

**METHOD AND SYSTEM OF MODIFYING A LIQUID LEVEL
DURING START-UP OPERATIONS**

CROSS REFERENCE TO RELATED APPLICATIONS

5 **[0001]** This application claims the priority benefit of both United States Provisional patent application number 61/912,984 on December 6, 2013 entitled METHOD AND SYSTEM OF MODIFYING A LIQUID LEVEL DURING START-UP OPERATIONS; the entirety of which is incorporated by reference herein.

10 **[0002]** This application is related to but does not claim priority to U.S. Provisional patent application numbers: 61/912,957 filed on December 6, 2013 entitled METHOD AND
DEVICE FOR SEPARATING HYDROCARBONS AND CONTAMINANTS WITH A
SPRAY ASSEMBLY; 62/044,770 filed on September 2, 2014 entitled METHOD AND
DEVICE FOR SEPARATING HYDROCARBONS AND CONTAMINANTS WITH A
SPRAY ASSEMBLY; 61/912,959 filed on December 6, 2013 entitled METHOD AND
15 SYSTEM OF MAINTAINING A LIQUID LEVEL IN A DISTILLATION TOWER;
61/912,964 filed on December 6, 2013 entitled METHOD AND DEVICE FOR
SEPARATING A FEED STREAM USING RADIATION DETECTORS; 61/912,970 filed
on December 6, 2013 entitled METHOD AND SYSTEM OF DEHYDRATING A FEED
STREAM PROCESSED IN A DISTILLATION TOWER; 61/912,975 filed on December 6,
20 2013 entitled METHOD AND SYSTEM FOR SEPARATING A FEED STREAM WITH A
FEED STREAM DISTRIBUTION MECHANISM; 61/912,978 filed on December 6, 2013
entitled METHOD AND SYSTEM FOR PREVENTING ACCUMULATION OF SOLIDS
IN A DISTILLATION TOWER; 61/912,983 filed on December 6, 2013 entitled METHOD
OF REMOVING SOLIDS BY MODIFYING A LIQUID LEVEL IN A DISTILLATION
25 TOWER; 61/912,986 filed on December 6, 2013 entitled METHOD AND DEVICE FOR
SEPARATING HYDROCARBONS AND CONTAMINANTS WITH A HEATING
MECHANISM TO DESTABILIZE AND/OR PREVENT ADHESION OF SOLIDS;
61/912,987 filed on December 6, 2013 entitled METHOD AND DEVICE FOR
SEPARATING HYDROCARBONS AND CONTAMINANTS WITH A SURFACE
30 TREATMENT MECHANISM.

BACKGROUND

Fields of Disclosure

[0003] The disclosure relates generally to the field of fluid separation. More specifically, the disclosure relates to the cryogenic separation of contaminants, such as acid gas, from a hydrocarbon.

Description of Related Art

[0004] This section is intended to introduce various aspects of the art, which may be associated with the present disclosure. This discussion is intended to provide a framework to facilitate a better understanding of particular aspects of the present disclosure. Accordingly, it should be understood that this section should be read in this light, and not necessarily as admissions of prior art.

[0005] The production of natural gas hydrocarbons, such as methane and ethane, from a reservoir oftentimes carries with it the incidental production of non-hydrocarbon gases. Such gases include contaminants, such as at least one of carbon dioxide (“CO₂”), hydrogen sulfide (“H₂S”), carbonyl sulfide, carbon disulfide and various mercaptans. When a feed stream being produced from a reservoir includes these contaminants mixed with hydrocarbons, the stream is oftentimes referred to as “sour gas.”

[0006] Many natural gas reservoirs have relatively low percentages of hydrocarbons and relatively high percentages of contaminants. Contaminants may act as a diluent and lower the heat content of hydrocarbons. Some contaminants, like sulfur-bearing compounds, are noxious and may even be lethal. Additionally, in the presence of water some contaminants can become quite corrosive.

[0007] It is desirable to remove contaminants from a stream containing hydrocarbons to produce sweet and concentrated hydrocarbons. Specifications for pipeline quality natural gas typically call for a maximum of 2 – 4% CO₂ and ¼ grain H₂S per 100 scf (4 ppmv) or 5 mg/Nm³ H₂S. Specifications for lower temperature processes such as natural gas liquefaction plants or nitrogen rejection units typically require less than 50 ppm CO₂.

[0008] The separation of contaminants from hydrocarbons is difficult and consequently significant work has been applied to the development of hydrocarbon/contaminant separation methods. These methods can be placed into three general classes: absorption by solvents (physical, chemical and hybrids), adsorption by solids, and distillation.

[0009] Separation by distillation of some mixtures can be relatively simple and, as such, is widely used in the natural gas industry. However, distillation of mixtures of natural gas hydrocarbons, primarily methane, and one of the most common contaminants in natural gas, carbon dioxide, can present significant difficulties. Conventional distillation principles and
5 conventional distillation equipment are predicated on the presence of only vapor and liquid phases throughout the distillation tower. The separation of CO₂ from methane by distillation involves temperature and pressure conditions that result in solidification of CO₂ if a pipeline or better quality hydrocarbon product is desired. The required temperatures are cold temperatures typically referred to as cryogenic temperatures.

10 [0010] Certain cryogenic distillations can overcome the above mentioned difficulties. These cryogenic distillations provide the appropriate mechanism to handle the formation and subsequent melting of solids during the separation of solid-forming contaminants from hydrocarbons. The formation of solid contaminants in equilibrium with vapor-liquid mixtures of hydrocarbons and contaminants at particular conditions of temperature and
15 pressure takes place in a controlled freeze zone section.

[0011] The solids formed in the controlled freeze zone section may be melted in a melt tray assembly of the controlled freeze zone liquid. Liquid in the melt tray assembly helps melt the solids.

[0012] Solids, however, may accumulate in the controlled freeze zone section when the
20 melt tray assembly does not contain a sufficient amount of liquid to melt the solids. The melt tray assembly may not contain a sufficient amount of liquid during start-up of the distillation tower. The liquid originates from the feed stream processed in the distillation tower. The melt-tray assembly may not accumulate enough liquid during start-up if the feed stream introduced into the distillation tower does not include enough contaminants. This feed stream
25 may not include enough contaminants if the feed stream comprises less than 20% contaminants.

