

TOPSIDE OIL PRODUCTION EQUIPMENT SYSTEM FOR REDUCTION IN SPACE AND WEIGHT

BACKGROUND OF THE INVENTION

5 This invention relates to systems, apparatuses, and methods used to dehydrate crude oil for storage in crude oil storage tanks of floating production storage and offloading ("FPSO") installations. More specifically, the invention relates to a process train that includes a compact electrostatic separator.

 Conventional topside oil separation trains on FPSO installations employ multiple three-
10 phase separators, which separate oil, water, and gas. These three-phase separators are typically large, heavy, and require a significant residence volume to achieve the required separation. In addition, the three-phase separators require significant space because they must be positioned horizontally within the process train.

 FPSO installations have limitations on the amount of space that is available and the
15 amount of weight that they are able to support. As a result, there is a need for systems to reduce the space and weight of the equipment required for process trains without compromising the effectiveness and efficiency of the treatment process.

SUMMARY OF THE INVENTION

20 A system for dehydrating crude oil on a FPSO installation includes a separator vessel to receive an incoming produced water stream, followed by a flash vessel, a treatment block, a crude oil storage tank, and an electrostatic treater. The treatment block includes a low pressure degasser followed by a compact electrostatic separator pre-treater or a compact electrostatic separator pre-treater followed by a low pressure degasser. The flash vessel and/or the low
25 pressure degasser may employ an inlet cyclonic distributor and demisting cyclones, while the electrostatic treater may employ DUAL FREQUENCY® technology. The separator vessel may be a single two-phase separator/degasser or two two-phase separator/degassers that operate in parallel with each receiving approximately 50 percent of the incoming produced water stream.

30 A method for dehydrating crude oil on a FPSO installation includes routing an incoming produced water stream to a separator vessel, routing the outlet stream from the separator vessel to a flash vessel, routing the outlet stream from the flash vessel to a treatment block, routing the outlet stream from the treatment block to a crude oil storage tank, and routing the outlet stream from the crude oil storage tank to an electrostatic treater. Within the treatment block,

the outlet stream from the flash vessel is routed to a low pressure degasser and a compact electrostatic separator pre-treater or to a compact electrostatic separator pre-treater and a low pressure degasser. The separator vessel may be a single two-phase separator/degasser or two two-phase separator/degassers that operate in parallel. The final outlet stream preferably
5 contains no more than 0.5 BS&W and 285 milligrams per liter salt.

Objectives of this invention include providing systems and methods that reduce the size and weight requirements of prior art FPSO process trains without compromising treatment performance.

10 BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a block flow diagram of a prior art topside process train.

FIG. 2 is a block flow diagram of a preferred embodiment of a topside process train that practices the system and method of this invention, showing the high pressure separator, the intermediate flash vessel, the low pressure degasser, the compact electrostatic separator
15 pre-treater, the crude oil storage tank, and the electrostatic treater in the process train.

FIG. 3 is a block flow diagram of a preferred embodiment of a topside process train that practices the system and method of this invention, showing the high pressure separator, the intermediate pressure flash vessel, the compact electrostatic separator pre-treater, the low pressure degasser, the crude oil storage tank, and the electrostatic treater in the process train.

20 FIG. 4 is a block flow diagram of a preferred embodiment of a topside process train that practices the system and method of this invention, showing the high pressure separator/degasser, the intermediate pressure flash vessel, the low pressure degasser, the compact electrostatic separator pre-treater, the crude oil storage tank, and the electrostatic treater in the process train.

25 FIG. 5 is a block flow diagram of a preferred embodiment of a topside process train that practices the system and method of this invention, showing the high pressure separator/degasser, the intermediate pressure flash vessel, the compact electrostatic separator pre-treater, the low pressure degasser, the crude oil storage tank, and the electrostatic treater in the process train.

30 FIG. 6 is a block flow diagram of a preferred embodiment of a topside process train that practices the system and method of this invention, showing two high pressure separator/degassers in parallel, the intermediate pressure flash vessel, the low pressure degasser, the compact electrostatic separator pre-treater, the crude oil storage tank, and the electrostatic treater in the process train.

FIG. 7 is a block flow diagram of a preferred embodiment of a topside process train that practices the system and method of this invention, showing two high pressure separator/degassers in parallel, the intermediate pressure flash vessel, the compact electrostatic separator pre-treater, the low pressure degasser, the crude oil storage tank, and the electrostatic treater in the process train.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

Employing a compact electrostatic separator in the process train allows all of the early stages of separation to be two-phase rather than three-phase. This minimizes the different types of equipment that are required, makes the individual components of the process train smaller, and allows the process vessels to be positioned vertically within the process train, thereby reducing its overall footprint and weight.

