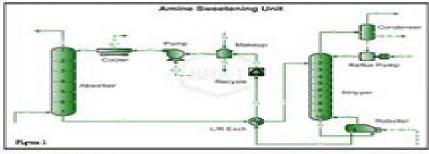
## Process Insight: Selecting the Best Solvent for Gas Treating

Selecting the best amine/solvent for gas treating is not a trivial task. There are a number of amines evailable to remove contaminants such as CO<sub>s</sub>, H<sub>s</sub>S and organic sulfur compounds from sour gas streams. The most commonly used amines are methanolamine (MDEA), diethanolamine (DEA), and methyldiethanolamine (MDEA). Other amines include diglycolamine (DOA), discopropanolamine (DIPA), and triethanolamine (TEA). Mintures of amines can also be used to customize or optimize the acid gas recovery. Temperature, pressure, sour gas composition, and purity requirements for the treated gas must all be considered when choosing the most appropriate amine for a given application.



#### Primary Amines

The primary amine MEA removes both CO, and H,S from sour gas and is effective at low pressure. Depending on the conditions, MEA can remove H,S to less than 4 ppsov while removing CO, to less than 100 ppsov. MEA systems generally require a reclaimer to remove degraded products from circulation. Typical solution strength ranges from 10 to 20 weight % with a maximum rich loading of 0.35 mole acid gas/mole MEA. DGA\* is another primary amine that removes CO, H,S, COS, and merceptane. Typical solution strengths are 50-60 weight %, which result in lower circulation rates and less energy required for stripping as compared with MEA. DGA also requires reclaiming to remove the degradation products.

#### Secondary Amines

The secondary amine DEA removes both CO, and H,S but generally requires higher pressure than NEA to meet overhead specifications. Because DEA is a weaker amine than MEA, it requires less energy for stripping. Typical solution strength ranges from 25 to 35 weight % with a maximum rich loading of 0.35 mole/mole. DIPA is a secondary amine.

that exhibits some selectivity for H,S although it is not as pronounced as for tertiary amines. DIPA also removes COS. Solutions are low in corrosion and require relatively low energy for regeneration. The most common applications for DIPA are in the ADIP\* and SULFINOL\* INDOCESSES.

#### Tertiary Amines

A tertiary amine such as MDEA is often used to selectively remove H.S. especially for cases with a high CO, to H.S. ratio in the sour gas. One benefit of selective absorption of H.S. is a Claus feed rich in H.S. MDEA can remove H.S to 4 ppm while maintaining 2% or less CO, in the treated gas using relatively less energy for regeneration than that for DEA. Higher weight percent amine and less CO, absorbed results in lower circulation rates as well. Typical solution stengths are 40-50 weight % with a maximum rich loading of 0.55 mole/mole. Because MDEA is not prone to degradation, comosion is low and a reclaimer is unsecessary. Operating pressure can range from atmospheric, typical of tail gas treating units, to over 1,000 psis.

#### Mixed Solvents

In certain situations, the solvent can be "customized" to optimize the sweetening process. For example, adding a primary or secondary assist to MDEA can increase the rate of CO, absorption without compromising the advantages of MDEA. Another less obvious application is adding MDEA to an existing DEA unit to increase the effective weight % assist to absorb more acid gas without increasing circulation rate or reboiler duty. Many plants utilize a mixture of amine with physical solvents. SULFINOL is a licensed product from Shell Oil Products that combines an amine with a physical solvent. Advantages of this solvent are increased mercaptan packup, lower regeneration energy, and selectivity to H.S.

#### Choosing the Best Alternative

Given the wide variety of gas treating options, a process simulator that can accurately predict aweetening results is a necessity when attempting to determine the best option. Problem has been proven to accurately predict results for numerous process schemes. Additionally, Probles can utilize a scenario tool to perform feasibility studies. The scenario tool may be used to systematically vary selected parameters in an effort to determine the optimum operating conditions and the appropriate solvent These studies can determine rich loading, reboiler duty, acid gas content of the sweet gas, amine losses, required circulation rate, type of amine or physical solvent, weight percent of amine, and other parameters. Problem can model virtually any flow process or configuration including multiple columns, liquid hydrocerbon treating, and split flow processes in addition. Problem can accurately model caustic treating applications as well as physical solvent sweetening with solvents such as Coastal AGR". methanol, and NMP For more information about ProMax and its ability to determine the appropriate solvent for a given set of conditions, contact Bryan Research & Engineering



