

ETHANOLAMINES/GLYCOL ETHERS TIER 3 PROCEDURE

Section Number: 217
Issue Number: 1.3
Original Date: 10-10-92 **Author:** Terry Pellowski
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Title: Loss of Oxide to R-201 for 1 to 4 hours
References: Glossary for Equipment Identification (Text #114)

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217. Loss of Oxide to R-201 for 1 to 4 Hours

1.0 Objective:

- 1.1 To stabilize R-201 for a short period of time during a loss of oxide.

2.0 Responsibility:

- 2.1 It is the responsibility of the operations supervisor and the senior operations specialist to ensure that this procedure is fully complied with.
- 2.2 It is the responsibility of the senior operations specialist and the operations specialist to ensure that this procedure is executed in a safe and efficient manner.

3.0 Special Notation:

- 3.1 Call Glycol II to find out what problems caused the loss of oxide and what the duration of the loss of flow may be. If the loss is expected to fall into the above range, the following procedure can be used to stabilize the amine's reactor until the flow can be restored.

4.0 Procedure:

- 4.1 Warm up the 30 pound steam line to R-201. After the shell temperature drops to 70 degrees, start heating R-201 shell.
- 4.2 Reduce the aqua ammonia flow to R-201.(discretion of boardman)
- 4.3 Switch T-240 bottoms to DV-243A and reduce feed to T-250. Increase the 475 pound steam to E-250 to make up for T-240 bottoms heat loss.
- 4.4 Switch T-230 bottoms to the recycle line and block T-230 bottoms to T-240.

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Page 1 Of 2

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- 4.5 Monitor oxide line for excessive pressure and temperature. If it pressures up, open the emergency block valve into MX-201 and relieve the pressure then drop solenoids again.
- 4.6 When Glycol II is ready and oxide can be restored, proceed with startup slowly. (Be careful not to come back too quickly, reaction will have to be established slowly.)
- 4.7 Start up T-240 and return bottoms to DV-243B when dry.

5.0 Revisions:

Revision no. 1	06-10-93	yearly review
Revision no. 2	12-19-94	yearly review
Revision No. 3	12-29-95	Yearly Review