

# 4Q 2008 Review

## Fluid Catalytic Cracking and Crude Distillation

<b>1. Introduction.....</b>	<b>1</b>
<b>2. Fluid Catalytic Cracking.....</b>	<b>3</b>
2.1 MARKET/TECHNOLOGY TRENDS & OPPORTUNITIES .....	3
2.1.1 <i>Market Conditions and Outlook</i> .....	3
2.1.1.1 Supply and Demand: Diesel vs. Gasoline.....	3
2.1.1.2 FCCU Capacity.....	4
2.1.1.3 Refinery Operations, Expansion, and Investment .....	4
2.1.1.4 Environmental Considerations.....	5
2.1.1.5 Catalyst Market Competition.....	7
2.1.2 <i>Technology Directions, Competition, and Future Prospects</i> .....	8
2.1.2.1 Environmental Emissions .....	8
2.1.2.2 FCC Light Olefin Production .....	9
2.1.2.3 Processing Alternative Feedstocks .....	9
2.1.2.4 Producing High-quality Gasoline and Increasing Yield .....	10
2.1.2.5 Spent Catalyst Removal/Rejuvenation .....	11
2.1.2.6 Process Modeling, Monitoring, and Control .....	11
2.1.2.7 LCO Production.....	12
2.2 STATE-OF-THE-ART TECHNOLOGY .....	13
2.2.1 <i>Introduction</i> .....	13
2.2.2 <i>Commercial Processes and Hardware</i> .....	14
2.2.2.1 Lummus Technology .....	14
2.2.2.2 ExxonMobil/KBR.....	16
2.2.2.2.1 Flexicracking III .....	17
2.2.2.2.2 Orthoflow .....	19
2.2.2.3 Fisher-Klosterman .....	22
2.2.2.4 Lawrence Pumps.....	23
2.2.2.5 Petrobras .....	23
2.2.2.6 Sinopec .....	25
2.2.2.7 Shaw Energy & Chemicals/Axens.....	26
2.2.2.8 Shell Global Solutions .....	29
2.2.2.8.1 FCC .....	30
2.2.2.8.2 MILOS.....	32
2.2.2.9 UOP .....	33
2.2.2.9.1 FCC .....	33
2.2.2.9.2 MSCC.....	38
2.2.3 <i>Summary of Commercial FCC Processes and Hardware</i> .....	39
2.2.4 <i>Commercial Catalysts and Additives</i> .....	43
2.2.4.1 Albemarle .....	43
2.2.4.1.1 Cracking Catalysts to Increase Liquid Products .....	45
2.2.4.1.2 Gasoline Olefins Reduction Formulations.....	48
2.2.4.1.3 Gasoline Sulfur Reduction Formulations .....	49
2.2.4.1.4 Bottoms Cracking Additives .....	52
2.2.4.1.5 Combustion Promoters .....	52
2.2.4.1.6 Microfine Reduction Catalyst Technology.....	53
2.2.4.1.7 Catalyst Circulation Improvement Additives .....	54
2.2.4.1.8 Catalyst Testing .....	54
2.2.4.2 Ambur Chemical Co. ....	55

2.2.4.3	BASF Catalysts .....	55
2.2.4.3.1	Cracking Catalysts to Increase Liquid Products .....	56
2.2.4.3.2	Gasoline Olefins Reduction Catalyst .....	57
2.2.4.3.3	Gasoline Sulfur Reduction Formulations.....	57
2.2.4.3.4	Bottoms Cracking Additives .....	58
2.2.4.3.5	Microfine Reduction Catalyst Technology .....	59
2.2.4.3.6	Catalyst Circulation Improvement Additive .....	59
2.2.4.3.7	Combustion Promoters.....	59
2.2.4.4	Catalysts & Chemicals Ind. (C&CI) .....	60
2.2.4.5	Grace Davison.....	60
2.2.4.5.1	Cracking Catalysts to Increase Liquid Products .....	61
2.2.4.5.2	Gasoline Olefins Reduction Catalysts.....	62
2.2.4.5.3	Gasoline Sulfur Reduction Formulations.....	63
2.2.4.5.4	Bottoms Cracking Additives .....	65
