

Table of Contents

Introduction	1
1. Gas Treating as a Mass Transfer Rate Process	5
Anatomy of a Mass Transfer Rate Model	8
Equilibrium Stage Modeling with Kinetics	16
Summary	18
2. Important Parameters in Gas Treating with Amines	21
Amine Absorbers	22
<i>Normal Temperature Profiles and Lean-End Pinches</i>	22
<i>Under-circulated Absorbers</i>	26
<i>Bulge Pinches</i>	32
<i>Solvent Strength</i>	34
<i>Other Factors Affecting Absorber Performance</i>	39
Amine Regenerators	39
<i>Effect of Reboiler Duty</i>	40
<i>Effect of Rich Amine Temperature</i>	44
<i>Reflux and Stripping Ratios</i>	45
<i>Other Operating Parameters</i>	48
References	49
3. Specialty Solvents: Blended Amines	51
Vapor-Liquid Equilibrium	51
Reaction Kinetics in Mixed Amine Systems	56
Case Study	57
Summary	63
References	65
4. Promoted Solvents: Activation with Piperazine	67
Effect of Piperazine Concentration on Treating	69

5. Specialty Solvents: Stripping Promoters	75
The Chemistry of Partially Neutralized Amines	75
Successful Use of Stripping Promoters	78
Case Study 1 — Tail Gas Treating	80
Case Study 2 — Low H ₂ S:CO ₂ Ratio Gas at High Pressure	85
Summary	90
References	90
6. Effect of Heat Stable Salts on Process Performance	91
Introduction	91
Sources of Heat Stable Salts	92
Amine Treating Solution Chemistry	94
Impacts of Heat Stable Salts on Treating	96
Solvent Reclaiming	97
Case Study 1: Refinery Fuel-Gas High-Pressure Treater	99
Case Study 2: Refinery Fuel-Gas Low-Pressure Treater	102
Case Study 3: Tail Gas Treater	103
7. Understanding Solvent Analysis	109
Analysis Errors and Their Effect	110
Terminology	112
Titrimetric Analyses and Their Errors	116
Virtual Titration Using Process Simulation	120
Example 7-1: Refinery Gas: H ₂ S-MDEA	126
<i>Rich Amine Loading</i>	130
Example 7-2: Natural Gas: CO ₂ -MEA	133
<i>pH Back-Titration Method</i>	135
<i>pH Acid Titration Method</i>	138
Summary	139
References	142
8. Using Simulation in Troubleshooting	143
Introduction	143
Troubleshooting Preliminaries	145

<i>Instrumentation</i>	145
<i>Sampling</i>	147
<i>Verifying Plant Data</i>	149
Troubleshooting Case Studies	150
Case Study 1	
<i>Situation</i>	151
<i>Troubleshoot</i>	152
Case Study 2	
<i>Situation</i>	155
<i>Troubleshoot</i>	156
Case Study 3	
<i>Situation</i>	162
Summary	169
9. Effect of Tray and Packing Hydraulics on Mass Transfer	173
Introduction	173
Random and Structured Packing, and Trays	176
Tray Hydraulic Regimes	180
<i>Downcomer Flood</i>	184
<i>Backup Flood</i>	184
<i>Choke Flood</i>	184
<i>Weeping Through Tray Openings</i>	185
<i>Spray Regime</i>	186
Foaming	189
<i>Anti-Foam</i>	190
Field Performance Data at Low Weir Loads	191
Summary	198
References	199
10. Acid Gas Enrichment	201
Introduction	201
Some Process Configurations	205
<i>Stand-Alone AGE</i>	205
<i>SCOT and AGE Units with Common Regenerator</i>	207
<i>DUAL-SOLVE Process</i>	208

<i>Enriched Gas Recycle: HIGHSULF™</i>	210
Case Study — A Disposal Problem	213
Summary	214
References	216
11. Bulk CO₂ Removal with MDEA	217
Introduction	217
Understanding the Process	218
Case Study 1	221
Case Study 2	226
Summary	230
12. Dimethylether of Polyethylene Glycol	233
Introduction	233
Physical Solvents versus Amines	234
Selectivity	236
DMPEG Regeneration	238
Typical Process Flowsheet	239
Simulation Using a Mass Transfer Rate Model	240
References	242
13. Glycol Dehydration	243
Introduction	243
Phase Equilibrium	244
Process Description	247
Process Simulation	248
Dehydration Column Performance	250
Stahl Columns and Stripping Gas	253
Interesting Observations from a Mass Transfer Rate Model	255
Factors that Affect Dehydration of Sweet Gases	258
Dehydration of Nearly Pure Acid Gases — H ₂ S	259
Conclusions	262
References	262

14. Post-combustion CO₂ Capture	265
Introduction	265
MEA: The Benchmarking Standard	270
<i>CO₂ Recovery Targets</i>	272
<i>Effect of MEA Absorber Packed Height on CO₂ Recovery</i>	273
<i>Effect of MEA Solvent Circulation Rate on CO₂ Recovery</i>	274
AMP Solvent	277
Amino Acid Salts	283
<i>Sodium Glycinate</i>	284
<i>Potassium Dimethyl Glycinate</i>	
MEA Promoter	285
Piperazine Promoter	286
<i>MDEA</i>	287
Comparison between Solvents	288
Other Considerations	293
References	294
15. Sour Water and Ammonia	295
Introduction	295
Chemistry of Ammonia with Acid Gases	295
Sour Water Generation	297
Basic Stripping Process	300
Sour Water Feed Preparation	304
Stripper Overhead System	305
Process Variations	
<i>2-Stage SWS or Chevron WWT</i>	306
<i>Phosam W Process</i>	309
Tray Efficiencies and Distribution of Ammonia	310
<i>Effect of Stripper Pressure</i>	315
Stripping Phenolic Water	316
<i>Effect of Heat Stable Salts on Stripped Water Quality</i>	317
<i>Where Should Neutralizing Caustic Be Injected?</i>	318
<i>The Effect of Caustic Injection Rate</i>	319
<i>The Set-point for pH Control and Optimal Stripping</i>	320
<i>Effect of Amine Carry-over into the SWS</i>	321

Other SWS Considerations	322
Ammonia in Amine Systems	322
Acid Gas removal with Ammonia	330
References	330
16. Corrosion: Theory and Management in Amine & Sour Water Systems	333
Introduction	333
Tenet 1: The Amine (or NH ₃) is NOT Corrosive	334
Tenet 2: Iron Sulfides <i>Can</i> Protect Against Further Corrosion	335
Tenet 3: Velocity <i>Physically</i> Exacerbates Corrosion	338
Tenet 4: Heat Stable Salts <i>Chemically</i> Exacerbate Corrosion	338
Bicene	341
A Model for H ₂ S Corrosion in Sour, Alkaline Aqueous Systems	342
Cracking and Blistering	345
Corrosion Management	
<i>Prevention</i>	347
<i>Mitigation</i>	348
<i>Obfuscation</i>	349
References	350