[0013] The accumulation of solids is disadvantageous. The accumulation can interference with the proper operation of and the effective separation of methane from contaminants.

30 [0014] A need, therefore, exists for improved technology for increasing the amount of liquid in the melt tray assembly during start-up of the distillation tower.

SUMMARY

[0015] The present disclosure provides a device and method for separating contaminants from hydrocarbons, among other things.

[0016] A method for separating a feed stream in a distillation tower may comprise operating a controlled freeze zone section in a distillation tower that separates a feed stream
5 at a temperature and pressure at which the feed stream forms a solid in the controlled freeze zone section, wherein the feed stream includes a first contaminant; maintaining a melt tray assembly in the controlled freeze zone section; introducing the feed stream to the controlled freeze zone section; and accumulating a liquid in the melt tray assembly until the liquid is at a predetermined liquid level in the controlled freeze zone section, by: feeding a second
10 contaminant to the controlled freeze zone section; and adding the second contaminant to the melt tray assembly, wherein the liquid comprises the second contaminant.

[0017] A method for producing hydrocarbons in a distillation tower may comprise operating a controlled freeze zone section in a distillation tower that separates the feed stream at a temperature and pressure at which the feed stream forms a solid in the controlled freeze
15 zone section, wherein the feed stream includes a first contaminant and a hydrocarbon; maintaining a melt tray assembly in the controlled freeze zone section; introducing the feed stream to the controlled freeze zone section; accumulating a liquid in the melt tray assembly until the liquid is at a predetermined liquid level in the controlled freeze zone section, by: feeding a second contaminant to the controlled freeze zone section; and adding the second
20 contaminant to the melt tray assembly, wherein the liquid comprises the second contaminant; and; producing the hydrocarbon after recovering the hydrocarbon.

[0018] A system for separating a first contaminant in a feed stream from a hydrocarbon in the feed stream may comprise a distillation tower comprising a controlled freeze zone section constructed and arranged to separate the feed stream at a temperature and pressure at which
25 the feed stream forms a solid, wherein the controlled freeze section includes a melt tray assembly having a liquid that melts the solid, and wherein the liquid comprises a first contaminant in the feed stream; an inlet channel extending to the controlled freeze zone section; and at least one of: a first storage unit holding a second contaminant; and a first channel extending from the first storage unit to the controlled freeze zone section; and an
30 indirect channel that extends from at least one of (i) the distillation tower to the inlet channel (ii) the distillation tower to the first channel and (iii) a second storage unit to the inlet channel, wherein the second storage unit holds the second contaminant.

[0019] The foregoing has broadly outlined the features of the present disclosure in order that the detailed description that follows may be better understood. Additional features will also be described herein.

BRIEF DESCRIPTION OF THE DRAWINGS

5 [0020] These and other features, aspects and advantages of the disclosure will become apparent from the following description, appending claims and the accompanying drawings, which are briefly described below.

[0021] Figure 1 is a schematic diagram of a tower with sections within a single vessel.

[0022] Figure 2 is a schematic diagram of a tower with sections within multiple vessels.

10 [0023] Figure 3 is a schematic diagram of a tower with sections within a single vessel.

[0024] Figure 4 is a schematic diagram of a tower with sections within multiple vessels.

[0025] Figure 5 is a schematic diagram of a controlled freeze zone section and a lower section of a distillation tower.

[0026] Figure 6 is a flowchart of a method within the scope of the present disclosure.

15 [0027] It should be noted that the figures are merely examples and no limitations on the scope of the present disclosure are intended thereby. Further, the figures are generally not drawn to scale, but are drafted for purposes of convenience and clarity in illustrating various aspects of the disclosure.

DETAILED DESCRIPTION

20 [0028] For the purpose of promoting an understanding of the principles of the disclosure, reference will now be made to the features illustrated in the drawings and specific language will be used to describe the same. It will nevertheless be understood that no limitation of the scope of the disclosure is thereby intended. Any alterations and further modifications, and any further applications of the principles of the disclosure as described herein are
25 contemplated as would normally occur to one skilled in the art to which the disclosure relates. It will be apparent to those skilled in the relevant art that some features that are not relevant to the present disclosure may not be shown in the drawings for the sake of clarity.

[0029] As referenced in this application, the terms “stream,” “gas stream,” “vapor stream,” and “liquid stream” refer to different stages of a feed stream as the feed stream is
30 processed in a distillation tower that separates methane, the primary hydrocarbon in natural

gas, from contaminants. Although the phrases “gas stream,” “vapor stream,” and “liquid stream,” refer to situations where a gas, vapor, and liquid is mainly present in the stream, respectively, there may be other phases also present within the stream. For example, a gas may also be present in a “liquid stream.” In some instances, the terms “gas stream” and
5 “vapor stream” may be used interchangeably.

[0030] The disclosure relates to a system and method for separating a feed stream in a distillation tower that ensures that enough liquid accumulates in a melt-tray assembly during start-up of the distillation tower to help prevent the accumulation of solids in the distillation tower. Figures 1-6 of the disclosure display various aspects of the system and method.

10 [0031] The system and method may separate a feed stream having methane and contaminants. The system may comprise a distillation tower **104, 204** (Figures 1-2). The distillation tower **104, 204** may separate the contaminants from the methane.

[0032] The distillation tower **104, 204** may be separated into three functional sections: a lower section **106**, a middle controlled freeze zone section **108** and an upper section **110**. The
15 distillation tower **104, 204** may incorporate three functional sections when the upper section **110** is needed and/or desired.

[0033] The distillation tower **104, 204** may incorporate only two functional sections when the upper section **110** is not needed and/or desired. When the distillation tower does not include an upper section **110**, a portion of vapor leaving the middle controlled freeze zone
20 section **108** may be condensed in a condenser **122** and returned as a liquid stream via a spray assembly **129**. Moreover, lines **18** and **20** may be eliminated, elements **124** and **126** may be one and the same, and elements **150** and **128** may be one and the same. The stream in line **14**, now taking the vapors leaving the middle controlled freeze section **108**, directs these vapors to the condenser **122**.

25 [0034] The lower section **106** may also be referred to as a stripper section. The middle controlled freeze zone section **108** may also be referred to as a controlled freeze zone section. The upper section **110** may also be referred to as a rectifier section.

