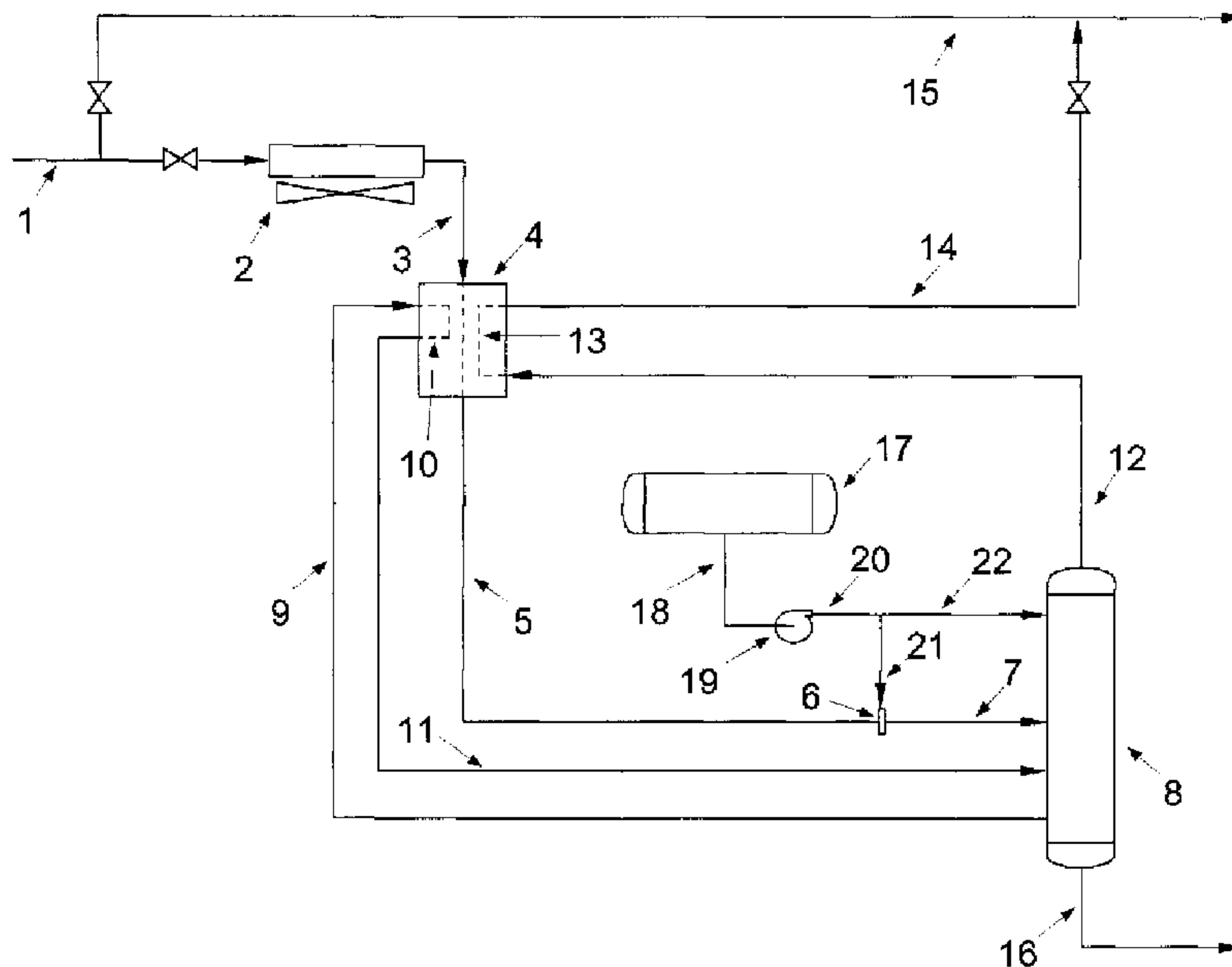




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(54) Titre : PROCÉDE DE RECUPERATION DES GPL ET DES CONDENSATS A PARTIR DES FLUX DE GAZ
COMBUSTIBLE DES RAFFINERIES
(54) Title: A METHOD TO RECOVER LPG AND CONDENSATES FROM REFINERIES FUEL GAS STREAMS



