

**CRYOGENIC SYSTEMS FOR REMOVING ACID GASES FROM A HYDROCARBON GAS STREAM
USING CO-CURRENT SEPARATION DEVICES**

CROSS-REFERENCE TO RELATED APPLICATIONS

5 **[0001]** This application claims the benefit of U. S. provisional patent application number 61/369,377, filed on 30 July 2010, entitled CRYOGENIC SYSTEMS FOR REMOVING ACID GASES FROM A HYDROCARBON GAS STREAM USING CO-CURRENT SEPARATION DEVICES. This application also claims the benefit of U. S. provisional patent application number 61/500,314, filed on 23 June 2011, entitled CRYOGENIC
10 SYSTEMS FOR REMOVING ACID GASES FROM A HYDROCARBON GAS STREAM USING CO-CURRENT SEPARATION DEVICES, the entirety of which is incorporated by reference herein.

FIELD OF THE INVENTION

15 **[0002]** The present invention relates to the field of fluid separation. More specifically, the present invention relates to the separation of carbon dioxide and other acid gases from a hydrocarbon fluid stream.

BACKGROUND

20 **[0003]** This section is intended to introduce various aspects of the prior art. This discussion is believed to assist in providing 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.

25 **[0004]** The production of hydrocarbons from a reservoir oftentimes carries with it the incidental production of non-hydrocarbon gases. Such gases include contaminants such as carbon dioxide (CO₂) and hydrogen sulfide (H₂S). When CO₂ and H₂S are produced as part of a hydrocarbon gas stream (such as methane (C₁) or ethane (C₂)), the gas stream is
sometimes referred to as “sour gas.”

30 **[0005]** Sour gas is usually treated to remove CO₂, H₂S, and other contaminants before it is sent downstream for further processing or sale. Removal of acid gases creates a “sweetened” hydrocarbon gas stream. The sweetened stream may be used as an environmentally-acceptable fuel or as feedstock to a chemicals or gas-to-liquids facility. The sweetened gas stream may be chilled to form liquefied natural gas, or LNG.

[0006] The gas separation process creates an issue as to the disposal of the separated contaminants. In some cases, the concentrated acid gas (consisting primarily of H₂S and CO₂) is sent to a sulfur recovery unit ("SRU"). The SRU converts the H₂S into benign elemental sulfur. However, in some areas (such as the Caspian Sea region), additional
5 elemental sulfur production is undesirable because there is a limited market. Consequently, millions of tons of sulfur have been stored in large, above-ground blocks in some areas of the world, most notably Canada and Kazakhstan.

[0007] While the sulfur is stored on land, the carbon dioxide associated with the acid gas is oftentimes vented to the atmosphere. However, the practice of venting CO₂ is sometimes
10 undesirable. One proposal to minimize CO₂ emissions is a process called acid gas injection ("AGI"). AGI means that unwanted sour gases are re-injected into a subterranean formation under pressure and sequestered for potential later use. Alternatively, the carbon dioxide is used to create artificial reservoir pressure for enhanced oil recovery operations.

[0008] To facilitate AGI, it is desirable to have a gas processing facility that effectively
15 separates out the acid gas components from the hydrocarbon gases. Some natural gas reservoirs contain relatively low percentages of hydrocarbons (less than 40%, for example) and high percentages of acid gases, principally carbon dioxide, but also hydrogen sulfide, carbonyl sulfide, carbon disulfide and various mercaptans. In these instances, cryogenic gas processing may be beneficially employed.

[0009] Cryogenic gas processing is a distillation process sometimes used for gas
20 separation. However, conventional cryogenic distillation towers may be bulky and/or create weight distribution issues for offshore vessels and platforms. Moreover, for gas streams having unusually high levels of CO₂ (such as greater than about 30 mol. percent), additional processing may be needed to remove methane that becomes entrained in the bottoms liquid
25 stream, or to remove carbon dioxide that becomes entrained in the overhead gas stream.

[0010] Challenges also exist with respect to cryogenic distillation of sour gases. For example at higher CO₂ concentrations, e.g., greater than about 5 mol. percent at total pressure less than about 700 psig, CO₂ may freeze out as a solid the cryogenic distillation tower. The formation of CO₂ as a solid disrupts the cryogenic distillation process.

[0011] Therefore, there is a need for improved cryogenic distillation systems, which
30 resolve one or more of the problems identified above.

SUMMARY

[0012] Provided are systems for removing acid gases from a raw gas stream, including

components (a)–(e): (a) a dehydration vessel for receiving the raw gas stream, and separating the raw gas stream into a dehydrated raw gas stream and a stream comprised substantially of an aqueous fluid, (b) a heat exchanger for cooling the dehydrated gas stream, and releasing a cooled sour gas stream, (c) a cryogenic distillation tower that receives the cooled sour gas stream, and separates the cooled sour gas stream into (i) an overhead gas stream comprised primarily of methane, and (ii) a bottom liquefied acid gas stream comprised primarily of carbon dioxide, (d) a final co-current contactor, and (e) a first co-current contactor.

[0013] In one or more embodiments, the present system utilizes a lower distillation section that is substantially reduced in size compared to conventional systems. In some embodiments, the lower distillation section is completely removed. In one or more embodiments, the system is configured to so that methane gas entrained in the cold, bottoms liquid stream is captured using a series of small, co-current separation devices, and redirected back into the controlled freezing section. In one or more embodiments, the system is configured to so that carbon dioxide entrained in the overhead methane gas stream is captured using a series of small, co-current separation devices, and redirected back into the controlled freezing section.

[0014] Also provided are methods of using the system for removing acid gases from a raw gas stream.

BRIEF DESCRIPTION OF THE DRAWINGS

[0015] So that the manner in which the present inventions can be better understood, certain illustrations, charts and/or flow charts are appended hereto. It is to be noted, however, that the drawings illustrate only selected embodiments of the inventions and are therefore not to be considered limiting of scope, for the inventions may admit to other equally effective embodiments and applications.

[0016] Figure 1 is a side view of an illustrative cryogenic distillation tower, in one embodiment. A chilled raw gas stream is being injected into the intermediate controlled freezing zone of the tower.

[0017] Figure 2 is a schematic diagram showing a gas processing facility for removing acid gases from a gas stream in accordance with the present invention, in one embodiment. The gas processing facility employs a series of co-current contactors for recapturing methane from the bottom acid gas stream.

[0018] Figure 3 provides a schematic diagram showing a gas processing facility for removing acid gases from a gas stream in accordance with the present invention, in an

alternate embodiment. The gas processing facility employs a series of co-current contactors for further sweetening methane from the overhead gas stream.

DETAILED DESCRIPTION OF CERTAIN EMBODIMENTS

Definitions

5 [0019] As used herein, the term “hydrocarbon” refers to an organic compound that includes primarily, if not exclusively, the elements hydrogen and carbon. Hydrocarbons generally fall into two classes: aliphatic, or straight chain hydrocarbons, and cyclic, or closed ring hydrocarbons, including cyclic terpenes. Examples of hydrocarbon-containing materials include any form of natural gas, oil, coal, and bitumen that can be used as a fuel or upgraded
10 into a fuel.

[0020] As used herein, the term “hydrocarbon fluids” refers to a hydrocarbon or mixtures of hydrocarbons that are gases or liquids. For example, hydrocarbon fluids may include a hydrocarbon or mixtures of hydrocarbons that are gases or liquids at formation conditions, at processing conditions or at ambient conditions (15° C and 1 atm pressure). Hydrocarbon
15 fluids may include, for example, oil, natural gas, coal bed methane, shale oil, pyrolysis oil, pyrolysis gas, a pyrolysis product of coal, and other hydrocarbons that are in a gaseous or liquid state.

[0021] The term “mass transfer device” refers to any object that receives fluids to be contacted, and passes those fluids to other objects, such as through gravitational flow. One
20 non-limiting example is a tray for stripping out certain components. A grid packing is another example.

[0022] As used herein, the term “fluid” refers to gases, liquids, and combinations of gases and liquids, as well as to combinations of gases and solids, and combinations of liquids and solids.

25 [0023] As used herein, the term “condensable hydrocarbons” means those hydrocarbons that condense at about 15° C and one atmosphere absolute pressure. Condensable hydrocarbons may include, for example, a mixture of hydrocarbons having carbon numbers greater than 4.

[0100] As used herein, the term “heavy hydrocarbons” refers to hydrocarbons having
30 more than one carbon atom. Principal examples include ethane, propane and butane. Other examples include pentane, aromatics, or diamondoids.

[0101] As used herein, the term “closed loop refrigeration system” means any

refrigeration system wherein an external working fluid such as propane or ethylene is used as a coolant to chill an overhead methane stream. This is in contrast to an “open loop refrigeration system” wherein a portion of the overhead methane stream itself is used as the working fluid.

5 [0102] As used herein, the term “co-current contacting device” or “co-current contactor” means a vessel that receives (i) a stream of gas and (ii) a separate stream of solvent or liquefied gas in such a manner that the gas stream and the solvent stream (or liquefied gas, as the case may be) contact one another while flowing in generally the same directions within the contacting device. Non-limiting examples include an eductor and a coalescer, or a static
10 mixer plus deliquidizer.

[0103] “Non-absorbing gas” means a gas that is not significantly absorbed by a solvent or liquefied gas during a gas sweetening process.

[0104] As used herein, the term “natural gas” refers to a multi-component gas obtained from a crude oil well (associated gas) or from a subterranean gas-bearing formation (non-
15 associated gas). The composition and pressure of natural gas can vary significantly. A typical natural gas stream contains methane (C_1) as a significant component. The natural gas stream may also contain ethane (C_2), higher molecular weight hydrocarbons, and one or more acid gases. The natural gas may also contain minor amounts of contaminants such as water, nitrogen, wax, and crude oil.

20 [0105] As used herein, an “acid gas” means any gas that dissolves in water producing an acidic solution. Nonlimiting examples of acid gases include hydrogen sulfide (H_2S), and carbon dioxide (CO_2). Sulfurous compounds include carbon disulfide (CS_2), carbonyl sulfide (COS), mercaptans, or mixtures thereof.

[0106] The term “liquid solvent” means a fluid in substantially liquid phase that
25 preferentially absorbs acid gases, thereby removing or “scrubbing” at least a portion of the acid gas components from a gas stream. The gas stream may be a hydrocarbon gas stream or other gas stream, such as a gas stream having nitrogen.

[0107] “Sweetened gas stream” refers to a fluid stream in a substantially gaseous phase that has had at least a portion of acid gas components removed.

30 [0108] As used herein, the terms “lean” and “rich,” with respect to the absorbent liquid removal of a selected gas component from a gas stream, are relative, merely implying, respectively, a lesser or greater degree of content of the selected gas component. The respective terms “lean” and “rich” do not necessarily indicate or require, respectively, either

that an absorbent liquid is totally devoid of the selected gaseous component, or that it is incapable of absorbing more of the selected gas component.

[0109] The term “raw gas stream” refers to a hydrocarbon fluid stream wherein the fluids are primarily in a gaseous phase, and which has not undergone steps to remove carbon dioxide, hydrogen sulfide, or other acidic components.

[0110] The term “sour gas stream” refers to a hydrocarbon fluid stream wherein the fluids are primarily in a gaseous phase, and contain at least 3 mol. percent carbon dioxide and/or more than 4 ppm hydrogen sulfide.

[0024] As used herein, the term “subsurface” refers to geologic strata occurring below the earth's surface.

Systems For Removing Acid Gases

[0025] Provided are systems for removing acid gases from a raw gas stream. In one embodiment, the system first includes a dehydration vessel. The dehydration vessel may be a vessel that uses glycol or other chemical to remove water or brine from a hydrocarbon fluid stream. The dehydration vessel receives the raw gas stream, and separates the raw gas stream into a dehydrated raw gas stream and a stream comprised substantially of an aqueous fluid.

[0026] The system also includes a heat exchanger. The heat exchanger receives the dehydrated raw gas stream and cools it through heat exchange with a colder working fluid or other mechanism. Cooling may include, for example, use of an expansion valve. The heat exchanger releases a cooled sour gas stream.

[0027] The system also includes a cryogenic distillation tower. The cryogenic distillation tower is preferably a CFZ™ tower, as discussed below. The cryogenic distillation tower receives the cooled sour gas stream, and separates the cooled sour gas stream into (i) an overhead gas stream comprised primarily of methane, and (ii) a bottom liquefied acid gas stream comprised primarily of carbon dioxide.

[0028] The system further includes a final co-current contactor. The final co-current contactor is configured to receive the bottom liquefied acid gas stream, or liquid from an optional melt tray. Therefore, it may be referred to as a final lower co-current contactor. The final co-current contactor also receives a partially-methane-enriched gas stream from a previous co-current contactor.

[0029] The final co-current contactor provides for rapid mixing of the bottom liquefied acid gas stream and the partially methane-enriched gas stream. From there, the final co-

current contactor releases a final methane-enriched gas stream back into the cryogenic distillation tower. The final co-current contactor also releases a first partially-stripped acid gas liquid.

[0030] The system also includes a first co-current contactor. The first co-current
5 contactor is configured to receive a stripping gas, for example from a reboiler. In one aspect, the stripping gas is carbon dioxide. The first co-current contactor is in series with the final lower co-current contactor. Therefore, the first co-current contactor may be referred to as a first lower co-current contactor. The first lower co-current contactor also receives a second partially-stripped acid gas liquid from a second co-current contactor. In one aspect, the
10 second partially-stripped acid gas liquid comprises about 98 mol. percent or more carbon dioxide.

[0031] The first co-current contactor provides for rapid mixing of the stripping gas and the final stripped acid gas liquid. From there, the first co-current contactor releases a final stripped acid gas liquid. The first co-current contactor also releases a first partially methane-
15 enriched gas stream to the second co-current contactor.

