



## CHEMICAL MANUFACTURER REDUCES RISK OF FACILITY DAMAGE WITH REMOTE MOUNT CAPABILITY

### Customer

Major Chemical Manufacturer in North America

### Application

Level measurement on coalescer filter separator in co-generation facility

### Challenge

A coalescer filter separator in a co-generation facility is used to separate liquid from natural gas prior to entering the gas turbine. During the primary stage of separation, large particulate and liquid are removed by gravitational force and upward gas drag force. Complete separation is achieved as the process passes through the coalescing filter, which pulls away any remaining liquid to the outside of the filter. From there, the liquid drains down to the lower collection chamber. Because liquid in the separator is atypical, a high level switch provides indication and monitoring of level within the separator. In the event of a high level condition, the separator is drained to prevent natural gas with liquid content from entering the gas turbine. Liquid within the turbine could cause severe turbine damage.

In this particular facility, the coalescer filter separator is at the end of the gas transmission line. Low areas within the transmission line were gathering oil and water. Consequently, gas carried to this co-generation facility contained abnormal amounts of oil and water. In addition, the existing level switch failed to indicate the rising level in the separator. Eventually, the level exceeded separator capacity and wet natural gas entered the turbine, resulting in catastrophic turbine damage and production loss. Estimated costs to the co-generation facility exceeded \$15 million, causing the engineers on site to re-evaluate the existing instrumentation and identify a more robust solution.

### Results

- Reduced risk of catastrophic turbine damage
- Provided higher accuracy
- Reduced maintenance time

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## Solution

The facility turned to Emerson for a solution that would provide optimal control of the level in the separator and redundancy for safety. The solution had to provide an extremely reliable and highly accurate measurement with at-grade indication and ease of access for technicians.

After significant evaluation, an instrumentation solution was proposed:

- Three Rosemount™ 3051S Pressure Transmitters with direct mount flush flanged seals installed at the very bottom of the separator to measure level in the collection chamber. A redundancy voting scheme (2 out of 3 must agree) would be used as an added safety precaution.
- One Rosemount™ 3051S Differential Pressure Transmitter with dual flush flanged seals installed across the filter to identify clogging (rising differential pressure indicates the filter is clogging.)
- Three Rosemount™ 3051S Pressure Transmitters with direct mount seals installed several feet from the bottom of the separator to measure the level of the coalescing filter (2 out of 3 must agree voting scheme).
- Remote mount LCD display and interface on all seven transmitters for local indication at grade and ease-of-use for instrument technicians.

Because of the critical nature of this measurement and the need to prevent future occurrences of turbine damage, redundant transmitters were used on all level measurements. If two out of three transmitter outputs do not agree, separator level is checked immediately and any necessary action taken.

The 316L SST hermetically sealed SuperModule Platform protects the 3051S electronics from moisture and field contaminants, providing superior reliability in the harshest environments.

To bring the transmitter to grade level, remote seal capillaries were considered. However, Instrument Toolkit™ performance calculations provided proof that capillary runs did not meet the performance requirements of this application. This indicated a perfect opportunity to use the 3051S remote mount LCD display and interface capabilities.

Rosemount 3051S SuperModule Platform protects the electronics from moisture and field contaminants, providing superior reliability.



*Coalescer separator with remote mount display.*

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Direct mount FFW seals with Rosemount™ 3051S Ultra Performance and remote mount LCD display & interface provided the optimal solution. Separator level is now being properly controlled and future occurrences of turbine damage due to level excursions are highly unlikely.

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*At-grade indication allows ease of access for technicians.*

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