

SYSTEM AND METHOD TO REMOVE ACIDIC SPECIES FROM A RICH MEG STREAM BY STRIPPING

BACKGROUND

Field

[0001] This present disclosure relates to processes designed to treat mono ethylene glycol ("MEG") used in the oil and gas industry to control hydrates formation. More particularly, the present disclosure relates to MEG reclamation processes which are designed to remove salts from a wet MEG feed stream.

[0002] In the oil and gas industry, dry (lean) MEG is used to control the formation of hydrates within a produced stream. Once used, the now wet (rich) MEG is, in turn, dried and cleaned by way of a MEG regeneration and reclamation process so the MEG can be used again in hydrate control. The systems and methods used to recover MEG include three sections: pre-treatment, flash separation, and MEG regeneration. These sections can be followed by salt management and followed or preceded by a calcium removal section.

[0003] The MEG used for hydrate inhibition in natural gas pipelines has a similar volatility to organic acids such as acetic acid. Therefore, if water from a well contains organic acids, the organic acid tends to stay with the MEG solution. Removing this organic acid can require large, costly and wasteful blowdown or purges of MEG.

[0004] Other options for the removal of organic acid from rich MEG include boiling off the organic acids, distillation of the rich MEG and organic acid, and precipitation using divalent cations. The boiling off method makes use of a relatively large heating duty to heat the whole stream and/or vacuum conditions. Because the relative volatilities of MEG and organic acid are similar this method also produces large MEG losses. The distillation method, similar to the boiling off method, makes use of a large heating (reboiling) and cooling (condensing) duty. Although the MEG losses are reduced by distillation, more equipment is required (e.g., column, reboiler, condenser). The precipitation method makes use of the addition of chemicals to increase the pH and a solid separation step such as centrifuge or filtration (see e.g. US 2015/0119609 A1).

SUMMARY

[0005] In general, disclosed herein are a system and method for removing acetic acid and other short chain fatty acids described as organic acids from a rich mono-ethylene glycol ("MEG") solution does so by:

- adjusting, if needed, the pH of the rich MEG solution to a pH < 4 to ensure the organic acids are in acid form;
- stripping the organic acids from the rich MEG solution by contacting the solution with a gas, the gas being nitrogen or a fuel gas such as methane; and
- stripping organic acids from the gas by contacting the gas with a caustic solution such as a dilute sodium hydroxide solution.

[0006] The stripping steps take place in respective stripping columns. A portion of the gas exiting the gas/organic acid stripping column can be recycled to the MEG/organic acid stripping column to reduce total gas usage. A portion of the waste stream exiting the gas/organic acid stripping column can be recycled back to the gas/organic acid stripping column to reduce the amount of caustic solution used as well as the amount of waste.

[0007] This method can be used as part of a MEG regeneration and reclamation process to remove acetic acid and other short chain fatty acids described as organic acids from rich MEG. The method reduces the amount of blowdown required, reduces the overall MEG loss, and does not require boiling off, distillation or precipitation steps.

[0008] Unlike the boiling off method, this method makes use of no heat input, no vacuum conditions, and has relatively low MEG losses. Unlike the distillation method, this method makes use of a low energy input, no heat input, much less cooling duty, operates at a much lower and therefore safer temperature, and does not require additional large equipment items like a reboiler or condenser. Unlike the precipitation method, this method operates at a low pH (as normally seen in rich MEG) so pH adjustment is minimized and does not require a solid separation step which can be expensive, complicated and have a low reliability.

BRIEF DESCRIPTION OF THE DRAWINGS

[0009] So that the manner in which the above recited features can be understood in detail, a more particular description may be had by reference to embodiments, some of which are illustrated in the appended drawings, wherein like reference numerals denote like elements. It is to be noted, however, that the appended drawings illustrate various embodiments and are therefore not to be considered limiting of its scope, and may admit to other equally effective embodiments.

[0010] FIG. 1 is an illustration of the method.

[0011] FIG. 2 is a table showing the results of a simulation of the method of FIG. 1 using PROMAX® software.

Elements Used in the Drawings and Detailed Description

[0012]	10	System or method
[0013]	21	Rich MEG solution or stream containing organic acid
[0014]	23	Gas make-up stream
[0015]	25	MEG/organic acid stripper column
[0016]	27	Gas stream containing the organic acid stripped from the 21)
[0017]	29	Rich MEG stream without or substantially free of the organic acid
[0018]	30.	Gas/organic acid stripper column
[0019]	31	Gas stream without or substantially free of the organic acid
[0020]	33	Gas recycle stream portion of 31
[0021]	35	Waste water stream
[0022]	41	Solution

DETAILED DESCRIPTION

[0023] In the following description, numerous details are set forth to provide an understanding of some embodiments of the present disclosure. However, it will be understood by those of ordinary skill in the art that the system and/or methodology may be practiced without these details and that numerous variations or modifications from the described embodiments may be possible.

