



UNION CARBIDE CORPORATION

LINDE DIVISION

3839 WEST ALABAMA, P. O. BOX 22127, HOUSTON, TEXAS 77027

February 5, 1970

Mr. R. H. Gerlach,
Chief Process Engineer
Continental Oil Company
Petrochemical Department,
VCM Plant
P. O. Box 605
Westlake, Louisiana

Aug. actual Price -
Feb. 5th
1 MM = 4.25/1000 4.00
1.5 MM = 4.17/1000 3.80
3.4 MM = 3.37/1000 3.80

Rev. Pricing
Feb. 5th

0.5 MM → \$4.25/1000
1 MM → \$3.85/1000
1.5 MM → \$3.55/1000
3.4 MM → \$3.15/1000

Dear Mr. Gerlach:

Mr. J. L. Baker has informed us of his visits with you November 20, and December 10, 1969, when you discussed your bulk nitrogen requirement for purging ships. We are pleased to quote on this requirement as follows on a three year contract:

(1) We will put a high volume pumper and operator on the jobs for 24 hours each job. This will assure continuity of purging at flow rates of 150,000 to 210,000 scf per hour.

(2) All nitrogen pumped during each separate ship purge operation will be billed at this schedule:

Quantity (In Cubic Feet Pumped)		Price Per 100 Cu.Ft. Delivered	
First	500,000 or fraction thereof	Now \$-.45	
Next	500,000 or fraction thereof	25.00 -.40	
All Over	1,000,000	29.00 -.30	(and so on at this rate)

In the event our pumps are called to the job and no service is performed for reasons of decisions by Continental Oil Company, and through no fault of Linde, a minimum (take or pay) charge for 100,000 cubic feet plus \$25.00 per hour stand-by pumper charge will be made after eight free hours.

Charged to:
0 to 250,000
250 to 500,000
500 to 1 MM
above 1 MM →

45¢
40¢
35¢
20¢

CCR 000032566

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Continental Oil Company
Westlake, Louisiana

(3) The above price schedule for nitrogen is based on a maximum of 24 hours on location for each job. Holdover of equipment and personnel for reasons not attributable to Linde personnel and/or equipment would be provided at the rate of \$25.00 per hour.

Our facilities will include the necessary high pressure hose required for pumping the nitrogen from our pumper parked on the dock to your 6" line to the ship. Our equipment also would include the necessary meters, pressure gauges and controls to accurately measure the volume of nitrogen delivered and to control flow rate and pressure.

Our terms are net 10th prox. We would anticipate at least five days advance notice of the expected arrival date of each ship and that we would be given the exact arrival time and location for our pumper on not less than 24 hour advance notice.

Mr. Gerlach, we believe we can give you the type of pumping equipment and high pressure dry nitrogen you need for performing this purging operation in the most economical as well as the most satisfactory manner. Mr. Baker will expect to discuss further details of our service at your convenience.

Very truly yours,

UNION CARBIDE CORPORATION
Linde Division



Manager, Southwest Region
Gas Products Sales

T. H. Cable, Jr./sld

CCR 000032567



UNION CARBIDE CORPORATION

LINDE DIVISION

3839 WEST ALABAMA, P. O. BOX 22127, HOUSTON, TEXAS 77027

December 9, 1969

Revision

Mr. R. H. Gerlach,
Chief Process Engineer
Continental Oil Company
Petrochemical Department,
VCM Plant
P. O. Box 605
Westlake, Louisiana

Dear Mr. Gerlach:

Mr. J. L. Baker has informed us of his visit with you on November 20, 1969 when you discussed your bulk nitrogen requirement for purging ships. We are pleased to quote on this requirement as follows:

(1) We will put two high volume pumpers and operators on the jobs for 24 hours each job. This will assure continuity of purging at flow rates of 150,000 to 300,000 scf per hour.

Each unit - 250,000 scfh.

(2) All nitrogen pumped during each separate ship purge operation will be billed at this schedule:

Quantity (In Cubic Feet Pumped)		Price Per 100 Cu.Ft. Delivered
First	1,000,000 or fraction thereof	\$.50
Next	1,000,000 or fraction thereof	\$.375
All Over	2,000,000	\$.30

avg. cost = \$38.2 / 1000

for 39 MM = total = \$12,950

In the event our pumpers are called to the job and no service is performed for reasons of decisions by Continental Oil Company, and through no fault of Linde, a minimum (take or pay) charge for 200,000 cubic feet plus \$25.00 per hour stand-by pumper charge will be made. *100* *per truck*

(3) The above price schedule for nitrogen is based on a maximum of 24 hours on location for each job. Holdover of equipment and personnel for reasons not attributable to Linde personnel and/or equipment would be provided at the rate of \$25.00 per hour. *2 trucks on jobs over 1 MM ft³*

Our facilities will include the necessary high pressure hose required for pumping the nitrogen from our pumper parked on the dock to your 6" line to the ship. Our equipment also would include the necessary meters, pressure gauges and controls to accurately measure the volume of nitrogen delivered and to control flow rate and pressure.

