

Basic Guide to Pipeline Compressor Stations

By Saad Mokhtab, Greg Lamberson and Sidney Pereira dos Santos

As natural gas moves through a pipeline, the pressure decreases due to friction of the gas along the pipe wall and the gas must be recompressed to maintain the flow. Gas compressor stations are installed at optimum locations along the pipeline as the load profile changes and are sized to sufficiently boost the gas pressure and maintain flow through the pipeline. Compressor stations may be small, situated on gathering lines (Figure 1) or laterals, or large on major trunk line transmission systems. However, all are built up from the same functional blocks of equipment. Each functional element (Figure 2) plays a role in the work of the station and the design and sizing of each is essential to the efficient and safe operation of the plant.

The functional elements include gas scrubbing and liquid removal, compressor and driver

units, aftercoolers, pipes and valves. Controls — including Supervisory Control And Data Acquisition (SCADA) system, monitoring and data recording, alarms and shut down procedures, both routine and emergency — are an integral part of the station. Provision also has to be made for venting the compressor and driver housing and buildings, complete with ventilation and fire protection, and safety equipment.

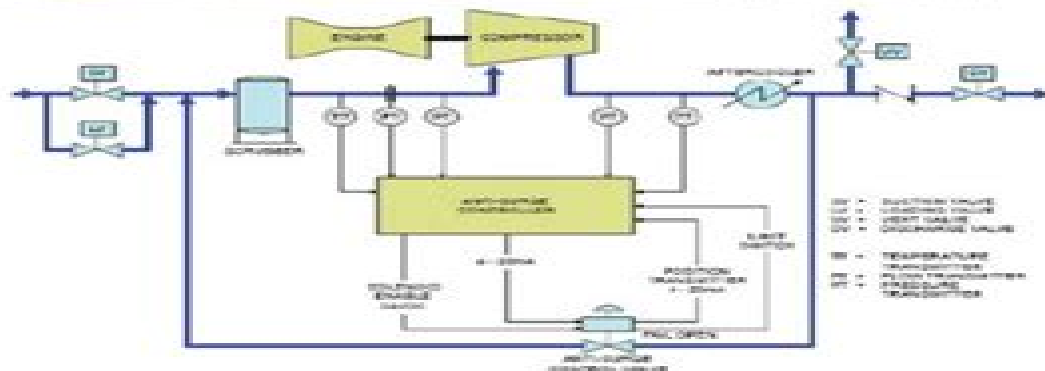
The financial elements include cost-of-service calculations which include the installed cost of the equipment, fuel, maintenance and operating costs for the expected project life (typically 10 – 25 years). A risk simulated discounted-cash-flow (IDCF), rate-of-return (ROR) method of investment (Saetos, 2003) analysis is recommended. Fuel cost is the major item in this calculation and the projection for escalation forms an important consideration and must be included in the risk simulation analysis.

Inlet Receiving

The gas in a main transmission line is nominally clean and dry while that in gas gathering lines may contain liquids prior to processing, but in all cases there can be entrained liquids.

Figure 1:
Cabiunas Terminal - Onshore
Gas Gathering Compressor
Station. (source: PETROBRAS -
Rio de Janeiro - Brazil)

Figure 2:
Typical Compressor
Station P&I Diagram
(Mishra et al. 2007)



and particulates which have to be removed before compression to maintain efficiency and stability. Efficient and safe handling of the liquids collected from the scrubbers in a compressor station is one of the keys to a good design. Individual scrubbers (with or without standby unit) may be installed for each stage of compression for each compressor unit.

A common scrubber should be considered for multiple units on a common section line. Filter/separators may also be used to remove smaller liquid droplets and/or solid particles. In the case of reciprocating compressors being used in the transmission system a coalescer filter is of capital importance to guarantee that cylinder lubricating oil will not enter the pipeline and affect gas specification. Poor handling of these liquids can be the major source of operating and maintenance problems and have a significant impact on station economics. The section scrubber should be equipped with mesh type mist elimination section to avoid liquid entrainment into the compressor. Scrubbers can take several forms, inertial — with or without demister pads — or the horizontal cyclonic type. The latter are commonly used on mainline transmission stations.

There are three main concerns that should be addressed in the liquid-handling design for any compressor station: safety, environmental impact, and economics. Another consideration should be operability, which includes issues like hydrate formation (when water is present in the gas composition), failure consequences, etc.