## **Gas Treating With Chemical Solvents**

Mohamed A. Fahim, Taher A. Al-Sahhaf, Amal Elkilani

#### **Gas Treating With Chemical Solvents:**

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processing Six new chapters have been added to include detailed discussion of the thermodynamic and energy efficiency of relevant processes and recent developments in treating super rich gas high CO2 content gas and high nitrogen content gas with other contaminants. The new material describes technologies for processing today s unconventional gases providing a fresh approach in solving today s gas processing challenges including greenhouse gas emissions. The updated edition is an excellent platform for gas processors and educators to understand the basic principles and innovative designs necessary to meet today s environmental and sustainability requirement while delivering acceptable project economics Covers all technical and operational aspects of natural gas transmission and processing Provides pivotal updates on the latest technologies applications and solutions Helps to understand today s natural gas resources and the best gas processing technologies Offers design optimization and advice on the design and operation of gas plants Fundamentals of Natural Gas Processing Arthur J. Kidnay, William R. Parrish, Daniel G. McCartney, 2011-01-05 Offering indispensable insight from experts in the field Fundamentals of Natural Gas Processing Second Edition provides an introduction to the gas industry and the processes required to convert wellhead gas into valuable natural gas and hydrocarbon liquids products The authors compile information from the literature meeting proceedings and the Fundamentals of Natural Gas Processing, Third Edition Arthur J. Kidnay, William R. Parrish, Daniel G. McCartney, 2019-10-01 Offering indispensable insight from experts in the field Fundamentals of Natural Gas Processing Third Edition provides an introduction to the gas industry and the processes required to convert wellhead gas into valuable natural gas and hydrocarbon liquids products including LNG The authors compile information from the literature meeting proceedings short courses and their own work experiences to give an accurate picture of where gas processing technology stands today as well as to highlight relatively new technologies that could become important in the future The third edition of this bestselling text features updates on North American gas processing and changing gas treating requirements due to shale gas production It covers the international nature of natural gas trade LNG economics and more To help nonengineers understand technical issues the first 5 chapters present an overview of the basic engineering concepts applicable throughout the gas oil and chemical industries The following 15 chapters address natural gas processing with a focus on gas plant processes and technologies The book contains 2 appendices The first contains an updated glossary of gas processing terminology The second is available only online and contains useful conversion factors and physical properties data Aimed at students as well as natural gas processing professionals this edition includes both discussion questions and exercises designed to reinforce important concepts making this book suitable as a textbook in upper level or graduate engineering courses **Natural Gas Processing** Alireza Bahadori, 2014-05-05 Natural gas is considered the dominant worldwide bridge between fossil fuels of today and future resources of tomorrow Thanks to the recent shale boom in North America natural gas is in a surplus and quickly becoming a major international commodity Stay current with conventional and now unconventional gas standards and procedures with

Natural Gas Processing Technology and Engineering Design Covering the entire natural gas process Bahadori's must have handbook provides everything you need to know about natural gas including Fundamental background on natural gas properties and single multiphase flow factors How to pinpoint equipment selection criteria such as US and international standards codes and critical design considerations A step by step simplification of the major gas processing procedures like sweetening dehydration and sulfur recovery Detailed explanation on plant engineering and design steps for natural gas projects helping managers and contractors understand how to schedule plan and manage a safe and efficient processing plant Covers both conventional and unconventional gas resources such as coal bed methane and shale gas Bridges natural gas processing with basic and advanced engineering design of natural gas projects including real world case studies Digs deeper with practical equipment sizing calculations for flare systems safety relief valves and control valves **Chemicals** and Fuels from Biomass via Fischer-Tropsch Synthesis Joshua Gorimbo, Xinying Liu, Yali Yao, Diane Hildebrandt, 2022-11-18 In an effort to reduce dependency on fossil fuel resources biomass could essentially be converted into chemicals using high capacity processes The Fischer Tropsch Synthesis FTS pathway has been chosen as the focus of this book as it is a mature area and unlike other pathways such as pyrolysis FTS is a potential way of producing fuel hydrocarbons with no sulfur no nitrogen and no heavy metals contamination making it a good choice Integrating technological development and business development rationales to highlight the key technological developments that are necessary to industrialize biofuels on a global scale this book focusses on the key challenges that still hinder the effective biomass use and the realization of zero fossil fuel use Traditional biomass to hydrocarbons pathways are covered showcasing how they are tailored to yield a specific group of chemicals with the aim of reducing downstream processes New developments are considered including process synthesis catalysts and reactors etc Providing an up to date overview of the production of specialty chemicals and fuels from biomass via the Fischer Tropsch Synthesis pathway this title makes an excellent addition to the libraries of academics and practitioners working in catalysis and chemical engineering

