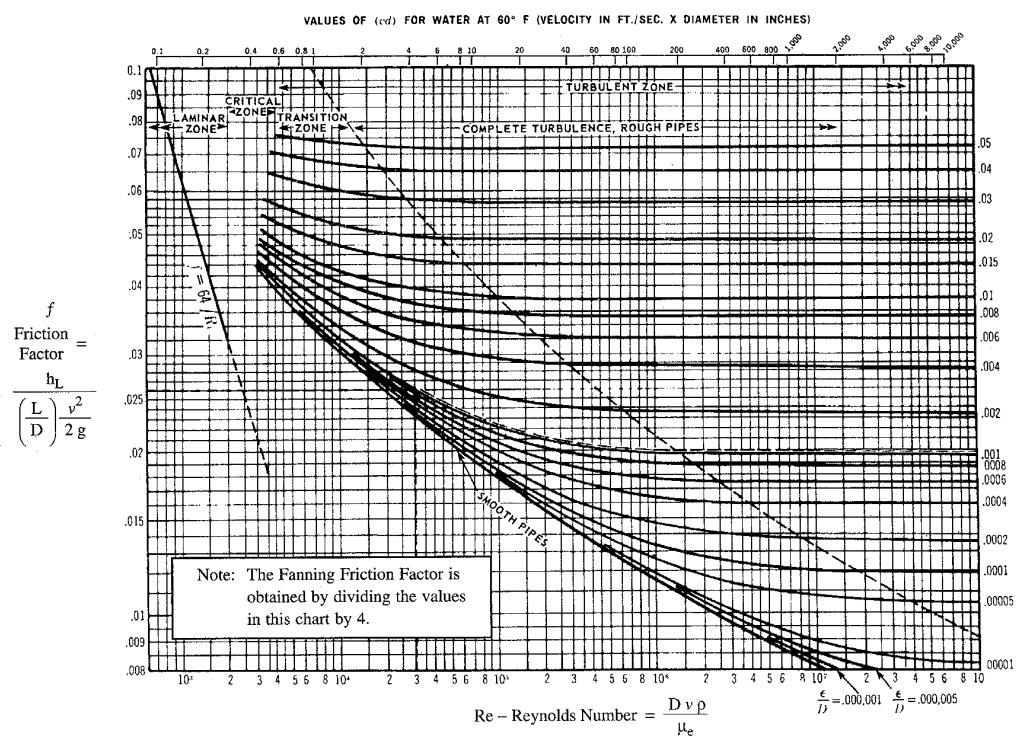
Liquid propane ($\gamma = 0.502$) at its bubble point is pumped from a pressure vessel (operating pressure = 10 bara) by a centrifugal pump. The elevation of the liquid level in the suction vessel is 5 m above datum. The elevation of the pump suction nozzle is 1 m above datum. The friction loss in the suction line is 0.075 bar.

- What is the available NPSH?
- The pump has a NPSH requirement of 5 m. How could you change the equipment configuration to achieve a NPSH of 5 m? Due to other restrictions the vessel cannot be elevated.

[Question end]**Question 50**

A plastic lined subsea water injection flowline is required to deliver 80,000 barrels per day of treated sea water to a subsea manifold at a pressure of 180 bara and temperature of 10 °C. The water pipeline route is as shown. The topsides piping is also plastic lined but the riser is flexible pipe. The pipe ID is 10.75 inch throughout. Viscosity and density of sea water at 10 °C is 1.31 cP and 1020 kg m⁻³ respectively. Calculate the required water injection pump discharge pressure and pump power requirements if the pump suction pressure is 10 bara. The pump efficiency is 75 %.