For the purpose of comparison to the preferred embodiments, the prior art topside process train of FIG. 1 is used. This prior art train includes a high pressure separator, an intermediate pressure flash vessel (mounted on the pre-treater), a pre-treater, a low pressure degasser (mounted on the electrostatic treater), and an electrostatic treater (*see* Table 1). The train also includes a crude oil storage tank located downstream of the electrostatic treater.

Table 1. Prior art process train.

HP Separator	
Operating Pressure:	2,000 kPa (a)
Operating Temperature:	40 °C
Slug volume:	20 m ³
Maximum Water Content in Crude Outlet:	25 %vol
Size:	4.4m ID x 16.0m T/T Horizontal
IP Flash Vessel (mounted on Pre-treater)	
Operating Pressure:	770 kPa (a)
Operating Temperature:	90 °C
Liquid Hold Up:	2 Minutes
Size:	3.3m ID x 10.0m T/T Horizontal mounted on Pre-treater
Pre-Treater	
Operating Pressure:	770 kPa (a)
Operating Temperature:	90 °C
Maximum Water Content in Crude Outlet:	1 %vol
Size:	3.3m ID x 10.0m T/T Horizontal
LP Degasser (mounted on Electrostatic Treater)	
Operating Pressure:	250 kPa (a)
Operating Temperature:	75 - 80 °C
Liquid Hold Up:	2 Minutes
Size:	3.3m ID x 10.0m T/T Horizontal mounted on Pre-treater
Electrostatic Treater	
Operating Pressure:	250 kPa (a)
Operating Temperature:	75 - 80 °C
Maximum Water Content in Crude Outlet:	0.5 %vol
Maximum Salt content in Crude Outlet:	285 mg/l

The train is designed to achieve a maximum total liquids flow rate of 24,000 m³/day (150,000 bpd), a maximum oil flow rate of 24,000 m³/day (150,000 bpd), a maximum produced water flow rate of 19,100 m³/day (120,000 bpd), and maximum gas flow rate of 6,000,000 m³/day. The incoming crude oil properties are 27 API; viscosity 47.1, 30.3 and 19.9 cSt at 30°, 40°, and 50° C respectively; initial paraffin deposit temperature of 40° C first event and 20° C second event; pour point of 12° C; and severe foaming. The oil temperature on arrival to the train is in a range of 20° C (maximum oil cases) to 40° C (maximum water cases).

The size and weight requirements of the prior art train are shown in Table 2. The train, not including the crude oil storage tank, requires a plot area of 275 m², with a dry weight of 353.4 tonnes and an operating weight of 1047.4 tonnes. Note the amount of water-in-oil decreases at each successive processing step, with 25% water content in the outlet stream of the high pressure separator to a 1% water content in the inlet stream to the low pressure degasser.

Table 2. Size and weight requirements of prior art process train.

Equipment Item	Technology & Performance	Residence Requirements	Plot		
			Size (ID x T/T)	Area (m ²)	Weights (Tonnes)
HP Separator	Existing 2/3-Phase Separator	2 Phase: 2 Mins Liquids @ 1255 m ³ /hr = 41.83 m ³	4.4m x 16m Horizontal	95	117.5 Dry 302.5 Op.
	Inlet: 20 – 80% Water, 80 – 20% Oil	3 Phase: 5 minutes Oil @ 1061 m ³ /hr = 88.4 m ³			
	Outlet: 25% Water-in-Oil	5 minutes Water @ 794 m ³ /hr = 66.2 m ³ 20 m ³ Surge both 2 & 3 phase			
IP Vessel	Flash Existing Design	2 minutes @ 1346 m ³ /hr = 44.8 m ³	3.3m x 10m Horizontal	Inc. Below	39.4 Dry 92.4 Op.
	Inlet: 20.8 – 28% Water-in-Oil				
Pre-Treater	Existing Electrostatic Technology Outlet: 1% Water-in-Oil	As Required for Spec	4.2m x 16m Horizontal	90	83.8 Dry 286.8 Op.
LP Degasser	Existing Design	2 minutes @ 1159 m ³ /hr = 38.6 m ³	3.2m x 10m Horizontal	Inc. Below	30.5 Dry 77.5 Op.
	Inlet: 1% Water-in-Oil				

Equipment Item	Technology & Performance	Residence Requirements	Size (ID x T/T)	Plot	
				Area (m ²)	Weights (Tonnes)
Electrostatic Treater	Existing Electrostatic Technology Desalter + 100 m ³ /hr Wash Water Outlet: 0.5% BS&W 285 mg/l Salt	As Required for Spec	4.2m x 16m Horizontal	90	82.2 Dry 288.2 Op.
Total	-	-	-	275	353.4 Dry 1047.4 Op.