The gas compressor station's inlet receiving facilities consist of "pig" receivers and a slug catcher to remove large solid and liquid contaminants followed by filter coalescers to remove fine solids and hydrocarbon mist. A filter coalescer also cleans the gas in each fuel supply to the turbines and gas engines. Removed liquids flow to a hydrocarbon storage tank where they are separated by gravity and then transported by truck as saleable hydrocarbon liquid or disposed of as waste product.

Design Pressures

The design pressure for station gas piping should at least equal the MAOP of the pipeline. For single-stage stations, the suction and discharge piping should have the same design pressure. For multi-stage stations, the suction piping design pressure should at least equal the highest attainable suction pressure under all operating and startup modes, and the interstage and discharge piping design pressures should at least equal the maximum discharge pressure. Multipressure systems must be designed to ensure that each system is not over-pressured during normal operation and is protected to the appropriate pressure level during upset conditions.

It is a general rule to use design pressures to accommodate use of a standard ANSI Class rating for compressor station piping components. The cost to increase design pressure to a standard ANSI Class is minimal and will provide greater flexibility in future use of the equipment and materials.

Compression

The gas pressure in the pipelines is increased by a combination of one or more compressors connected in parallel or in series to the

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Handbook of Natural Gas Transmission and Processing Saeid Mokhatab, William A. Poe, John Y. Mak, 2015-02-14 Written by an internationally recognized author team of natural gas industry experts the third edition of Handbook of Natural Gas Transmission and Processing is a unique well documented and comprehensive work on the major aspects of natural gas transmission and processing Two new chapters have been added to the new edition a chapter on nitrogen rejection to address today's high nitrogen gases and a chapter on gas processing plant operations to assist plant operators with optimizing their plant operations In addition overall updates to Handbook of Natural Gas Transmission and Processing provide a fresh look at new technologies and opportunities for solving current gas processing problems on plant design and operation and on greenhouse gases emissions It also does an excellent job of highlighting the key considerations that must be taken into account for any natural gas project in development Covers all technical and operational aspects of natural gas transmission and processing in detail Provides pivotal updates on the latest technologies applications and solutions Offers practical advice on design and operation based on engineering principles and operating experiences

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stands as an engaging primer for students professionals and citizens eager to understand how CCS can help secure a sustainable future for the planet **Moody's Manual of Investments, American and Foreign** ,1928 Natural Gas Processing Alireza Bahadori,2014-05-05 Natural gas is considered the dominant worldwide bridge between fossil fuels of today and future resources of tomorrow Thanks to the recent shale boom in North America natural gas is in a surplus and quickly becoming a major international commodity Stay current with conventional and now unconventional gas standards and procedures with Natural Gas Processing Technology and Engineering Design Covering the entire natural gas process Bahadori's must have handbook provides everything you need to know about natural gas including Fundamental background on natural gas properties and single multiphase flow factors How to pinpoint equipment selection criteria such as US and international standards codes and critical design considerations A step by step simplification of the major gas processing procedures like sweetening dehydration and sulfur recovery Detailed explanation on plant engineering and design steps for natural gas projects helping managers and contractors understand how to schedule plan and manage a safe and efficient processing plant Covers both conventional and unconventional gas resources such as coal bed methane and shale gas Bridges natural gas processing with basic and advanced engineering design of natural gas projects including real world case studies Digs deeper with practical equipment sizing calculations for flare systems safety relief valves and control valves

Pipeline Risk Management Manual W. Kent Muhlbauer,2004 Here's the ideal tool if you're looking for a flexible straightforward analysis system for your everyday design and operations decisions This new third edition includes sections on stations geographical information systems absolute versus relative risks and the latest regulatory developments From design to day to day operations and maintenance this unique volume covers every facet of pipeline risk management arguably the most important definitely the most hotly debated aspect of pipelining today Now expanded and updated this widely accepted standard reference guides you in managing the risks involved in pipeline operations You'll also find ways to create a resource allocation model by linking risk with cost and customize the risk assessment technique to your specific requirements The clear step by step instructions and more than 50 examples make it easy This edition has been expanded to include offshore pipelines and distribution system pipelines as well as cross country liquid and gas transmission pipelines The only comprehensive manual for pipeline risk management Updated material on stations geographical information systems absolute versus relative risks and the latest regulatory developments Set the standards for global pipeline risk management

Alaska Natural Gas Transportation System Final Environment Statement--North Border United States. Bureau of Land Management,1976

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