(57) **Abrégé/Abstract:**

A method to recover olefins and C₂+ fractions from refineries gas streams. The traditional recovery methods employed at refineries are absorption with solvents and cryogenic technology using compression and expansion aided by external refrigeration systems. In contrast to known methods, there is provided first a pre-cooling heat exchanger on a feed line feeding the gas stream to a in-line mixer, secondly by injecting and mixing a stream of LNG to condense the C₂+ fractions upstream of the fractionator. The temperature of the gas stream entering the fractionator is monitored downstream of the in- line mixer. A LNG stream is temperature controlled to flow through the injection inlet and mix with the feed gas at a temperature which results in the condensation of the C₂+ fractions before entering the fractionator. A LNG reflux stream is temperature controlled to maintain fractionator overhead temperature. The fractionator bottoms temperature is controlled by a circulating reboiler stream.



ABSTRACT OF THE DISCLOSURE

A method to recover olefins and C_2^+ fractions from refineries gas streams. The traditional recovery methods employed at refineries are absorption with solvents and cryogenic technology using compression and expansion aided by external refrigeration systems. In contrast to known methods, there is provided first a pre-cooling heat exchanger on a feed line feeding the gas stream to a in-line mixer, secondly by injecting and mixing a stream of LNG to condense the C_2^+ fractions upstream of the fractionator. The temperature of the gas stream entering the fractionator is monitored downstream of the in-line mixer. A LNG stream is temperature controlled to flow through the injection inlet and mix with the feed gas at a temperature which results in the condensation of the C_2^+ fractions before entering the fractionator. A LNG reflux stream is temperature controlled to maintain fractionator overhead temperature. The fractionator bottoms temperature is controlled by a circulating reboiler stream.

TITLE OF THE INVENTION:

A method to recover LPG and condensates from refineries fuel gas streams.

FIELD OF THE INVENTION

5 The present invention relates to a method that condenses and recovers low pressure gas (LPG) and condensates from fuel gas headers in oil refineries using Liquid Natural Gas (LNG) as a cryogenic process.

BACKGROUND OF THE INVENTION

10 Refineries process crude oil by separating it into a range of components, or fractions, and then rearranging those into components to better match the yield of each fraction with market demand. Petroleum fractions include heavy oils and residual materials used to make asphalt or petroleum coke, mid range materials such as diesel, heating oil, jet fuel and gasoline, and lighter products such as butane propane and fuel
15 gases. Refineries are designed and operated so that there will be a balance between the rates of gas production and consumption. Under normal operating conditions, essentially all gases that are produced are routed to the refinery fuel gas system, allowing them to be used for combustion equipment such as refinery heaters and boilers. Before the fuel gas is consumed at the refinery it is first amine treated to remove carbon dioxide and hydrogen
20 sulfide before combustion. The treated typical refinery fuel gas systems are configured so that the fuel gas header pressure is maintained by using imported natural gas to make up the net fuel demand. This provides a simple way to keep the system in balance so long as gas needs exceeds the volume of gaseous products produced.

 A typical refinery fuel gas stream is rich in hydrogen, C_2^+ and olefins. It is well
25 known that gas streams can be separated into their component parts, involving chilling, expansion and distillation, to separate methane from heavier hydrocarbon components. Cryogenic processing of refinery fuel gas to recover valuable products (hydrogen, olefins and LPG) are a standard in the refining industry. Cryogenic processes in practice provide refrigeration by turbo-expansion of fuel gas header pressure re-compression and or
30 mechanical refrigeration. Others have employed the use of membranes to first separate and produce a hydrogen stream and a hydrocarbon stream. In these cryogenic mechanical

processes, there is a need for compression since typical fuel gas header pressures vary between 60 to 200 psi.

It is desirable therefore to have a process wherein the C_2^+ fractions from refinery fuel gas streams are efficiently and effectively separated as value added products.