Referring now to FIG. 2, a preferred embodiment of a topside process train 10 includes a high pressure separator 20, an intermediate pressure flash vessel 30 arranged downstream of the high pressure separator 20, a low pressure degasser 40 arranged downstream of the intermediate pressure flash vessel 30, a compact electrostatic separator pre-treater 50 arranged downstream of the low pressure degasser 40, a crude oil storage tank ("cargo tank") 60 arranged downstream of the compact electrostatic separator pre-treater 50, and, finally, an electrostatic treater 70 arranged downstream of the cargo tank 60.

Compared to the prior art train of FIG. 1, the process train of FIG. 2, excluding the cargo tank, has a plot area of 177 m², thereby reducing space requirements by 103 m² (a 37% reduction), and a dry weight of 178.8 tonnes, thereby reducing the total dry weight by 176.2 tonnes (a 50% reduction, with operating weight reduced by 513.3 tonnes or 49%).

Table 3. Preferred embodiment of the process train.

Equipment Item	Technology & Performance	Residence Rqmts.	Size (ID x T/T)	Plot Area (m ²)	Plot Area Reduction	Weights (Tonnes)	Weight Reduction
HP Separator	Existing 2/3-Phase Separator Inlet: 20 – 80% Water, 80 – 20% Oil Outlet: 25% Water-in-Oil	2 Phase: 2 Mins Liquids @ 1255 m ³ /hr = 41.83 m ³ 3 Phase: 5 minutes Oil @ 1061 m ³ /hr = 88.4 m ³ 5 minutes Water @ 794 m ³ /hr = 66.2 m ³ 20 m ³ Surge both 2 & 3 phase	4.4m x 16m Horizontal	≈ 95	n/a	117.5 Dry 302.5 Op.	n/a Dry n/a Op.
IP Flash Vessel	CONSEPT Compact Design Inlet: 20.8 – 28% Water-in-Oil	Cyclonic degassing with no slug volume rqmt.	1.6m x 5.3m Vertical	≈ 6	≈ +6	1.4 Dry 3.4 Op.	-38.0 Dry -89.0 Op.
LP Degasser	CONSEPT Compact Design Inlet: 20.8 – 28% Water-in-Oil	Cyclonic degassing with no slug volume rqmt.	1.6m x 5.3m Vertical	≈ 6	≈ +6	1.4 Dry 3.4 Op.	-29.1 Dry -73.1 Op.

Equipment Item	Technology & Performance	Residence Rqmts.	Size (ID x T/T)	Plot Area (m ²)	Plot Area Reduction	Weights (Tonnes)	Weight Reduction
Pre-Treater	Cameron Compact Electrostatic Separator (C.E.S.) Technology Inlet: 20.8 - 28% Water-in-Oil Outlet: 3 - 10% Water-in-Oil	As required for spec.	4.2m x 3.3m Vertical	≈ 25	≈ -70	24.0 Dry 100.5 Op.	-59.8 Dry -186.3 Op.
Cargo Tank	Inlet: 3 - 10% Water-in-Oil Outlet: 1% Water-in-Oil	Existing	Existing	Existing	n/a	n/a	n/a
Electrostatic Treater	Hi-Flux Dual Frequency Electrostatic Desalter + 100 m ³ /hr Wash Water Outlet: 0.5% BS&W 285 mg/l Salt	As required for spec.	4.2m x 6.1m Horizontal	≈ 45	≈ -45	34.5 Dry 123.3 Op.	-49.3 Dry -164.9 Op.
Total	-	-	-	177	≈ -103	178.8 Dry 533.1 Op.	-176.2 Dry -513.3 Op.

Referring to FIG. 2, the high pressure separator 20 for this embodiment has the same characteristics, requirements, and performance as the high pressure separator in the prior art process train shown in FIG. 1. The high pressure separator 20 receives a mixed process stream 15 that may contain from 20 to 80% water and from 80 to 20% oil.

- 5 The outlet stream 25 from the high pressure separator 20 is routed to the intermediate pressure flash vessel 30, which may have a CONCEPT® inlet cyclonic distributor (Cameron Solutions, Inc., Houston, TX) and demisting cyclones. Using the CONCEPT® inlet cyclonic distributor, which has a liquid hold-up time of only thirty seconds, allows the intermediate pressure flash vessel 30 to be vertically situated within the process train 10, with significant
- 10 reductions in the space and weight of the process train 10.

The outlet stream 35 from the intermediate pressure flash vessel 30 is then routed to the low pressure degasser 40, which may also have an CONCEPT® inlet cyclonic distributor and demisting cyclones. Using the CONCEPT® inlet cyclonic distributor allows the low pressure degasser 40 to be vertically situated within the process train 10, with significant reductions in the space and weight of the process train 10.