Requires 2" flg. conn. within 30' of truck

*5% discount if a 3 yr. contract
Renegotiated after 1 yr.*

2nd cost =

*34 MM = 3.62
1.5 MM = 4.46
1.0 MM = 4.75*

*350
3.80
4.00*

CCR 000032568

Page 2
Continental Oil Company
W stlake, Louisiana

Our terms are net 10th prox. We would anticipate at least five days advance notice of the expected arrival date of each ship and that we would be given the exact arrival time and location for our pumper on not less than 24 hour advance notice.

Mr. Gerlach, we believe we can give you the type of pumping equipment and high pressure dry nitrogen you need for performing this purging operation in the most economical as well as the most satisfactory manner. Mr. Baker will expect to discuss further details of our service at your convenience.

Very truly yours,

UNION CARBIDE CORPORATION
Linde Division



Manager, Southwest Region
Gas Products Sales

T.H. Cable, Jr. /ph

CCR 000032569

J. D. Minott

Dept. ☒ Process Engineering

SIGNED

J D Month

CCR 000032570

Mr. Koppfauver - Kampstead
713-497-1572 - Nitrogen Svc.
Company

Days - 726-9116
713-781-0318

NA
713-NA-1-0050 - Leginal Tanks
Dispatches

5-882-0550-051 - Toll Call
by Mr.

RHG. 477-8005

Mr. Koppfauver, 02
Mr. Dlass
713-781-0318 - Nitrogen Svc. Co.
713-781-0318 - Nitrogen Svc.

Days 713-621-1000

Notes 713-781-3611 - Am. Svc.
NA 1-1000

CCR 000032571

SUBJECT

N₂ Purging of VCM Ships

DATE

2/20/70

1-81X3

~~Bob Hyberg~~~~Debs Samplin~~

FROM

Dept.

Process Engineering

MEMO

The results of purging the "Humboldt" on 2/20/70 show that our present 2" N₂ connection & pipe is too small to allow proper purging. Please have a 4"-300psig valve installed on the top of the 6" Sundyne Compressor suction line and put a 4" tee with 2" screwed ends on top of the valve. If this can be done by Thursday, 2/26/70, it will save us about 10 hrs of ship demurrage time. SIGNED J. Minott

REPL

DATE

Locate valve just behind the present 2" N₂ valve if possible (due East). A gate or ball valve is fine.

~~287-74~~
- 14 - 0000 m
08611 - 0801 - 387 - 23 - 0000 L

Complete
JCB

SIGNED

CCR 000032572

RECEIVER'S COPY

N₂ Purging of VCM Ships

2/20/70

1-8123

M
C
F

JDM

Bob Hybarger
Debra SamplinT
O

J. Minott

Dept.

Process Engineering

M
E
M
O

The results of purging the "Humboldt" on 2/20/70 show that our present 2" N₂ connection + pipe is too small to allow proper purging. Please have a 4"-300psig valve installed on the top of the 6" Sundyne compressor suction line and put a 4" tee with 2" screwed ends on top of the valve. If this can be done by Thursday, 2/26/70, it will save us about 10 hrs of ship demurrage time.

SIGNED

J. Minott

R
E
P
L

DATE

Locate valve just behind the present 2" N₂ valve if possible (due East). A gate or ball valve is fine.

CCR 000032573

SIGNED

RETURN THIS COPY TO SENDER

from

J. D. MINOTT

Feb. 12, 1970

To Humboldt

4500 MHz ≥ 10 , recall. = 2 of them

Finalize volume = $45,00 \text{ m}^3 \text{ H}_2\text{O}$ + $49,00 \text{ m}^3 \text{ VCN}$

Find $\frac{d}{dx} \sin^{-1} x$ when $x = \frac{1}{2}$

... ..

... ..

$\angle A = 50^\circ$

$$\frac{27,400}{10,000} \times \frac{1}{100} = 2,740 \text{ ppm. or } \mu\text{mole/l. KM}$$

1. μ is acceptable time to the ma.

[Faint handwritten notes at the bottom of the page]

will take about 4.5 cycles at 53 giving tank process.

- 17 volumes of *Conte*

$10,560(17) = 2,07 \text{ MM} \quad \text{K}3 = 9,200$

(b). Sp. vol. comes in with air + B.D. under 2%
185 - 10 to 2.93% - B.D.

need 7.5 volumes (O_2 to 0.93% - BV to 265 ppm)

$$1,500(7.5) = 1.35 \text{ MM ft}^3 = 4900$$

CCR 000032574

⁸¹
 1st Purge - 1 volume BD 100% 0.01% BD
 4.76 Vol. N₂ 3.76

2nd Purge - 4.4% BD

3rd Purge - 0.925% BD

4th Purge - 0.195% BD

5th Purge - 0.041% BD = 416 ppm.