Description				Equivalent Length in Pipe Diameters (L/D)
Globe Valves	Stem perpendicular to run	No Obstruction Wing or Pin guided disc	100% Open 100% Open	340 450
	Y-pattern	Stem 60° from run of pipe Stem 45° from run of pipe	100% Open 100% Open	175 145
Angle Valves		No Obstruction Wing or Pin guided disc	100% Open 100% Open	145 200
Gate Valves	Wedge Disc Double Disc, Plug Disc		100% Open 75% Open 50% Open 25% Open	13 35 160 900
	Pulp Stock		100% Open 75% Open 50% Open 25% Open	17 50 260 1200
Conduit Pipe Line Gate, Ball and Plug Valves			100% Open	3
Check Valves	Conventional Swing Clearway Swing Globe Lift or Stop; Stem Perpendicular to Run or Y-pattern Angle lift or Stop In-Line Ball			135 50 same as globe same as globe 150
Foot Valves with Strainer		Poppet lift-type disc Leather-hinger disc		420 75
Butterfly Valves (8-inch and larger)				40
Cocks	Straight-through	Rectangular plug port area equal to 100% of pipe area		18
	Three-way	Rectangular plug port area equal to 80% of pipe area	Straight through Through branch	44 140
Fittings	90° Standard Elbow 45° Standard Elbow 90° Long Radius Elbow			30 16 20
	90° Street Elbow 45° Street Elbow Square Corner Elbow			50 26 57
	Standard Tee	Flow through run Flow through branch		20 60
	Close Pattern Return Bend			50

[Question end]

Question 51

A waste water treatment plant is considering a new pumping station. The plant owner has requested quotes from the approved pump supplier for supplying pumps with differing efficiencies. The costs received are:

Efficiency %	Pump station cost £
65	3,400,000
70	5,400,000
75	6,310,000
80	7,200,000
85	8,875,000

The pumps are electric motor driven. At 65 % efficiency the pump power requirement will be 10 MW. The plant design life is 15 years, the required availability is 0.95 and the cost of electricity is $0.025 \text{ £ kW}^{-1} \text{ hr}^{-1}$. What is the optimal efficiency to minimise life of field costs? Assume a discount rate of 3 %.

[Question end]