[0032] Preferably, a substantial portion of the final stripped acid gas liquid is injected into a subsurface formation through one or more acid gas injection wells. However, a portion of the final stripped acid gas liquid may be diverted and re-used as the stripping gas via introduction to the reboiler.

[0033] The system may have only the two co-current contactors for processing the
20 bottom liquefied acid gas stream. In this instance, the final co-current contactor is the second co-current contactor, while the previous co-current contactor is the first co-current contactor. Further, the first partially-methane-enriched gas stream released by the first co-current contactor is the partially methane-enriched gas stream received by the final co-current
25 contactor. In addition, the first partially-stripped acid gas liquid received by the final co-current contactor is the second partially-stripped acid gas liquid received by the first co-current contactor.

[0034] Alternatively, the system may have three co-contactors for processing the bottom liquefied acid gas stream. In this instance, the previous co-current contactor is a second co-
30 current contactor. The second co-current contactor is then configured to receive the first partially methane-enriched gas stream from the first co-current contactor, and the first partially-stripped acid gas liquid from the final co-current contactor. Further, the second co-current contactor releases a second partially methane-enriched gas stream to the final co-

current contactor, and a second partially-stripped acid gas liquid to the first co-current contactor.

[0035] Alternatively, the system may have more than three co-current contactors for processing the bottom acid gas stream. The final co-current contactor, any intermediate co-
5 contactors, the second co-current contactor and the first co-current contactor are arranged to deliver respective stripped acid gas liquids as progressively CO₂-richer acid gas liquids in series. At the same time, the first co-current contactor, the second co-current contactor, any intermediate co-contactors, and the final co-current contactor are arranged to deliver the respective methane-enriched gas streams as progressively methane-enriched gas streams in
10 series.

[0036] In any of these systems, the cryogenic distillation tower may have a melt tray below the freezing zone. The melt tray receives a cold slurry of acid gas components, and then delivers the slurry to the final lower co-current contacting device as the bottom liquefied acid gas stream.

[0037] An alternative system for removing acid gases from a raw gas stream is provided herein. Once again, the system includes a dehydration vessel for receiving the raw gas stream, and separating the raw gas stream into a dehydrated raw gas stream and a stream comprised substantially of an aqueous fluid. In addition, the system again includes a heat exchanger for cooling the dehydrated raw gas stream, and releasing a cooled sour gas stream.

[0038] The system also includes a cryogenic distillation tower. The cryogenic distillation tower is preferably a CFZ™ tower, such as the column discussed below. The cryogenic distillation tower receives the cooled sour gas stream, and separates the cooled sour gas stream into (i) an overhead gas stream comprised primarily of methane, and (ii) a bottom liquefied acid gas stream comprised primarily of carbon dioxide.

[0039] The system further includes a first co-current contactor. The first co-current contactor is configured to receive the overhead gas stream. Therefore, it may be referred to as a first upper co-current contactor. The first co-current contactor also receives a second partially-CO₂-enriched reflux liquid from a second co-current contactor.

[0040] The first co-current contactor provides for rapid mixing of the overhead gas stream and the second partially-CO₂-enriched reflux liquid. From there, the first co-current contactor releases a first partially-sweetened methane gas stream to the second co-current contactor. The first co-current contactor also releases a final CO₂-enriched reflux liquid back to the cryogenic distillation tower.

[0041] The system also includes a final co-current contactor. The final co-current contactor is configured to receive a partially-sweetened gas. In one aspect, the partially-sweetened gas is methane. The final co-current contactor is in series with the first upper co-current contactor. Therefore, the final co-current contactor may be referred to as a final upper co-current contactor. The final upper co-current contactor also receives a reflux liquid. The reflux liquid is preferably methane.

[0042] The final co-current contactor provides for rapid mixing of the reflux liquid and the final partially-sweetened methane gas. From there, the final co-current contactor releases a first partially- CO₂-enriched reflux liquid to the next-to-last co-current contactor. The final co-current contactor also releases a final sweetened methane gas stream. In one aspect, the final sweetened methane gas stream comprises about 99 mol. percent or more methane.

[0043] Preferably, a substantial portion of the final sweetened methane gas stream is delivered for liquefaction and sale. However, a portion of the final sweetened methane gas stream may be diverted and used to generate the reflux liquid.

[0044] The system may have only the two co-current contactors for processing the overhead gas stream. In this instance, the final co-current is the second co-current contactor, while the next-to-last co-current contactor is the first co-current contactor. Further, the first partially-sweetened methane gas stream released by the first co-current contactor is the next-to-last partially sweetened methane gas stream received by the final co-current contactor. In addition, the second partially-CO₂-enriched reflux liquid received by the first co-current contactor is the first partially-CO₂-enriched reflux liquid released by the final co-current contactor.

[0045] Alternatively, the system may have three co-contactors for processing the overhead gas stream. In this instance, the next-to-last co-current contactor is a second co-current contactor. The second co-current contactor is then configured to receive the first partially-sweetened methane gas stream from the first co-current contactor, and the first partially-CO₂-enriched reflux liquid from the final co-current contactor. Further, the second co-current contactor releases a second partially-sweetened methane gas stream to the final co-current contactor, and a final partially- CO₂-enriched reflux liquid to the first co-current contactor.

[0046] Alternatively, the system may have more than three co-current contactors for processing the overhead gas stream. The final co-current contactor, any intermediate co-contactors, the second co-current contactor and the first co-current contactor are arranged to

deliver respective partially-CO₂-enriched reflux liquid as progressively CO₂-enriched reflux liquids in series. At the same time, the first co-current contactor, the second co-current contactor, any intermediate co-contactors, and the final co-current contactor are arranged to deliver the respective sweetened gas streams as progressively sweetened gas streams in series.

[0047] In these systems, the cryogenic distillation tower also has an upper distillation zone. The upper distillation zone is above the freezing zone, and receives vapor from the freezing zone. The upper distillation zone then releases the overhead gas stream to the first upper co-current contacting device.

[0048] In one or more embodiments, a system is provided for removing acid gases from a raw gas stream that employs two sets of co-current contactors. One set is placed in series to receive the bottom acid gas stream and concentrate it using a stripping gas such as carbon dioxide. The other set is placed in series to receive the overhead gas stream, and sweeten it using a reflux liquid such as methane. In the first instance, the stripping gas is directed back into the cryogenic distillation column for further processing. In the latter instance, the sweetened gas is optionally liquefied and delivered for commercial sale, or is used as fuel gas on-site.

Cryogenic Separation

[0049] Typically, cryogenic gas separation generates a cooled overhead gas stream at moderate pressures (e.g., 350-500 pounds per square inch gauge (psig)). In addition, liquefied acid gas is generated as a “bottoms” product. Since liquefied acid gas has a relatively high density, hydrostatic head can be beneficially used in an AGI well to assist in the injection process. This means that the energy required to pump the liquefied acid gas into the formation is lower than the energy required to compress low-pressure acid gases to reservoir pressure. Fewer stages of compressors and pumps are required.

[0050] Challenges exist with respect to cryogenic distillation of sour gases. When CO₂ is present at concentrations greater than about 5 mol. percent at total pressure less than about 700 psig in the gas to be processed, it will freeze out as a solid in a standard cryogenic distillation unit. The formation of CO₂ as a solid disrupts the cryogenic distillation process. To circumvent this problem, the assignee has previously designed various “Controlled Freeze Zone™” (CFZ™) processes. The CFZ™ process takes advantage of the propensity of carbon dioxide to form solid particles by allowing frozen CO₂ particles to form within an open portion of the distillation tower, and then capturing the particles on a melt tray. As a result, a

clean methane stream (along with any nitrogen or helium present in the raw gas) is generated at the top of the tower, while a cold liquid CO₂/H₂S stream is generated at the bottom of the tower.

[0051] Certain aspects of the CFZ™ process and associated equipment are described in
5 U.S. Pat. No. 4,533,372; U.S. Pat. No. 4,923,493; U.S. Pat. No. 5,062,270; U.S. Pat. No. 5,120,338; and U.S. Pat. No. 6,053,007, which are each herein incorporated by reference in their entirety.

[0052] As generally described in the above U.S. patents, the distillation tower, or column,
10 used for cryogenic gas processing includes a lower distillation zone and an intermediate controlled freezing zone. Preferably, an upper distillation zone is also included. The column operates to create solid CO₂ particles by providing a portion of the column having a temperature range below the freezing point of carbon dioxide, but above the boiling temperature of methane at that pressure. More preferably, the controlled freezing zone is operated at a temperature and pressure that permits methane and other light hydrocarbon
15 gases to vaporize, while causing CO₂ to form frozen (solid) particles.

[0053] As the gas feed stream moves up the column, frozen CO₂ particles break out of the dehydrated, raw feed stream and gravitationally descend from the controlled freezing zone onto a melt tray. There, the particles liquefy. A carbon dioxide-rich liquid stream then flows from the melt tray down to the lower distillation zone at the bottom of the column. The lower
20 distillation zone is maintained at a temperature and pressure at which substantially no carbon dioxide solids are formed, but dissolved methane boils out. In one aspect, a bottom acid stream is created at 30° to 40° F.

[0054] In one embodiment, some or all of the frozen CO₂ particles may be collected on a tray at the bottom of the freezing zone. The particles are then transported out of the
25 distillation tower for further processing.

[0055] The controlled freezing zone includes a cold liquid spray. This is a methane-enriched liquid stream known as “reflux.” As the vapor stream of light hydrocarbon gases and entrained sour gases moves upward through the column, the vapor stream encounters the liquid spray. The cold liquid spray aids in breaking out solid CO₂ particles while permitting
30 methane gas to evaporate and flow upward in the column.

[0056] In the upper distillation zone (sometimes referred to as a rectification zone), the methane is captured overhead and piped away for sale or made available for fuel. In one aspect, the overhead methane stream is released at about -130° F. The overhead gas may be

partially liquefied by additional cooling, and a part of the liquid returned to the column as the reflux. The liquid reflux is injected as the cold spray into the spray section of the controlled freezing zone, usually after flowing through trays or packing of the rectification section of the column.

5 Specific Embodiments

[0057] **Figure 1** presents a schematic view of a cryogenic distillation tower **100** used in connection with the separation of carbon dioxide from a raw natural gas stream. The cryogenic distillation tower **100** may be interchangeably referred to herein as a “column,” a “CFZ column,” or just a “tower.”

10 [0058] The cryogenic distillation tower **100** of **Figure 1** receives an initial fluid stream **10**. The fluid stream **10** is comprised primarily of production gases. Typically, the fluid stream represents a dried gas stream from a wellhead or collection of wellheads (not shown), and contains about 65% to about 95% methane. However, the fluid stream **10** may contain a lower percentage of methane, such as about 30% to 65%, or even as low as 20% to 40%.

15 [0059] The methane may be present along with trace elements of other hydrocarbon gases such as ethane. In addition, trace amounts of helium and nitrogen may be present. In the present application, the fluid stream **10** will also include certain contaminants. These include acid gases such as CO₂ and H₂S.

[0060] The initial fluid stream **10** may be at a post-production pressure of approximately
20 600 pounds per square inch (psi). In some instances, the pressure of the initial fluid stream **10** may be up to about 750 psi or even 1,000 psi.

[0061] The fluid stream **10** is typically chilled before entering the distillation tower **100**. A heat exchanger **150**, such as a shell-and-tube exchanger, is provided for the initial fluid stream **10**. A refrigeration unit (not shown) provides cooling fluid (such as liquid propane) to
25 the heat exchanger **150** to bring the temperature of the initial fluid stream **10** down to about -30° to -40° F. The chilled fluid stream may then be moved through an expansion device **152**. The expansion device **152** may be, for example, a Joule-Thompson (“J-T”) valve.

[0062] The expansion device **152** serves as an expander to obtain additional cooling of the fluid stream **10**. Preferably, partial liquefaction of the fluid stream **10** is achieved through
30 expansion. A Joule-Thompson (or “J-T”) valve is preferred for gas feed streams that are prone to forming solids. The expansion device **152** is preferably mounted close to the cryogenic distillation tower **100** to minimize heat loss in the feed piping and to minimize the

chance of plugging with solids in case some components (such as CO₂ or benzene) are dropped below their freezing points.

[0063] As an alternative to a J-T valve, the expander device **152** may be a turbo-expander. A turbo-expander provides greater cooling and creates a source of shaft work for processes like a refrigeration unit. The heat exchanger **150** is part of a refrigeration unit. In this manner, the operator may minimize the overall energy requirements for the distillation process. However, the turbo-expander may not handle frozen particles as well as the J-T valve.

[0064] In either instance, the heat exchanger **150** and the expander device **152** convert the raw gas in the initial fluid stream **10** into a chilled fluid stream **12**. Preferably, the temperature of the chilled fluid stream **12** is around -40° to -70° F. In one aspect, the cryogenic distillation tower **100** is operated at a pressure of about 550 psi, and the chilled fluid stream **12** is at approximately -62° F. At these conditions, the chilled fluid stream **12** is in a substantially liquid phase, although some vapor phase may inevitably be entrained into the chilled fluid stream **12**. Most likely, no solids formation has arisen from the presence of CO₂.

[0065] The CFZ™ cryogenic distillation tower **100** is divided into three primary sections. These are a lower distillation zone, or “stripping section” **106**, an intermediate controlled freezing zone, or “spray section” **108**, and an upper distillation zone, or “rectification section” **110**. In the tower arrangement of **Figure 1**, the chilled fluid stream **12** is introduced into the distillation tower **100** in the controlled freezing zone **108**. However, the chilled fluid stream **12** may alternatively be introduced near the top of the lower distillation zone **106**.

[0066] It is noted in the arrangement of **Figure 1** that the lower distillation zone **106**, the intermediate spray section **108**, the upper distillation zone **110**, and the related components are housed within a single vessel **100**. However, for offshore applications in which height of the tower **100** and motion may need to be considered, or for remote locations in which transportation limitations are an issue, the tower **110** may optionally be split into two separate pressure vessels (not shown). For example, the lower distillation zone **106** and the controlled freezing zone **108** may be located in one vessel, while the upper distillation zone **108** is in another vessel. External piping would then be used to interconnect the two vessels.