5 Cryogenic separation is typically viewed as being the most thermodynamically efficient separation technology. It is one of the first choices when higher value can be obtained from other products (olefins, LPG), especially when BTU removal from the fuel gas header system is of high priority. As, will be discussed, the present invention provides a process that achieves high product recoveries from refinery fuel gases economically, both
10 in capital and operating costs. The process does not require feed or product compression, so its very reliable, pumps are the only rotating equipment. In addition, the present invention offers the ability to regulate a refinery gas variable pressure and composition.

SUMMARY OF THE INVENTION

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The claimed invention provides a method to cool and condense the C_2^+ fractions from a treated refinery fuel gas stream. First by cooling the fuel gas to ambient temperature through an air cooling fin-fan exchanger, secondly by pre-cooling the fuel gas stream in a plate fin exchanger, thirdly by adding and mixing a stream of Liquefied Natural Gas (LNG)
20 sufficient to meet the desired dew point of the C_2^+ fractions in the refinery fuel gas stream. The cooled refinery fuel gas stream is separated into a C_2^+ fraction and a C_1^- fraction. The cold C_1^- fraction is routed through the plate fin exchanger to give up its cold in the pre-cooling step before entering the fuel gas system. The C_2^+ fraction can be routed to a fractionation unit for products separation. The process can meet various modes of
25 operation such as a C_2^- fraction and a C_3^+ fraction streams, if so desired by controlling the temperature profile in the tower and LNG addition. At present, there is an incentive for the recovery of ethane as feed stock for the petrochemical industry.

In a preferred embodiment, the present invention is a process for the recovery of C_2^+ fractions from a hydrocarbon containing refinery fuel gas stream comprised of
30 hydrogen and C_1, C_2, C_3^+ hydrocarbons, comprising:

- (a) First cooling the treated refinery fuel gas stream to ambient temperature in an air heat exchanger, alternatively a cooling water heat exchanger can also be employed.
- (b) Second by pre-cooling the fuel gas stream in a cold box, acting as a reboiler to the tower bottoms and as a condenser to the tower overhead stream.
- 5 (c) Third, the pre-cooled fuel gas stream is then mixed with a controlled stream of LNG to achieve the desired temperature to condense the desired liquids from the fuel gas stream. The mixture of liquids and gases enters a fractionation tower where the gases and liquids are separated. The liquids fraction is circulated through a reboiler and back to the tower to remove the light fraction in the stream. The gaseous fraction is
- 10 stripped of its heavier components by a controlled reflux stream of LNG. The exiting produced cold vapour pre-cools the process feed gas giving up its cold energy before entering the fuel gas header.

A major feature of the invention is its ability to operate under varying refinery flow rates, feed compositions and pressures. Refinery fuel gas streams are variable since they are

15 fed from multiple units. The inventive process can meet any refinery process plant variations, which are not uncommon in refinery fuel gas systems. The process is not dependent on plant refrigeration size and or equipment such as compressors employed in conventional LPG recovery processes.

The refrigeration plant is a supply of LNG which is added and directly mixed with the

20 refinery fuel gas achieving the maximum heat transfer efficiency, the amount of LNG added is controlled on demand to meet desired product specs. Whereas, in conventional LPG recovery cryogenic plants, gas composition has an effect on the amount of compression horsepower required; richer gas generally requires more horsepower to achieve the same recovery level than a leaner gas because of having more heavy

25 components. As inlet pressure decreases, more heat transfer area is required to achieve the same recovery level inside the cold box, as well, more exchanger area is required for ethane recovery than for propane recovery due to the higher amount of energy that must be transferred to cool the gas to the required temperatures.

Another benefit of the inventive process is the improvement of the refinery fuel gas stream,

30 the reduced dew point of the fuel gas stream improves winter operations significantly. Thus, safety issues and operating difficulties associated with hydrocarbon condensate are eliminated.

As will hereinafter be described, the above method can operate at any refinery fuel gas operating conditions, resulting in substantial savings in both capital and operating costs.

5 The above described method was developed with a view to recover LPG from refinery fuel gas streams using LNG as a cryogenic process.