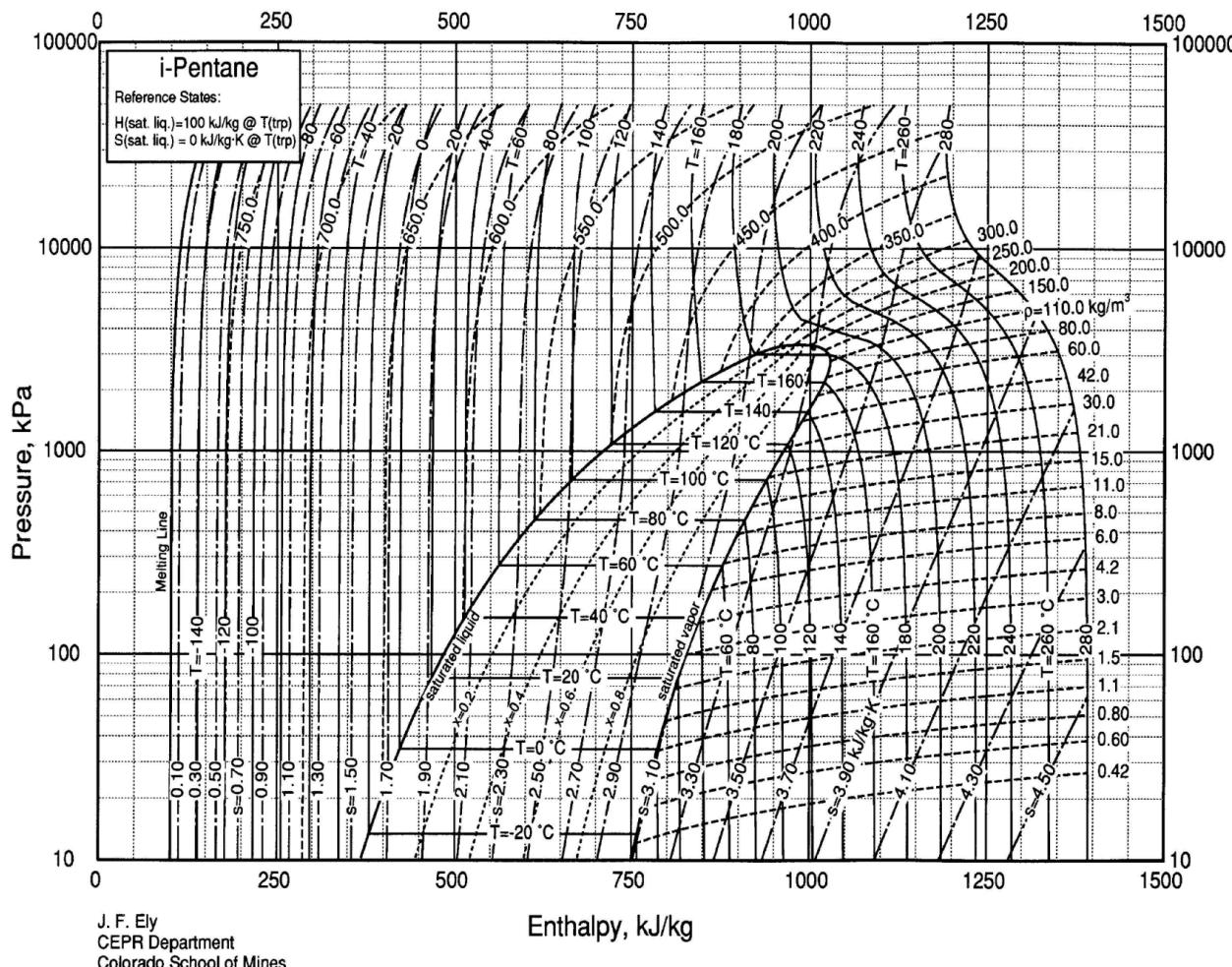
Question 52

A high pressure gas condensate well flows at $30,000 \text{ kg hr}^{-1}$. The arrival pressure and temperature are 650 bara and 160°C . The pressure is dropped across a choke valve to 100 bara. If the choke were replaced by an expander how much energy could be produced? The inlet and outlet compressibilities are 0.85 and 0.9 respectively. The gas k factor is 1.18. Assume a polytropic efficiency of 70 %. The gas molecular weight is 28.

[Question end]

Question 53

i-pentane is to be utilised in an Organic Rankine Cycle (ORC). 100,000 BPD of hot water is available at 100°C . Cooling water is available at 20°C . Use the attached Mollier chart and estimate the potential for power recovery in kW.



[Question end]

Question 54

15 kg s^{-1} of methane is to be compressed from 5 bara to 15 bara. The suction temperature to the compressor is 30°C .

- Compare a single stage compressor power requirements with a two stage compressor with intercooling to 30°C . Assume the compressor polytropic is 77 % and equal compression ratios across the two stage option.

- The single stage compressor is in operation. Conditions are steady with a constant compression ratio, but the following outlet temperatures are recorded. The inlet temperature remains at 30 °C. Quantify the corresponding compressor polytropic efficiencies. What could cause this trend?

Year	Outlet temperature °C
1	150
2	161
3	166

[Question end]

Question 55

A reciprocating compressor has 6 cylinders each with a total cylinder volume of 0.002 m³. The cylinder diameter is 8 cm. The cylinder has a full stroke of 18 cm but the design has left a clearance distance of 4 mm. Quantify how this will affect the volumetric efficiency.

[Question end]

Question 56

An oilfield with a 20 year life has the following energy demand

Year	Load MW	Year	Load MW
1	22	11	24
2	22	12	24
3	22	13	24
4	24	14	24
5	24	15	24
6	24	16	24
7	24	17	24
8	26	18	24
9	28	19	24
10	28	20	24

The choice of gas turbine to provide this power is between Solar Titan and a Solar Mars. Data for these two machines is shown.

Platform Load MW	Solar Titan			
	No Req'd	Load per Machine (MW)	Load (% of maximum)	Efficiency per Machine (%)
10	1	10.0	80.3	29.8
12	1	12.0	96.4	31.1
14	2	7.0	56.2	25.3
16	2	8.0	64.2	27.1
18	2	9.0	72.3	28.6
20	2	10.0	80.3	29.8
22	2	11.0	88.3	30.6
24	2	12.0	96.4	31.1
26	3	8.7	69.6	28.2
28	3	9.3	74.9	29.1
30	3	10.0	80.3	29.8