[0067] In either embodiment, the temperature of the lower distillation zone **106** is higher than the feed temperature of the chilled fluid stream **12**. The temperature of the lower distillation zone **106** is designed to be well above the boiling point of the methane in the

chilled fluid stream **12** at the operating pressure of the column **100**. In this manner, methane is preferentially stripped from the heavier hydrocarbon and liquid acid gas components. Of course, those of ordinary skill in the art will understand that the liquid within the distillation tower **100** is a mixture, meaning that the liquid will “boil” at some intermediate temperature
5 between pure methane and pure CO₂. Further, in the event that there are heavier hydrocarbons present in the mixture (such as ethane or propane), this will increase the boiling temperature of the mixture. These factors become design considerations for the operating temperatures within the cryogenic distillation tower **100**.

[0068] In the lower distillation zone **106**, the CO₂ and any other liquid-phase fluids
10 gravitationally fall towards the bottom of the cryogenic distillation tower **100**. At the same time, methane and other vapor-phase fluids break out and rise upwards towards the top of the tower **100**. This separation is accomplished primarily through the density differential between the gas and liquid phases. However, the separation process is optionally aided by internal components within the distillation tower **100**. As described below, these include a
15 melt tray **130**, a plurality of advantageously-configured mass transfer devices **126**, and an optional heater line **25**. A side reboiler (seen at **173**) may likewise be added to the lower distillation zone **106** to facilitate removal of methane.

[0069] Referring again to **Figure 1**, the chilled fluid stream **12** may be introduced into the column **100** near the top of the lower distillation zone **106**. Alternatively, it may be desirable
20 to introduce the feed stream **12** into the controlled freezing zone **108** above the melt tray **130**. The point of injection of the chilled fluid stream **12** is a design issue dictated primarily by the composition of the initial fluid stream **10**.

[0070] Where the temperature of the chilled fluid stream **12** is high enough (such as greater than -70° F) such that solids are not expected, it may be preferable to inject the chilled
25 fluid stream **12** directly into the lower distillation zone **106** through a two-phase flashbox type device (or vapor distributor) **124** in the column **100**. The use of a flashbox **124** serves to at least partially separate the two-phase vapor-liquid mixture in the chilled fluid stream **12**. The flashbox **124** may be slotted such that the two-phase fluid impinges against baffles in the flashbox **124**.

[0071] If solids are anticipated due to a low inlet temperature, the chilled fluid stream **12**
30 may need to be partially separated in a vessel **173** prior to feeding the column **100** as described above. In this case, the chilled feed stream **12** may be separated in a two phase separator **173** to minimize the possibility of solids plugging the inlet line and internal

components of the column **100**. Gas vapor leaves the phase separator **173** through a vessel inlet line **11**, where it enters the spray section **108** through an inlet distributor **121**. The gas then travels upward through the column **100**. At the same time, a liquid/solid slurry **13** is discharged from the phase separator **173**. The liquid/solid slurry is directed into the column **100** through the vapor distributor **124** and to the melt tray **130**. The liquid/solid slurry **13** can be fed to the lower distillation zone **106** by gravity or by a pump **175**.

[0072] In either arrangement, that is, with or without the two phase separator **173**, the chilled fluid stream **12** (or **11**) enters the column **100**. The liquid component travels down a collection of stripping trays **126** within the lower distillation zone **106**. The stripping trays **126** typically include a series of weirs **128** and downcomers **129**. The stripping trays **126**, in combination with the warmer temperature in the lower distillation zone **106**, cause methane to break out of solution. The resulting vapor carries the methane and any entrained carbon dioxide molecules that have boiled off upward through the column **100**.

[0073] In the arrangement of **Figure 1**, the vapor proceeds upward through risers or chimneys of the melt tray **130** and into the freezing zone **108**. The chimneys **131** act as a vapor distributor for uniform distribution through the freeze zone **108**. The vapor will then contact cold liquid from spray headers **120** to “freeze out” the CO₂. Stated another way, CO₂ will freeze and then precipitate or “snow” back onto the melt tray **130**. The solid CO₂ then melts and gravitationally flows in liquid form down the melt tray **130** and through the lower distillation zone **106** there below.

[0074] As will be discussed more fully below, the spray section **108** is an intermediate freeze zone of the cryogenic distillation tower **100**. With the alternate configuration in which the chilled fluid stream **12** is separated in vessel **173** prior to entering the tower **100**, a small portion of the liquid/solid slurry **13** is inevitably introduced into the tower **100** immediately above the melt tray **130**. Thus, a liquid-solid mixture of acid gas and heavier hydrocarbon components will flow from the distributor **121**, with solids and liquids falling down onto the melt tray **130**.

[0075] The melt tray **130** is configured to gravitationally receive liquid and solid materials, primarily CO₂ and H₂S, from the intermediate controlled freezing zone **108**. The melt tray **130** serves to warm the liquid and solid materials and direct them downward through the lower distillation zone **106** in liquid form for further purification. The melt tray **130** collects and warms the solid-liquid mixture from the controlled freezing zone **108** in a pool of liquid. The melt tray **130** is designed to release vapor flow back to the controlled

freezing zone **108**, to provide adequate heat transfer to melt the solid CO₂, and to facilitate liquid/slurry drainage to the lower distillation zone **106** of the column **100** below the melt tray **130**.

[0076] Additional details concerning the Controlled Freeze Zone tower **100** are disclosed
5 in U.S. Pat. Publ. No. 2010/0018248, entitled “Controlled Freeze Zone Tower”, which is
herein incorporated by reference in its entirety. For example, Figure 2A of the 2010
publication provides a plan view of the melt tray **130**, in one embodiment. Figure 2B
provides a cross-sectional view of the melt tray **130**, taken across line B-B of Figure 2A.
Figure 2C shows a cross-sectional view of the melt tray **130**, taken across line C-C. The
10 2010 publication is incorporated by reference herein in its entirety.

[0077] Referring again to **Figure 1**, the melt tray **130** may also be designed with an
external liquid transfer system. The external transfer system serves to ensure that all liquid is
substantially free of solids and that sufficient heat transfer has been provided. The transfer
system first includes a draw-off nozzle **136**. In one embodiment, the draw-off nozzle **136**
15 resides within the draw-off sump, or channel **138** (shown in Figure 2C of the 2010
publication). Fluids collected in the channel **138** are delivered to a transfer line **135**. Flow
through the transfer line **135** may be controlled by a control valve **137** and a level controller
“LC” (seen in **Fig. 1**). Fluids are returned to the lower distillation zone **106** via the transfer
line **135**. If the liquid level is too high, the control valve **137** opens; if the level is too low,
20 the control valve **137** closes. If the operator chooses not to employ the transfer system in the
lower distillation zone **106**, then the control valve **137** is closed and fluids are directed
immediately to the mass transfer devices, or “stripping trays” **126** below the melt tray **130** for
stripping via an overflow downcomer **139**.

[0078] Whether or not an external transfer system is used, solid CO₂ is warmed on the
25 melt tray **130** and converted to a CO₂-rich liquid. The melt tray **130** is heated from below by
vapors from the lower distillation zone **106**. Supplemental heat may optionally be added to
the melt tray **130** or just above the melt tray base **134** by various means such as heater line
25. The heater line **25** utilizes thermal energy already available from a bottom reboiler **160** to
facilitate thawing of the solids.

[0079] The CO₂-rich liquid is drawn off from the melt tray **130** under liquid level control
30 and gravitationally introduced to the lower distillation zone **106**. As noted, a plurality of
stripping trays **126** is provided in the lower distillation zone **106** below the melt tray **130**.
The stripping trays **126** are preferably in a substantially parallel relation, one above the other.

Each of the stripping trays **126** may optionally be positioned at a very slight incline, with a weir such that a liquid level is maintained on the tray. Fluids gravitationally flow along each tray, over the weir, and then flow down onto the next tray via a downcomer.

[0080] The stripping trays **126** may be in a variety of arrangements. The stripping trays **126** may be arranged in generally horizontal relation to form a back-and-forth, cascading liquid flow. However, it is preferred that the stripping trays **126** be arranged to create a cascading liquid flow that is divided by separate stripping trays substantially along the same horizontal plane. This is shown in the arrangement of Figure 3 of the 2010 publication, where the liquid flow is split at least once so that liquid flows across separate trays and falls into two opposing downcomers **129**.

[0081] The percentage of methane in the liquid becomes increasingly small as the liquid moves downward through the lower distillation zone **106**. The extent of distillation depends on the number of trays **126** in the lower distillation zone **106**. In the upper part of the lower distillation zone **106**, the methane content of the liquid may be as high as 25 mol. percent, while at the bottom stripping tray the methane content may be as low as 0.04 mol. percent. The methane content flashes out quickly along the stripping trays **126** (or other mass transfer devices). The number of mass transfer devices used in the lower distillation zone **106** is a matter of design choice based on the composition of the raw gas stream **10**. However, only a few levels of stripping trays **126** need be typically utilized to remove methane to a desired level of 1% or less in the liquefied acid gas, for example.

[0082] Various individual stripping tray **126** configurations that facilitate methane breakout may be employed. The stripping tray **126** may simply represent a panel with sieve holes or bubble caps. However, to provide further heat transfer to the fluid and to prevent unwanted blockage due to solids, so called “jet trays” may be employed below the melt tray. In lieu of trays, random or structured packing may also be employed. Figures 4A and 4B of the 2010 publication show an illustrative jet tray **426**.

[0083] In operation, one or more jet trays may be located in the lower distillation zone **106** and/or the upper distillation zone **110** of the tower **100**. The trays may be arranged with multiple passes such as the pattern of stripping trays **126**. However, any tray or packing arrangement may be utilized that facilitates the breakout of methane gas. Fluid cascades down upon each jet tray.

[0084] As the down-flowing liquid hits the stripping trays **126**, separation of materials occurs. Methane gas breaks out of solution and moves upward in vapor form. The CO₂,

however, is generally cold enough and in high enough concentration that it mostly remains in its liquid form and travels down to the bottom of the lower distillation zone **106**, although some CO₂ will necessarily be vaporized in the process. The liquid is then moved out of the cryogenic distillation tower **100** in an exit line as a bottoms fluid stream **22**.

5 **[0085]** Upon exiting the distillation tower **100**, the bottoms fluid stream **22** enters a reboiler **160**. In **Figure 1**, the reboiler **160** is a kettle-type vessel that provides reboiled vapor to the bottom of the stripping trays **126**. A reboiled vapor line is seen at **27**. In addition, reboiled vapor may be delivered through a heater line **25** to provide supplemental heat to the melt tray **130**. The supplemental heat is controlled through a valve **165** and temperature
10 controller **TC**. Alternatively, a heat exchanger, such as a thermosyphon heat exchanger (not shown) may be used to cool the initial fluid stream **10** to economize energy. In this respect, the liquids entering the reboiler **160** remain at a relatively low temperature, for example, about 30° to 40° F. By heat integrating with the initial fluid stream **10**, the operator may warm and partially boil the cool bottoms fluid stream **22** from the distillation tower **100** while
15 pre-cooling the production fluid stream **10**. For this case, the fluid providing supplemental heat through line **25** is a vapor phase return from the reboiler **160**.

[0086] It is contemplated that under some conditions, the melt tray **130** may operate without heater line **25**. In these instances, the melt tray **130** may be designed with an internal heating feature such as an electric heater. However, it is preferred that a heat system be
20 offered that employs the heat energy available in the bottoms fluid stream **22**. The warm fluids in heater line **25** exist in one aspect at 30° to 40° F, so they contain relative heat energy. Thus, in **Figure 1**, a warm vapor stream in heater line **25** is shown being directed to the melt tray **130** through a heating coil (not shown) on the melt tray **130**. The warm vapor stream may alternatively be tied to the transfer line **135**.

25 **[0087]** In operation, most of the reboiled vapor stream is introduced at the bottom of the column through line **27**, above the bottom liquid level and at or below the last stripping tray **126**. As the reboiled vapor passes upward through each tray **126**, residual methane is stripped out of the liquid. This vapor cools off as it travels up the tower. By the time the vapor stream from line **27** reaches the corrugated melt tray **130**, the temperature may drop to
30 about -20° F to 0° F. However, this remains quite warm compared to the melting solid on the melt tray **130**, which may be around -50° F to -70° F. The vapor still has enough enthalpy to melt the solids CO₂ as it comes in contact with the melt tray **130**.

[0088] Referring back to reboiler **160**, fluids exit the reboiler **160** as a CO₂-rich liquid

stream **24**. The fluids in the liquid stream **24** may optionally be passed through an expander valve **162**. The expander valve **162** reduces the pressure of the liquid steam, effectively providing a refrigeration effect. Thus, a chilled bottom stream **26** is provided. The CO₂-rich liquid exiting the reboiler **160** as the chilled bottom stream **26** may be pumped downhole
5 through one or more AGI wells (seen schematically at **164** in **Figure 1**). In some situations, the liquid CO₂ may be pumped into a partially recovered oil reservoir as part of an enhanced oil recovery process. Thus, the CO₂ could be a miscible injectant. As an alternative, the CO₂ may be used as a miscible flood agent for enhanced oil recovery.

[0089] Referring again to the lower distillation zone **106** of the tower **100**, gas moves up
10 through the lower distillation zone **106**, through the chimneys **131** in the melt tray **130**, and into the controlled freezing zone **108**. The controlled freezing zone **108** defines an open chamber having a plurality of spray nozzles **122**. As the vapor moves upward through the controlled freezing zone **108**, the temperature of the vapor becomes much colder. The vapor is contacted by liquid methane (“reflux”) coming from the spray nozzles **122**. This liquid
15 methane is much colder than the upwardly-moving vapor, having been chilled by an external refrigeration unit that includes a heat exchanger **170**. In one arrangement, the liquid methane exits from spray nozzles **122** at a temperature of approximately -120° F to -130° F. However, as the liquid methane evaporates, it absorbs heat from its surroundings, thereby reducing the temperature of the upwardly-moving vapor. The vaporized methane also flows upward due
20 to its reduced density (relative to liquid methane) and the pressure gradient within the distillation tower **100**.