3.76 x 5 = 18.8 volumes for 5 cycles

3.76 x 4.5 = 16.9 volumes for 4.5 cycles

CCR 000032575)

To *Ed. Segundo*

DATE

2/9/70

TIME

1969 *Perry's* *Isba*

WHILE YOU WERE OUT

Mt.
Mts.
Miss*atlantic - 150,000 ft³ - 50¢/100**2 tanks 606,000 ft³ - 40¢/100**3 units milage chg. 112 miles -**etc by time - 21 hrs.*

PHONE

\$15.00/hr.

TELEPHONED		CALLED TO SEE YOU		WANTS TO SEE YOU	
PLEASE CALL HIM		WILL CALL AGAIN		RUSH	

REMARKS *201-P45-3800**Bermuda.**150,000 - 50¢/100**203,850 - 40¢/100*

SIGNED

CCR 000032576

J Minott - 478-3086

2/28/70

1830 through inspecting tanks

1915 have sample connections for
head gas hooked up - writing on
N₂ trailer

2030 lining up valves to N₂

2040 start N₂ flowing to tank

2110 start N₂ flowing to tank

2155 depressed N₂ tank

2205 tank #3 35 P.S.I.G.

2225 start purge #5

2247 #2 tank pressure down

2255 #5 tank pressure down

2305 #5 tank pressure down

2330 #1 tank pressure down

2400 #1 tank pressure down

2400 #3 tank 35" going to tank

2420 #5 tank 35" going to tank

0030 #1 tank pressure down

0040 #1 tank pressure down

0050 #3 tank pressure down

0110 #5 tank pressure down

0116 sample #1 tank

0122 sample #3 tank

0140 sample #5 tank

Had to purge 30 min get 2 samples to get in shape OK.

CCR 000032577

A sphere - 52°F B sphere - 57°F

Pumping at 1300 at start - down to 1150 by noon

Comp. Suction steamer plugged - at 10 AM - Steel Vent Rec. at 9 AM. ship up to 35 psig
Seal apparently gone on Sunolene Comp.

Tank #1 = 1.04 O₂

#3 .77 O₂

#5 1.08 O₂

from

J. D. MINOTT

Feb 6, 1970

To

avg. cost/100 ft³
Nowak V.C.

~~Est~~ Volume

	→ 0.5	5.56%
4.00	→ 1.0	3.90%
3.85	→ 1.5	7.05%
3.80	→ 3.4	20.8%
3.80	→ 3.15	

3.4 MF Y.B.

11,900 - Nowak
10,150 - V.C.
1,750 diff.
2,400 diff. = 11.5%

1.5 MF Y.B.

5,700 - Nowak
5,320 - V.C.
380

1.1 MF Y.B.

3,250 - V.C.
1,500 diff.

CCR 000032579

from

J. D. MINOTT

,19

To

Price /1000sf - based on 24 hrs time
and 3.4 MM ft³ (std.)

V.C. - ~~\$3.15~~
3.81 less 5% = \$3.62 by 3 yrs. contract

Nowaco - ~~3.80~~ - Revised to \$3.80 by 3 yrs. contract.

airco. - 4.04

Duff O. - 5.80

Price /1000sf - based on 24 hrs. time and
10 MM ft³ (std.)

V.C. - \$5.00 less 5% = \$4.75

Nowaco - \$4.00

airco. - \$6.00

Duff O. - \$6.10

based on 24 hrs. + 1.5 MM ref.

V.C. - 4.75 less 5% = 4.51

Nowaco - \$3.80/1000

CCR 000032580

from

J. D. MINOTT

19

To Purging Lines for Ship's

3,000 scfm/truck 333 Min.

$$\begin{array}{r} 6000 \\ \times 5 \\ \hline 30000 \\ \times 3 \\ \hline 18000 \\ \hline 30000 \\ \times 3 \\ \hline 90000 \\ \times 3 \\ \hline 270000 \\ \times 3 \\ \hline 810000 \\ \times 3 \\ \hline 2430000 \\ \times 3 \\ \hline 7290000 \\ \times 3 \\ \hline 21870000 \\ \times 3 \\ \hline 65610000 \\ \times 3 \\ \hline 196830000 \\ \times 3 \\ \hline 590490000 \\ \times 3 \\ \hline 1771470000 \\ \times 3 \\ \hline 5314410000 \\ \times 3 \\ \hline 15943230000 \\ \times 3 \\ \hline 47829690000 \\ \times 3 \\ \hline 143489070000 \\ \times 3 \\ \hline 430467210000 \\ \times 3 \\ \hline 1291401630000 \\ \times 3 \\ \hline 3874204890000 \\ \times 3 \\ \hline 11622614670000 \\ \times 3 \\ \hline 34867844010000 \\ \times 3 \\ \hline 104603532030000 \\ \times 3 \\ \hline 313810596090000 \\ \times 3 \\ \hline 941431788270000 \\ \times 3 \\ \hline 2824295364810000 \\ \times 3 \\ \hline 8472886094430000 \\ \times 3 \\ \hline 25418658283290000 \\ \times 3 \\ \hline 76255974849870000 \\ \times 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