

Ethanolamines/Glycol Ethers Tier 3 Procedure

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Title: Leak checking plate exchangers
References: Glossary for equipment identification (text # 114)

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1307. Leak Checking Plate Exchangers

1.0 Objective:

1.1 To test the gasket seal on all plate exchangers prior to being put in service.

2.0 Purpose:

2.1 To prevent contamination of product with water and in the case E-244, provide for maximum efficiency with no plate by-pass.

3.0 Special Notation:

3.1 The procedure for putting E-244 in service is also good for leak checking. External leaks are of concern here, where water contamination is not a problem.

4.0 Responsibility:

4.1 It is the responsibility of the operations supervisor and the senior operations specialist to ensure that this procedure is fully complied with.

4.2 It is the responsibility of the senior operation specialist and the operation specialist to ensure that this procedure is executed in a safe and efficient manner.

5.0 Procedure:

5.1 With exchanger blocked in install a double block and bleed with a pressure gauge on the low point bleed to the product side of E-262P or E-272P. Connect nitrogen here. (air supplies to much pressure.)

5.2 Slowly pressure up the product side with nitrogen while at the same time slowly opening the water side. Bring the pressures up together to prevent gasket displacement.

5.3 After both sides are under about 40 pounds per square inch gauge, observe exchanger for leaks. (external leaks)

5.0 Procedure: Cont'd.

5.4 If exchanger leaks, try torqueing it up a little more unless gaskets are observed out of place. If gaskets are out of place the exchanger will need to be separated again for replacement of gasket(s).

5.5 If there are no leaks, put exchanger in service and periodically analyze the water content (analysis should be run every couple of hours for water to make sure that the exchanger is not leaking internally) water analysis should be $<.10\%$).

6.0 Revisions

Revision No. 1	07-20-93	Yearly Review
Revision No. 2	12-23-94	Yearly Review
Revision No. 3	12-29-95	Yearly Review