 According there is provided a LPG recovery plant, which includes cooling the refinery fuel gas stream to ambient temperature, pre-cooling the refinery fuel gas by cross
10 exchange with fractionation unit bottom and overhead streams, adding and mixing LNG to directly cool and condense the desired liquid fractions, generating a two-phase stream that enters the fractionation unit. The fractionation unit is supplied at the top tray with LNG on demand as a reflux stream. At the bottom of the fractionation unit a reboiler is provided to fractionate the light fractions from the bottom stream. The trays in the fractionation unit
15 provide additional fractionation and heat exchange thus facilitating the separation. The fractionator generates two streams, a liquid stream (LPG) and a very cold vapour stream.

 As will hereinafter be further described, the refinery feed gas is first cooled to ambient temperature, secondly, the ambient cooled refinery feed gas stream is pre-cooled by the
20 fractionator bottoms reboiler stream and the fractionator overhead cold vapour stream in a counter-current flow. To the pre-cooled refinery feed gas stream, a stream of LNG is added and mixed with the refinery feed gas to meet a selected fractionation unit operating temperature. The fractionator overhead temperature is controlled by a LNG reflux stream. The fractionator bottoms temperature is controlled by a circulating reboiler stream.

25

BRIEF DESCRIPTION OF THE DRAWINGS

 These and other features of the invention will become more apparent from the
30 following description in which reference is made to the appended drawings, the drawings are for the purpose of illustration only and are not intended to in any way limit the scope of the invention to the particular embodiment or embodiments shown, wherein:

FIG. 1 is a schematic diagram of a gas liquids recovery facility equipped with a heat exchangers, a in-line mixer, a LNG storage bullet, pumps and a fractionator. The LNG is supplied to two locations; the in-line mixer and a reflux stream to the fractionator.

FIG. 2 is a schematic diagram of a gas liquids recovery facility equipped with a variation in the process whereas LNG is added only as a reflux stream.

FIG. 3 is a schematic diagram of a gas liquids recovery facility equipped with a variation in the process whereas LNG is added only to the feed gas and mixed before fractionation.

10 DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENT

The method will now be described with reference to **FIG. 1**.

As set for the above, this method was developed with a view for cryogenic recovery of C_2^+ fractions from typical refinery fuel gas streams. The description of application of the method should, therefore, be considered as an example.

Referring to **FIG. 1**, a refinery feed gas stream 1 is cooled to ambient temperature in a fin-fan air heat exchanger 2. The ambient cooled refinery feed gas stream 3 enters a heat exchanger (cold box) 4. The heat exchanger (cold box) houses the reboiler coils 10 and the overhead condenser coils 13. The stream 3, is first pre-cooled by a circulating reboiler stream 9 in a counter-current flow through coil 10, this counter-current heat exchange, provides the heat required to fractionate the bottoms stream while cooling the inlet refinery gas stream. The reboiler re-circulation stream 9 feed rate is controlled to meet fractionator bottoms needs. The refinery feed gas stream is further cooled by a stripped fractionator overhead stream 12 in a counter-current flow through coil 13, this counter current heat exchange substantially cools the refinery feed gas stream. The pre-cooled refinery feed gas stream 5 exits heat exchanger (cold box) 4 and flows through in-line mixer 6 where LNG stream 21 is added and mixed as required to meet a selected stream temperature in stream 7. The two-phase temperature controlled stream 7, enters fractionator 8 to produce a vapour and a liquid stream.

30 In this mode of operation the fractionator 8 overhead vapour stream 12 is primarily a C_1^- fraction. The fractionator 8 overhead temperature is controlled by a LNG reflux stream 22. The trays in the fractionator 8 provide additional fractionation and heat exchange thus

facilitating the separation. The bottoms temperature in Fractionator 8 is controlled by a circulating liquid stream 9 that gains heat through coil 10 in heat exchanger (cold box) 4, the heated circulating bottoms stream 11 is returned to the upper bottom section of fractionator 8 to be stripped of its light fraction. The fractionated liquid stream 16 is primarily a C_2^+ fraction, it exits fractionator 8 as its bottoms stream for further fractionation ie: a de-ethanizer, de-propanizer, etc...