[0090] As the methane vapors move further up the cryogenic distillation tower **100**, they leave the intermediate controlled freezing zone **108** and enter the upper distillation zone **110**. The vapors continue to move upward along with other light gases broken out from the
25 original chilled fluid stream **12** (or vessel inlet line **11**). The combined hydrocarbon vapors move out of the top of the cryogenic distillation tower **100**, becoming an overhead methane stream **14**.

[0091] The hydrocarbon gas in overhead methane stream **14** is moved into the external refrigeration unit **170**. In one aspect, the refrigeration unit **170** uses an ethylene refrigerant or
30 other refrigerant capable of chilling the overhead methane stream **14** down to about -135° to -145° F. This serves to at least partially liquefy the overhead methane stream **14**. The refrigerated methane stream **14** is then moved to a reflux condenser or separation chamber **172**.

[0092] The separation chamber 172 is used to separate gas 16 from liquid, referred to sometimes as “liquid reflux” 18. The gas 16 represents the lighter hydrocarbon gases, primarily methane, from the original raw gas stream 10. Nitrogen and helium may also be present. The methane gas 16 is, of course, the “product” ultimately sought to be captured and sold commercially, along with any traces of ethane. This non-liquefied portion of the overhead methane stream 14 is also available for fuel on-site. The methane gas 16 may be further chilled for LNG transportation.

[0093] A portion of the overhead methane stream 14 exiting the refrigeration unit 170 is condensed. This portion is the liquid reflux 18 that is separated in the separation chamber 172 and returned to the tower 100. A pump 19 may be used to move the liquid reflux 18 back into the tower 100. Alternatively, the separation chamber 172 is mounted above the tower 100 to provide a gravity feed of the liquid reflux 18. The liquid reflux 18 will include some carbon dioxide that escaped from the upper distillation zone 110. However, most of the liquid reflux 18 is methane, typically 95% or more, with nitrogen (if present in the initial fluid stream 10) and traces of hydrogen sulfide (also if present in the initial fluid stream 10).

[0094] In one cooling arrangement, the overhead methane stream 14 is taken through an open-loop refrigeration system. In this arrangement, the overhead methane stream 14 is taken through a cross-exchanger to chill a return portion of the overhead methane stream used as the liquid reflux 18. Thereafter, the overhead methane stream 14 is pressurized to about 1,000 psi to 1,400 psi, and then cooled using ambient air and possibly an external propane refrigerant. The pressurized and chilled gas stream is then directed through an expander for further cooling. A turbo expander may be used to recover even more liquid as well as some shaft work. U.S. Pat. No. 6,053,007 entitled “Process for Separating a Multi-Component Gas Stream Containing at Least One Freezable Component,” describes the cooling of an overhead methane stream, and is incorporated herein in its entirety by reference.

[0095] Returning again to **Figure 1**, the liquid reflux 18 is returned into the upper distillation zone 110. The liquid reflux 18 is then gravitationally carried through one or more mass transfer devices 116 in the upper distillation zone 110. In one embodiment, the mass transfer devices 116 are rectification trays that provide a cascading series of weirs 118 and downcomers 119, similar to trays 126 described above.

[0096] As fluids from the liquid reflux stream 18 move downward through the rectification trays 116, additional methane vaporizes out of the upper distillation zone 110. The methane gases rejoin the overhead methane stream 14 to become part of the gas product

stream **16**. However, the remaining liquid phase of the liquid reflux **18** falls onto a collector tray **140**. As it does so, the liquid reflux stream **18** unavoidably will pick up a small percentage of hydrocarbon and residual acid gases moving upward from the controlled freezing zone **108**. The liquid mixture of methane and carbon dioxide is collected at a collector tray **140**.

[0097] The collector tray **140** preferably defines a substantially planar body for collecting liquids. However, as with melt tray **130**, collector tray **140** also has one, and preferably a plurality of chimneys for venting gases coming up from the controlled freezing zone **108**. A chimney and cap arrangement such as that presented by components **131** and **132** in Figures 2B and 2C of the 2010 publication may be used.

[0098] It is noted here that in the upper distillation zone **110**, any H₂S present has a preference towards being dissolved in the liquid versus being in the gas at the processing temperature. In this respect, the H₂S has a comparatively low relative volatility. By contacting the remaining vapor with more liquid, the cryogenic distillation tower **100** drives the H₂S concentration down to within the desired parts-per-million (ppm) limit, such as a 10 or even a 4 ppm specification. As fluid moves through the mass transfer devices **116** in the upper distillation zone **110**, the H₂S contacts the liquid methane and is pulled out of the vapor phase and becomes a part of the liquid stream **20**. From there, the H₂S moves in liquid form downward through the lower distillation zone **106** and ultimately exits the cryogenic distillation tower **100** as part of the liquefied acid gas bottoms stream **22**. For those cases where little to no H₂S is present in the feed stream, or if H₂S is selectively removed by an upstream process, virtually no H₂S will be present in the overhead gas.

[0099] In the cryogenic distillation tower **100**, the liquid captured at collector tray **140** is drawn out of the upper distillation zone **110** as a liquid stream **20**. The liquid stream **20** is comprised primarily of methane. In one aspect, the liquid stream **20** is comprised of about 93 mol. percent methane, 3% CO₂, 0.5% H₂S, and 3.5% N₂. At this point, the liquid stream **20** is at about -125° F to -130° F. This is only slightly warmer than the liquid reflux stream **18**. The liquid stream **20** is directed into a reflux drum **174**. The purpose of the reflux drum **174** is to provide surge capacity for a pump **176**. Upon exiting the reflux drum **174**, a spray stream **21** is created. Spray stream **21** is pressurized in a pump **176** for a second reintroduction into the cryogenic distillation tower **100**. In this instance, the spray stream **21** is pumped into the intermediate controlled freezing zone **108** and emitted through nozzles **122**.

[00100] Some portion of the spray stream **21**, particularly the methane, vaporizes and evaporates upon exiting the nozzles **122**. From there, the methane rises through the controlled freezing zone **108**, through the chimneys in the collector tray **140**, and through the mass transfer devices **116** in the upper distillation zone **110**. The methane leaves the distillation tower **100** as the overhead methane stream **14** and ultimately becomes part of the commercial product in gas stream **16**.

[00101] The spray stream **21** from the nozzles **122** also causes carbon dioxide to desublime from the gas phase. In this respect, CO₂ initially dissolved in the liquid methane may momentarily enter the gas phase and move upward with the methane. However, because of the cold temperature within the controlled freezing zone **108**, any gaseous carbon dioxide quickly nucleates and agglomerates into a solid phase and begins to "snow." This phenomenon is referred to as desublimation. In this way, some CO₂ never re-enters the liquid phase until it hits the melt tray **130**. This carbon dioxide "snows" upon the melt tray **130**, and melts into the liquid phase. From there, the CO₂-rich liquid cascades down the mass transfer devices or trays **126** in the lower distillation zone **106**, along with liquid CO₂ from the chilled raw gas stream **12** as described above. At that point, any remaining methane from the spray stream **21** of the nozzles **122** should quickly break out into vapor. These vapors move upwards in the cryogenic distillation tower **100** and re-enter the upper distillation zone **110**.

[00102] It is desirable to have chilled liquid contacting as much of the gas that is moving up the tower **100** as possible. If vapor bypasses the spray stream **21** emanating from the nozzles **122**, higher levels of CO₂ could reach the upper distillation zone **110** of the tower **100**. To improve the efficiency of gas/liquid contact in the controlled freezing zone **108**, a plurality of nozzles **122** having a designed configuration may be employed. Thus, rather than employing a single spray source at one or more levels with the reflux fluid stream **21**, several spray headers **120** optionally designed with multiple spray nozzles **122** may be used. Thus, the configuration of the spray nozzles **122** has an impact on the heat and mass transfer taking place within the controlled freezing zone **108**. Also, the nozzles themselves can be designed to generate optimal droplet sizes and areal distribution of those droplets.

[00103] The assignee herein has previously proposed various nozzle arrangements in co-pending U.S. Pat. Publ. No. 2010/0018248, referenced above. Figures 6A and 6B are referred to for teachings of nozzle configurations. The nozzles seek to ensure 360° coverage within the controlled freezing zone **108** and provide good vapor-liquid contact and heat/mass transfer. This, in turn, more effectively chills any gaseous carbon dioxide moving upward

through the cryogenic distillation tower **100**.

[00104] The cryogenic tower and associated heat transfer devices provide a reliable system for creating liquefied natural gas that is substantially free of acid gases. The methane produced in the upper distillation zone meets most specifications for pipeline delivery. For example, the methane can meet a pipeline CO₂ specification of less than 2 mol. percent, as well as a 4 ppm H₂S specification, if sufficient reflux is generated and/or if there are enough stages of separation from packing or trays in the upper distillation zone **110**.

[00111] The above acid gas removal system described in connection with **Figure 1** is profitable for producing a commercial methane product **16** that is substantially free of acid gases. The product **16** is preferably a gas and sent down a pipeline for sale. The gas product preferably meets a pipeline CO₂ specification of 1 to 4 mol. percent, where sufficient reflux is generated. At the same time, carbon dioxide and hydrogen sulfide are substantially removed through a bottom stream **26**.

[00112] It is noted that some methane may also be inevitably entrained in the bottom acid gas stream **22**. The column **100** of **Figure 1** does include a reboiler **160** as discussed above. The reboiler **160** provides reboiled vapor to the bottom of the stripping trays. The reboiled vapor will include methane that is reintroduced into the column **100** through line **27**. However, it is desirable to recapture more methane than can be captured using the reboiler **160**, and then deliver the recaptured methane directly into the freezing zone **108**. Further, it is desirable to reduce the size and weight of the column **100** by substantially reducing the size of the lower distillation zone **106**, or even removing it altogether.

[00113] **Figure 2** is a schematic diagram showing a gas processing facility **200** for removing acid gases from a gas stream in accordance with the present invention, in one embodiment. The gas processing facility **200** is placed at or near a hydrocarbon development area **201**. The hydrocarbon development area **201** may represent any location where gaseous hydrocarbons are produced. The development area **201** may be onshore, near shore, or offshore. The development area **201** may be operating from original reservoir pressure or may be undergoing enhanced recovery procedures. The systems and methods claimed herein are not limited to the type of field that is under development so long as it is producing hydrocarbons, including methane, contaminated with carbon dioxide.

[00114] In either respect, a plurality of production wells **212** is shown at the hydrocarbon development area **201**. The production wells **212** extend through a subsurface region **205**, and into a selected formation **210**. In the illustrative development area **201** of **Figure 2**, three

production wells **212** are shown. However, it is understood that the hydrocarbon development area **201** may include many more production wells.

[0115] Production through the production wells **212** is preferably merged at a subsurface flow-line **214**. The flow-line **214** contains a raw gas stream. The gas stream is “raw,”
5 meaning that it has not yet undergone any treatment to remove water or acid gases. The raw gas stream in flow-line **214** contains primarily hydrocarbon fluids in a vapor phase. The hydrocarbons are primarily methane, but may also include ethane and even other heavy hydrocarbons such as trace amounts of propane or butane, and even aromatic hydrocarbons.

[0116] The raw gas stream may also include trace amounts of nitrogen, helium and other
10 inert gases. The raw gas stream will further include at least some brine or other aqueous fluid. Finally, the raw gas stream will include carbon dioxide and, possibly, other acid gases.

[0117] The raw gas stream travels through the flow-line **214**, and is introduced into a dehydration vessel **220**. The dehydration vessel **220** may be, for example, a glycol dehydration vessel that uses a glycol-based chemical. A glycol-based process such as the so-
15 called DRIZO process wherein benzene is used as a stripping agent may be employed. In some cases, the raw gas from flow-line **214** may be mixed with monoethylene glycol (MEG) in order to prevent water drop-out and hydrate formation. The MEG may be sprayed on a chiller, for example, and the liquids collected for separation into water, more concentrated MEG, and possibly some heavy hydrocarbons, depending on the temperature of the chiller
20 and the inlet gas composition. Alternatively, the dehydration vessel **220** may use a mole sieve.

[0118] As a result of passing the raw gas from flow-line **214** through the dehydration vessel **220**, an aqueous stream **222** is generated. The aqueous stream **222** may be sent to a water treatment facility (not shown). Alternatively, the aqueous stream **222** may be re-
25 injected into the subsurface formation **210**. Alternatively still, the removed aqueous stream **222** may be treated to meet environmental standards and then released into the local watershed or the offshore environment as treated water.

[0119] Also, as a result of passing the raw gas stream through the dehydration vessel **220**, a substantially dehydrated gas stream **224** is produced. In connection with the present
30 systems and methods, the dehydrated gas stream **224** includes carbon dioxide and, perhaps, small amounts of hydrogen sulfide. The gas stream **224** may also contain other sulfurous components such as carbonyl sulfide, carbon disulfide, sulfur dioxide, and various mercaptans.

[0120] The dehydrated gas stream **224** is passed through a preliminary heat exchanger **230**. The heat exchanger **230** will include a refrigeration unit. The heat exchanger **230** chills the dehydrated gas stream **224** down to a temperature of about -30° F to -40° F. The heat exchanger **230** may be, for example, an air cooler or an ethylene or propane refrigerator.

5 [0121] A cooled sour gas stream is released from the heat exchanger **230**. This is shown at line **232**. The cooled sour gas stream is optionally taken through an expansion device **234**. The expansion device **234** may be, for example, a Joule-Thompson (“J-T”) valve. The expansion device **234** serves as an expander to obtain further cooling of the dehydrated gas stream **232**. A final cooled sour gas stream **236** is thus generated. The final cooled sour gas
10 stream **236** may be at a temperature of about -40° F to -70° F.