The outlet stream 45 from the low pressure degasser 40 is routed to the compact electrostatic separator pre-treater 50. The pre-treater 50 includes at least two elongated separator vessels oriented at an incline and connected to one another so that an upwardly flowing oil-predominant fluid passes from the first separator vessel to the second separator vessel where further electrostatic separation of water from the oil-predominant fluid occurs. Each vessel has an electrode at its upper end preferably connected to a different voltage source. The inlet to each vessel is located relative to the electrode to provide an up flow or a down flow vessel. Additionally, the first vessel may be at a different elevation than the second vessel. An additional vessel may be included with output from the first vessel bypassing the additional vessel, the second vessel, or both. Baffles may be added in the water collection portion of each vessel to reduce turbulence and settling distances. The compact electrostatic separator pre-treater 50 is further described in U.S. Patent No. 9,095,790 B2, the contents of which are incorporated herein by reference.

The compact electrostatic separator pre-treater 50 may take an inlet water cut of 20.8 to 28% water-in-oil and reduce it to between 3 to 10% water-in-oil. This pre-treater 50 is also a vertical unit, which further reduces the space and weight of the process train 10 compared to the prior art process train in FIG. 1.

The outlet stream 55 from the compact electrostatic separator pre-treater 50 is routed to the cargo tank 60, where it is de-watered from 3 to 10% water-in-oil to 1% water-in-oil. The cargo tank 60 may be any size and type that are well known in the art.

The outlet stream 65 from the cargo tank 60 is routed to the electrostatic treater 70. The electrostatic treater employs DUAL FREQUENCY® technology (Cameron Solutions, Inc., Houston, TX) as described in U.S. Patent No. 6,860,979 B2 and U.S. Patent No. 7,351,320 B2, the contents of which are herein incorporated by reference. This technology includes passing the oil-water emulsion into a treatment vessel, establishing at least one dual frequency electric field within the vessel, and selectably varying the electric field at a first frequency modulated in intensity at a second frequency where the first frequency is greater than the second[GG1]. Preferably, the BS&W content of the stream 75 exiting the electrostatic treater 70 is no greater than 0.5% BS&W and 285 mg/l salt.

Referring now to FIG. 3, another preferred embodiment of a topside process train 80 includes a high pressure separator 20 that receives a mixed stream 15 containing 20 to 80% water and 80 to 20% oil, an intermediate pressure flash vessel 30 arranged downstream of the high pressure separator 20 that receives the outlet stream 25 from the high pressure separator 20, a compact electrostatic separator pre-treater 50 arranged downstream of the intermediate pressure flash vessel 30 that receives the outlet stream 35 from the intermediate pressure flash vessel 30, a low pressure degasser 40 arranged downstream of the compact electrostatic separator pre-treater 50 that receives the outlet stream 85 from the pre-treater 50, a crude oil storage tank ("cargo tank") 60 arranged downstream of the low pressure degasser 40 that receives the outlet stream 90 from the low pressure degasser 40, and, finally, an electrostatic treater 70 arranged downstream of the cargo tank 60 that receives the outlet stream 95 from the cargo tank 60.

The equipment for each component of the process train in FIG. 3 is the same as the equipment for the process train described in FIG. 2 and Table 3, with the same advantages in reduced space and weight, and the size of the low pressure degasser 40 is not affected by the relative position of the compact electrostatic separator pre-treater 50. Preferably, the BS&W content of the stream 100 as it exits the process train 80 is no greater than 0.5% BS&W and 285 mg/l salt.

Referring now to FIG. 4, a preferred embodiment of a topside process train 110 includes a high pressure separator/degasser 120, an intermediate pressure flash vessel 30 arranged downstream of the high pressure separator/degasser 120, a low pressure degasser 40 arranged downstream of the intermediate pressure flash vessel 30, a compact electrostatic separator pre-treater 50 arranged downstream of the low pressure degasser 40, a crude oil storage tank ("cargo tank") 60 arranged downstream of the compact electrostatic separator pre-treater 50, and, finally, an electrostatic treater 70 arranged downstream of the cargo tank 60.

Compared to the prior art train of FIG. 1, the process train of FIG. 4, excluding the cargo tank, has a plot area of 137 m², thereby reducing space requirements by 138 m² (a 50% reduction), and a dry weight of 101.3 tonnes, thereby reducing the total dry weight by 253.7 tonnes (a 72% reduction, with operating weight reduced by 765.8 tonnes or 73%).

Table 4. Preferred embodiment of the process train.