The refrigerant used in the process is LNG which is stored in bullet 17. The LNG is added to the process through LNG feed line 18 to LNG pump 19. The pressurized LNG stream 20 supplies LNG through stream 21 to a in-line mixer 6. The LNG stream 21 flow rate is controlled to meet a selected two-phase stream 7 temperature. Stream 21 is added and mixed with pre-cooled refinery gas stream 5 at in-line mixer 6 to produce a desired temperature two-phase stream 7. The LNG pressurized stream 21 also supplies LNG to reflux stream 22 that enters the top tray in fractionator 8. LNG reflux stream 22 controls the temperature at the top of fractionator 8.

A main feature of this invention is the simplicity of the process which eliminates the use of compression and expansion and or external refrigeration systems. Another feature of the invention is the flexibility of the process to meet various operating conditions since only LNG is added on demand to meet process operations parameters. The invention also provides for a significant savings in energy when compared to other processes since no compression or external refrigeration facilities are employed as in conventional cryogenic processes. The proposed invention can be applied at any refinery fuel gas plant size.

Referring to FIG. 2, the main difference from Fig.1, is the removal of in-line mixer 6. In this process mode, LNG is added only as a reflux stream to the top tray of fractionator 8. The temperature of the refinery feed gas stream 5 into fractionator 8 is fully dependent on the pre-cooling at heat exchanger (cold box) 4. The operation of the fractionator 8, bottoms is controlled by a circulating reboiler flow rate stream 9, through coil 10, the heated stream 11 flows back to the upper bottom section of fractionator 8, just as in FIG. 1. The temperature at the top of fractionator 8 is controlled by a LNG reflux stream 22. The trays in the fractionator 8 provide additional fractionation and heat exchange thus facilitating the separation. This process orientation provides an alternative method to fractionate refinery

feed gas at albeit less efficiency than when using an in-line mixer 6 as shown in Fig.1.

Referring to **FIG. 3**, the main difference from FIG. 1 and FIG.2 is the removal of the reflux stream to the top of fractionator 8 and the removal of a circulating reboiler stream from the bottoms of fractionator 8. In this mode of operation, fractionator 8 becomes a simple gas/liquid separator where both vapour and liquid streams are not fractionated. This simple mode of operation allows for the recovery of LPG and reduction of the dew point in refinery fuel gas for combustion.

In this patent document, the word "comprising" is used in its non-limiting sense to mean that items following the word are included, but items not specifically mentioned are not excluded. A reference to an element by the indefinite article "a" does not exclude the possibility that more than one of the element is present, unless the context clearly requires that there be one and only one of the elements.

15

The scope of the claims should not be limited by the preferred embodiments set forth in the examples, but should be given a broad purposive interpretation consistent with the description as a whole.

What is Claimed is:

1. A method of recovering C_2^+ fractions from refinery gas where liquefied natural gas (LNG) is employed as the cryogenic energy source to condense and fractionate the C_2^+ fractions from a refinery gas stream, comprising:
 - 5 providing an heat exchanger on a feed line feeding the gas stream to the gas in-line mixer;
 - providing a in-line gas mixer downstream of the heat exchanger on a feed line feeding the gas stream to the fractionator;
 - 10 providing a LNG storage bullet and a cryogenic feed pump to supply LNG to the in-line mixer and a reflux stream to the top tray in the fractionator;
 - controlling the LNG injection to the mixer to condense the C_2^+ fractions present in the feed gas stream entering the fractionator
 - controlling the LNG reflux stream injection to the top tray in the fractionator to control fractionator overhead temperature
 - 15 providing trays in the fractionator for heat exchange and fractionation; and
 - controlling the temperature of the fractionator bottoms by a flow controlled circulating gas stream entering the gas through a reboiler.
- 20 2. The method of Claim 1, wherein pre-cooling is provided by a vapour fraction from the fractionator.
3. The refinery liquids recovery plant, comprising:
 - 25 a gas heat exchanger to pre-cool the feed gas;
 - a in-line mixer assembly on the feed line for injecting LNG;
 - a fractionator;
 - a LNG storage tank and feed pumps;
 - a LNG reflux line to the top tray in the fractionator;
 - a fractionator bottoms circulating reboiler circuit;