2.2.4.5.5	Combustion Promoters.....	66
2.2.4.6	Inst. Mexicano del Petróleo.....	66
2.2.4.7	INTERCAT .....	66
2.2.4.7.1	Gasoline Sulfur Reduction Additives .....	67
2.2.4.7.2	Gasoline Olefins Reduction Additives.....	68
2.2.4.7.3	Bottoms Cracking Additives.....	68
2.2.4.7.4	Catalyst Enhancement Additives .....	69
2.2.4.7.5	Combustion Promoters.....	70
2.2.4.8	Nalco Energy Services/Refining Process Services .....	71
2.2.4.8.1	MVP.....	71
2.2.4.8.2	NPP.....	72
2.2.4.9	Sinopec.....	73
2.2.4.9.1	Cracking Catalysts .....	73
2.2.4.9.2	Gasoline Sulfur Reduction Additives .....	73
2.2.4.9.3	Gasoline Olefins Reduction Formulations .....	73
2.2.4.9.4	Diesel Maximizing Catalysts .....	74
2.2.5	<i>Comparison of Commercially Available FCC Catalysts.....</i>	75
2.2.6	<i>Comparison of Commercially Available FCC Additives.....</i>	76
2.2.7	<i>Spent Catalyst Separation and Rejuvenation Technologies .....</i>	78
2.2.7.1	Coastal Catalyst Technology.....	78
2.2.7.2	KBR .....	79
2.2.7.3	Nippon Oil Corp. ....	80
2.2.8	<i>Advanced Process Control Systems.....</i>	81
2.2.8.1	ABB .....	81
2.2.8.2	AspenTech .....	81
2.2.8.3	Cutler Technology Corp.....	82
2.2.8.4	Expertune .....	83
2.2.8.5	Honeywell Industry Solutions.....	83
2.2.8.6	Invensys .....	83
2.2.8.7	Petrocontrol.....	84
2.2.8.8	Yokogawa .....	85
2.2.9	<i>Summary of Commercially Available Advanced Control Systems .....</i>	85
2.2.10	<i>Process Models and Simulation .....</i>	87
2.2.10.1	AspenTech .....	88
2.2.10.2	Eurotek Refining Services .....	89
2.2.10.3	KBC Advanced Technologies.....	89
2.2.10.4	Petrobras .....	90
2.2.10.5	Shell .....	90

2.2.11	<i>Summary of Commercially Available Process Models and Simulation Software</i> .....	91
2.3	PLANT OPERATIONS AND PRACTICES .....	92
2.3.1	<i>Feedstock Quality</i> .....	92
2.3.1.1	FCC Feed Contaminants.....	92
2.3.1.2	Effect of Sulfur Compounds in FCCU Feed.....	93
2.3.1.3	Impact of Adding Diesel-range Material to FCC Feedstocks.....	94
2.3.1.4	Running an RFCCU on Lighter Feeds: Maintaining Regenerator Temperature .....	95
2.3.1.5	Responding to Opportunity Crudes .....	96
2.3.1.6	Fouling Prevention for Heavy Feed Processing .....	96
2.3.1.7	Coker Naphtha Streams in FCCU Feed.....	97
2.3.2	<i>Process</i> .....	97
2.3.2.1	Optimizing Reactor Temperature .....	97
2.3.2.2	Configuration.....	98
2.3.2.2.1	Reactor Design .....	98
2.3.2.2.2	Minimizing Delta Coke .....	99
2.3.2.2.3	Benefits and Drawbacks of Oxygen Enrichment.....	100
2.3.2.2.4	Catalyst Coolers versus Quench Injection.....	101
2.3.2.2.5	FCCU-Hydrocracker Integration.....	101
2.3.2.3	Monitoring, Controls, and Modeling.....	102
2.3.2.3.1	Determining Process Efficiency with Key Performance Indicators (KPIs).....	102
2.3.2.3.2	Applying Advanced Simulation Techniques .....	102
2.3.2.3.3	Parameters for FCCU Startup Control.....	103