[0122] It is understood that the cooling arrangement shown for the gas processing facility **200** is merely illustrative. Other cooling arrangements, such as the one shown in **Figure 1**, may be used. The present inventions are not limited by the manner of generating a cooled sour gas stream **236**. However, it is preferred that at least partial liquefaction of the sour gas
15 stream **236** is accomplished.

[0123] It is desirable to remove the carbon dioxide (and any sulfurous components) from the cooled sour gas stream **236**. In accordance with the gas processing facility **200**, a cryogenic distillation tower **240** is provided. The tower **240** may be a trayed tower, a packed tower, or other type of tower, so long as it operates to “freeze” carbon dioxide and other
20 acidic components out of methane gas vapor as solids.

[0124] The dehydrated and cooled sour gas stream **236** enters the distillation tower **240**. The chilled sour gas of line **236** enters the tower **200** at about 500 to 600 psig. The distillation tower **240** has a freezing zone **242**. This may be in accordance with the intermediate controlled freezing zone, or “spray section” **108**, of **Figure 1**. The distillation
25 tower **200** also includes an upper distillation zone **244**. This may be in accordance with the upper distillation zone, or “rectification section” **110** of **Figure 1**.

[0125] The distillation tower **100** operates to separate methane (and some ethane) from carbon dioxide (and other acid gas components). The methane gas is released through the upper distillation zone **244** as an overhead gas stream **246**, while the carbon dioxide is
30 released through the bottom of the distillation tower **100** as a bottom acid gas stream **248**.

[0126] The overhead gas stream **246** is preferably taken through further cooling. In the arrangement of **Figure 2**, the overhead gas stream **246** is directed through a heat exchanger **250**. The heat exchanger **250** includes a refrigeration unit for causing liquefaction of the

methane gas. In one aspect, the heat exchanger **250** uses an ethylene refrigerant or other refrigerant capable of chilling the overhead methane stream **246** down to about -135° to -145° F. An expander valve (not shown) may also be used in series with the heat exchanger **250** to achieve a temperature necessary for liquefaction. In either event, a liquefied natural gas (LNG) stream is produced at line **252**.

[0127] The gas processing facility **200** also includes a separator **260**. The separator releases cold natural gas from overhead line **262**. The natural gas in line **262** is the commercial product that is delivered downstream for sale. Optionally, a portion of the natural gas product may be captured as fuel gas for an on-sight or near-sight gas processing facility.

[0128] The separator **260** also captures liquefied natural gas from line **252**, and directs it back to the distillation tower **200** as “reflux.” A reflux line is seen at **264**. A pressure boosting pump **266** may be used to assist in injecting the reflux from line **264** into the distillation tower **200**. In the arrangement of **Figure 2**, the reflux is injected into the top of the freezing zone (shown at **108** in **Figure 1**). However, the reflux in line **264** may be injected into the distillation zone **244** as is provided in the tower **100** of **Figure 1**.

[0129] The reflux from line **264** is directed into the freezing zone **242** as a cold liquid spray. Spray headers (such as spray headers **120** of **Figure 1**) may be used. As discussed above, the cold liquid spray helps to precipitate any upward-moving carbon dioxide within the distillation tower **200**.

[0130] Carbon dioxide and other acid gases precipitate downward towards the bottom of the freezing zone **242**. A melt tray (not shown) may be used to capture solids and direct them out of the bottom of the freezing zone **242**. The temperature in the distillation tower **240** at the bottom of the freezing zone **242** may be about -50° F to -100° F. However, in accordance with the present systems, no lower distillation zone (such as lower distillation zone **106** of **Figure 1**) is required. The operator may choose to have a very small lower distillation zone, but this is not necessary for capturing methane gas entrained with the solid or liquid acid gasses.

[0131] The acid gas components exit the tower **240** as a bottom acid gas stream **248**. The bottom acid gas stream **284** represents a cold slurry that primarily contains carbon dioxide. It may also contain about 5% H₂S and other sulfurous components. It will also contain about 1% to 5% methane and ethane, which ideally is recaptured.

[0132] In order to recapture hydrocarbon gases from the bottom liquefied acid gas stream

248, the gas processing facility 200 employs a series of co-flowing contacting devices **CD₁**, **CD₂**, . . . , **CD_(n-1)**, **CD_n**. These devices are used to contact the bottom liquefied acid gas stream 248 with a stripping gas.

[0133] The co-current contacting devices **CD₁**, **CD₂**, . . . **CD_(n-1)**, **CD_n** may be any of a variety of short contact-time mixing devices. Examples include static mixers, centrifugal mixers, and demisters. Some mixing equipment breaks the liquid apart through an eductor. The eductor delivers gas through a venturi-like tube that in turn pulls liquid into the tube. Because of the venturi effect, the liquid is dragged in and broken into smaller particles, allowing a large surface area of contact with the gas.

[0134] The stripping gas is preferably substantially pure carbon dioxide. A tank or reservoir of carbon dioxide is seen at 270. To feed the contacting devices **CD₁**, **CD₂**, . . . , **CD_(n-1)**, **CD_n**, a CO₂ line is provided at line 272 from the tank 270. Flow of CO₂ through the line 272 is regulated by a valve 274. Once the system 200 is operational, the valve 274 is substantially closed. Alternatively, the stripping gas is provided by boiling a portion of the stripped liquefied bottoms stream.

[0135] In operation, CO₂ is introduced into the first contacting device **CD₁** as a stripping gas. The CO₂ moves through each contacting device **CD₁**, **CD₂**, . . . , **CD_(n-1)**, **CD_n**, in series for the removal of residual methane from the liquid. As the stripping gas moves through the contacting devices **CD₁**, **CD₂**, . . . , **CD_(n-1)**, **CD_n**, the stripping gas becomes progressively closer to the distillation tower 200, and the operating temperature will go down. In addition, as the stripping gas moves through the contacting devices **CD₁**, **CD₂**, . . . , **CD_(n-1)**, **CD_n**, the gas in the contacting devices becomes progressively enriched with methane as it is stripped out of the liquefied acid gas.

[0136] The first contactor **CD₁** releases a first partially-methane-enriched gas stream 280(1) to the second contactor **CD₂**. The first partially-methane-enriched gas stream 280(1) may be, for example, at about 20°F to 30° F, and about 400 to 500 psig. The second contactor **CD₂** releases a second partially-methane-enriched gas stream 280(2). This may be at, for example, about 10° F to 20° F, and about 400 to 450 psig. A next-to-last contactor **CD_(n-1)** releases a next partially-methane-enriched gas stream 280(n-1) to the final contactor **CD_n**, and a final contactor **CD_n** releases a final methane-enriched gas stream 280(n). The final enriched gas stream 280(n) may be at, for example, about -70° F and 400 psig.

[0137] The final methane-enriched gas stream 280(n) is comprised of methane and CO₂. The methane and CO₂ are reintroduced into the freezing zone 242 of the distillation tower.

The recaptured methane then passes upward through the upper distillation section **244**, and ultimately becomes a part of the overhead gas stream **246**.

[0138] Referring again to the bottom acid gas stream **248**, the bottom liquefied gas stream **248** is carried into the final contactor **CD_n**. The liquefied acid gas stream **248** moves through each contacting device **CD_n**, **CD_{n-1}**, . . . , **CD₂**, **CD₁**. As the liquefied acid gas moves through the contacting devices **CD_n**, **CD_{n-1}**, . . . , **CD₂**, **CD₁** in series, the CO₂ gas content in the liquid becomes progressively richer. Thus, the final contactor **CD_n** releases a first partially-stripped acid gas liquid **285(n)** to the previous co-current contactor **CD_{n-1}**, the previous co-current contactor **CD_{n-1}** releases a next partially-stripped acid gas liquid **285(n-1)**, the second co-current contactor **CD₂** releases a second partially-stripped acid gas liquid **285(2)**, and the first contactor **CD₁** releases a final stripped acid gas liquid **285(1)**.

[0139] It is preferred that the second partially-stripped acid gas liquid **285(2)** released by the second contactor **CD₂** be warmed. To this end, a reboiler **276** is provided. The reboiler **276** may warm the second partially-stripped acid gas liquid **285(2)** to a temperature of, for example, 30° F to 40° F. This aids in breaking out methane in the first contactor **CD₁**.

[0140] The final stripped acid gas liquid **285(1)** represents a solution that is comprised substantially of carbon dioxide, plus any sulfurous components from the original raw gas stream in flow-line **214**. The final stripped acid gas liquid **285(1)** may be delivered to one or more acid gas injection wells **216**. The final stripped acid gas liquid **285(1)** may then be either sequestered, or possibly used to maintain reservoir pressure in the subsurface formation **210**. To facilitate injection, a pump **290** is used.

[0141] Since the final stripped acid gas liquid **285(1)** represents a substantially pure CO₂ stream, a portion of the final stripped acid gas liquid **285(1)** may be diverted and re-used as the stripping gas. In the arrangement of **Figure 2**, a diversion line **288** is provided. The CO₂-rich liquid in line **288** is merged with the second partially-stripped acid gas liquid **285(2)** before the second partially-stripped acid gas liquid **285(2)** enters the heater **276** (which in function is a reboiler). Alternatively, the CO₂-rich liquid in line **288** may be directed into line **278**.

[0142] It is noted that in each co-current contacting device, the flow of acid gas and stripping gas is parallel, that is, along a longitudinal axis of the respective contactors. This allows the co-current contacting devices **CD₁**, **CD₂**, . . . , **CD_(n-1)**, **CD_n** to operate at much higher fluid velocities than counter-current contactors. As a result, co-current flow contactors tend to be smaller than counter-current flow contactors that utilize packed or trayed towers.

[0143] One preferred contacting device is the ProsCon™ contactor. This contactor utilizes an eductor followed by a centrifugal coalescer. The centrifugal coalescer induces large centrifugal forces to re-integrate the liquid solvent in a small volume. It is believed that the ProsCon™ contactor has been used in pharmaceutical applications, but has not yet been used in a gas processing and separation facility. Alternatively, it is believed that the ProScav™ separator available from ProPure of Bergen, Norway may serve as an acceptable co-current contactor. Marketing information presently available on-line states that the ProScav™ contactor is used to inject an H₂S scavenger for the removal of H₂S. The ProScav™ contactor appears to operate as a static mixer followed by a coalescer. In whatever embodiment, compact vessel technology is employed, allowing for a reduction of the hardware in comparison to the large contactor towers, and further allowing for the substantial removal of the lower distillation zone of a cryogenic distillation tower.

[0144] In one aspect, a combination of a mixing device and a corresponding coalescing device is employed in the contactors. Thus, for example, the first contactor CD₁ and second contactor CD₂ may utilize static mixers as their mixing devices, a third contactor (not shown) or other contactors may utilize eductors, and the next-to-last contactor CD_(n-1) and CD_n contactor may utilize centrifugal mixers.

[0145] In the arrangement of **Figure 2**, four co-current contacting devices CD₁, CD₂, . . . , CD_(n-1), CD_n are shown. However, a fewer or greater number of co-current contacting devices may be employed. In a general sense, a first co-current contactor is configured to:

- receive the stripping gas;
- receive a second partially-stripped acid gas liquid from a next-to-last (or second) co-current contactor;
- release the final stripped acid gas liquid; and
- release a first partially-methane-enriched gas stream to the next-to-last (or second) co-current contactor.

[0146] In addition, a final co-current contactor is configured to:

- receive the bottom liquefied acid gas stream;
- receive a partially-methane-enriched gas stream from a previous co-current contactor;
- release the final methane-enriched gas stream to the cryogenic distillation

tower; and

- release a first partially-stripped acid gas liquid to the previous co-current contactor.

[0147] The number of contacting devices (at least one) prior to the final contactor **CD_n** is dictated primarily by the level of methane removal needed to meet the desired standard, such as less than 1% methane in the final stripped acid gas liquid **285(1)**. For example, the system **200** may have two co-current contactors for processing the bottom acid gas stream **248**. In this instance, the final co-current contactor **CD_n** is the second co-current contactor, while the previous co-current contactor is the first co-current contactor **CD₁**.

[0148] Alternatively, the system **200** may have three co-current contactors for processing the bottom acid gas stream **248**. In this instance, the previous co-current contactor is the second co-current contactor. The second co-current contactor is then configured to receive the first partially-methane-enriched gas stream from the first co-current contactor **CD₁**, and the first partially-stripped acid gas liquid from the final co-current contactor **CD_n**. Further, the second co-current contactor releases a second partially-methane-enriched gas stream to the final co-current contactor **CD_n**, and a second partially-stripped acid gas liquid into the first co-current contactor **CD₁**.

[0149] Alternatively, the system **200** may have more than three co-current contactors for processing the bottom acid gas stream **248**. The final co-current contactor **CD_n**, any intermediate co-contactors, the second co-current contactor **CD₂**, and the first co-current contactor **CD₁** are arranged to deliver respective stripped acid gas liquids as progressively richer acid gas liquids in series. At the same time, the first co-current contactor **CD₁**, the second co-current contactor **CD₂**, any intermediate co-contactors, and the final co-current contactor **CD_n** are arranged to deliver the respective methane-enriched gas streams as progressively sweetened gas streams in series.

[0150] The use of multiple, co-current contacting devices may also be used to recapture any carbon dioxide that escapes from a cryogenic distillation tower with the overhead gas stream. **Figure 3** provides a schematic diagram showing a gas processing facility **300** for removing acid gases from a gas stream in accordance with the present invention, in an alternate embodiment. The gas processing facility **300** employs a series of co-current contactors for further sweetening methane from the overhead gas stream.

