



DAK - 1960

Interoffice Communication

To Distribution

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From J. F. Alix

AUG 12 1977

Date August 11, 1977

Subject HANDLING OF MURIATIC ACID PRODUCT FROM LC VCM INCINERATOR

A meeting was held on August 9, 1977, to review the status of the options for handling the muriatic acid to be produced by the LC VCM incinerator. Attendees were:

L. N. Vernon
J. A. DeBernardi
J. J. Langford
M. D. McGee

R. D. Gamblin
B. D. Ratliff
R. W. McPherson
J. F. Alix

The attached tables and notes cover the basic information presented. The gist of this was:

1. At least initially the incinerator will not operate at "design" HCl output.
 - a. Tars have high salt content; economic solution not known.
 - b. Light ends will probably be fed at minimum rates.
 - c. Average vent rate not accurately known.
2. Current proposal from Reagent Chemical Company for purchase of product is most economic alternate.
3. All alternatives would require provision for in-plant neutralization. (Or other back-up arrangement?)
4. HCl recovery scheme would be least attractive economically. Total cost would be above budgeted funds.
5. Best schedule for HCl recovery requires at least four months of alternate disposal arrangements.

Issues and Decisions

1. Is maintenance of maximum effort on HCl recovery justified.

Decision: Put on hold. Complete Process Design work. Definitive estimate not justified at this time.

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2. Reagent have proposed to install, maintain, and operate the storage and loading facilities. They have indicated that any other type of arrangements would be equally satisfactory to them. What do we want?

Decision: It would be more desirable for CONOCO to have full control of the facility with Reagent doing the loading, only. Operating personnel should be involved in discussions with Reagent on these provisions. R. W. McPherson is handling.

3. Other aspects of commercial arrangements?

(See attached RWMcP memo.)

4. Full-rate (4800 #/hour) neutralization system for back-up may be \$1.5 MM.

Decision: Review requirements to see if there is cheaper back-up:

- a. Design throughput
- b. Incremental capacity of existing facilities
- c. Other disposal arrangements.

5. Specific plan of action and timing requirements.

(Will be issued following Project Team meeting next week.)

J. F. Almy
J. D.

/jn

Copies to:

RJA-JDB-RAC-GGG-DAK-JJL

REL-RWMcP-BDR-LNV

R. G. Gantz, PED, Ponca City

M. D. McGee

J. R. Campbell

G. L. Kreutzer, CEP, Ponca City

D. Kidd, LCCP

R. D. Gamblin, LCCP

J. A. DeBernardi, VCM, Lake Charles

G. Foshee

J. Friend

J. Holcomb

J. Gibson

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A P P E N D I X

VVC 000012059

INCINERATOR PROJECT

Design basis: 48 MM Btu/Hour, based on maximum vent flows. Burn tars and light ends for temperature maintenance and disposal. No. 1 Unit scheduled for completion July, 1978. EPA deadline October, 1978.