2.3.2.3.4	Benchmarking the Performance of Riser Termination Devices and Ecat .....	103
2.3.2.3.5	Larson Miller Parameter and Life Fraction Approach for Stress Measurement....	105
2.3.2.3.6	Monitoring FCC Slurry Exchanger Fouling.....	105
2.3.2.3.7	Controlling Naphtha Stabilizers .....	105
2.3.2.3.8	Benefits of Dynamic Modeling in FCC Operations .....	106
2.3.2.3.9	Predicting FCC Yields.....	106
2.3.2.3.10	Vapor Line Sampling .....	106
2.3.3	<i>Product Yield, Quality, and Composition</i> .....	107
2.3.3.1	Increasing Gasoline Yield.....	107
2.3.3.2	Improving Gasoline Octane.....	107
2.3.3.3	FCC Gasoline Sulfur Reduction .....	108
2.3.3.4	Characterizing Sulfur Distribution .....	109
2.3.3.5	Lowering FCC Gasoline Olefinicity.....	109
2.3.3.6	FCC Gasoline Stability.....	110
2.3.3.7	Variables Influencing Gasoline Aromatics Content .....	111
2.3.3.8	Increasing FCC LCO Production.....	111
2.3.3.9	Shifting Product Selectivity with Minimum Impact on Light Olefins Yield.....	114
2.3.3.10	Minimizing Slurry Oil Production.....	114
2.3.4	<i>Catalyst</i> .....	115
2.3.4.1	Additives for Feed Flexibility.....	115
2.3.4.2	Performance Evaluation/Catalyst Selection Method .....	116
2.3.4.3	Potential Pitfalls.....	118
2.3.4.3.1	Catalyst Losses from the FCCU .....	118
2.3.4.3.2	Catalyst Circulation Problems .....	120
2.3.4.4	Regeneration.....	121
2.3.4.4.1	Guidelines for Regenerator Design .....	121
2.3.4.4.2	Meeting Regenerator Temperature Constraints.....	122
2.3.4.4.3	Optimizing Regenerator Efficiency.....	123
2.3.4.4.4	Regenerator Combustion Mode: Effect on Contaminant Mobility and Activity ...	123

	2.3.4.4.5	Operating Partial Burn Units in Total Combustion Mode .....	124
	2.3.4.4.6	Regenerator CO Emissions Considerations .....	124
2.3.5		<i>Hardware</i> .....	125
	2.3.5.1	Main Fractionator .....	125
	2.3.5.1.1	FCCU Operating Problems: Coking, Salt Deposition, Catalyst Standpipe Hotspots, Carbonate Stress Corrosion, Fractionator Bottoms Ash .....	125
	2.3.5.2	Stripper Vessel .....	127
	2.3.5.2.1	Measuring Stripper Performance .....	127
	2.3.5.3	Auxiliary Equipment .....	128
	2.3.5.3.1	Slide Valve Failure .....	128
	2.3.5.3.2	FCCU Cyclone Dipleg Trickle Valves .....	129
	2.3.5.3.3	Valves and Withdrawal Lines: Impact of High Catalyst Withdrawal Rate .....	130
	2.3.5.3.4	Preventing Catalyst Backflow with Proper Steam and Air Distribution .....	130
	2.3.5.3.5	Improving FCC Flue Gas Turbo-Expander Reliability .....	130
	2.3.5.3.6	Expanding Air blower Capacity .....	131
	2.3.5.3.7	Replacing Refractory Material .....	132
	2.3.5.3.8	Relief Valves in the FCCU .....	132
	2.3.5.3.9	Online Cleaning of FCC Equipment .....	132
	2.3.5.3.10	Isolation Valve Considerations .....	133
2.3.6		<i>NO<sub>x</sub> and SO<sub>x</sub> Emissions</i> .....	133
	2.3.6.1	Performance of Electrostatic Precipitators Over Time .....	133