Equipment Item	Technology & Performance	Residence Rqmts.	Size (ID x T/T)	Plot Area (m ²)	Plot Area Reduction	Weights (Tonnes)	Weight Reduction
HP Separator/ Degasser	CONSEPT Compact Design Inlet: 20 – 80% Water, 80 – 20% Oil	30 seconds liquid retention with cyclonic degassing	3.2m x 11.2m Horizontal	≈ 55	≈ -40	40.0 Dry 50.0 Op.	-77.5 Dry -252.5 Op.
IP Flash Vessel	CONSEPT Compact Design Inlet: 20 – 80% Water, 80 – 20% Oil	Cyclonic degassing with no slug volume rgmt.	1.6m x 5.3m Vertical	≈ 6	≈ +6	1.4 Dry 3.4 Op.	-38.0 Dry -89.0 Op.
LP Degasser	CONSEPT Compact Design Inlet: 20 – 80% Water, 80 – 20% Oil	Cyclonic degassing with no slug volume rgmt.	1.6m x 5.3m Vertical	≈ 6	≈ +6	1.4 Dry 3.4 Op.	-29.1 Dry -73.1 Op.
Pre-Treater	Cameron Compact Electrostatic Separator (C.E.S.) Technology Inlet: 20 - 80% Water, 80 - 20% Oil Outlet: 3 - 10% Water-in-Oil	As required for spec.	4.2m x 3.3m Vertical	≈ 25	≈ -65	24.0 Dry 100.5 Op.	-59.8 Dry -186.3 Op.

Equipment Item	Technology & Performance	Residence Rqmts.	Size (ID x T/T)	Plot Area (m ²)	Plot Area Reduction	Weights (Tonnes)	Weight Reduction
Cargo Tank	Inlet: 3 - 10% Water-in-Oil Outlet: 1% Water-in-Oil	Existing	Existing	Existing	n/a	n/a	n/a
Electrostatic Treater	Hi-Flux Dual Frequency Electrostatic Desalter + 100 m ³ /hr Wash Water Outlet: 0.5% BS&W 285 mg/l Salt	As required for spec.	4.2m x 6.1m Horizontal	≈ 45	≈ -45	34.5 Dry 123.3 Op.	-49.3 Dry -164.9 Op.
Total	-	-	-	137	≈ -138	101.3 Dry 280.6 Op.	-253.7 Dry -765.8 Op.

Referring to FIG. 4, the high pressure separator/degasser 120 for this embodiment is in two-phase service and employs a CONCEPT® inlet cyclonic distributor (Cameron Solutions, Inc., Houston, TX) and demisting cyclones, which allows for the degassing of stream 15 in a compact vessel with only thirty seconds of liquid retention. Although the high pressure separator/degasser 120 remains in a horizontal position within the process train 110, both the size and weight of the high pressure separator/degasser 120 are reduced as shown in Table 4.

The outlet stream 125 from the high pressure separator/degasser 120 is routed to the intermediate pressure flash vessel 30, which may have a CONCEPT® inlet cyclonic distributor (Cameron Solutions, Inc., Houston, TX) and demisting cyclones. Using the CONCEPT® inlet cyclonic distributor, which has a liquid hold-up time of only thirty seconds, allows the intermediate pressure flash vessel 30 to be vertically situated within the process train 110, with significant reductions in the space and weight of the process train 110.

The outlet stream 130 from the intermediate pressure flash vessel 30 is then routed to the low pressure degasser 40, which may also have an CONCEPT® inlet cyclonic distributor and demisting cyclones. Using the CONCEPT® inlet cyclonic distributor allows the low pressure degasser 40 to be vertically situated within the process train 110, with significant reductions in the space and weight of the process train 110.

The outlet stream 135 from the low pressure degasser 40 is routed to the compact electrostatic separator pre-treater 50. The pre-treater 50 includes at least two elongated

separator vessels oriented at an incline and connected to one another so that an upwardly flowing oil-predominant fluid passes from the first separator vessel to the second separator vessel where further electrostatic separation of water from the oil-predominant fluid occurs. Each vessel has an electrode at its upper end preferably connected to a different voltage source.

5 The inlet to each vessel is located relative to the electrode to provide an up flow or a down flow vessel. Additionally, the first vessel may be at a different elevation than the second vessel. An additional vessel may be included with output from the first vessel bypassing the additional vessel, the second vessel, or both. Baffles may be added in the water collection portion of each vessel to reduce turbulence and settling distances. The compact electrostatic separator pre-

10 treater 50 is further described in U.S. Patent No. 9,095,790 B2, the contents of which are incorporated herein by reference.

The compact electrostatic separator pre-treater 50 may take an inlet water cut of 20 to 80% water-in-oil and reduce it to between 3 to 10% water-in-oil. This pre-treater 50 is also a vertical unit, which further reduces the space and weight of the process train 110 compared to

15 the prior art process train in FIG. 1.

The outlet stream 140 from the compact electrostatic separator pre-treater 50 is routed to the cargo tank 60, where it is de-watered from 3 to 10% water-in-oil to 1% water-in-oil. The cargo tank 60 may be any size and type that are well known in the art.