Platform Load MW	Solar Mars			
	No Req'd	Load per Machine (MW)	Load (% of maximum)	Efficiency per Machine (%)
10	2	5.0	52.6	24.4
12	2	6.0	63.2	26.9
14	2	7.0	73.7	28.9
16	2	8.0	84.2	30.2
18	2	9.0	94.7	31.0
20	3	6.7	70.2	28.3
22	3	7.3	77.2	29.4
24	3	8.0	84.2	30.2
26	3	8.7	91.2	30.8
28	3	9.3	98.2	31.2
30	4	7.5	78.9	29.6

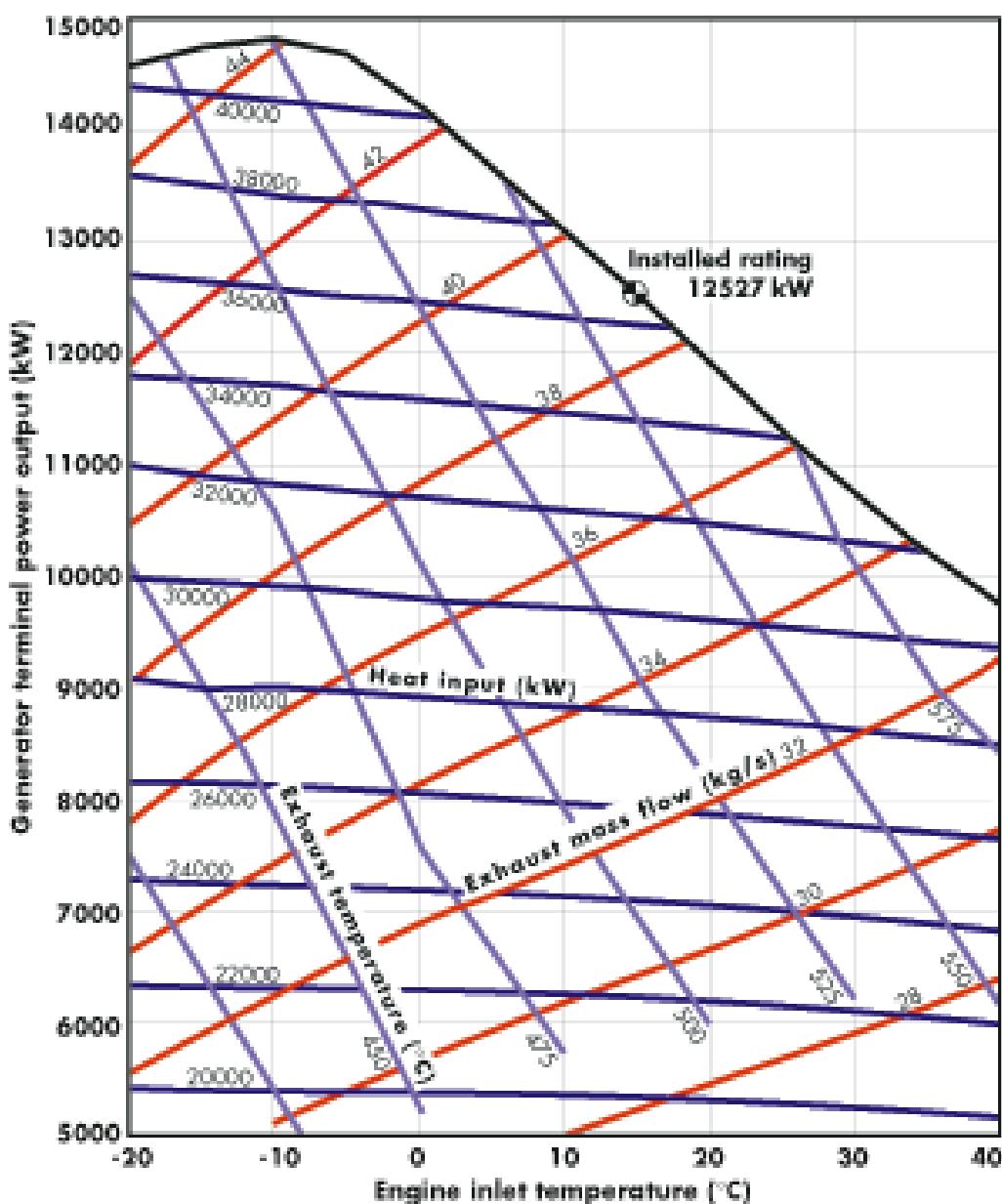
By conducting an annual review of machine efficiencies, determine which GT would be the most efficient over the field life.