	2.3.6.2	Controlling FCC SO <sub>x</sub> Emissions .....	134
	2.3.6.2.1	FCC Variables .....	134
	2.3.6.2.2	Flue Gas Scrubber .....	135
	2.3.6.2.3	Hydrotreating .....	135
	2.3.6.3	NO <sub>x</sub> Emissions Considerations .....	135
	2.3.6.3.1	Predicting Regenerator Flue Gas NO <sub>x</sub> Emissions .....	135
	2.3.6.3.2	Effect of O <sub>2</sub> Availability and Discharge Design on Regenerator NO <sub>x</sub> Emissions .....	136
	2.3.6.3.3	NO <sub>x</sub> Reduction Additives .....	137
	2.3.6.3.4	Reducing Deposits in Selective Catalytic Reduction Units .....	137
2.3.7		<i>Reliability, Maintenance, and Turnarounds</i> .....	137
	2.3.7.1	FCCU Turnaround Frequency .....	137
	2.3.7.2	Improving Unit Reliability and Profitability .....	138
	2.3.7.3	Role of Reliability and Downtime in FCC Revamp Projects .....	140
	2.3.7.4	Staged Revamp Approach: Main Fractionator .....	140
	2.3.7.5	Revamping FCCUs for Improved Plant Performance .....	141
	2.3.7.5.1	Arpechim .....	142
	2.3.7.5.2	ConocoPhillips .....	142
	2.3.7.5.3	Hindustan Petroleum Corp. ....	143
	2.3.7.5.4	Marathon Petroleum Co. ....	144
	2.3.7.5.5	Navajo Refining Co. ....	144
	2.3.7.5.6	Sinopec .....	145
	2.3.7.5.7	Suncor Energy .....	145
	2.3.7.5.8	Total Refining .....	146
	2.3.7.5.9	Williams Refining .....	147
2.3.8		<i>Safety in the FCCU</i> .....	148
	2.3.8.1	Startup Procedure .....	148
	2.3.8.2	Emergency Shutdowns .....	148
2.4		REFINING R&D ALERT! .....	149
	2.4.1	<i>Introduction</i> .....	149
	2.4.2	<i>Light Olefins Yield Improvement</i> .....	154
	2.4.2.1	Patents .....	155
	2.4.2.2	Research .....	160

2.4.3	<i>Gasoline Yield Improvement</i> .....	161
2.4.3.1	Patents.....	161
2.4.4	<i>Gasoline Reformulation</i> .....	162
2.4.4.1	Patents.....	163
2.4.4.2	Research.....	167
2.4.5	<i>LCO Yield Improvement</i> .....	169
2.4.5.1	Patents.....	169
2.4.6	<i>NO<sub>x</sub>, SO<sub>x</sub>, CO, and PM Reduction</i> .....	170
2.4.6.1	Patents.....	171
2.4.6.2	Research.....	177
2.4.7	<i>GHG Reduction</i> .....	178
2.4.7.1	Patents.....	178
2.4.7.2	Research.....	180
2.4.8	<i>Resid and Biofeed Processing</i> .....	180
2.4.8.1	Resid Feedstock.....	180
2.4.8.1.1	Patents.....	180
2.4.8.1.2	Research.....	181
2.4.8.2	Biofeeds.....	183
2.4.8.2.1	Patents.....	184
2.4.8.2.2	Research.....	186
2.4.9	<i>Catalyst Separation and Rejuvenation</i> .....	186
2.4.9.1	Patents.....	187
2.4.9.2	Research.....	187
2.4.10	<i>Process Monitoring and Control, and Computer Modeling</i> .....	188
2.4.10.1	Monitoring and Control.....	188
2.4.10.1.1	Patents.....	188
2.4.10.1.2	Research.....	189
2.4.10.2	Computer Modeling.....	192
2.4.10.2.1	Research.....	192
2.4.11	<i>Metal Traps and Passivation</i> .....	193
2.4.11.1	Patents.....	193
2.4.12	<i>Miscellaneous: Catalysts and Processes</i> .....	194
2.4.12.1	Patents.....	194
2.4.12.2	Research.....	195