The outlet stream 145 from the cargo tank 60 is routed to the electrostatic treater 70.

20 The electrostatic treater 70 employs DUAL FREQUENCY® technology (Cameron Solutions, Inc., Houston, TX) as described in U.S. Patent No. 6,860,979 B2 and U.S. Patent No. 7,351,320 B2, the contents of which are herein incorporated by reference. This technology includes passing the oil-water emulsion into a treatment vessel, establishing at least one dual frequency electric field within the vessel, and selectably varying the electric field at a first frequency

25 modulated in intensity at a second frequency where the first frequency is greater than the second. Preferably, the BS&W content of the stream 150 as it exits the electrostatic treater 70 is no greater than 0.5% BS&W and 285 mg/l salt.

Referring now to FIG. 5, another preferred embodiment of a topside process train 160 includes a high pressure separator/degasser 120 that receives a mixed stream 15 containing 20 to 80% water and 80 to 20% oil, an intermediate pressure flash vessel 30 arranged downstream

30 of the high pressure separator/degasser 120 that receives the outlet stream 125 from the high pressure separator/degasser 120, a compact electrostatic separator pre-treater 50 arranged downstream of the intermediate pressure flash vessel 30 that receives the outlet stream 130 from the intermediate pressure flash vessel 30, a low pressure degasser 40 arranged

downstream of the compact electrostatic separator pre-treater 50 that receives the outlet stream 165 from the pre-treater 50, a crude oil storage tank ("cargo tank") 60 arranged downstream of the low pressure degasser 40 that receives the outlet stream 170 from the low pressure degasser 40, and, finally, an electrostatic treater 70 arranged downstream of the cargo tank 60 that receives the outlet stream 175 from the cargo tank 60.

The equipment for each component of the process train in FIG. 5 is the same as the equipment for the process train described in FIG. 4 and Table 4, with the same advantages in reduced space and weight, and the size of the low pressure degasser 40 is not affected by the relative position of the compact electrostatic separator pre-treater 50. Preferably, the BS&W content of the stream 180 as it exits the process train 160 is no greater than 0.5% BS&W and 285 mg/l salt.

Referring now to FIG. 6, a preferred embodiment of a topside process train 190 includes two high pressure separators/degassers 200, an intermediate pressure flash vessel 30 arranged downstream of the high pressure separators/degassers 200, a low pressure degasser 40 arranged downstream of the intermediate pressure flash vessel 30, a compact electrostatic separator pre-treater 50 arranged downstream of the low pressure degasser 40, a crude oil storage tank ("cargo tank") 60 arranged downstream of the compact electrostatic separator pre-treater 50, and, finally, an electrostatic treater 70 arranged downstream of the cargo tank 60.

Compared to the prior art train of FIG. 1, the process train of FIG. 6, excluding the cargo tank, has a plot area of 102 m², thereby reducing space requirements by 173 m² (a 63% reduction), and a dry weight of 107.3 tonnes, thereby reducing the total dry weight by 247.7 tonnes (a 70% reduction, with operating weight reduced by 759.8 tonnes or 73%).

Table 5. Preferred embodiment of the process train.

Equipment Item	Technology & Performance	Residence Rqmts.	Size (ID x T/T)	Plot Area (m ²)	Plot Area Reduction	Weights (Tonnes)	Weight Reduction
HP Separator/ Degasser	CONSEPT Compact Design	30 seconds liquid retention	Two (2) 2.5m x 10.0m Vertical	≈ 20	≈ -75	46.0 Dry 56.0 Op.	-71.5 Dry -246.5 Op.
Two (2) x 50%	20 – 80% Water, 80 – 20% Oil	with cyclonic degassing					

Equipment Item	Technology & Performance	Residence Rqmts.	Size (ID x T/T)	Plot Area (m ²)	Plot Area Reduction	Weights (Tonnes)	Weight Reduction
IP Flash Vessel	CONSEPT Compact Design Inlet: 20 - 80% Water, 80 - 20% Oil	Cyclonic degassing with no slug volume rqmt.	1.6m x 5.3m Vertical	≈ 6	≈ +6	1.4 Dry 3.4 Op.	-38.0 Dry -89.0 Op.
LP Degasser	CONSEPT Compact Design Inlet: 20 - 80% Water, 80 - 20% Oil	Cyclonic degassing with no slug volume rqmt.	1.6m x 5.3m Vertical	≈ 6	≈ +6	1.4 Dry 3.4 Op.	-29.1 Dry -73.1 Op.
Pre-Treater	Cameron Compact Electrostatic Separator (C.E.S.) Technology Inlet: 20.8 - 28% Water-in-Oil Outlet: 3 - 10% Water-in-Oil	As required for spec.	4.2m x 3.3m Vertical	≈ 25	≈ -65	24.0 Dry 100.5 Op.	-59.8 Dry -186.3 Op.
Cargo Tank	Inlet: 3 - 10% Water-in-Oil Outlet: 1% Water-in-Oil	Existing	Existing	Existing	n/a	n/a	n/a
Electrostatic Treater	Hi-Flux Dual Frequency Electrostatic Desalter + 100 m ³ /hr Wash Water Outlet: 0.5% BS&W 285 mg/l Salt	As required for spec.	4.2m x 6.1m Horizontal	≈ 45	≈ -45	34.5 Dry 123.3 Op.	-49.3 Dry -164.9 Op.
Total	-	-	-	102	≈ -173	107.3 Dry 286.6 Op.	-247.7 Dry -759.8 Op.