[Question end]

Question 57

A gas turbine iso rating is as shown.

- What full load power output would be achieved at an air temperature of 15 °C?
- What output could be achieved if the air temperature increased to 30 °C?
- What is the machine efficiency at 15 °C and 30 °C?



[Question end]

Question 58

9: Energy efficiency

The following oil, gas, water separation and associated compression arrangement has been proposed for an offshore development. It is a single process train comprising two stages of three phase separation with interstage heating.

An export pump and cooler deliver the oil to an export pipeline. The export pump is driven by a fixed speed electric motor in a $2 \times 100\%$ parallel configuration. The pump efficiency at design conditions is 70%.

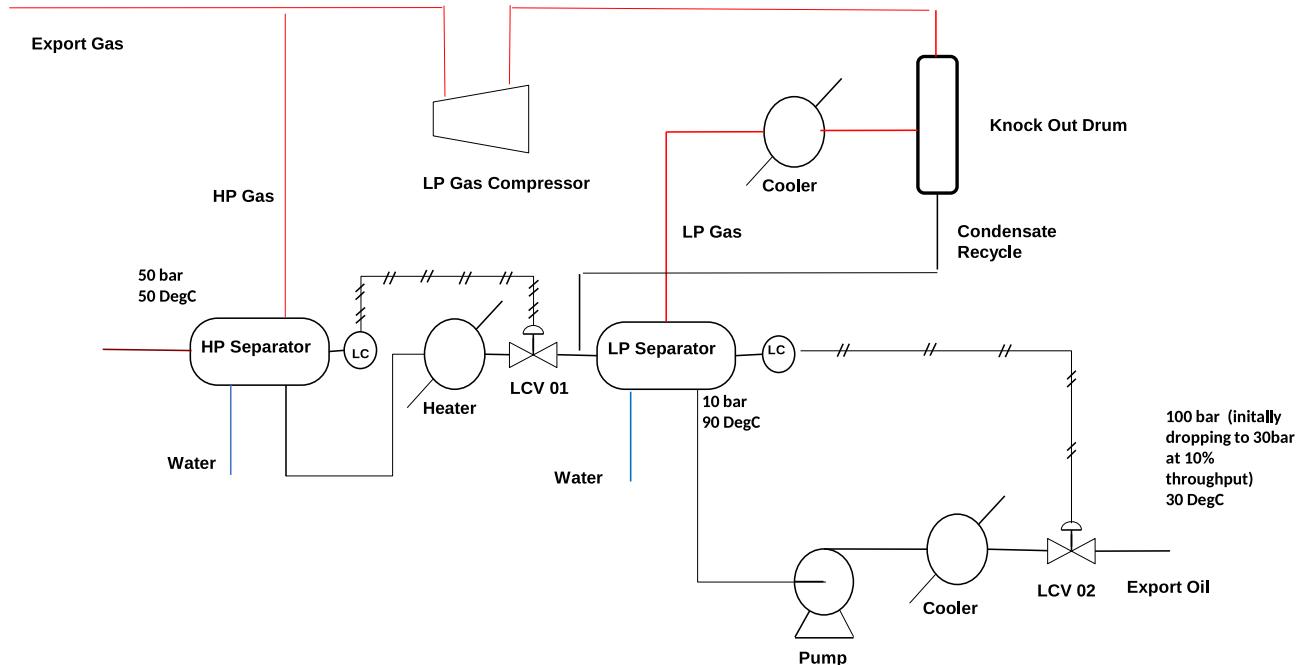
Large quantities of hot water are produced from each separator.

The interstage heater is an electric unit. Electrical supply to the heater, pump and compressor is from a simple cycle, gas turbine coupled to an alternator. The gas turbine is fuelled by process gas.