2.4.13	<i>Miscellaneous: Hardware</i> .....	196
2.4.13.1	Patents.....	196
2.5	WORLDWIDE INSTALLED CAPACITY.....	198
2.6	CONSTRUCTION.....	200
2.6.1	<i>Recent Construction Activity</i> .....	200
2.6.2	<i>Completed Construction Projects</i> .....	206
2.7	REFERENCES.....	218
<b>3.</b>	<b>Crude Distillation.....</b>	<b>245</b>
3.1	MARKET/TECHNOLOGY TRENDS & OPPORTUNITIES.....	245
3.1.1	<i>Market Conditions and Outlook</i> .....	245
3.1.1.1	Supply and Demand: Diesel vs. Gasoline.....	246
3.1.1.1.1	US.....	248
3.1.1.1.2	Europe.....	249
3.1.1.1.3	Middle East.....	250
3.1.1.1.4	Asia.....	250

3.1.1.2	Crude Capacity and Throughput .....	250
3.1.1.2.1	US .....	251
3.1.1.2.2	Canada .....	251
3.1.1.2.3	Europe .....	251
3.1.1.2.4	Middle East .....	252
3.1.1.2.5	Asia .....	252
3.1.1.3	Refinery Expansion.....	252
3.1.1.3.1	US and Canada.....	253
3.1.1.3.2	Latin America .....	254
3.1.1.3.3	Western Europe.....	254
3.1.1.3.4	Asia .....	255
3.1.1.3.5	Middle East .....	256
3.1.1.3.6	Africa .....	256
3.1.2	<i>Technology Competition, Directions, and Future Prospects</i> .....	257
3.1.2.1	Competition.....	257
3.1.2.2	Feed Variability.....	257
3.1.2.3	Product Selective Operations .....	258
3.1.2.4	Energy Efficiency .....	259
3.1.2.5	Internals and Hardware .....	259
3.1.2.6	Research and Development.....	259
3.2	STATE-OF-THE-ART TECHNOLOGY .....	260
3.2.1	<i>Introduction</i> .....	260
3.2.2	<i>Commercial Processes</i> .....	261
3.2.2.1	Foster Wheeler .....	261
3.2.2.2	KBR .....	262
3.2.2.3	Shell Global Solutions .....	263
3.2.2.4	Total/Technip-Coflexip.....	265
3.2.2.5	Uhde .....	266
3.2.3	<i>Summary of Commercial Crude Distillation Processes</i> .....	268
3.2.4	<i>Comparison of Commercially Available Advanced Control and Optimization Systems</i> .....	269
3.2.5	<i>Process Models, Simulators, and Analyzers</i> .....	270
3.3	PLANT OPERATIONS AND PRACTICES.....	274
3.3.1	<i>Alternative Approach to Crude Distillation</i> .....	274
3.3.2	<i>Feed Flexibility</i> .....	275
3.3.2.1	Heavy Crude Processing and Blending with NG Condensates.....	277
3.3.2.2	Processing High Metals Crudes .....	278
3.3.2.3	Processing High Naphthenic Acid Crudes .....	279
3.3.2.3.1	Detecting Corrosion .....	279
3.3.2.3.2	Mitigating Corrosion.....	279
3.3.3	<i>Maximizing Yield of Specific Product Cuts</i> .....	280
3.3.3.1	Catalytic Reformer Feed .....	281
3.3.3.2	Diesel .....	282
3.3.3.3	VGO.....	287
3.3.4	<i>Improving Energy Efficiency in the Crude Preheat Train</i> .....	288
3.3.4.1	Optimizing Heat Integration .....	289
3.3.4.2	Hydraulic Problems in the Preheat Train .....	290
3.3.4.3	Methods to Prevent or Reduce Fouling and Corrosion in Crude Preheat Exchangers.....	290
3.3.4.3.1	Process Design .....	292
3.3.4.3.2	Operational Adjustments .....	293
3.3.4.3.3	New Technologies .....	293
3.3.4.3.3.1	Tube Inserts.....	293