Referring to FIG. 6, the two high pressure separator/degassers 200 for this embodiment operate in parallel, with each separator/degasser 200 receiving approximately fifty percent of

the stream 15. Each high pressure separator/degasser 200 is in two-phase service and employs a CONCEPT® inlet cyclonic distributor (Cameron Solutions, Inc., Houston, TX) and demisting cyclones, which allows for the degassing of the stream 15 in a compact vessel with only thirty seconds of liquid retention. Dividing the stream between the two separator/degassers 200
5 allows the separator/degassers 200 to be mounted vertically rather than horizontally, thereby reducing the space requirements and weight of the process train 190 as shown in Table 5.

The outlet streams 205 from the high pressure separator/degassers 200 are combined and routed to the intermediate pressure flash vessel 30, which may have a CONCEPT® inlet cyclonic distributor (Cameron Solutions, Inc., Houston, TX) and demisting cyclones. Using
10 the CONCEPT® inlet cyclonic distributor, which has a liquid hold-up time of only thirty seconds, allows the intermediate pressure flash vessel 30 to be vertically situated within the process train 190, with significant reductions in the space and weight of the process train 190.

The outlet stream 210 from the intermediate pressure flash vessel 30 is then routed to the low pressure degasser 40, which may also have an CONCEPT® inlet cyclonic distributor and demisting cyclones. Using the CONCEPT® inlet cyclonic distributor allows the low
15 pressure degasser 40 to be vertically situated within the process train 190, with significant reductions in the space and weight of the process train 190.

The outlet stream 220 from the low pressure degasser 40 is routed to the compact electrostatic separator pre-treater 50. The pre-treater 50 includes at least two elongated
20 separator vessels oriented at an incline and connected to one another so that an upwardly flowing oil-predominant fluid passes from the first separator vessel to the second separator vessel where further electrostatic separation of water from the oil-predominant fluid occurs. Each vessel has an electrode at its upper end preferably connected to a different voltage source. The inlet to each vessel is located relative to the electrode to provide an up flow or a down flow
25 vessel. Additionally, the first vessel may be at a different elevation than the second vessel. An additional vessel may be included with output from the first vessel bypassing the additional vessel, the second vessel, or both. Baffles may be added in the water collection portion of each vessel to reduce turbulence and settling distances. The compact electrostatic separator pre-treater 50 is further described in U.S. Patent No. 9,095,790 B2, the contents of which are
30 incorporated herein by reference.

The compact electrostatic separator pre-treater 50 may take an inlet water cut of 20.8 to 28% water-in-oil and reduce it to between 3 to 10% water-in-oil. This pre-treater 50 is also a vertical unit, which further reduces the space and weight of the process train 190 compared to the prior art process train in FIG. 1.

The outlet stream 230 from the compact electrostatic separator pre-treater 50 is routed to the cargo tank 60, where it is de-watered from 3 to 10% water-in-oil to 1% water-in-oil. The cargo tank 60 may be any size and type that are well known in the art. The outlet stream 240 from the cargo tank 60 is routed to the electrostatic treater 70. The electrostatic treater employs
5 DUAL FREQUENCY® technology (Cameron Solutions, Inc., Houston, TX) as described in U.S. Patent No. 6,860,979 B2 and U.S. Patent No. 7,351,320 B2, the contents of which are herein incorporated by reference. This technology includes passing the oil-water emulsion into a treatment vessel, establishing at least one dual frequency electric field within the vessel, and selectably varying the electric field at a first frequency modulated in intensity at a second
10 frequency where the first frequency is greater than the second. Preferably, the BS&W content of the stream 250 as it exits the electrostatic treater 70 is no greater than 0.5% BS&W and 285 mg/l salt.