Re-Engineering the Chemical Processing Plant Andrzej Stankiewicz, Jacob A. Moulijn, 2003-11-07 The first guide to compile current research and frontline developments in the science of process intensification PI Re Engineering the Chemical Processing Plant illustrates the design integration and application of PI principles and structures for the development and optimization of chemical and industrial plants This volume updates professionals on emerging PI equipment and methodologies to promote technological advances and operational efficacy in chemical biochemical and engineering environments and presents clear examples illustrating the implementation and application of specific process intensifying equipment and methods in various commercial arenas 

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Wines, Saeid Mokhatab, 2021-11-25 Contamination Control in the Natural Gas Industry delivers the separation fundamentals and technology applications utilized by natural gas producers and processors This reference covers principles and practices

for better design and operation of a wide range of media filters and systems to remove contaminants from liquids and gases enabling gas industry professionals to fulfill diverse fluid purification requirements Packed to cover practical technologies diagnostics and troubleshooting methods this book provides gas engineers and technologists with a critical first ever reference geared to contamination control Covers contamination control methods and equipment specific to the natural gas industry Includes guidelines on fundamentals and real world technologies used today Gives engineers better design and operation with rating methods standards and case histories

Petroleum and Gas Field Processing Hussein K.

Abdel-Aal, Mohamed A. Aggour, Mohamed A. Fahim, 2003-07-03 The immediate product extracted from oil and gas wells consists of mixtures of oil gas and water that is difficult to transport requiring a certain amount of field processing This reference analyzes principles and procedures related to the processing of reservoir fluids for the separation handling treatment and production of quality petroleum oil and gas products It details strategies in equipment selection and system design field development and operation and process simulation and control to increase plant productivity and safety and avoid losses during purification treatment storage and export Providing guidelines for developing efficient and economical treatment systems the book features solved design examples that demonstrate the application of developed design equations as well as review problems and exercises of key engineering concepts in petroleum field development and operation

Modeling, Control, and Optimization of Natural Gas Processing Plants William A. Poe, Saeid Mokhatab, 2016-09-09 Modeling Control and Optimization of Natural Gas Processing Plants presents the latest on the evolution of the natural gas industry shining a light on the unique challenges plant managers and owners face when looking for ways to optimize plant performance and efficiency including topics such as the various feed gas compositions temperatures pressures and throughput capacities that keep them looking for better decision support tools The book delivers the first reference focused strictly on the fast growing natural gas markets Whether you are trying to magnify your plants existing capabilities or are designing a new facility to handle more feedstock options this reference guides you by combining modeling control and optimization strategies with the latest developments within the natural gas industry including the very latest in algorithms software and real world case studies Helps users adapt their natural gas plant quickly with optimization strategies and advanced control methods Presents real world application for gas process operations with software and algorithm comparisons and practical case studies Provides coverage on multivariable control and optimization on existing equipment Allows plant managers and owners the tools they need to maximize the value of the natural gas produced Green Solvents II Ali Mohammad, Dr. Inamuddin, 2012-03-18 The conventional solvents used in chemical pharmaceutical biomedical and separation processes represent a great challenge to green chemistry because of their toxicity and flammability Since the beginning of the 12 Principles of Green Chemistry in 1998 a general effort has been made to replace conventional solvents with environmentally benign substitutes Water has been the most popular choice so far followed by ionic liquids surfactant