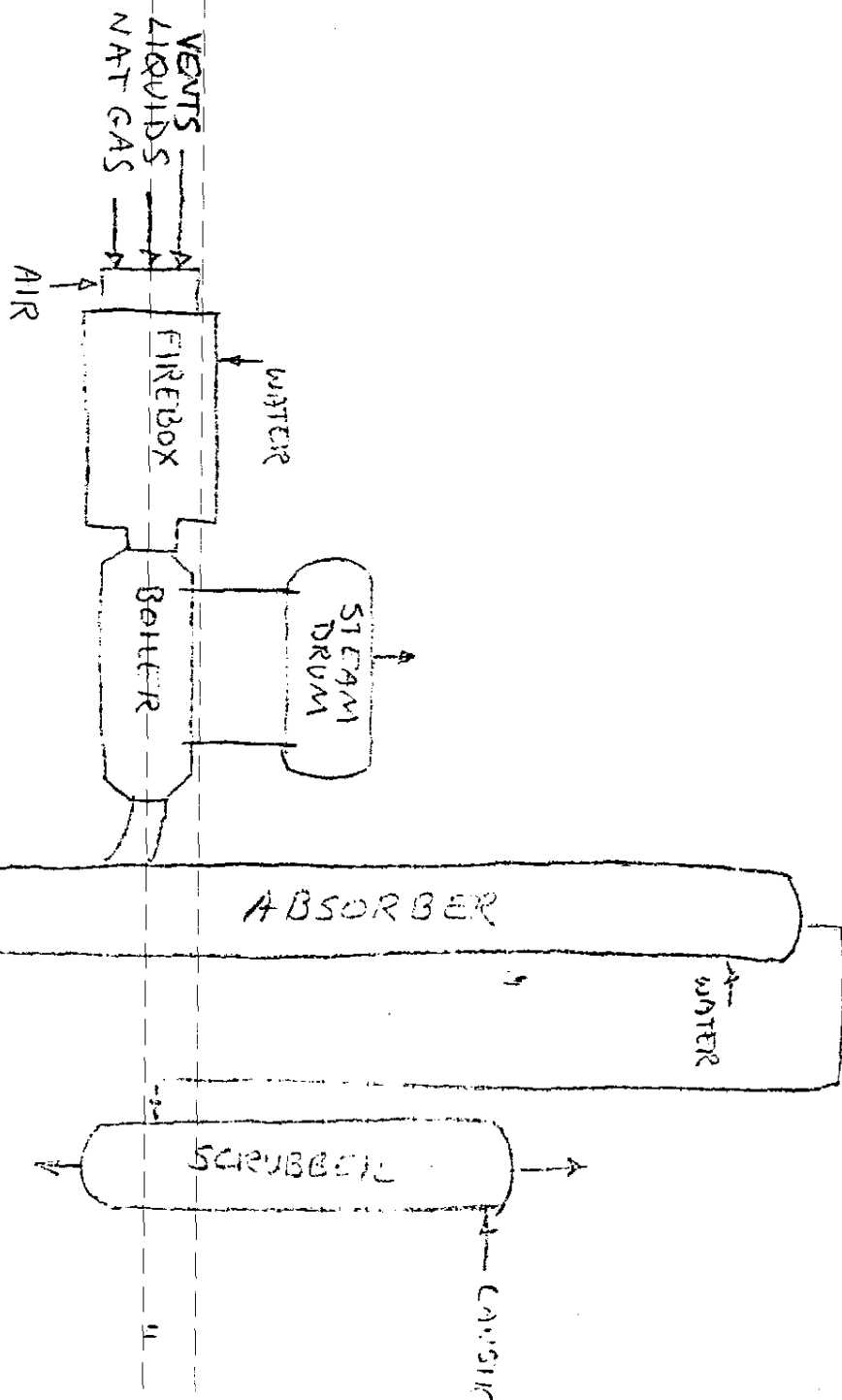
Tars have excessive salt content for burning in this incinerator. Economic solution not known.

Light ends have sales potential. Will probably not be burned over minimum required for temperature maintenance.

Throughput on this basis would be less than 50% of design.

25 Weight percent product is maximum that can be produced. At low firing rates, may be 22%. Commercial strength muriatic is 20° Be (31.5 wt. %).