[0035] The sections of the distillation tower **104** may be housed within a single vessel (Figures 1 and 3). For example, the lower section **106**, the middle controlled freeze zone
30 section **108**, and the upper section **110** may be housed within a single vessel **164**.

[0036] The sections of the distillation tower **204** may be housed within a plurality of

vessels to form a split-tower configuration (Figures 2 and 4). Each of the vessels may be separate from the other vessels. Piping and/or another suitable mechanism may connect one vessel to another vessel. In this instance, the lower section **106**, middle controlled freeze zone section **108** and upper section **110** may be housed within two or more vessels. For example, as shown in Figures 2 and 4, the upper section **110** may be housed within a single vessel **254** and the lower and middle controlled freeze zone sections **106**, **108** may be housed within a single vessel **264**. When this is the case, a liquid stream exiting the upper section **110**, may exit through a liquid outlet bottom **260**. The liquid outlet bottom **260** is at the bottom of the upper section **110**. Although not shown, each of the sections may be housed within its own separate vessel, or one or more section may be housed within separate vessels, or the upper and middle controlled freeze zone sections may be housed within a single vessel and the lower section may be housed within a single vessel, etc. When sections of the distillation tower are housed within vessels, the vessels may be side-by-side along a horizontal line and/or above each other along a vertical line.

[0037] The split-tower configuration may be beneficial in situations where the height of the distillation tower, motion considerations, and/or transportation issues, such as for remote locations, need to be considered. This split-tower configuration allows for the independent operation of one or more sections. For example, when the upper section is housed within a single vessel and the lower and middle controlled freeze zone sections are housed within a single vessel, independent generation of reflux liquids using a substantially contaminant-free, largely hydrocarbon stream from a packed gas pipeline or an adjacent hydrocarbon line, may occur in the upper section. And the reflux may be used to cool the upper section, establish an appropriate temperature profile in the upper section, and/or build up liquid inventory at the bottom of the upper section to serve as an initial source of spray liquids for the middle controlled freeze zone section. Moreover, the middle controlled freeze zone and lower sections may be independently prepared by chilling the feed stream, feeding it to the optimal location be that in the lower section or in the middle controlled freeze zone section, generating liquids for the lower and the middle controlled freeze zone sections, and disposing the vapors off the middle controlled freeze zone section while they are off specification with too high a contaminant content. Also, liquid from the upper section may be intermittently or continuously sprayed, building up liquid level in the bottom of the middle controlled freeze zone section and bringing the contaminant content in the middle controlled freeze zone section down and near steady state level so that the two vessels may be connected to send the

vapor stream from the middle controlled freeze zone section to the upper section, continuously spraying liquid from the bottom of the upper section into the middle controlled freeze zone section and stabilizing operations into steady state conditions. The split tower configuration may utilize a sump of the upper section as a liquid receiver for the pump **128**,
5 therefore obviating the need for a liquid receiver **126** in Figures 1 and 3.

[0038] The system may also include a heat exchanger **100** (Figures 1-4). The feed stream **10** may enter the heat exchanger **100** before entering the distillation tower **104**, **204**. The feed stream **10** may be cooled within the heat exchanger **100**. The heat exchanger **100** helps drop the temperature of the feed stream **10** to a level suitable for introduction into the
10 distillation tower **104**, **204**.

[0039] The system may include an expander device **102** (Figures 1-4). The feed stream **10** may enter the expander device **102** before entering the distillation tower **104**, **204**. The feed stream **10** may be expanded in the expander device **102** after exiting the heat exchanger **100**. The expander device **102** helps drop the temperature of the feed stream **10** to a level
15 suitable for introduction into the distillation tower **104**, **204**. The expander device **102** may be any suitable device, such as a valve. If the expander device **102** is a valve, the valve may be any suitable valve that may aid in cooling the feed stream **10** before it enters the distillation tower **104**, **204**. For example, the valve **102** may comprise a Joule-Thompson (J-T) valve.

20 [0040] The system may include a feed separator **103** (Figures 3-4). The feed stream may enter the feed separator before entering the distillation tower **104**, **204**. The feed separator may separate a feed stream having a mixed liquid and vapor stream into a liquid stream and a vapor stream. Lines **12** may extend from the feed separator to the distillation tower **104**, **204**. One of the lines **12** may receive the vapor stream from the feed separator. Another one of the
25 lines **12** may receive the liquid stream from the feed separator. Each of the lines **12** may extend to the same and/or different sections (i.e. middle controlled freeze zone, and lower sections) of the distillation tower **104**, **204**. The expander device **102** may or may not be downstream of the feed separator **103**. The expander device **102** may comprise a plurality of expander devices **102** such that each line **12** has an expander device **102**.

30 [0041] The system may include a dehydration unit **261** (Figures 1-4). The feed stream **10** may enter the dehydration unit **261** before entering the distillation tower **104**, **204**. The feed stream **10** enters the dehydration unit **261** before entering the heat exchanger **100** and/or the

expander device **102**. The dehydration unit **261** removes water from the feed stream **10** to prevent water from later presenting a problem in the heat exchanger **100**, expander device **102**, feed separator **103**, or distillation tower **104**, **204**. The water can present a problem by forming a separate water phase (i.e., ice and/or hydrate) that plugs lines, equipment or negatively affects the distillation process. The dehydration unit **261** dehydrates the feed stream to a dew point sufficiently low to ensure a separate water phase does not form at any point downstream during the rest of the process. The dehydration unit may be any suitable dehydration mechanism, such as a molecular sieve or a glycol dehydration unit.

[0042] The system may include a filtering unit (not shown). The feed stream **10** may enter the filtering unit before entering the distillation tower **104**, **204**. The filtering unit may remove undesirable contaminants from the feed stream before the feed stream enters the distillation tower **104**, **204**. Depending on what contaminants are to be removed, the filtering unit may be before or after the dehydration unit **261** and/or before or after the heat exchanger **100**.

[0043] The system may include a line **12** (Figures 1-4). The line may also be referred to as an inlet channel **12**. The feed stream **10** may be introduced into the distillation tower **104**, **204** through the line **12**. The line **12** may extend to the lower section **106** or the middle controlled freeze zone section **108** of the distillation tower **104**, **204**. For example, the line **12** may extend to the lower section **106** such that the feed stream **10** may enter the lower section **106** of the distillation tower **104**, **204** (Figures 1-4). The line **12** may directly or indirectly extend to the lower section **106** or the middle controlled freeze zone section **108**. The line **12** may extend to an outer surface of the distillation tower **104**, **204** before entering the distillation tower.