The system is designed for a 100% throughput but as the development ages, flowrates will drop progressively to 10% of design. The initial discharge requirement from the pump is 100 bara, but as the throughput reduces, the back pressure from the pipeline reduces requiring

less pump discharge pressure.

Gas from the low-pressure separator is cooled and passed to a knock out drum. The liquids from the drum are recycled to the inlet of the low pressure Separator. The gas is compressed in a $1 \times 100\%$ low pressure centrifugal compressor to a pressure equal to the high pressure Gas. The compressor is driven by a fixed speed electric motor and controlled by an anti-surge recycle system. The compressor polytropic efficiency is 70%.



Review this arrangement from an energy efficiency standpoint, identifying 10 topics which you would recommend require investigation before the design is finalised. For each topic identified give a short description of why you think it is worthy of consideration. **[20 marks]**

[Question total: 20 marks]

Question 59
9: Energy efficiency

a) An anti-surge control system is to be designed for a centrifugal compressor. Three options are under consideration:

- suction throttling at constant speed.
- discharge gas recycling at constant speed.
- speed control.

In all cases the compressor discharge pressure is fixed. With respect to energy requirements discuss the merits or otherwise of the three options. **[6 marks]**

b) A refrigeration plant is to be designed using propane as the refrigerant. It is proposed to use a variable speed drive for the propane compressor to save energy during winter and summer operations. The mass of process gas is fixed and has to be cooled to -35°C at all times. The refrigeration system is a single stage design and refrigerant condensation is via an air cooler. Summer temperatures are 35°C and winter temperatures are 10°C. Use the attached propane pressure-enthalpy chart in Fig. 12 to determine the percentage energy saving from winter to summer operations that speed control provides.

Assume the refrigeration cycle is isentropic and the temperature approach in the air cooler and evaporator is 5°C.

Include your marked up pressure-enthalpy chart with your exam paper. Put your student number on the chart. **[10 marks]**

c) Estimate the percentage speed reduction of the refrigeration compressor from summer to winter. **[4 marks]**

[Question total: 20 marks]

If you use this graph, you must attach it to your exam booklet using the provided tag.