supercritical fluids fluorous solvents liquid polymers bio solvents and switchable solvent systems Green Solvents Volume I and II provides a throughout overview of the different types of solvents and discusses their extensive applications in fields such as extraction organic synthesis biocatalytic processes production of fine chemicals removal of hydrogen sulphide biochemical transformations composite material energy storage devices and polymers These volumes are written by leading international experts and cover all possible aspects of green solvents properties and applications available in today s literature Green Solvents Volume I and II is an invaluable guide to scientists R D industrial specialists researchers upper level undergraduates and graduate students Ph D scholars college and university professors working in the field of chemistry Food Engineering Handbook Theodoros Varzakas, Constantina Tzia, 2014-12-02 Food Engineering Handbook Food Engineering Fundamentals provides a stimulating and up to date review of food engineering phenomena Combining theory with a practical hands on approach this book covers the key aspects of food engineering from mass and heat transfer to steam and boilers heat exchangers diffusion and absorption A complement to Food Engineering Handbook Food Process Engineering this text Explains the interactions between different food constituents that might lead to changes in food properties Describes the characterization of the heating behavior of foods their heat transfer heat exchangers and the equipment used in each food engineering method Discusses rheology fluid flow evaporation and distillation and includes illustrative case studies of food behaviors Presenting cutting edge information Food Engineering Handbook Food Engineering Fundamentals is an essential reference on the fundamental concepts associated with food engineering today

Encyclopedia of Chemical Processing and Design John J. McKetta Jr,1995-06-26 Written by engineers for engineers with over 150 International Editorial Advisory Board members this highly lauded resource provides up to the minute information on the chemical processes methods practices products and standards in the chemical and related industries Ullmann's Energy Wiley-VCH,2015-06-02 Mit einer Sammlung der wichtigsten Artikel aus ULLMANN s Encyclopedia of Industrial Chemistry bietet dieses dreib ndige Handbuch unz hlige Informationen zu Energieressourcen und technologien Dabei werden erneuerbare und auch fossile Energietr ger gleicherma en behandelt Rules of Thumb for Chemical Engineers Stephen M Hall,2011-03-31 This new edition of the most complete handbook for chemical and process engineers incorporates the latest information for engineers and practitioners who depend on it as a working tool New material explores the recent trends and updates of gas treating and fractionator computer solutions analysis Substantial additions to this edition include a new section on gasification that reflects the many new trends and techniques in the field and a treatment on compressible fluid flow This convenient volume provides engineers with hundreds of common sense techniques shortcuts and calculations to quickly and accurately solve day to day design operations and equipment problems Here in a compact easy to use format are practical tips handy formulas correlations curves charts tables and shortcut methods that will save engineers valuable time and effort The standard handbook for chemical and process engineers All new material on pinch point analysis on networks

of heat exchangers and updates on gas treating in process design and heat transfer Hundreds of common sense techniques Fundamentals of Petroleum Refining Mohamed A. Fahim, Taher A. Al-Sahhaf, Amal and calculations Elkilani, 2009-11-19 Fundamentals of Petroleum Refining presents the fundamentals of thermodynamics and kinetics and it explains the scientific background essential for understanding refinery operations. The text also provides a detailed introduction to refinery engineering topics ranging from the basic principles and unit operations to overall refinery economics. The book covers important topics such as clean fuels gasification biofuels and environmental impact of refining which are not commonly discussed in most refinery textbooks Throughout the source problem sets and examples are given to help the reader practice and apply the fundamental principles of refining Chapters 1 10 can be used as core materials for teaching undergraduate courses The first two chapters present an introduction to the petroleum refining industry and then focus on feedstocks and products Thermophysical properties of crude oils and petroleum fractions including processes of atmospheric and vacuum distillations are discussed in Chapters 3 and 4 Conversion processes product blending and alkylation are covered in chapters 5 10 The remaining chapters discuss hydrogen production clean fuel production refining economics and safety acid gas treatment and removal and methods for environmental and effluent treatments This source can serve both professionals and students on undergraduate and graduate levels of Chemical and Petroleum Engineering Chemistry and Chemical Technology Beginners in the engineering field specifically in the oil and gas industry may also find this book invaluable Provides balanced coverage of fundamental and operational topics Includes spreadsheets and process simulators for showing trends and simulation case studies Relates processing to planning and management to give an integrated picture of refining Greenhouse Gases Guoxiang Liu, 2012-03-09 Understanding greenhouse gas capture utilization reduction and storage is essential for solving issues such as global warming and climate change that result from greenhouse gas Taking advantage of the authors experience in greenhouse gases this book discusses an overview of recently developed techniques methods and strategies Novel techniques and methods on greenhouse gas capture by physical adsorption and separation chemical structural reconstruction and biological utilization Systemic discussions on greenhouse gas reduction by policy conduction mitigation strategies and alternative energy sources A comprehensive review of geological storage monitoring technologies

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