PETROLITE CORPORATION
TRETOLITE DIVISION
369 Marshall Avenue / Saint Louis, Missouri 63119
(314) 961-3500 / TWX 910-760-1660 / Telex 44-2417

January 24, 1983

Steve Reynolds
CONOCO VCM PLANT
P.O. Box 37
Westlake, LA 70669

Attention: Mr. Reynolds

We have analysis of the VCM waste from the CONOCO plant at Westlake, LA.

Element	Concentration
Sodium	13 ppm
Potassium	Nil
Lead	3 ppm
Vanadium	3 ppm
Sulfur	Nil

We have previously recommended KONTOL KI-66 for this case because of the high sodium content (relative to vanadium and lead). We can make a current recommendation, with some restrictions.

For this particular fuel, proper treatment is 0.04 gallon/1000 gallons of VCM waste, or less than a half-pint for 1000 gallons of waste. However, we understand that the contaminant (sodium) level changes a great deal from batch to batch. The ideal method is to draw a representative sample of material from each waste load, analyse for sodium, and adjust the injection rate according to the formula given on the KI-66 data sheet. A simple graph can be drawn up showing dosage or pumpstroke vs. sodium level. For example, if sodium level varies from 100 ppm to 1000 ppm, the KI-66 dosage rate will vary from 0.18 gallon to 1.8 gallon for every 1000 gallons of VCM waste.

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I must stress that the dosage rate of KI-66 is matched to the contaminant level of the fuel. Analysis and dosage adjustment must occur before the fuel is burned, or such attempts at matching dose rate to contaminant level will be useless. If CONOCO can provide rapid analysis and pump adjustment, this method will work well and most economically. If rapid analysis is not possible, the dosage rate could be set for the worst possible contaminant level; for example, 1.8 gallons KI-66 for each 1000 gallons of VCM waste (corresponding to 1000 ppm Na). This will suit until a contaminant history can be established and a dosage rate, mathematically weighted to treat most cases, can be determined. Overtreatment will cause no problem, other than using a little more additive than necessary; undertreatment could result in deposits and corrosion of refractory.

We recommend a trial be run for 2 - 4 weeks minimum, with combustion unit fireside inspection prior to and following the test period. If possible, the unit should be cleaned in order to better see the results of the trial.

Additive Requirements

Sodium Level	100 ppm	(0.18 gallon KI-66/1000 gallon waste) additive cost $2.35
Sodium Level	1000ppm	(1.8 gallon KI-66/1000 gallon waste) additive cost $23.50

KONTOL KI-66 is priced at $13.06/gallon delivered to your plant.

Injection Pump

Tretolite will provide the required injection pump. Injection of KI-66 should be as far upstream of the combustion chamber as possible. This will ensure good mixing of the additive with the waste stream.

We welcome your comments, as well as the opportunity to be of service to CONOCO VCM.

CWH 000000715

Very truly yours,

Steve Adams