FIG. 1

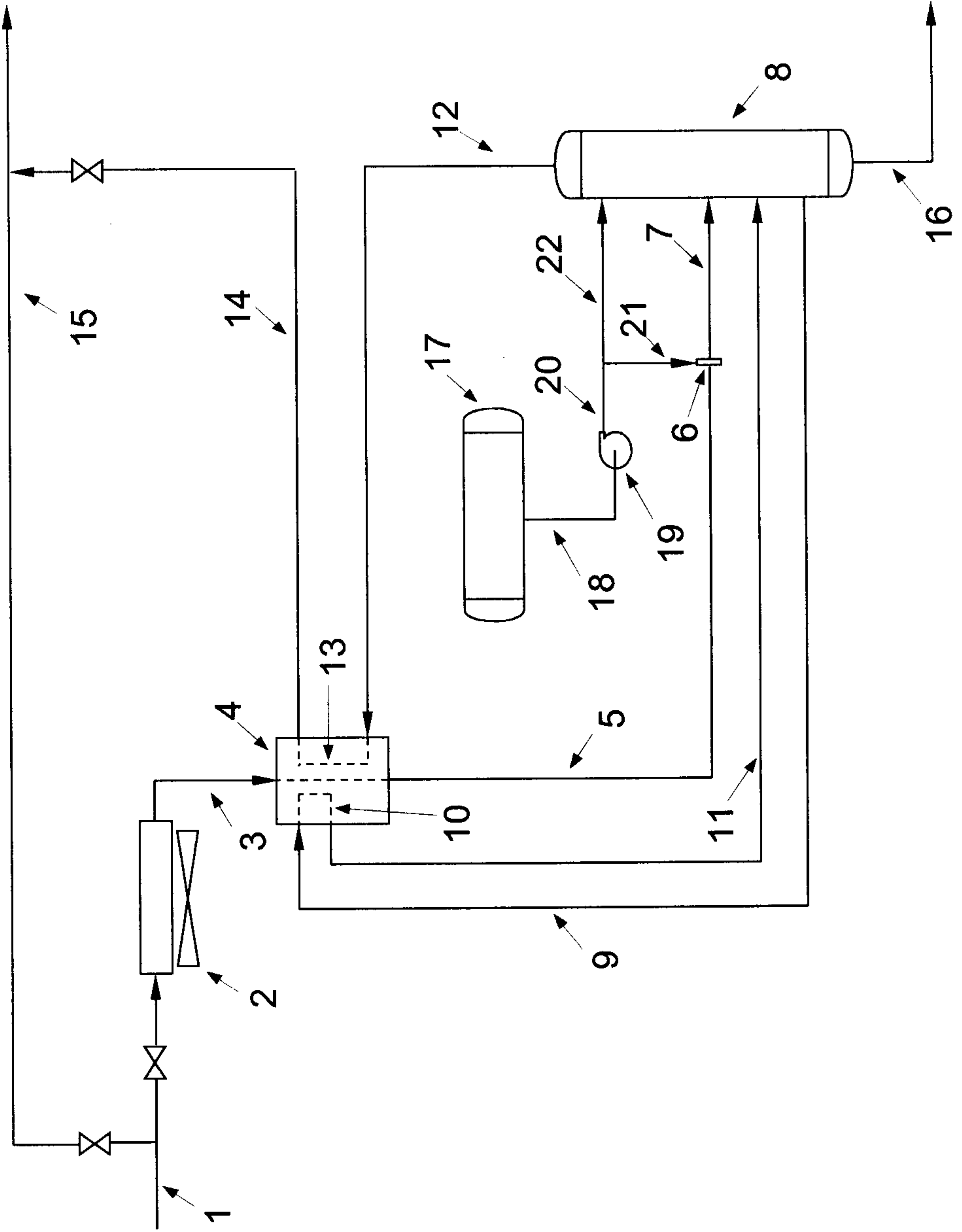