[0044] If the system includes the feed separator **103** (Figures 3-4), the line **12** may comprise a plurality of lines **12**. Each line may be the same line as one of the lines that extends from the feed separator to a specific portion of the distillation tower **104**, **204**.

[0045] The lower section **106** is constructed and arranged to separate the feed stream **10** into an enriched contaminant bottom liquid stream (i.e., liquid stream) and a freezing zone vapor stream (i.e., vapor stream). The lower section **106** separates the feed stream at a temperature and pressure at which no solids form. The liquid stream may comprise a greater quantity of contaminants than of methane. The vapor stream may comprise a greater quantity of methane than of contaminants. In any case, the vapor stream is lighter than the liquid

stream. As a result, the vapor stream rises from the lower section **106** and the liquid stream falls to the bottom of the lower section **106**.

[0046] The lower section **106** may include and/or connect to equipment that separates the feed stream. The equipment may comprise any suitable equipment for separating methane from contaminants, such as one or more packed sections **181**, or one or more distillation trays with perforations downcomers and weirs (Figures 1-4).

[0047] The equipment may include components that apply heat to the stream to form the vapor stream and the liquid stream. For example, the equipment may comprise a first reboiler **112** that applies heat to the stream. The first reboiler **112** may be located outside of the distillation tower **104**, **204**. The equipment may also comprise a second reboiler **172** that applies heat to the stream. The second reboiler **172** may be located outside of the distillation tower **104**, **204**. Line **117** may lead from the distillation tower to the second reboiler **172**. Line **17** may lead from the second reboiler **172** to the distillation tower. Additional reboilers, set up similarly to the second reboiler described above, may also be used.

[0048] The first reboiler **112** may apply heat to the liquid stream that exits the lower section **106** through a liquid outlet **160** of the lower section **106**. The liquid stream may travel from the liquid outlet **160** through line **28** to reach the first reboiler **112** (Figures 1-4). The amount of heat applied to the liquid stream by the first reboiler **112** can be increased to separate more methane from contaminants. The more heat applied by the reboiler **112** to the stream, the more methane separated from the liquid contaminants, though more contaminants will also be vaporized.

[0049] The first reboiler **112** may also apply heat to the stream within the distillation tower **104**, **204**. Specifically, the heat applied by the first reboiler **112** warms up the lower section **106**. This heat travels up the lower section **106** and supplies heat to warm solids entering a melt tray assembly **139** (Figures 1-4) of the middle controlled freeze zone section **108** so that the solids form a liquid and/or slurry mix.

[0050] The second reboiler **172** applies heat to the stream within the lower section **106**. This heat is applied closer to the middle controlled freeze zone section **108** than the heat applied by the first reboiler **112**. As a result, the heat applied by the second reboiler **172** reaches the middle controlled freeze zone section **108** faster than the heat applied by the first reboiler **112**. The second reboiler **172** also helps with energy integration.

[0051] The equipment may include a chimney assembly **135** (Figures 1-4). While falling

to the bottom of the lower section **106**, the liquid stream may encounter one or more of the chimney assemblies **135**.

[0052] Each chimney assembly **135** includes a chimney tray **131** that collects the liquid stream within the lower section **108**. The liquid stream that collects on the chimney tray **131** may be fed to the second reboiler **172**. After the liquid stream is heated in the second reboiler **172**, the stream may return to the middle controlled freeze zone section **106** to supply heat to the middle controlled freeze zone section **106** and/or the melt tray assembly **139**. Unvaporized stream exiting the second reboiler **172** may be fed back to the distillation tower **104, 204** below the chimney tray **131**. Vapor stream exiting the second reboiler **172** may be routed under or above the chimney tray **131** when the vapor stream enters the distillation tower **104, 204**.

[0053] The chimney tray **131** may include one or more chimneys **137**. The chimney **137** serves as a channel that the vapor stream in the lower section **106** traverses. The vapor stream travels through an opening in the chimney tray **131** at the bottom of the chimney **137** to the top of the chimney **137**. The opening is closer to the bottom of the lower section **106** than it is to the bottom of the middle controlled freeze zone section **108**. The top is closer to the bottom of the middle controlled freeze zone section **108** than it is to the bottom of the lower section **106**.

[0054] Each chimney **137** has attached to it a chimney cap **133**. The chimney cap **133** covers a chimney top opening **138** of the chimney **137**. The chimney cap **133** prevents the liquid stream from entering the chimney **137**. The vapor stream exits the chimney assembly **135** via the chimney top opening **138**.

[0055] After falling to the bottom of the lower section **106**, the liquid stream exits the distillation tower **104, 204** through the liquid outlet **160**. The liquid outlet **160** is within the lower section **106** (Figures 1-4). The liquid outlet **160** may be located at the bottom of the lower section **106**.

[0056] After exiting through the liquid outlet **160**, the feed stream may travel via line **28** to the first reboiler **112**. The feed stream may be heated by the first reboiler **112** and vapor may then re-enter the lower section **106** through line **30**. Unvaporized liquid may continue out of the distillation process via line **24**.

[0057] The system may include an expander device **114** (Figures 1-4). After entering line **24**, the heated liquid stream may be expanded in the expander device **114**. The expander

device **114** may be any suitable device, such as a valve. The valve **114** may be any suitable valve, such as a J-T valve.

[0058] The system may include a heat exchanger **116** (Figures 1-4). The liquid stream heated by the first reboiler **112** may be cooled or heated by the heat exchanger **116**. The heat
5 exchanger **116** may be a direct heat exchanger or an indirect heat exchanger. The heat exchanger **116** may comprise any suitable heat exchanger.

[0059] The vapor stream in the lower section **106** rises from the lower section **106** to the middle controlled freeze zone section **108**. The middle controlled freeze zone section **108** is constructed and arranged to separate the feed stream **10** introduced into the middle controlled
10 freeze zone section, or into the top of lower section **106**, into a solid and a vapor stream. The middle controlled freeze zone section **108** operates at a temperature and pressure at which the feed stream forms a solid in the controlled freeze zone section, **301** (Figure 1). The contaminant in the feed stream includes a first contaminant. The solid may be comprised more of contaminants than of methane. The vapor stream (i.e., methane-enriched vapor
15 stream) formed may comprise more methane than contaminants.