[0024] In the specification and appended claims: the terms "connect", "connection", "connected", "in connection with", and "connecting" are used to mean "in direct connection with" or "in connection with via one or more elements"; and the term "set" is used to mean "one element" or "more than one element". Further, the terms "couple", "coupling", "coupled", "coupled together", and "coupled with" are used to mean "directly coupled together" or "coupled together via one or more elements". As used herein, the terms "up" and "down", "upper" and "lower", "upwardly" and "downwardly", "upstream" and "downstream"; "above" and "below"; and other like terms indicating relative positions above or below a given point or element are used in this description to more clearly describe some embodiments of the disclosure.

[0025] Although the preceding description has been described herein with reference to particular means, materials and embodiments, it is not intended to be limited to the particulars disclosed herein; rather, it extends to all functionally equivalent structures, methods, and uses, such as are within the scope of the appended claims.

[0026] For the purpose of this disclosure, an "organic acid" is a carboxylic acid having a general formula $R-C(O)OH$, where R is H (formic acid), CH_3 (acetic acid), CH_3CH_2 (propionic acid), or $CH_3(CH_2)_2$ (butyric acid) and where the total number of carbon atoms C is no greater than 4.

[0027] Referring to FIG. 1, a wet or rich MEG stream 21 containing an organic acid is routed to a MEG/organic acid stripper column 25 where the rich MEG stream 21 is contacted by a gas make-up stream 23 or gas recycle stream 33 (or some combination of the streams 23, 33). Gas 23, 33 can be a fuel gas such as natural gas or can be nitrogen. The pH of the rich MEG stream 21 can be monitored and

adjusted when needed to a $\text{pH} < 4$. This helps ensure the organic acid is in acid form.

[0028] The gas 23, 33 that has stripped the organic acid from the stream 21 exits a top end of the MEG/organic acid stripper column 25 as a gas stream 27 containing the organic acid. A rich MEG stream 29 without organic acid (or substantially free of organic acid) exits a bottom end of the column 25. "Substantially free of organic acid" means at least 90% of the acetic acid present in the rich MEG stream 21 is removed. If other organic acids are present in stream 21, preferably at least 50% of those organic acids are also stripped from the rich MEG stream 21.

[0029] The gas stream 27 containing the organic acids stripped from stream 21 is routed to a gas/organic acid stripper column 30 where the stream 27 is contacted by the solution 41. Solution 41 can be a dilute sodium hydroxide solution (e.g., 1.0 wt% NaOH and water) or its equivalent. A gas stream 31 without organic acid (or substantially free of organic acid) exits at the top end of the column 30. "Substantially free of organic acid" means at least 90% of the acetic acid is stripped from the gas stream 27 containing organic acids. Preferably at least 95% is removed.

[0030] A waste water stream 35 containing organic acid exits the bottom end of the gas stripper column 25. This stream 35 can be recycled to the gas/organic acid stripper column 30. The gas stream 31 can be recycled to the MEG/organic acid stripper column 25 as a recycle gas stream 33.

[0031] The temperature range operated in is about 40° C to 60° C, with 60° C for the rich MEG stream 21 and gas stream 27 containing organic acids, 40° C for the gas make-up and recycle streams 23, 33, and 40° for solution 41 and water streams. Those temperatures can vary depending on the application-specific requirements.

[0032] Referring to FIG. 2, and by way of example, a simulation using a rich MEG stream of 50.85 m³/hr containing 1497 ppm acetic acid shows that 94% of the acetic acid can be stripped from the rich MEG stream by circulating 1100 kg/hr of stripping gas in the MEG/organic acid stripping column, where 100 kg/hr is provided by the gas make-up flow and 1000 kg/hr is provided by the recycled gas flow. The

method also removes 57% of the incoming propionic acid, 99% of the formic acid, and 72% of the butyric acid.

[0033] The use of a caustic solution such as a dilute sodium hydroxide solution in the gas/organic acid stripper removes > 99% of the acetic acid from the stripping gas. About 90% of the now substantially organic acid-free stripping gas is then recycled in the MEG/organic acid stripper column. This minimizes the amount of stripping gas make-up. A portion of the caustic solution can also be recycled to minimize the amount of caustic and water make-up as well as reduce the waste stream exiting the gas/organic acid stripper column.

[0034] The embodiments described above and illustrated in the drawing figures provide examples of the system and method. The following claims define the inventive system and method and cover the full range of equivalents to which the recited elements of the claims are entitled.