FIG. 2

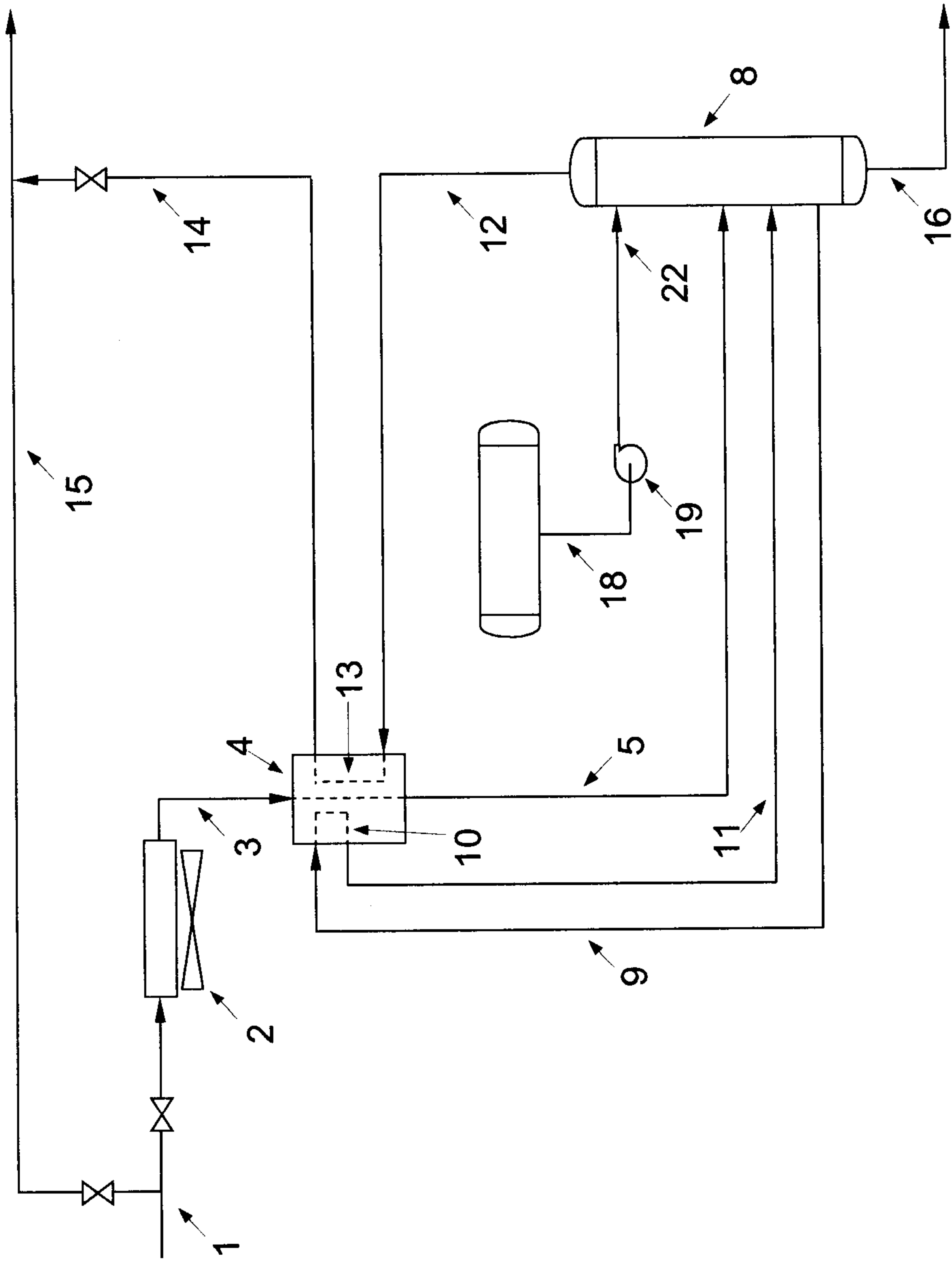


FIG. 3