[0151] As with gas processing facility **200**, the gas processing facility **300** is placed at or near a hydrocarbon development area **301**. The hydrocarbon development area **301** may again represent any location where gaseous hydrocarbons are produced. The development

area **301** may be onshore, near shore, or offshore. The systems claimed herein are not limited to the type of field that is under development so long as it is producing hydrocarbons, including methane, containing carbon dioxide.

5 [0152] A plurality of production wells **312** are shown at the hydrocarbon development area **301**. The production wells **312** extend through a subsurface region **305**, and into a selected formation **310**. In the illustrative development area **301** of **Figure 3**, three production wells **312** are once again shown. However, it is understood that the hydrocarbon development area **301** may include many more production wells.

10 [0153] Production through the production wells **312** is preferably merged at a subsurface flow-line **314**. The flow-line **314** contains a raw gas stream. The raw gas stream in the flow-line **314** contains primarily hydrocarbon fluids in a vapor phase. The hydrocarbons are primarily methane, but may also include ethane and even other heavy hydrocarbons such as trace amounts of propane or butane, and even aromatic hydrocarbons.

15 [0154] The raw gas stream may also include trace amounts of nitrogen, helium and other inert gases. The raw gas stream will further include at least some brine or other aqueous fluid. Finally, the raw gas stream will include carbon dioxide and, possibly, other acid gases.

[0155] The raw gas stream travels through the flow-line **314**, and is introduced into a dehydration vessel **320**. The dehydration vessel **320** may be in accordance with dehydration vessel **220** from **Figure 2**. As a result of passing the raw gas from flow-line **314** through the
20 dehydration vessel **320**, an aqueous stream **322** is once again generated. The aqueous stream **322** may be sent to a water treatment facility (not shown). Alternatively, the aqueous stream **322** may be re-injected into the subsurface formation **310**. Alternatively still, the removed aqueous stream **322** may be treated to meet environmental standards and then released into the local watershed or, if applicable, the offshore environment as treated water.

25 [0156] Also, as a result of passing the raw gas stream through the dehydration vessel **320**, a substantially dehydrated gas stream **324** is produced. In connection with the present systems, the dehydrated gas stream **324** includes carbon dioxide and, perhaps, small amounts of hydrogen sulfide. The gas stream **324** may also contain other sulfurous components such as carbonyl sulfide, carbon disulfide, sulfur dioxide, and various mercaptans.

30 [0157] The dehydrated gas stream **324** is passed through a preliminary heat exchanger **330**. The heat exchanger **330** will include a refrigeration unit. The heat exchanger **330** chills the dehydrated gas stream **324** down to a temperature of about -30° F to -40° F. The heat exchanger **330** may be, for example, an air cooler or an ethylene or propane refrigerator.

[0158] A cooled sour gas stream is released from the heat exchanger **330**. This is shown at line **332**. The cooled sour gas stream is optionally taken through an expansion device **334**. The expansion device **334** may be, for example, a Joule-Thompson (“J-T”) valve. The expansion device **334** serves as an expander to obtain further cooling of the dehydrated gas stream **332**. A final cooled sour gas stream **336** is thus generated. The final cooled sour gas stream **336** may be at a temperature of about -40° F to -70° F.

[0159] It is understood that the cooling arrangement shown for the gas processing facility **300** is merely illustrative. Other cooling arrangements, such as that shown in **Figure 1**, may be used. The facility **300** is not limited by the manner of generating a cooled sour gas stream **336**. However, it is preferred that at least partial liquefaction of the sour gas stream **336** is accomplished.

[0160] It is once again desirable to remove the carbon dioxide (and any sulfurous components) from the cooled sour gas stream **336**. In accordance with the gas processing facility **300**, a cryogenic distillation tower **340** is provided. The tower **340** may be a trayed tower, a packed tower, or other type of tower, so long as it operates to “freeze” carbon dioxide and other acidic components out of methane gas vapor as solids.

[0161] The dehydrated and cooled sour gas stream **336** enters the distillation tower **340**. The chilled sour gas of line **336** enters the tower **340** at about 500 to 600 psig. The distillation tower **340** has a freezing zone **342**. This may be in accordance with the intermediate controlled freezing zone, or “spray section” **108**, of **Figure 1**. The distillation tower **340** also includes an upper distillation zone **344**. This may be in accordance with the upper distillation zone, or “rectification section” **110** of **Figure 1**. Finally, the distillation tower **340** includes a lower distillation zone **341**. This may be in accordance with the lower distillation zone, or “stripping section” **106** of **Figure 1**.

[0162] The distillation tower **340** operates to separate methane (and some ethane) from carbon dioxide (and other acid gas components). The methane gas is released through the upper distillation zone **344** as an overhead gas stream **346**, while the carbon dioxide is released through the lower distillation zone **341** as a bottom liquefied acid gas stream **348**.

[0163] Within the distillation tower **340**, carbon dioxide and other acid gases precipitate downward towards the lower distillation zone **341**. A melt tray (not shown) may be used to capture solids and direct them into weirs and trays. This enables the melting of solid acidic components, and the break-out of methane gas. The temperature in the distillation tower **340** at the bottom of the lower distillation zone **341** may be about 0° F to 20° F. The bottom acid

gas stream **348** is released from the lower distillation zone **341** as a liquid stream.

[0164] The bottom acid gas stream **348** is preferably taken through a reboiler **350**. The liquid acid gas stream entering the reboiler **350** is at a relatively low temperature, for example, about 30° to 40° F. Reboiler **350** is in accordance with reboiler **160** of **Figure 1**.

5 The reboiler **350** allows methane gas entrained in the bottom acid gas stream **348** to flash from the liquid acid gases. The methane vapor (along with vaporized CO₂) then travels through vapor line **352**, and returns to the distillation tower **340**. Preferably, the vapor line **352** delivers the methane-containing vapor into the intermediate freezing zone **342**. Alternatively, the vapor line **352** may deliver the methane vapor to the stripping trays (such
10 as weirs and cascading trays **126** in **Figure 1**) in the lower distillation zone **341**.

[0165] Carbon dioxide and any other trace acidic components exit the reboiler **350** primarily as a liquid stream. This is shown at line **354**. The liquid acidic components are optionally directed through an expansion device **356** for further cooling. This decreases the temperature of the liquid stream in line **354**. A chilled liquid stream **358** is thus released.

15 The CO₂-rich liquid stream **358** may be pumped downhole through one or more AGI wells. In the arrangement of **Figure 3**, the chilled liquid CO₂ is injected into the subsurface formation **310** through injection wells **316** as part of an enhanced oil recovery process.

[0166] As noted, the distillation tower also releases an overhead gas stream **346**. The overhead gas stream **346** is comprised primarily of methane. The overhead gas stream **346**
20 will preferably comprise no more than about 2 mol. percent carbon dioxide. At this percentage, the overhead gas stream **346** may be used as fuel gas or may be sold into certain markets as natural gas. However, in accordance with certain methods herein, it is desirable that the overhead gas stream **346** undergo further processing. More specifically, it is desirable to drive down the amount of carbon dioxide in the overhead gas stream **346**.

25 [0167] In order to recapture carbon dioxide in the overhead gas stream **346**, the gas processing facility **300** employs a series of co-flowing contacting devices **CD₁**, **CD₂**, . . . , **CD_(n-1)**, **CD_n**. These devices are used to contact the overhead gas stream **346** with a refluxing liquid.

[0168] The refluxing liquid is preferably substantially pure methane. A start-up tank or
30 reservoir of methane is seen at **370**. To feed the contacting devices **CD₁**, **CD₂**, . . . , **CD_(n-1)**, **CD_n**, a CH₄ line is provided at line **372** from the tank **370**. Flow of CH₄ through the line **372** is regulated by a valve **374**. Once the system **300** is operational, the valve **374** is substantially closed.

[0169] The co-current contacting devices CD_1 , CD_2 , . . . $CD_{(n-1)}$, CD_n may again be any of a variety of short contact-time mixing devices. Examples include static mixers and centrifugal mixers. In operation, substantially pure methane is introduced into a final contacting device CD_n as a liquid. The methane first moves through line 372, and is then
5 directed into a chilling unit 360. Preferably, the chilling unit 360 is an ethylene cooler. The chilling unit 360 brings the temperature of the product gas down to about -130° F to -145° F. The chilling unit 360 releases a chilled methane (CH_4) liquid stream through line 362. A pump 364 is preferably provided along line 362 to increase operating pressure.

[0170] Chilled liquid CH_4 moves through each contacting device CD_n , $CD_{(n-1)}$, . . . ,
10 $CD_{(2)}$, CD_1 , in series for the removal of acidic components from the gas. As the methane-rich gas moves through the contacting devices CD_1 , CD_2 , . . . , $CD_{(n-1)}$, CD_n , the acid gas content in the gas becomes progressively leaner. Thus, the final contactor CD_n releases a first partially- CO_2 -enriched liquid 385(1) to the previous contactor CD_{n-1} . The first partially- CO_2 -enriched liquid 385(1) will still have a very low acidic component, such as less than 1%
15 CO_2 and less than 10 ppm H_2S .

[0171] A next-to-last contactor $CD_{(n-1)}$ releases a next-to-last partially- CO_2 -enriched liquid 385(n-1); a second contactor CD_2 releases a second partially- CO_2 -enriched liquid 385(2) to the first contactor CD_1 ; and a first contactor CD_1 releases a CO_2 -enriched liquid 385(1). Thus, moving closer to the distillation tower 300, the acidic components in the reflux
20 liquids will increase.

[0172] The final reflux liquid 385(1) represents a solution that is comprised substantially of methane and carbon dioxide, plus some of the sulfurous components from the original raw gas stream in flow-line 314. The final reflux liquid 385(1) is returned to the distillation tower 300. More specifically, the final reflux liquid 385(1) is injected into the upper distillation
25 zone 344. Preferably, the final reflux liquid 385(1) passes through a pump 382 to increase line pressure. A pressurized reflux stream 383 enters the upper distillation zone 344.

[0173] Two things are noted here about the final reflux liquid 385(1). First, the percentage of acidic components in the reflux liquid is very small. Depending on the percentage of carbon dioxide in the original raw gas stream 314, the degree of pre-chilling
30 applied to the dehydrated sour gas stream 324, the pressure in the distillation tower 340, the number of co-current contacting devices used, and other factors, the carbon dioxide composition in the final reflux liquid 385(1) will likely be less than 5 mol. percent, and possibly less than 2 mol. percent.

[0174] Second, the final reflux liquid **385(1)** becomes a part of the cold spray used in the freezing zone **342**. The final reflux liquid **385(1)** may be injected directly into the freezing zone **342**. However, in the arrangement for the gas processing facility **300** shown in **Figure 3**, a portion of the final reflux liquid **385(1)** is captured from stripping trays (such as weirs and trays **116** shown in **Figure 1**) residing near the top of the distillation tower **340** in the upper distillation zone **344**. Line **384** shows a portion of a liquid stream containing methane and CO₂. The liquid line **384** delivers the methane and CO₂ mixture to a reflux drum **381**. The reflux drum **381** provides surge capacity for a pump **387**. The pump **387** delivers the methane and CO₂ liquid stream into the freezing zone **342** as a cold liquid spray, such as through spray nozzles. As discussed above, the cold liquid spray helps to precipitate any upward-moving carbon dioxide within the distillation tower **300**. Line **388** is shown delivering the methane and CO₂ liquid stream into the freezing zone **342**.

[0175] Referring again to the overhead gas stream **346**, the overhead gas stream **346** is carried into the first contactor **CD₁**. The overhead gas stream **346** moves through each contacting device **CD₁**, **CD₂**, . . . , **CD_(n-1)**, **CD_n**. As the overhead gas moves through the contacting devices **CD₁**, **CD₂**, . . . , **CD_(n-1)**, **CD_n** in series, the gas content in the contacting devices becomes progressively sweeter. Thus, the first contactor **CD₁** releases a first partially-sweetened methane gas stream **380(1)** to the second co-current contactor **CD₂**; the second co-current contactor **CD₂** releases a second partially-sweetened gas stream to a next-to-last co-current contactor **CD_(n-1)**; and the next-to-last co-current contactor **CD_(n-1)** releases a final partially-sweetened methane gas stream **380(n-1)**. The final co-current contactor **CD_n** releases a final sweetened methane gas stream **380(n)**.

[0176] The final sweetened gas stream **380(n)** is comprised substantially of methane and may be taken as the product gas. In **Figure 3**, it can be seen that a part of the final methane gas stream **380(n)** is diverted into line **361**. The diverted methane in line **361** is taken through the chilling unit **360**. Chilled liquid methane is then reintroduced to the final contactor **CD_n** in line **362**.

[0177] The majority of the final sweetened gas stream **380(n)** may be sold as a commercial product. Preferably, some of the final sweetened gas stream **380(n)** is directed through a heat exchanger **390** for re-cooling. A portion of the final sweetened gas stream **380(n)** is released from the heat exchanger **390** as the commercial product (LNG, after pressure let-down). Preferably, the heat exchanger **390** is capable of chilling the final sweetened methane stream **380(n)** down to about -135° to -145° F as the final product **392**.

In one or more embodiments, heat exchangers **360** and **390** could be one and the same, with the liquid generated going to a collection vessel. The liquid could then be split between reflux and commercial product. This alternative embodiment may be a more capital-efficient process.

5 **[0178]** The heat exchanger **390** preferably uses ethylene as a refrigerant. An ethylene loop is seen at line **394**. The ethylene is condensed against propane in a chiller **396**. Preferably, a compressor (not shown) is placed along line **394** to move ethylene through the chiller **396**. The ethylene in line **394** passes through chiller **396** for cooling, and then preferably moves through a Joule-Thompson valve **398** for further cooling. The ethylene in
10 line **394** leaves the J-T valve **398** at a temperature of about -140° F.