[0060] The middle controlled freeze zone section **108** includes a lower section **40** and an upper section **39** (Figure 5). The lower section **40** is below the upper section **39**. The lower section **40** directly abuts the upper section **39**. The lower section **40** is primarily but not exclusively a heating section of the middle controlled freeze zone section **108**. The upper
20 section **39** is primarily but not exclusively a cooling section of the middle controlled freeze zone section **108**. The temperature and pressure of the upper section **39** are chosen so that the solid can form in the middle controlled freeze zone section **108**.

[0061] The middle controlled freeze zone section **108** may comprise a melt tray assembly **139** that is maintained in the middle controlled freeze zone section **108**, **302** (Figures 1-5).
25 The melt tray assembly **139** is within the lower section **40** of the middle controlled freeze zone section **108**. The melt tray assembly **139** is not within the upper section **39** of the middle controlled freeze zone section **108**.

[0062] The melt tray assembly **139** is constructed and arranged to melt solids formed in the middle controlled freeze zone section **108**. When the warm vapor stream rises from the
30 lower section **106** to the middle controlled freeze zone section **108**, the vapor stream immediately encounters the melt tray assembly **139** and supplies heat to melt the solid. The melt tray assembly **139** may comprise at least one of a melt tray **118**, a bubble cap **132**, a

liquid **130** and heat mechanism(s) **134**.

[0063] The melt tray **118** may collect a liquid and/or slurry mix. The melt tray **118** divides at least a portion of the middle controlled freeze zone section **108** from the lower section **106**. The melt tray **118** is at the bottom **45** of the middle controlled freeze zone section **108**.

[0064] One or more bubble caps **132** may act as a channel for the vapor stream rising from the lower section **106** to the middle controlled freeze zone section **108**. The bubble cap **132** may provide a path for the vapor stream up the riser **140** and then down and around the riser **140** to the melt tray **118**. The riser **140** is covered by a cap **141**. The cap **141** prevents the liquid **130** from travelling into the riser and it also helps prevent solids from travelling into the riser **140**. The vapor stream's traversal through the bubble cap **132** allows the vapor stream to transfer heat to the liquid **130** within the melt tray assembly **139**.

[0065] One or more heat mechanisms **134** may further heat up the liquid **130** to facilitate melting of the solids into a liquid and/or slurry mix. The heat mechanism(s) **134** may be located anywhere within the melt tray assembly **139**. For example, as shown in Figures 1-4, a heat mechanism **134** may be located around bubble caps **132**. The heat mechanism **134** may be any suitable mechanism, such as a heat coil. The heat source of the heat mechanism **134** may be any suitable heat source.

[0066] The liquid **130** in the melt tray assembly is heated by the vapor stream. The liquid **130** may also be heated by the one or more heat mechanisms **134**. The liquid **130** helps melt the solids formed in the middle controlled freeze zone section **108** into a liquid and/or slurry mix. Specifically, the heat transferred by the vapor stream heats up the liquid, thereby enabling the heat to melt the solids. The liquid **130** is at a level sufficient to melt the solids.

[0067] The middle controlled freeze zone section **108** may also comprise a spray assembly **129**. The spray assembly **129** cools the vapor stream that rises from the lower section **40**. The spray assembly **129** sprays liquid, which is cooler than the vapor stream, on the vapor stream to cool the vapor stream. The spray assembly **129** is within the upper section **39**. The spray assembly **129** is not within the lower section **40**. The spray assembly **129** is above the melt tray assembly **139**. In other words, the melt tray assembly **139** is below the spray assembly **129**.

[0068] The spray assembly **129** includes one or more spray nozzles **120** (Figures 1-4). Each spray nozzle **120** sprays liquid on the vapor stream. The spray assembly **129** may also

include a spray pump **128** (Figures 1-4) that pumps the liquid. Instead of a spray pump **128**, gravity may induce flow in the liquid.

5 **[0069]** The liquid sprayed by the spray assembly **129** contacts the vapor stream at a temperature and pressure at which solids form. Solids, containing mainly contaminants, form when the sprayed liquid contacts the vapor stream. The solids fall toward the melt tray assembly **139**.

10 **[0070]** The temperature in the middle controlled freeze zone section **108** cools down as the vapor stream travels from the bottom of the middle controlled freeze zone section **108** to the top of the middle controlled freeze zone section **108**. The methane in the vapor stream rises from the middle controlled freeze zone section **108** to the upper section **110**. Some contaminants may remain in the methane and also rise. The contaminants in the vapor stream tend to condense or solidify with the colder temperatures and fall to the bottom of the middle controlled freeze zone section **108**.

15 **[0071]** The solids form the liquid and/or slurry mix when in the liquid **130**. The liquid and/or slurry mix flows from the middle controlled freeze zone section **108** to the lower distillation section **106**. The liquid and/or slurry mix flows from the bottom of the middle controlled freeze zone section **108** to the top of the lower section **106** via a line **22** (Figures 1-4). The line **22** may be an exterior line. The line **22** may extend from the distillation tower **104, 204**. The line **22** may extend from the middle controlled freeze zone section **108**. The
20 line may extend to the lower section **106**. The line **22** may extend from an outer surface of the distillation tower **104, 204**.

25 **[0072]** The vapor stream that rises in the middle controlled freeze zone section **108** and does not form solids or otherwise fall to the bottom of the middle controlled freeze zone section **108**, rises to the upper section **110**. The upper section **110** operates at a temperature and pressure and contaminant concentration at which no solid forms. The upper section **110** is constructed and arranged to cool the vapor stream to separate the methane from the contaminants. Reflux in the upper section **110** cools the vapor stream. The reflux is introduced into the upper section **110** via line **18**. Line **18** may extend to the upper section **110**. Line **18** may extend from an outer surface of the distillation tower **104, 204**.

30 **[0073]** After contacting the reflux in the upper section **110**, the feed stream forms a vapor stream and a liquid stream. The vapor stream mainly comprises methane. The liquid stream comprises relatively more contaminants. The vapor stream rises in the upper section **110** and

the liquid falls to a bottom of the upper section **110**.