Referring now to FIG. 7, another preferred embodiment of a topside process train 260 includes two high pressure separator/degassers 200 operating in parallel, with each
15 separator/degasser 200 receiving approximately half of a mixed stream 15 containing 20 to 80% water and 80 to 20% oil, an intermediate pressure flash vessel 30 arranged downstream of the high pressure separator/degassers 200 that receives the combined outlet stream from the separator/degassers 200, a compact electrostatic separator pre-treater 50 arranged downstream of the intermediate pressure flash vessel 30 that receives the outlet stream 210 from the
20 intermediate pressure flash vessel 30, a low pressure degasser 40 arranged downstream of the compact electrostatic separator pre-treater 50 that receives the outlet stream 270 from the pre-treater 50, a crude oil storage tank ("cargo tank") 60 arranged downstream of the low pressure degasser 40 that receives the outlet stream 280 from the low pressure degasser 40, and, finally, an electrostatic treater 70 arranged downstream of the cargo tank 60 that receives the outlet
25 stream 290 from the cargo tank 60.

The equipment for each component of the process train in FIG. 7 is the same as the equipment for the process train described in FIG. 6 and Table 5, with the same advantages in reduced size and weight. Preferably, the BS&W content of the stream 300 as it exits the process train 260 is no greater than 0.5% BS&W and 285 mg/l salt.

30 While the invention has been described with a certain degree of particularity, many changes may be made in the details of construction, the arrangement of components, the steps of the process, and the order of the steps without departing from the spirit and scope of this disclosure. Further, multiple systems may be operated in parallel. The invention is not limited to the embodiments set forth herein for purposes of exemplification, but is limited only by the

scope of the attached claims, including the full range of equivalency to which each element thereof is entitled.

WHAT IS CLAIMED

1. A method for dehydrating crude oil on a floating production storage and offloading installation, the method comprising:
 - routing an incoming produced water stream containing approximately 20 to 80 percent water and 80 to 20 percent oil to a separator vessel;
 - routing an outlet stream from the separator vessel to a flash vessel;
 - routing an outlet stream from the flash vessel to a treatment block, wherein the treatment block consists of a low pressure degasser and a compact electrostatic separator pre-treater;
 - routing an outlet stream from the treatment block to a cargo tank, wherein the outlet stream from the treatment block comprises approximately 3 to 10 percent water-in-oil and an outlet stream from the cargo tank comprises approximately 1 percent water-in-oil; and
 - routing the outlet stream from the cargo tank to an electrostatic treater, which produces a final outlet stream containing no more than approximately 0.5 percent BS&W.
2. A method according to claim 1, wherein the separator vessel is a two-phase separator/degasser, the two-phase separator/degasser including an inlet cyclonic distributor and demisting cyclones.
3. A method according to claim 1, wherein the separator vessel is two, two-phase separator/degassers that operate in parallel, with each separator/degasser receiving approximately 50 percent of the incoming produced water stream.
4. A method according to claim 1, wherein the low pressure degasser receives the outlet stream of the flash vessel and the compact electrostatic separator pre-treater receives an outlet stream of the low pressure degasser.
5. A method according to claim 1, wherein the compact electrostatic separator pre-treater receives the outlet stream of the flash vessel and the low pressure degasser receives an outlet stream of the compact electrostatic separator pre-treater.

6. A method for dehydrating crude oil on a floating production storage and offloading installation, the method comprising
 - routing an incoming produced water stream containing approximately 20 to 80 percent water and 80 to 20 percent oil to a separator vessel;
 - routing an outlet stream from the separator vessel to a flash vessel;
 - routing an outlet stream from the flash vessel to a treatment block, the treatment block comprising a low pressure degasser and a compact electrostatic separator pre-treater;
 - routing an outlet stream from the treatment block to a cargo tank, wherein the outlet stream from the treatment block comprises approximately 3 to 10 percent water-in-oil and an outlet stream from the cargo tank comprises approximately 1 percent water-in-oil; and
 - routing the outlet stream from the cargo tank to an electrostatic treater, which produces a final outlet stream containing no more than approximately 0.5 percent BS&W.
7. A method according to claim 6, wherein the separator vessel is a two-phase separator/degasser, the two-phase separator/degasser including an inlet cyclonic distributor and demisting cyclones.
8. A method according to claim 6, wherein the separator vessel is two, two-phase separator/degassers that operate in parallel, each two-phase separator/degasser receiving a portion of the incoming produced water stream.
9. A method according to claim 6, wherein the low pressure degasser receives the outlet stream of the flash vessel and the compact electrostatic separator pre-treater receives an outlet stream of the low pressure degasser.
10. A method according to claim 6, wherein the compact electrostatic separator pre-treater receives the outlet stream of the flash vessel and the low pressure degasser receives an outlet stream of the compact electrostatic separator pre-treater.

11. A method according to claim 6, wherein the final outlet stream contains a salt content no greater than approximately 285 mg per liter.
 12. A method according to claim 6, wherein the compact electrostatic separator pre-treater comprises two elongated separator vessels that are oriented at an incline and connected to each other.
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