[0179] A propane loop is provided at line **391**. Propane is taken from the chiller **396** and moved through a compressor **393**. This will cause an increase in pressure and temperature in the propane in line **391**. Accordingly, the propane is taken through an aerial cooler **395** to bring the temperature of the propane down to about an ambient temperature. A cooled
15 propane stream is released through line **397**. The propane may be expanded through a Joule-Thompson valve **399** or a turbo-expander in order to bring the temperature of the propane in line **397** down to about -40° F.

[0180] The illustrative refrigeration system of **Figure 3** with the heat exchanger **390** is considered to be a closed-loop system, meaning that an external working fluid such as
20 propane or ethylene is used as a coolant to chill the final sweetened gas stream **380(n)**. However, it is understood that the inventions herein are not limited by the manner in which the final sweetened gas stream **380(n)** is cooled. For example, an open-loop system may be employed wherein a portion of the overhead methane stream **346** itself is ultimately used as the working fluid. In some cases, the product gas will not be chilled, but actually warmed,
25 then sent to a pipeline for sale as a gaseous product. In this case, it is desirable to capture the cold energy from the gas stream **380(n)**.

[0181] It is also noted that in each co-current contacting device, the flow of methane gas and stripping liquid is parallel, that is, along a longitudinal axis of the respective contactors. This allows the co-current contacting devices **CD₁**, **CD₂**, . . . , **CD_(n-1)**, **CD_n** to operate at much
30 higher fluid velocities than counter-current contactors. As a result, co-current flow contactors tend to be smaller than counter-current flow contactors that utilize packed or trayed towers. The co-current contacting devices of **Figure 3** may be designed in accordance with the co-current contacting devices of **Figure 2**. In this respect, for example, the co-current contacting

devices of **Figure 3** may each be a ProsCon™ contactor.

[0182] In the arrangement of **Figure 3**, four co-current contacting devices **CD₁**, **CD₂**, . . . , **CD_(n-1)**, **CD_n** are shown. However, a fewer or greater number of co-current contacting devices may be employed. In a general sense, a first co-current contactor is configured to:

- 5 — receive the overhead acid gas stream;
- receive a second partially- CO₂-enriched liquid reflux from a second co-current contactor;
- release a first partially-sweetened methane gas stream to the second co-current contactor; and
- 10 — release a final CO₂-enriched liquid reflux to the cryogenic distillation tower.

[0183] In addition, a final co-current contactor is configured to:

- receive the liquid reflux;
- receive a next-to-last partially sweetened methane gas stream from a next-to-last co-current contactor;
- 15 — release the final sweetened methane gas stream; and
- release a first partially-CO₂-enriched liquid reflux to the next-to-last co-current contactor.

[0184] The number of contacting devices used is dictated primarily by the level of CO₂ removal needed to meet the desired standard. For example, the system **300** may have two co-current contactors for processing the overhead gas stream **346**. In this instance, the final co-current contactor **CD_n** is the second co-current contactor, while the next-to-last co-current contactor is the first co-current contactor **CD₁**.

[0185] Alternatively, the system **300** may have three co-contactors for processing the overhead gas stream **346**. In this instance, the next-to-last co-current contactor is the second co-current contactor. The second co-current contactor is then configured to receive the first partially-sweetened methane gas stream **380(1)** from the first co-current contactor **CD₁**, and the first partially CO₂-enriched liquid **385(3)** from the final co-current contactor **CD_n**. Further, the second co-current contactor releases a second partially-sweetened methane gas stream **380(2)** to the final co-current contactor **CD_n**, and a second partially- CO₂-enriched liquid reflux **385(2)** to the first co-current contactor **CD₁**.

[0186] Alternatively, the system **300** may have more than three co-current contactors for processing the overhead gas stream **346**. The first co-current contactor **CD₁**, the second co-

current contactor **CD₂**, any intermediate co-contactors, and the final co-current contactor **CD_n** are arranged to deliver progressively sweeter methane gas streams, in series. At the same time, the final co-current contactor **CD_n**, any intermediate co-contactors, the second co-current contactor **CD₂**, and the first co-current contactor **CD₁** are arranged to deliver the
5 respective CO₂-enriched liquid reflux streams as progressively richer reflux streams in series.

[0187] It will be appreciated that **Figures 2** and **3** represent simplified schematic diagrams intended to make clear only selected aspects of the gas processing systems **200** and **300**. A gas processing system will usually include many additional components such as heaters, chillers, condensers, liquid pumps, gas compressors, blowers, other types of
10 separation and/or fractionation equipment, valves, switches, controllers, along with pressure-, temperature-, level-, and flow-measuring devices. Of particular relevance in the present disclosure, booster pumps (not shown) may be needed between contactor stages, due to potentially high pressure drops at the eductors. Note also that the contactors should preferably be well-insulated for cryogenic service.

[0188] As an alternative to the systems **200** and **300** described above, a gas processing facility may utilize co-current contacting devices to process both the bottom acid gas stream (stream **248** of **Figure 2**) and the overhead gas stream (stream **346** of **Figure 3**). In this embodiment, the distillation tower would not need a lower distillation zone except to the extent to optionally house a melt tray. A benefit of using co-current contacting devices is that
20 they reduce the size of the distillation tower. Further, they can be much smaller than typical distillation columns and internal components. Further still, they are not substantially affected by motion in the way that liquids on trays may be, which makes them suitable for offshore installations. Using co-current contacting devices in both the bottom acid gas stream **248** and the overhead gas stream **346** reduces the bulk of the distillation tower, reduces the loss of
25 methane in the bottom acid gas stream **248**, and increases the purity of the final LNG stream **394**.

[0189] Further embodiments A-BB are provided in the following paragraphs.

[0190] Embodiment A: A system for removing acid gases from a raw gas stream, comprising: (a) a dehydration vessel for receiving the raw gas stream, and separating the raw
30 gas stream into a dehydrated raw gas stream and a stream comprised substantially of an aqueous fluid; (b) a heat exchanger for cooling the dehydrated gas stream, and releasing a cooled sour gas stream; (c) a cryogenic distillation tower that receives the cooled sour gas stream, and separates the cooled sour gas stream into (i) an overhead gas stream comprised

primarily of methane, and (ii) a bottom liquefied acid gas stream comprised primarily of carbon dioxide; (d) a final co-current contactor configured to (i) receive the bottom liquefied acid gas stream, (ii) receive a partially-methane-enriched gas stream from a previous co-current contactor, (iii) release a final methane-enriched gas stream to the cryogenic distillation tower, and (iv) release a first partially-stripped acid gas liquid to the previous co-current contactor; and (e) a first co-current contactor configured to (i) receive a stripping gas, (ii) receive a second partially-stripped acid gas liquid from a second co-current contactor, (iii) release a final stripped acid gas liquid, and (iv) release a first partially-methane-enriched gas stream to the second co-current contactor.

10 [0191] Embodiment B: The system of Embodiment A, wherein the final stripped acid gas liquid comprises about 98 mol. percent or more acid gas.

[0192] Embodiment C: The system of Embodiment A or B, wherein a substantial portion of the final stripped acid gas liquid is injected into a subsurface formation through one or more acid gas injection wells.

15 [0193] Embodiment D: The system of any of Embodiments A-C, wherein a portion of the final stripped acid gas liquid is diverted and used as at least a portion of the stripping gas via reboiling.

[0194] Embodiment E: The system of any of Embodiments A-D, wherein: (a) the cryogenic distillation tower comprises a freezing zone; (b) the freezing zone receives the cooled sour gas stream, a cold liquid spray comprised primarily of methane, and the final methane-enriched gas stream from the final co-current contacting device; and (c) the cryogenic distillation tower further comprises refrigeration equipment downstream of the cryogenic distillation tower for cooling the overhead methane stream and returning a portion of the overhead methane stream to the cryogenic distillation tower as the cold liquid spray.

25 [0195] Embodiment F: The system of Embodiments E, further comprising a melt tray below the freezing zone for receiving a cold slurry of acid gas particles, and delivering a substantially solids-free slurry to the final co-current contacting device as the bottom liquefied acid gas stream.

[0196] Embodiment G: The system of Embodiment E or F, wherein the bottom liquefied acid gas stream exits the cryogenic distillation tower at a temperature no greater than about -70° F.

30 [0197] Embodiment H: The system of any of Embodiments E-G, further comprising a lower distillation zone below the freezing zone for receiving a cold slurry of acid gas

particles, at least partially melting the slurry of acid gas particles into a liquid stream, and delivering the liquid stream to the final co-current contacting device as the bottom liquefied acid gas stream.

5 [0198] Embodiment I: The system of any of Embodiments E-H, further comprising an upper distillation zone above the freezing zone for receiving vapor from the freezing zone and releasing the overhead gas stream.

[0199] Embodiment J: The system of any of Embodiments A-I, wherein the system comprises only two co-current contactors for processing the bottom acid gas stream such that: (a) the final co-current contactor is the second co-current contactor; (b) the previous co-
10 current contactor is the first co-current contactor; (c) the first partially-methane-enriched gas stream released by the first co-current contactor is the partially methane-enriched gas stream received by the final co-current contactor; and (d) the first partially-stripped acid gas liquid released by the final co-current contactor is the second partially-stripped acid gas liquid received by the first co-current contactor.

15 [0200] Embodiment K: The system of any of Embodiments A-I, wherein the system comprises three co-current contactors for processing the bottom acid gas stream, such that: (a) the previous co-current contactor is the second co-current contactor; and (b) the second co-current contactor is configured to (i) receive the first partially-methane-enriched gas stream from the first co-current contactor, (ii) receive the first partially-stripped acid gas
20 liquid from the final co-current contactor, (iii) release a second partially-methane-enriched gas stream into the final co-current contactor, and (iv) release the second partially-stripped acid gas liquid into the first co-current contactor.

[0201] Embodiment L: The system of any of Embodiments A-I, wherein the system comprises at least three co-current contactor for processing the bottom liquefied acid gas stream, such that: (a) the final co-current contactor, any intermediate co-contactors, the
25 second co-current contactor and the first co-current contactor are arranged to deliver respective stripped acid gas liquids as progressively CO₂-richer acid gas liquids in series, and (b) the first co-current contactor, the second co-current contactor, any intermediate co-contactors, and the final co-current contactor are arranged to deliver the respective methane-enriched gas streams as progressively methane-enriched gas streams in series.
30

[0202] Embodiment M: A system for removing acid gases from a raw gas stream, comprising: (a) a dehydration vessel for receiving the raw gas stream, and separating the raw gas stream into a dehydrated raw gas stream and a stream comprised substantially of an

aqueous fluid; (b) a heat exchanger for cooling the dehydrated raw gas stream, and releasing a cooled sour gas stream; (c) a cryogenic distillation tower that receives the cooled sour gas stream, and separates the cooled sour gas stream into (i) an overhead gas stream comprised primarily of methane, and (ii) a bottom liquefied acid gas stream comprised primarily of carbon dioxide; (d) a first co-current contactor configured to (i) receive the overhead gas stream, (ii) receive a second partially-CO₂-enriched reflux liquid from a second co-current contactor, (iii) release a first partially-sweetened methane gas stream to the second co-current contactor, and (iv) release a final CO₂-enriched reflux liquid to the cryogenic distillation tower; and (e) a final co-current contactor configured to (i) receive a reflux liquid, (ii) receive a next-to-last partially-sweetened methane gas stream from a next-to-last co-current contactor, (iii) release a first partially-CO₂-enriched reflux liquid to the next-to-last co-current contactor, and (iv) release a final sweetened methane gas stream.

[0203] Embodiment N: The system of Embodiment M, wherein the final sweetened methane gas stream comprises about 99 mol. percent or more methane.

15 [0204] Embodiment O: The system of Embodiment M or N, wherein a substantial portion of the final sweetened methane gas stream is delivered for liquefaction and sale.

[0205] Embodiment P: The system of any of Embodiments M-O, wherein a portion of the final sweetened methane gas stream is diverted and used as at least a portion of the reflux liquid during operation.

20 [0206] Embodiment Q: The system of any of Embodiments M-P, wherein: (a) the cryogenic distillation tower comprises a freezing zone; (b) the freezing zone receives the cooled sour gas stream and a cold liquid spray comprised primarily of methane; and (c) the cryogenic distillation tower further comprises refrigeration equipment downstream of the cryogenic distillation tower for cooling the final sweetened methane gas stream and returning a portion of the overhead methane stream to the cryogenic distillation tower as the cold spray.

[0207] Embodiment R: The system of Embodiment Q, wherein the cold spray comprises the final CO₂-enriched reflux liquid from the final co-current contactor.

[0208] Embodiment S: The system of Embodiment Q or R, further comprising a melt tray below the freezing zone for receiving a cold slurry of acid gas particles.

30 [0209] Embodiment T: The system of any of Embodiments Q-S, further comprising an upper distillation zone above the freezing zone for receiving vapor from the freezing zone and releasing the overhead gas stream.

[0210] Embodiment U: The system of any of Embodiments Q-T, wherein the system

comprises only two co-current contactors for processing the overhead acid gas stream such that: (a) the final co-current contactor is the second co-current contactor; (b) the next-to-last co-current contactor is the first co-current contactor; (c) the first partially-sweetened methane gas stream released by the first co-current contactor is the partially sweetened methane gas stream received by the final co-current contactor; and (d) the second partially-CO₂-enriched reflux liquid received by the first co-current contactor is the partially-CO₂-enriched reflux liquid released by the final co-current contactor.

[0211] Embodiment V: The system of any of Embodiments Q-T, wherein the system comprises three co-current contactors for processing the overhead gas stream, such that: (a) the next-to-last co-current contactor is the second co-current contactor; and (b) the second co-current contactor is configured to (i) receive the first partially-sweetened methane gas stream from the first co-current contactor, (ii) receive the first partially-CO₂-enriched reflux liquid from the final co-current contactor, (iii) release a second partially-sweetened methane gas stream to the final co-current contactor, and (iv) release the second partially-CO₂-enriched reflux liquid to the first co-current contactor.