[0074] To facilitate separation of the methane from the contaminants when the stream contacts the reflux, the upper section **110** may include one or more mass transfer devices **176**. Each mass transfer device **176** helps separate the methane from the contaminants. Each mass transfer device **176** may comprise any suitable separation device, such as a tray with perforations, or a section of random or structured packing to facilitate contact of the vapor and liquid phases.

[0075] After rising, the vapor stream may exit the distillation tower **104, 204** through line **14**. The line **14** may emanate from an upper part of the upper section **110**. The line **14** may extend from an outer surface of the upper section **110**.

[0076] From line **14**, the vapor stream may enter a condenser **122**. The condenser **122** cools the vapor stream to form a cooled stream. The condenser **122** at least partially condenses the stream.

[0077] From line **14**, the vapor stream may enter a condenser **122** of the system. The condenser **122** cools the vapor stream to form a cooled stream. The condenser **122** at least partially condenses the stream.

[0078] After exiting the condenser **122**, the cooled stream may enter a separator **124** of the system. The separator **124** separates the vapor stream into liquid and vapor streams. The separator may be any suitable separator that can separate a stream into liquid and vapor streams, such as a reflux drum.

[0079] Once separated, the vapor stream may exit the separator **124** as sales product. The sales product may travel through line **16** for subsequent sale to a pipeline and/or condensation to be liquefied natural gas.

[0080] Once separated, the liquid stream may return to the upper section **110** through line **18** as the reflux. The reflux may travel to the upper section **110** via any suitable mechanism, such as a reflux pump **150** (Figures 1 and 3) or gravity (Figures 2 and 4).

[0081] The liquid stream (i.e., freezing zone liquid stream) that falls to the bottom of the upper section **110** collects at the bottom of the upper section **110**. The liquid may collect on tray **183** (Figures 1 and 3) or at the bottommost portion of the upper section **110** (Figures 2 and 4). The collected liquid may exit the distillation tower **104, 204** through line **20** (Figures 1 and 3) or outlet **260** (Figures 2 and 4). The line **20** may emanate from the upper section

110. The line **20** may emanate from a bottom end of the upper section **110**. The line **20** may extend from an outer surface of the upper section **110**.

[0082] The line **20** and/or outlet **260** connect to a line **41**. The line **41** leads to the spray assembly **129** in the middle controlled freeze zone section **108**. The line **41** emanates from
5 the holding vessel **126**. The line **41** may extend to an outer surface of the middle controlled freeze zone section **108**.

[0083] The line **20** and/or outlet **260** may directly or indirectly (Figures 1-4) connect to the line **41**. When the line **20** and/or outlet **260** directly connect to the line **41**, the liquid spray may be sent to the spray nozzle(s) **120** via any suitable mechanism, such as the spray
10 pump **128** or gravity. When the line **20** and/or outlet **260** indirectly connect to the line **41**, the lines **20**, **41** and/or outlet **260** and line **41** may directly connect to a holding vessel **126** (Figures 1 and 3). The holding vessel **126** may house at least some of the liquid spray before it is sprayed by the nozzle(s). The liquid spray may be sent from the holding vessel **126** to the spray nozzle(s) **120** via any suitable mechanism, such as the spray pump **128** (Figures 1-
15 4) or gravity. The holding vessel **126** may be needed when there is not a sufficient amount of liquid stream at the bottom of the upper section **110** to feed the spray nozzles **120**.

[0084] To help prevent accumulation of solid in the middle controlled freeze zone section **108**, the liquid **130** in the middle controlled freeze zone section **108** should be at, at least a predetermined liquid level. The predetermined level is a level of liquid that is sufficient to
20 melt the solid by the end of start-up. The start-up is the period of time that the system must run to establish a normal temperature and/or composition profile within the distillation tower **104**, **204** and/or to establish a normal mass flow into and out of the distillation tower, **104**, **204**.

[0085] Additional processing may need to occur during start-up of the distillation tower
25 **104**, **204** to ensure that the liquid level is at least at the predetermined liquid level by the end of start-up. The additional processing may need to occur if the feed stream entering the distillation tower **104**, **204** during start-up contains less than 20% contaminant. If the feed stream entering the distillation tower **104**, **204** during start-up contains less than 20% contaminant, solids may accumulate in the middle controlled freeze zone section **108**. For
30 example, solids may accumulate on the melt tray **118** without melting to form liquid. Solids may accumulate because the feed stream entering the distillation tower **104**, **204** does not contain enough contaminant to yield sufficient melt tray liquid in the early stages of operation

while starting up the unit. This accumulation of solids may disrupt the entire process of separating the feed stream after start-up. While the additional processing may not need to occur if the feed stream contains more than 20% contaminant, the additional processing can still occur.

5 **[0086]** The additional processing may include introducing the feed stream **10** to the middle controlled freeze zone section **108** during start-up, **303** (Figure 6). The feed stream **10** may be directly introduced to the distillation tower **104**, **204** via the middle controlled freeze zone section **108**. The feed stream **10** may be introduced into the middle controlled freeze zone section **108** via any suitable mechanism. For example, the feed stream **10** may be introduced into the middle controlled freeze zone section **108** in the manner described in the application entitled “Method and System for Separating a Feed Stream with a Feed Distribution Mechanism” by Jaime Valencia and filed on the same day as the instant application. After the feed stream **10** is introduced into the middle controlled freeze zone section **108**, liquid may be sprayed on the feed stream **10** by the spray assembly **129** to help separate the contaminant in the feed stream from the methane in the feed stream by forming the solid. The contaminant may comprise a first contaminant. Solid that falls to the bottom of the middle controlled freeze zone section **108** may melt, because of heat applied by the heating mechanism **134**, first reboiler **112**, second reboiler **172**, and/or vapor stream rising from the lower section **106**, thereby becoming part of the liquid in the melt tray assembly **139**. The liquid that becomes part of the liquid in the melt tray assembly **139** helps accumulate the liquid in the melt tray assembly **139** until the liquid is at least at the predetermined liquid level, **304** (Figure 6).

