

# Contents

## Preface — VII

## Preface to the 2<sup>nd</sup> edition — IX

### 1 Engineering projects — 1

- 1.1 Process engineering activities — 1
- 1.2 Realization of a plant — 8
- 1.3 Cost estimation — 18

### 2 Thermodynamic models in process simulation — 25

- 2.1 Phase equilibria — 27
- 2.2  $\varphi$ - $\varphi$ -approach — 32
- 2.3  $\gamma$ - $\varphi$ -approach — 40
  - 2.3.1 Activity coefficients — 40
  - 2.3.2 Vapor pressure and liquid density — 49
  - 2.3.3 Association — 54
- 2.4 Electrolytes — 56
- 2.5 Liquid-liquid equilibria — 59
- 2.6 Solid-liquid equilibria — 62
- 2.7  $\varphi$ - $\varphi$ -approach with  $g^E$  mixing rules — 64
- 2.8 Enthalpy calculations — 66
- 2.9 Model choice and data management — 69
- 2.10 Binary parameter estimation — 73
- 2.11 Model changes — 75
- 2.12 Transport properties — 76

### 3 Working on a process — 81

- 3.1 Flowsheet setup — 82
- 3.2 PID discussion — 92
- 3.3 Heat integration options — 97
- 3.4 Batch processes — 105
- 3.5 Equipment design — 109
- 3.6 Troubleshooting — 110
- 3.7 Dynamic process simulation — 113
  - 3.7.1 Basic considerations for dynamic models — 115
  - 3.7.2 Basics of Process Control for Dynamic Simulations — 118

### 4 Heat exchangers — 127

- 4.1 Something general — 127
- 4.2 Shell-and-tube heat exchangers — 129

|          |                                                         |            |
|----------|---------------------------------------------------------|------------|
| 4.3      | Heat exchangers without phase change —                  | 130        |
| 4.4      | Condensers —                                            | 141        |
| 4.5      | Evaporators —                                           | 143        |
| 4.6      | Plate heat exchangers —                                 | 152        |
| 4.7      | Double pipes —                                          | 154        |
| 4.8      | Air coolers —                                           | 154        |
| 4.9      | Fouling —                                               | 156        |
| 4.10     | Vibrations —                                            | 158        |
| <b>5</b> | <b>Distillation and absorption —</b>                    | <b>163</b> |
| 5.1      | Thermodynamics of distillation and absorption columns — | 166        |
| 5.2      | Packed columns —                                        | 168        |
| 5.3      | Maldistribution in packed columns —                     | 179        |
| 5.4      | Tray columns —                                          | 181        |
| 5.5      | Comparison between packed and tray columns —            | 201        |
| 5.6      | Distillation column control —                           | 203        |
| 5.7      | Constructive issues in column design —                  | 208        |
| 5.8      | Separation of azeotropic systems —                      | 211        |
| 5.9      | Rate-based approach —                                   | 214        |
| 5.10     | Dividing wall columns —                                 | 216        |
| 5.11     | Batch distillation —                                    | 219        |
| 5.12     | Troubleshooting in distillation —                       | 221        |
| <b>6</b> | <b>Two liquid phases —</b>                              | <b>225</b> |
| 6.1      | Liquid-liquid separators —                              | 225        |
| 6.2      | Extraction —                                            | 228        |
| 6.2.1    | Mixer-settler arrangement —                             | 231        |
| 6.2.2    | Extraction columns —                                    | 232        |
| 6.2.3    | Centrifugal extractors —                                | 235        |
| <b>7</b> | <b>Alternative separation processes —</b>               | <b>237</b> |
| 7.1      | Membrane separations —                                  | 237        |
| 7.2      | Adsorption —                                            | 245        |
| 7.3      | Crystallization —                                       | 252        |
| <b>8</b> | <b>Fluid flow engines —</b>                             | <b>257</b> |
| 8.1      | Pumps —                                                 | 257        |
| 8.2      | Compressors —                                           | 265        |
| 8.3      | Jet pumps —                                             | 274        |
| 8.4      | Vacuum generation —                                     | 277        |
| <b>9</b> | <b>Vessels and separators —</b>                         | <b>283</b> |

|           |                                                         |
|-----------|---------------------------------------------------------|
| <b>10</b> | <b>Chemical reactions — 291</b>                         |
| 10.1      | Reaction basics — 291                                   |
| 10.2      | Reactors — 299                                          |
| <b>11</b> | <b>Mechanical strength and material choice — 307</b>    |
| <b>12</b> | <b>Piping and measurement — 313</b>                     |
| 12.1      | Pressure drop calculation — 313                         |
| 12.1.1    | Single-phase flow-through pipes — 313                   |
| 12.1.2    | Pressure drops in special piping elements — 318         |
| 12.1.3    | Pressure drop calculation for compressible fluids — 318 |
| 12.1.4    | Two-phase pressure drop — 321                           |
| 12.2      | Pipe specification — 327                                |
| 12.3      | Valves — 329                                            |
| 12.3.1    | Isolation valves — 329                                  |
| 12.3.2    | Control valves — 332                                    |
| 12.4      | Measurement devices — 334                               |
| <b>13</b> | <b>Utilities and waste streams — 339</b>                |
| 13.1      | Steam and condensate — 339                              |
| 13.2      | Heat transfer oil — 346                                 |
| 13.3      | Cooling media — 346                                     |
| 13.4      | Exhaust air treatment — 348                             |
| 13.4.1    | Condensation — 351                                      |
| 13.4.2    | Combustion — 354                                        |
| 13.4.3    | Absorption — 359                                        |
| 13.4.4    | Biological exhaust air treatment — 361                  |
| 13.4.5    | Exhaust air treatment with membranes — 362              |
| 13.4.6    | Adsorption processes — 363                              |
| 13.5      | Waste water treatment — 364                             |
| 13.6      | Biological waste water treatment — 367                  |
| <b>14</b> | <b>Process safety — 371</b>                             |
| 14.1      | HAZOP procedure — 375                                   |
| 14.2      | Pressure relief — 380                                   |
| 14.2.1    | Introduction — 380                                      |
| 14.2.2    | Mass flow to be discharged — 384                        |
| 14.2.3    | Fire case — 386                                         |
| 14.2.4    | Actuation cases — 392                                   |
| 14.2.5    | Safety valve peculiarities — 399                        |
| 14.2.6    | Maximum relief amount — 402                             |
| 14.2.7    | Two-phase-flow safety valves — 411                      |

**XIV — Contents**

**14.3 Explosions — 414**

**Glossary — 419**

**List of Symbols — 427**

**Bibliography — 431**

**A Some numbers to remember — 443**

**B Pressure drop coefficients — 447**

**Index — 451**