[0212] Embodiment W: The system of any of Embodiments Q-T, wherein the system comprises at least three co-current contactor for processing the overhead gas stream, such that: (a) the final co-current contactor, any intermediate co-contactors, the second co-current contactor and the first co-current contactor are arranged to deliver respective CO₂-enriched reflux liquids as progressively CO₂-richer reflux liquids in series; and (b) the first co-current contactor, the second co-current contactor, any intermediate co-contactors, and the final co-current contactor are arranged to deliver the respective sweetened gas streams as progressively sweetened gas streams in series.

[0213] Embodiment X: The system of any of Embodiments A-W, wherein the overhead gas stream comprises not only methane, but also helium, nitrogen, or combinations thereof.

[0214] Embodiment Y: A system for removing acid gases from a raw gas stream, comprising: (a) a dehydration vessel for receiving the raw gas stream, and separating the raw gas stream into a dehydrated raw gas stream and a stream comprised substantially of an aqueous fluid; (b) a heat exchanger for cooling the dehydrated raw gas stream, and releasing a cooled sour gas stream; (c) a cryogenic distillation tower that receives the cooled sour gas stream, and separates the cooled sour gas stream into (i) an overhead gas stream comprised primarily of methane, and (ii) a bottom acid gas stream comprised primarily of carbon

dioxide; (d) a final lower co-current contactor configured to (i) receive the bottom liquefied acid gas stream, (ii) receive a partially-methane-enriched gas stream from a previous lower co-current contactor, (iii) release a final methane-enriched gas stream into the cryogenic distillation tower, and (iv) release a first partially-stripped acid gas liquid into the previous lower co-current contactor; (e) a first lower co-current contactor configured to (i) receive a stripping gas, (ii) receive a second stripped acid gas liquid from a second lower co-current contactor, (iii) release a final stripped acid gas liquid, and (iv) release a first partially-methane-enriched gas stream to the second lower co-current contactor; (f) a first upper co-current contactor configured to (i) receive the overhead gas stream, (ii) receive a second partially-CO₂-enriched reflux liquid from a second co-current contactor, (iii) release a first partially-sweetened methane gas stream to the second co-current contactor, and (iv) release a final CO₂-enriched reflux liquid to the cryogenic distillation tower; and (g) a final upper co-current contactor configured to (i) receive a reflux liquid, (ii) receive a next-to-last partially-sweetened methane gas stream from a next-to-last co-current contactor, (iii) release a first partially-CO₂-enriched reflux liquid to the next-to-last co-current contactor, and (iv) release a final sweetened methane gas stream.

[0215] Embodiment Z: The system of Embodiment Y, wherein the bottom liquefied acid gas stream exits the cryogenic distillation tower at a temperature no greater than about -70° F.

20 [0216] Embodiment AA: The system of Embodiment Y or Z, wherein the cryogenic distillation tower is a bulk fractionation tower.

[0217] Embodiment BB: The system of any of Embodiments Y-AA, wherein the cryogenic distillation tower comprises a freezing zone that receives (i) the cooled sour gas stream, (ii) a cold liquid spray comprised primarily of methane, and (iii) the final methane-enriched gas stream from the final lower co-current contacting device.

25 [0218] While it will be apparent that the inventions herein described are well calculated to achieve the benefits and advantages set forth above, it will be appreciated that the inventions are susceptible to modification, variation and change without departing from the spirit thereof. Improvements to the operation of an acid gas removal process using a controlled freezing zone are provided. The improvements provide a design for the removal of H₂S down to very low levels in the product gas.

30

CLAIMS

What is claimed is:

1. A system for removing acid gases from a raw gas stream, comprising:

5 a dehydration vessel for receiving the raw gas stream, and separating the raw gas stream into a dehydrated raw gas stream and a stream comprised substantially of an aqueous fluid;

a heat exchanger for cooling the dehydrated gas stream, and releasing a cooled sour gas stream;

10 a cryogenic distillation tower that receives the cooled sour gas stream, and separates the cooled sour gas stream into (i) an overhead gas stream comprised primarily of methane, and (ii) a bottom liquefied acid gas stream comprised primarily of carbon dioxide;

a final co-current contactor configured to (i) receive the bottom liquefied acid gas stream, (ii) receive a partially-methane-enriched gas stream from a previous co-current contactor, (iii) release a final methane-enriched gas stream to the cryogenic distillation tower, and (iv) release a first partially-stripped acid gas liquid to the previous co-current contactor; and

20 a first co-current contactor configured to (i) receive a stripping gas, (ii) receive a second partially-stripped acid gas liquid from a second co-current contactor, (iii) release a final stripped acid gas liquid, and (iv) release a first partially-methane-enriched gas stream to the second co-current contactor.

2. The system of claim 1, wherein the final stripped acid gas liquid comprises about 98 mol. percent or more acid gas.

3. The system of claim 2, wherein a substantial portion of the final stripped acid gas liquid is injected into a subsurface formation through one or more acid gas injection wells.

25 4. The system of claim 2, wherein a portion of the final stripped acid gas liquid is diverted and used as at least a portion of the stripping gas via reboiling.

5. The system of claim 1, wherein:

the cryogenic distillation tower comprises a freezing zone;

30 the freezing zone receives the cooled sour gas stream, a cold liquid spray comprised primarily of methane, and the final methane-enriched gas stream from the final co-current contacting device; and

the cryogenic distillation tower further comprises refrigeration equipment

downstream of the cryogenic distillation tower for cooling the overhead methane stream and returning a portion of the overhead methane stream to the cryogenic distillation tower as the cold liquid spray.

6. The system of claim 5, further comprising:

5 a melt tray below the freezing zone for receiving a cold slurry of acid gas particles, and delivering a substantially solids-free slurry to the final co-current contacting device as the bottom liquefied acid gas stream.

7. The system of claim 6, wherein the bottom liquefied acid gas stream exits the cryogenic distillation tower at a temperature no greater than about -70° F.

10 8. The system of claim 5, further comprising:

a lower distillation zone below the freezing zone for receiving a cold slurry of acid gas particles, at least partially melting the slurry of acid gas particles into a liquid stream, and delivering the liquid stream to the final co-current contacting device as the bottom liquefied acid gas stream.

15 9. The system of claim 5, further comprising:

an upper distillation zone above the freezing zone for receiving vapor from the freezing zone and releasing the overhead gas stream.

10. The system of claim 2, wherein the system comprises only two co-current contactors for processing the bottom acid gas stream such that:

20 the final co-current contactor is the second co-current contactor;

the previous co-current contactor is the first co-current contactor;

the first partially-methane-enriched gas stream released by the first co-current contactor is the partially methane-enriched gas stream received by the final co-current contactor; and

25 the first partially-stripped acid gas liquid released by the final co-current contactor is the second partially-stripped acid gas liquid received by the first co-current contactor.

11. The system of claim 2, wherein the system comprises three co-current contactors for processing the bottom acid gas stream, such that:

the previous co-current contactor is the second co-current contactor; and

30 the second co-current contactor is configured to (i) receive the first partially-methane-enriched gas stream from the first co-current contactor, (ii) receive the first partially-stripped acid gas liquid from the final co-current contactor, (iii) release a second partially-methane-

enriched gas stream into the final co-current contactor, and (iv) release the second partially-stripped acid gas liquid into the first co-current contactor.

12. The system of claim 2, wherein the system comprises at least three co-current contactor for processing the bottom liquefied acid gas stream, such that:

5 the final co-current contactor, any intermediate co-contactors, the second co-current contactor and the first co-current contactor are arranged to deliver respective stripped acid gas liquids as progressively CO₂-richer acid gas liquids in series, and

the first co-current contactor, the second co-current contactor, any intermediate co-contactors, and the final co-current contactor are arranged to deliver the respective methane-enriched gas streams as progressively methane-enriched gas streams in series.

13. A system for removing acid gases from a raw gas stream, comprising:

a dehydration vessel for receiving the raw gas stream, and separating the raw gas stream into a dehydrated raw gas stream and a stream comprised substantially of an aqueous fluid;

15 a heat exchanger for cooling the dehydrated raw gas stream, and releasing a cooled sour gas stream;

a cryogenic distillation tower that receives the cooled sour gas stream, and separates the cooled sour gas stream into (i) an overhead gas stream comprised primarily of methane, and (ii) a bottom liquefied acid gas stream comprised primarily of carbon dioxide;

20 a first co-current contactor configured to (i) receive the overhead gas stream, (ii) receive a second partially-CO₂-enriched reflux liquid from a second co-current contactor, (iii) release a first partially-sweetened methane gas stream to the second co-current contactor, and (iv) release a final CO₂-enriched reflux liquid to the cryogenic distillation tower; and

25 a final co-current contactor configured to (i) receive a reflux liquid, (ii) receive a next-to-last partially-sweetened methane gas stream from a next-to-last co-current contactor, (iii) release a first partially-CO₂-enriched reflux liquid to the next-to-last co-current contactor, and (iv) release a final sweetened methane gas stream.

14. The system of claim 13, wherein the final sweetened methane gas stream comprises about 99 mol. percent or more methane.

30 15. The system of claim 14, wherein a substantial portion of the final sweetened methane gas stream is delivered for liquefaction and sale.

16. The system of claim 14, wherein a portion of the final sweetened methane gas stream is diverted and used as at least a portion of the reflux liquid during operation.

17. The system of claim 13, wherein:

the cryogenic distillation tower comprises a freezing zone;

5 the freezing zone receives the cooled sour gas stream and a cold liquid spray comprised primarily of methane; and

the cryogenic distillation tower further comprises refrigeration equipment downstream of the cryogenic distillation tower for cooling the final sweetened methane gas stream and returning a portion of the overhead methane stream to the cryogenic distillation
10 tower as the cold spray.

18. The system of claim 17, wherein the cold spray comprises the final CO₂-enriched reflux liquid from the final co-current contactor.

19. The system of claim 17, further comprising:

a melt tray below the freezing zone for receiving a cold slurry of acid gas particles.

15 20. The system of claim 17, further comprising:

an upper distillation zone above the freezing zone for receiving vapor from the freezing zone and releasing the overhead gas stream.

21. The system of claim 14, wherein the system comprises only two co-current contactors for processing the overhead acid gas stream such that:

20 the final co-current contactor is the second co-current contactor;

the next-to-last co-current contactor is the first co-current contactor;

the first partially-sweetened methane gas stream released by the first co-current contactor is the partially sweetened methane gas stream received by the final co-current contactor; and

25 the second partially-CO₂-enriched reflux liquid received by the first co-current contactor is the partially-CO₂-enriched reflux liquid released by the final co-current contactor.

22. The system of claim 14, wherein the system comprises three co-current contactors for processing the overhead gas stream, such that:

30 the next-to-last co-current contactor is the second co-current contactor; and

the second co-current contactor is configured to (i) receive the first partially-

sweetened methane gas stream from the first co-current contactor, (ii) receive the first partially-CO₂-enriched reflux liquid from the final co-current contactor, (iii) release a second partially-sweetened methane gas stream to the final co-current contactor, and (iv) release the second partially-CO₂-enriched reflux liquid to the first co-current contactor.

- 5 23. The system of claim 14, wherein the system comprises at least three co-current contactor for processing the overhead gas stream, such that:

the final co-current contactor, any intermediate co-contactors, the second co-current contactor and the first co-current contactor are arranged to deliver respective CO₂-enriched reflux liquids as progressively CO₂-richer reflux liquids in series; and

- 10 the first co-current contactor, the second co-current contactor, any intermediate co-contactors, and the final co-current contactor are arranged to deliver the respective sweetened gas streams as progressively sweetened gas streams in series.

24. The system of claim 13, wherein the overhead gas stream comprises not only methane, but also helium, nitrogen, or combinations thereof.

- 15 25. A system for removing acid gases from a raw gas stream, comprising:

a dehydration vessel for receiving the raw gas stream, and separating the raw gas stream into a dehydrated raw gas stream and a stream comprised substantially of an aqueous fluid;

- 20 a heat exchanger for cooling the dehydrated raw gas stream, and releasing a cooled sour gas stream;

a cryogenic distillation tower that receives the cooled sour gas stream, and separates the cooled sour gas stream into (i) an overhead gas stream comprised primarily of methane, and (ii) a bottom acid gas stream comprised primarily of carbon dioxide;

- 25 a final lower co-current contactor configured to (i) receive the bottom liquefied acid gas stream, (ii) receive a partially-methane-enriched gas stream from a previous lower co-current contactor, (iii) release a final methane-enriched gas stream into the cryogenic distillation tower, and (iv) release a first partially-stripped acid gas liquid into the previous lower co-current contactor; and

- 30 a first lower co-current contactor configured to (i) receive a stripping gas, (ii) receive a second stripped acid gas liquid from a second lower co-current contactor, (iii) release a final stripped acid gas liquid, and (iv) release a first partially-methane-enriched gas stream to the second lower co-current contactor;

a first upper co-current contactor configured to (i) receive the overhead gas stream, (ii) receive a second partially-CO₂-enriched reflux liquid from a second co-current contactor, (iii) release a first partially-sweetened methane gas stream to the second co-current contactor, and (iv) release a final CO₂-enriched reflux liquid to the cryogenic distillation tower; and

5 a final upper co-current contactor configured to (i) receive a reflux liquid, (ii) receive a next-to-last partially-sweetened methane gas stream from a next-to-last co-current contactor, (iii) release a first partially-CO₂-enriched reflux liquid to the next-to-last co-current contactor, and (iv) release a final sweetened methane gas stream.

26. The system of claim 25, wherein the bottom liquefied acid gas stream exits the
10 cryogenic distillation tower at a temperature no greater than about -70° F.

27. The system of claim 25, wherein the cryogenic distillation tower is a bulk fractionation tower.

28. The system of claim 25, wherein the cryogenic distillation tower comprises a freezing zone that receives (i) the cooled sour gas stream, (ii) a cold liquid spray comprised primarily
15 of methane, and (iii) the final methane-enriched gas stream from the final lower co-current contacting device.