25 **[0087]** To prevent the solid from accumulating, the additional process may also include feeding a second contaminant to the middle controlled freeze zone section **108**, **305** (Figure 6). After the second contaminant is fed to the middle controlled freeze zone section **108**, the second contaminant may be added to the melt tray assembly **139**, **306** (Figure 6) as part of the liquid. The feeding and adding of the second contaminant helps accumulate the liquid in the melt tray assembly **139** (Figure 6) until the liquid is at least at a predetermined liquid level in the middle controlled freeze zone section **108**. The predetermined liquid level is the level needed to prevent accumulation of the solid in the middle controlled freeze zone section **108** during start-up.

30 **[0088]** The second contaminant may be continuously or intermittently fed to the melt tray assembly **139**. The second contaminant may be continuously or intermittently fed to ensure

that the liquid level is at least at the predetermined liquid level at the end of start-up. During start-up, some of the liquid in the melt tray assembly **139** may turn into vapor and/or be sent to the upper section **106**, thereby lowering the liquid level in the melt tray assembly **139**. The lowering of the liquid level may cause a liquid level that was once at least equal to the predetermined liquid level to be less than the predetermined liquid level. When a liquid level once at least equal to the predetermined liquid level is less than the predetermined liquid level before the end of start-up, the second contaminant may continue to be intermittently or continuously fed to the melt tray assembly **139** during start-up. At times the second contaminant may be fed intermittently and at other times the second contaminant may be fed continuously in the same distillation tower.

[0089] Any suitable mechanism may be used to determine that the liquid level is less than the predetermined liquid level. For example, at least one of the underflow and overflow weirs, and the liquid level indicators described in the application entitled “A Method and System of Maintaining a Liquid Level in a Distillation Tower” by Jaime Valencia et al. and filed on the same day as the instant application may be used to determine whether the liquid is less than the predetermined liquid level.

[0090] The second contaminant may be continuously or intermittently fed to the middle controlled freeze zone section from at least one of a first storage unit **318** and an indirect channel **127**, **145**, **147** (Figure 5).

[0091] The first storage unit **318** holds the second contaminant. The first storage unit **318** may be any suitable storage unit. The second contaminant in the first storage unit **318** may be directly fed to the melt tray assembly **139**. The first storage unit **318** may connect to a line **119** that connects to the melt tray assembly **139**. The line **119** may extend from the portion of the middle controlled freeze zone section **108** that includes the melt tray assembly **139** to the first storage unit **318**. The line **119** may be referred to as a first channel. The second contaminant from the first storage unit **318** may be fed to the middle tray assembly **139** before and/or after the feed stream is fed to the middle controlled freeze zone section **108**.

[0092] The second contaminant from the first storage unit **318** may be any suitable contaminant. For example, the second contaminant may comprise carbon dioxide. The carbon dioxide may be liquid carbon dioxide. The second contaminant may comprise at least one the same type of contaminant as the first contaminant and a different type of contaminant as the first contaminant.

[0093] The indirect channel **127, 145, 147** transports the second contaminant to the line **12, 119**. Because the indirect channel **127, 145, 147** transports the second contaminant to the line **12, 119** before the second contaminant enters the middle controlled freeze zone section **108**, the second contaminant is indirectly fed to the melt tray assembly **139** when the second contaminant is fed to the middle controlled freeze zone section **108**. The second contaminant may be directly fed above the melt tray assembly **139** when the second contaminant is fed to the middle controlled freeze zone section **108**. The second contaminant may be directly fed into the melt tray assembly **139** when the second contaminant is fed to the middle controlled freeze zone section **108**.

[0094] When the indirect channel **127, 145** transports the second contaminant, the second contaminant may be mixed with the feed stream before the feed stream is introduced to the middle controlled freeze zone section **108**. This is so the second contaminant is mixed with the feed stream outside of the distillation tower **104, 204**.

[0095] When the indirect channel **147** transports the second contaminant, the second contaminant may not be mixed with the feed stream before the feed stream is introduced to the middle controlled freeze zone section **108**.

[0096] The indirect channel **127, 145, 147** extends from at least one of (i) the distillation tower **104, 204** to the inlet channel **12**, (ii) the distillation tower **104, 204** to the first channel **119** and (iii) a second storage unit **146** to the inlet channel **12**. The indirect channel **127** may be referred to as the first indirect channel. The indirect channel **145** may be referred to as the second indirect channel. The indirect channel **147** may be referred to as the third indirect channel. The first storage unit **318** and the second storage unit **146** could be one and the same.

[0097] When the first indirect channel **127** extends from the distillation tower **104, 204** to the inlet channel **12**, the first indirect channel **127** extends from the lower section **106**. The first indirect channel **127** may extend from the bottom of the lower section **106**. For example, the first indirect channel **127** may extend from the liquid outlet **160** of the lower section **106**. The first indirect channel **127** may indirectly extend from the liquid outlet **160**. For example, the first indirect channel **127** may extend from line **28** and/or line **24**. The first indirect channel **127** transports the liquid stream (e.g., enriched contaminant bottom liquid stream) that exits the lower section **106** via the liquid outlet **160**.

[0098] When the third indirect channel **147** extends from the distillation tower **104, 204**

to the first channel **119**, the third indirect channel **147** extends from the lower section **106**. The third indirect channel **147** may extend from the bottom of the lower section **106**. For example, the third indirect channel **147** may extend from the liquid outlet **160** of the lower section **106**. The third indirect channel **147** may indirectly extend from the liquid outlet **160**.
5 For example, the third indirect channel **147** may extend from line **28** and/or line **24**. The third indirect channel **147** transports the liquid stream (e.g. enriched contaminant bottom liquid stream) that exits the lower section **106** via the outlet **160**. The third indirect channel **147** may feed the second contaminant to the first channel **119** in the absence of feeding the second contaminant to the feed stream. In other words, the third indirect channel **147** may
10 feed the second contaminant to the first channel **119** without the third indirect channel **147** connecting to the inlet channel **12** such that the third indirect channel **147** connects to the first channel **119** but not the inlet channel **12**.

[0099] The second contaminant in the indirect channel **145**, **147** may comprise the same type of contaminant as the first contaminant. This second contaminant includes the first
15 contaminant because the second contaminant is the first contaminant processed in the middle controlled freeze zone section **108** and the lower section **106**.

[0100] When the second indirect channel **145** extends from the second storage unit **146** to the inlet channel **12**, the second storage unit **146** holds the second contaminant. The second storage unit **146** may be any suitable storage unit.