Student ID: _____

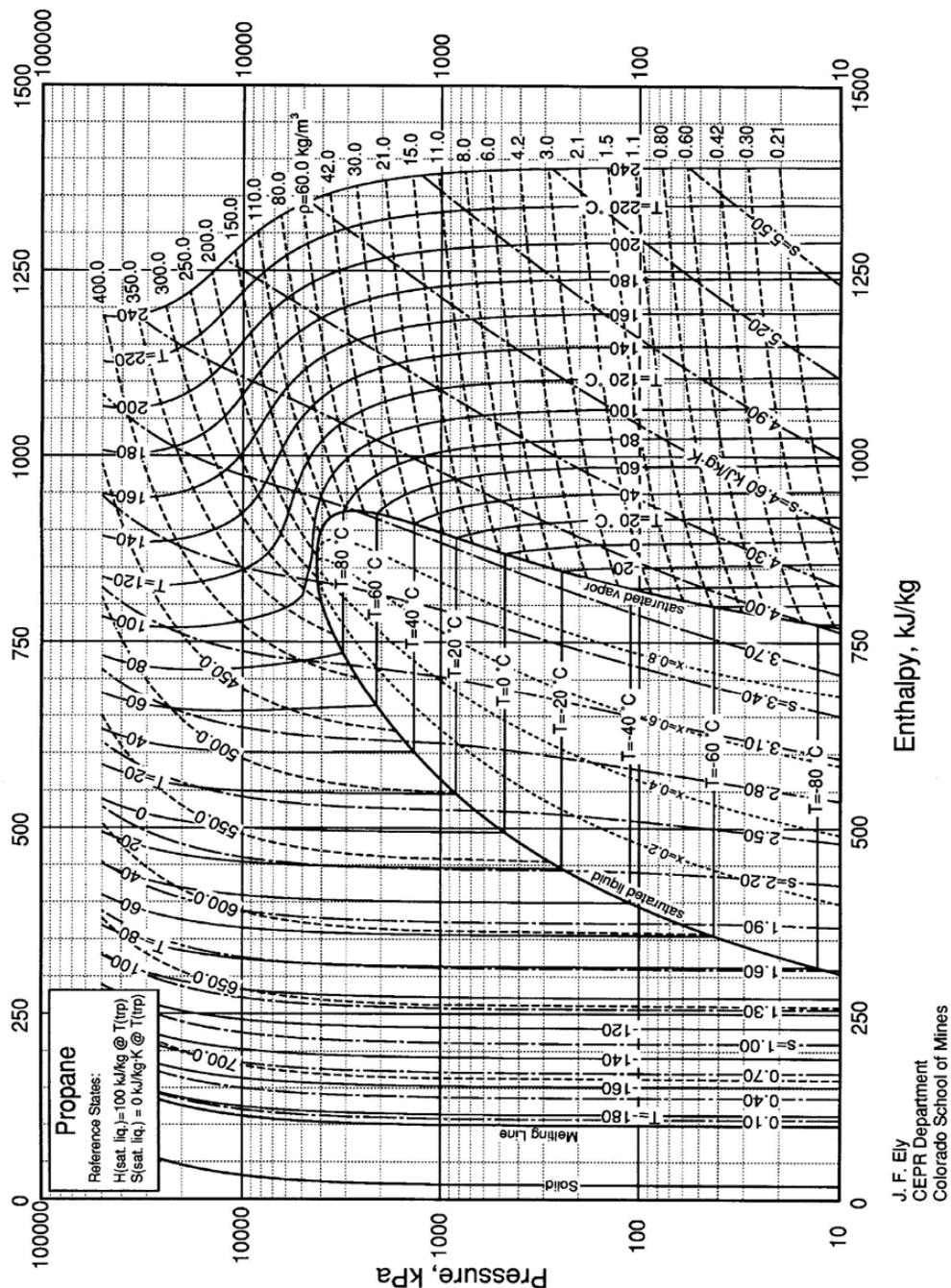


Figure 12: A Mollier chart for propane.

10 10: Water injection

Question 60

Calculate the dissolved oxygen concentration of seawater at 5 ° C and 20 ° C.

[Question end]

Question 61

A seawater deaeration column utilising gas stripping in a single packed bed is operating with the following conditions.

Stripping gas is nitrogen. The oxygen partial pressure contained within the nitrogen at inlet and outlet conditions is 0 and 0.02 atm respectively. Seawater counter flows to the nitrogen. The seawater enters the column with an oxygen concentration of $8 \times 10^{-6} \text{ mol fraction}$, the seawater leaves the bottom of the column with a concentration of $0.05 \times 10^{-6} \text{ mol fraction}$. The column operates at 10° C . The height of the packing is 3.5 m.

The information is to be used to design a new column to achieve an oxygen outlet concentration of $0.04 \times 10^{-6} \text{ mol fraction}$. The other conditions for the new column are as above. Calculate the packing height which would be required in the new column.

Henry's constant for seawater can be taken as

Temperature $^\circ \text{C}$	$H_{O_2} \text{ atm / mol fraction}$
0	22,500
5	29,100
10	32,700
15	36,400
20	40,100
25	43,800
30	47,500
35	50,70
40	53,500
45	56,300
50	58,800
60	62,900
70	66,300
80	68,700
90	69,900
100	70,100

[Question end]

Datasheet

Unit conversions

1 US barrel = 42 US gallons = 0.159 m³

1 ft = 12 in = 0.3048 m

1 lb = 0.453592 kg

°F = (°C × 9/5) + 32

°C = (°F – 32) 5/9

Physical constants/properties

Air molecular weight = 29 g mol⁻¹

Darcy's equation

$$\Delta p = \frac{\rho f L v^2}{2 D}$$

Blasius correlation (turbulent flow)

$$f = 0.316 \text{ Re}^{-0.25}$$

Pipe fitting	Equiv. length (L/D)
90° standard elbow	30
45° standard elbow	16
90° long elbow	20
90° street elbow	50
45° street elbow	26
Square corner elbow	57
Standard tee (flow through run)	20
Standard tee (flow through branch)	60
Close pattern return bend	50

Table 1: A list of equivalent lengths for single phase fluid flow calculations.