LC VCM INCINERATOR



CONTAMINANTS - PHASE
 H₂ 120-240 HC 0-5
 CO 10-30 C₁ 2 15-25
 N₂ 2-10
 O₂ 5-20

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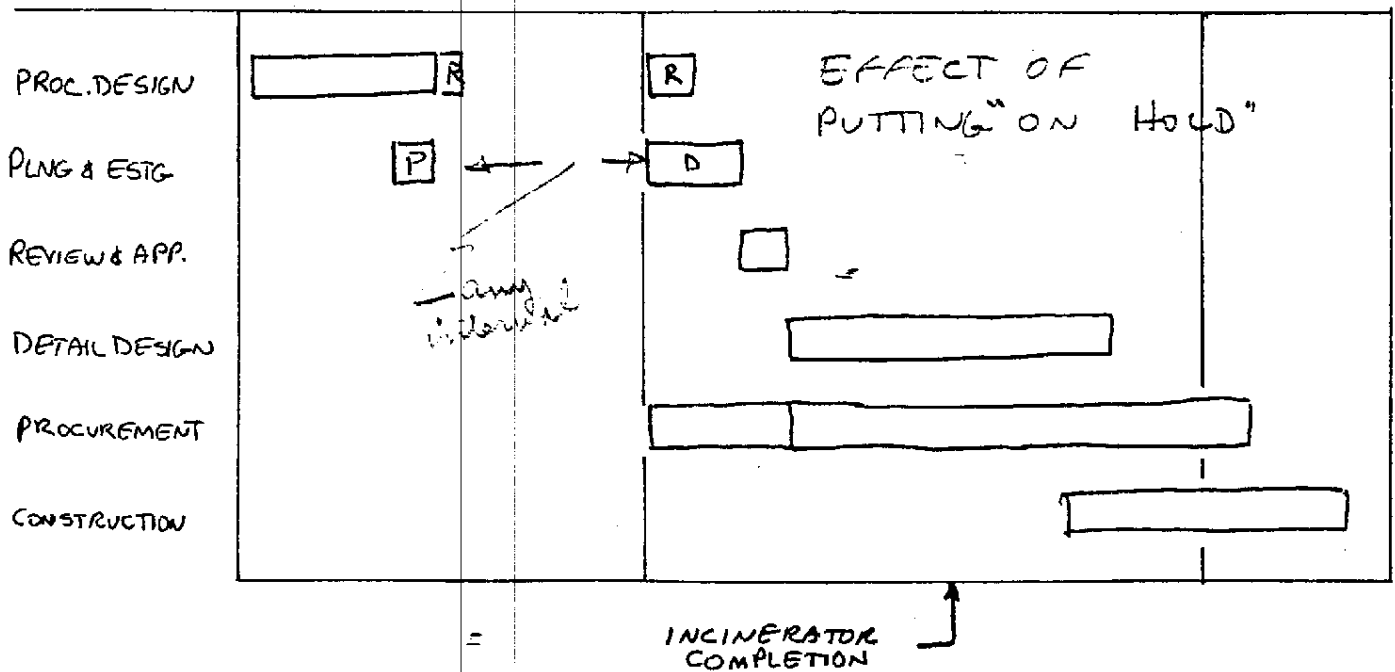
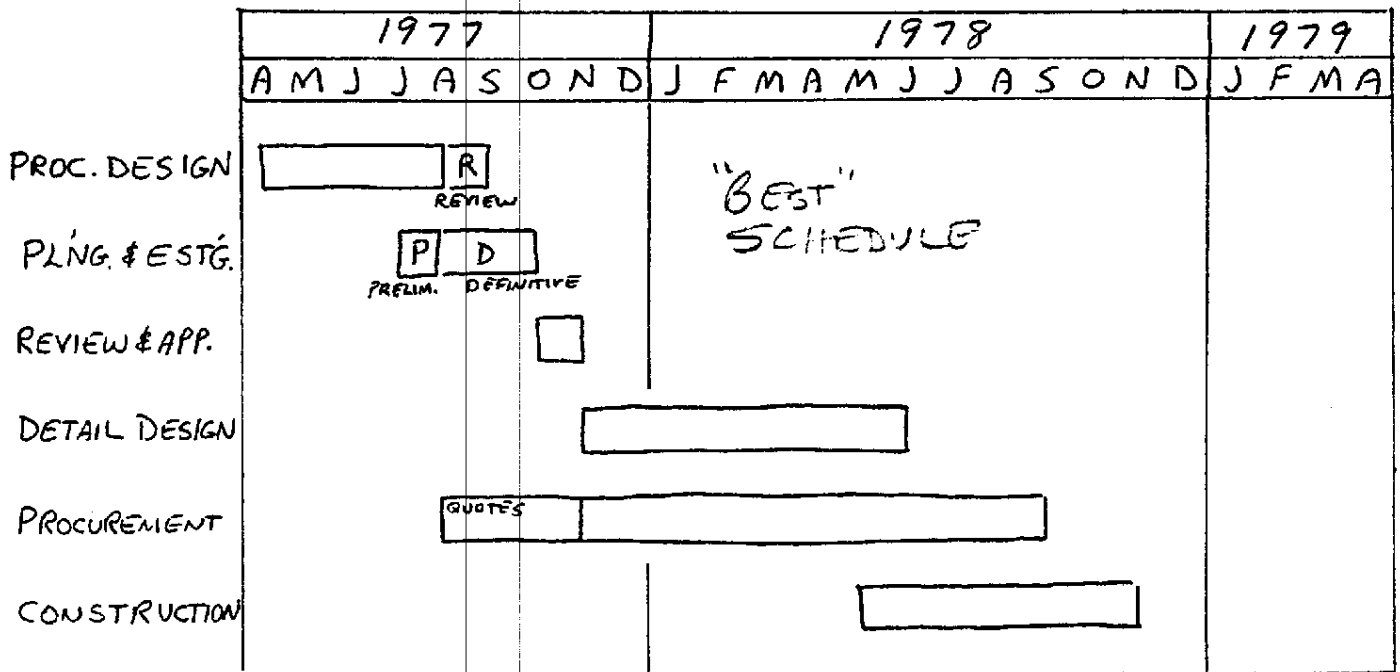
HCl Recovery

At this time of incinerator design:

- Sales not considered viable
- Neutralization costly & not desirable
- HCl recovery (to anhydrous HCl) considered ultimate solution.
- Design basis 4800^g/hr HCl
- Process Design winding up.
- Preliminary estimate \$3.8MM $\pm$ 25%
"battery limits", does not include tankage & offsites
- Budget \$3.33, including tankage
- For system producing strong muriatic only (no anhydrous),
\$2.4MM $\pm$ 25%, "battery limits".

HC2 RECOVERY PROJECT

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VVC 000012063

Sales

A market survey was commissioned,
generally optimistic on Gulf Coast
merchandise market.

Identified Reagent Chemical Co
as major factor in Gulf Coast
merchandise market.

Reagent provides "Letter of Intent":

- Take-and-pay
- 25% or 20%
- Price based on % of "market price"
- They install facilities

Turned Reagent operations
showed "profitability".

Other potential sales arrangements:
Arkla Chem.
Kaiser Chemical.