20 [0101] The second contaminant from the second storage unit **146** may be any suitable contaminant. For example, the second contaminant may comprise at least one of carbon dioxide and an anti-freeze solution. The anti-freeze solution may comprise at least one of ethane, methanol, propane, butane, light olefins (e.g. ethylene), light ethers (e.g. dimethyl ether), acetylene, and hydrogen sulfide. Other examples of anti-freeze solution are also
25 contemplated. The second contaminant may comprise at least one the same type of contaminant as the first contaminant and a different type of contaminant as the first contaminant.

[0102] While the second contaminant is generally discussed above as only being fed to the middle controlled freeze zone section **108** during start-up, the second contaminant may
30 also be fed after start-up. The second contaminant may be fed after start-up if, for example, the liquid level becomes lower than the predetermined liquid level.

[0103] The second contaminant may be fed to the middle controlled freeze zone section

108 at least one of before and after introducing the feed stream into the middle controlled freeze zone section **108**. For example, the second contaminant may be fed to the middle controlled freeze zone section **108** when feed stream is first fed to the middle controlled freeze zone section **108** and/or not initially fed until after feed stream is first fed to the middle controlled freeze zone section **108**.

[0104] It is important to note that the steps depicted in Figure 6 are provided for illustrative purposes only and a particular step may not be required to perform the inventive methodology. The claims, and only the claims, define the inventive system and methodology.

[0105] Disclosed aspects may be used in hydrocarbon management activities. As used herein, “hydrocarbon management” or “managing hydrocarbons” includes hydrocarbon extraction, hydrocarbon production, hydrocarbon exploration, identifying potential hydrocarbon resources, identifying well locations, determining well injection and/or extraction rates, identifying reservoir connectivity, acquiring, disposing of and/or abandoning hydrocarbon resources, reviewing prior hydrocarbon management decisions, and any other hydrocarbon-related acts or activities. The term “hydrocarbon management” is also used for the injection or storage of hydrocarbons or CO₂, for example the sequestration of CO₂, such as reservoir evaluation, development planning, and reservoir management. The disclosed methodologies and techniques may be used to produce hydrocarbons in a feed stream extracted from, for example, a subsurface region. The feed stream extracted may be processed in the distillation tower **104**, **204** and separated into hydrocarbons and contaminants. The separated hydrocarbons exit the middle controlled freeze zone section **108** or the upper section **110** of the distillation tower. Some or all of the hydrocarbons that exit are produced, **307**. Hydrocarbon extraction may be conducted to remove the feed stream from for example, the subsurface region, which may be accomplished by drilling an oil well using oil drilling equipment. The equipment and techniques used to drill a well and/or extract the hydrocarbons are well known by those skilled in the relevant art. Other hydrocarbon extraction activities and, more generally, other hydrocarbon management activities, may be performed according to known principles.

[0106] As utilized, the terms “approximately,” “about,” “substantially,” and similar terms are intended to have a broad meaning in harmony with the common and accepted usage by those of ordinary skill in the art to which the subject matter of this disclosure pertains. It should be understood by those of skill in the art who review this disclosure that these terms

are intended to allow a description of certain features described and claimed without restricting the scope of these features to the precise numeral ranges provided. Accordingly, these terms should be interpreted as indicating that insubstantial or inconsequential modifications or alterations of the subject matter described and are considered to be within
5 the scope of the disclosure.

[0107] It should be understood that numerous changes, modifications, and alternatives to the preceding disclosure can be made without departing from the scope of the disclosure. The preceding description, therefore, is not meant to limit the scope of the disclosure. Rather, the scope of the disclosure is to be determined only by the appended claims and their
10 equivalents. It is also contemplated that structures and features in the present examples can be altered, rearranged, substituted, deleted, duplicated, combined, or added to each other.

[0108] The articles “the”, “a” and “an” are not necessarily limited to mean only one, but rather are inclusive and open ended so as to include, optionally, multiple such elements.

CLAIMS

1. A method for separating a feed stream in a distillation tower, the method comprising:
 - providing a controlled freeze zone section in the distillation tower, wherein the controlled freeze zone section comprises a melt tray assembly and a spray assembly and wherein the spray assembly is above the melt tray assembly;
 - introducing the feed stream to the controlled freeze zone section, wherein the feed stream comprises a first contaminant;
 - spraying a liquid from the spray assembly onto the feed stream in the controlled freeze zone section of the distillation tower;
 - operating the controlled freeze zone section of the distillation tower at a temperature and pressure at which the first contaminant in the feed stream forms a solid in the controlled freeze zone section; and
 - feeding a liquid comprising a second contaminant to the melt tray assembly above the melt tray in the controlled freeze zone section of the distillation tower;
 - wherein the liquid comprising the second contaminant is fed into the controlled freeze zone section until the liquid accumulated in the melt tray assembly is at a predetermined level in the controlled freeze zone section; and
 - wherein the feeding of the second contaminant only occurs while starting up the distillation tower.
2. The method of claim 1, wherein feeding the second contaminant occurs before introducing the feed stream.
3. The method of claim 1, wherein feeding the second contaminant comprises directly feeding the second contaminant to the controlled freeze zone section.
4. The method of claim 3, wherein directly feeding the second contaminant occurs one of continuously and intermittently.

5. The method of claim 1, wherein the second contaminant comprises the same contaminant as the first contaminant.
6. The method of claim 1, wherein the first contaminant comprises the same contaminant as the second contaminant.
7. The method of claim 1, wherein each of the first contaminant and the second contaminant comprise carbon dioxide.
8. The method of claim 1, further comprising recovering hydrocarbons from the feed stream.
9. The method of claim 1, wherein feeding the second contaminant occurs after introducing the feed stream.
10. The method of claim 1, wherein feeding the second contaminant comprises indirectly feeding the second contaminant to the controlled freeze zone section.
11. The method of claim 10, wherein indirectly feeding the second contaminant occurs one of continuously and intermittently.
12. The method of claim 10, wherein indirectly feeding the second contaminant comprises at least one of (i) feeding the second contaminant before introducing the feed stream to the controlled freeze zone section and (ii) feeding the second contaminant to a first channel in the absence of feeding the second contaminant to the feed stream.
13. The method of claim 12, wherein (i) comprises mixing the second contaminant with the feed stream before introducing the feed stream to the controlled freeze zone section.
14. The method of claim 1, wherein the first contaminant comprises carbon dioxide.