3.3.4.3.3.2	Chemical Additives .....	294
3.3.4.3.3.3	Novel Exchangers .....	295

3.3.4.3.4	Case Study .....	296
3.3.5	<i>Preflash Drum Foaming</i> .....	297
3.3.6	<i>Solving Corrosion Problems in Crude Tower Overhead Systems</i> .....	298
3.3.7	<i>Detecting Improper Operations in Distillation Towers</i> .....	302
3.3.8	<i>Developments in Structured Packing and Trays in Crude Distillation</i> .....	302
3.3.9	<i>Prevention of Packing Fires in Distillation Columns</i> .....	303
3.3.10	<i>Tray Failure brought on by Harmonic Vibrations</i> .....	305
3.3.11	<i>Atmospheric Column Key Performance Indicators</i> .....	306
3.3.12	<i>Selecting Vacuum Tower Type</i> .....	306
3.3.13	<i>Methods of Determining Vacuum Bottoms Cut Point</i> .....	307
3.3.14	<i>Vacuum Tower Best Practices</i> .....	308
3.3.14.1	Design .....	308
3.3.14.2	Operation .....	309
3.3.15	<i>Troubleshooting the Vacuum Tower and Related Systems</i> .....	309
3.3.15.1	Vacuum Overhead Ejector System .....	310
3.3.15.2	Equipment Damage .....	312
3.3.15.3	Flash Zone Quenching .....	312
3.3.15.4	Flash Zone Coking .....	313
3.3.15.5	Vacuum Tower Wash Zone .....	313
3.3.15.6	Inaccurate Tower Pressure Measurement .....	316
3.4	REFINING R&D ALERT! .....	316
3.4.1	<i>Introduction</i> .....	316
3.4.2	<i>General CDU</i> .....	319
3.4.2.1	Process .....	319
3.4.2.1.1	Patents .....	319
3.4.2.1.2	Research .....	323
3.4.2.2	Hardware .....	327
3.4.2.2.1	Patents .....	327
3.4.2.2.2	Research .....	328
3.4.3	<i>Atmospheric Tower Process and Hardware</i> .....	329
3.4.3.1	Patents .....	329
3.4.3.2	Research .....	331
3.4.4	<i>Vacuum Tower</i> .....	331
3.4.4.1	Process .....	331
3.4.4.2	Hardware .....	333
3.4.5	<i>Corrosion and Coking Inhibitors</i> .....	334
3.4.6	<i>Advanced Process Control</i> .....	337
3.4.6.1	Patents .....	337
3.4.6.2	Research .....	339
3.4.7	<i>Other</i> .....	339
3.4.7.1	Patents .....	339
3.4.7.2	Research .....	340
3.5	WORLDWIDE INSTALLED CAPACITY .....	341
3.6	CONSTRUCTION .....	344
3.6.1	<i>Recent Construction Activity</i> .....	344
3.6.2	<i>Completed Construction Projects</i> .....	351
3.7	REFERENCES .....	362
<b>4.</b>	<b>Latest Refining TEchnology Developments &amp; Licensing.....</b>	<b>371</b>
4.1	HYDROTREATING (INCLUDING HDS) .....	371
4.2	BIODESULFURIZATION (WITHOUT HYDROGEN) .....	371
4.3	HYDROCRACKING .....	371

4.4	COKING .....	372
4.5	RESID UPGRADING.....	372
4.6	HEAVY OIL, EXTRA-HEAVY OIL, AND BITUMEN UPGRADING.....	372
4.7	GASIFICATION .....	373
4.8	SULFUR PLANT .....	374
4.9	CORROSION .....	374
4.10	GAS-TO-LIQUID (OR CHEMICALS) AND COAL-TO-LIQUID (OR CHEMICALS) .....	375
4.11	BIOFUELS PRODUCTION .....	377
4.12	CO <sub>2</sub> EMISSIONS (CARBON CAPTURE AND SEQUESTRATION).....	382
4.13	SITE EMISSIONS .....	383
4.14	AUTOMOBILE ENGINE DESIGN INNOVATIONS.....	383
4.15	MISCELLANEOUS .....	384
4.16	REFERENCES.....	384