



Ethanolamines 40-17-42
Glycol Ethers

Dow U.S.A.

The Dow Chemical Company
P.O. Box 400
Plaquemine, Louisiana 70765-0400

June 22, 1992

Anthony Machie
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cc: Tony Grant, 5501
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**REACTIVE CHEMICALS REVIEW FOR ETHANOLAMINES/GLYCOL
ETHERS PLANT - JUNE 17, 1992**

Project: Management of Change Review for the following:

- Review changing the location where DEA recycle is introduced into the ethanolamines reactor
- Review how the impurities in EO (especially CO₂ affects the Ethanolamines purity and how the plant plans to duplicate this with help from Glycol 2
- Review how high reactor temperature might affect the Ethanolamines purity. Currently max. reactor temperature is approximately 110 deg C and ASPEN predicts that plant can run at 130 deg C maximum.

Committee Members present: Joe Schell, John Monroe and Gerald Wagener

Project rep: Anthony Machie

Concerns:

1. Concerning the "impurities in EO" test: a maximum safe operating pressure for T-240 should be established and if exceeded the test should be aborted. Monitor rate of pressure rise as a means of detecting air leaks into the system.

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2. Concerning the "high reactor temperature" test: Don't by-pass the current high reactor trip temperature. If this is anticipated, ARC data with appropriate interpretation should be reviewed to determine if a reactive chemicals hazard will exist.

Please respond in writing to the committee chairman within one month as to action taken or planned in regard to these concerns.



Gerald Wagener, Chairman
Reactive Chemicals Committee