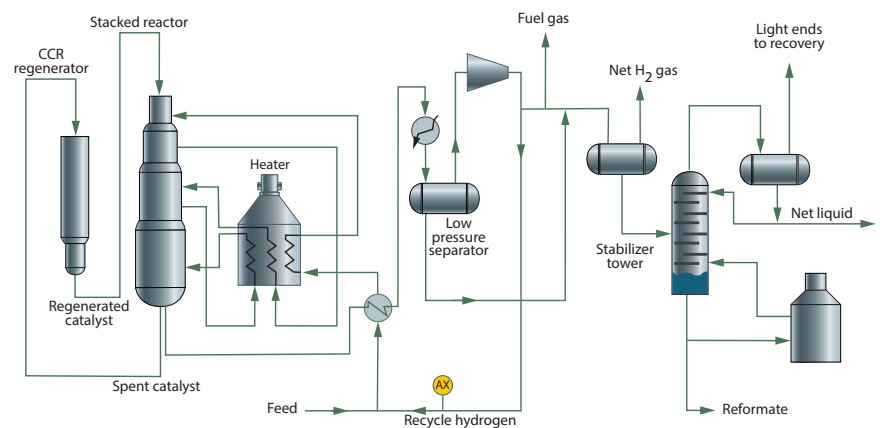


Refining: H₂O in continuous catalytic reformer H₂ recycle streams

Benefits at a glance

- Fast response to H₂O concentration changes for process monitoring and control
- Non-contact laser measurement avoids detector contact, corrosion and damage from HCl
- Laser-based measurement is highly selective and accurate for H₂O in catalytic reformer hydrogen recycle streams



Continuous catalytic reformer

Catalytic reforming

A catalytic reformer unit converts naphtha into high-octane compounds termed reformates used in gasoline blending, and yields large quantities of hydrogen, which is recycled and used in other processes. A continuous catalytic reformer (CCR) unit has a 3-stage stacked reactor employing a platinum/rhenium catalyst on a chloride alumina support. Water and a chloride compound are continuously injected to chlorinate the alumina and maintain acid sites needed to perform the conversion reactions. The catalyst is continuously extracted from the bottom of the reactor stack and transferred to a separate, external catalyst regenerator. Inside the regenerator, coke deposits on the catalyst are burned off and the catalyst is oxy-chlorinated and dried sequentially in separate zones. Following reactivation with hydrogen the catalyst is returned to the top reactor in the CCR stack.

On-line H₂O monitoring

On-line monitoring of the H₂O concentration in CCR hydrogen

recycle streams enables refineries to control the chloride level required for optimum catalyst activity and helps minimize HCl formation which causes corrosion damage. Maintaining an H₂O concentration of 15 - 30 ppmv in a CCR hydrogen recycle stream helps maintain chloride levels (typically 1.0 - 1.3 wt%) on the catalyst by regulating injection of H₂O and the chloriding agent.

Endress+Hauser's solution

Tunable diode laser absorption spectroscopy (TDLAS) is a SpectraSensors technology proven highly effective for this important measurement. TDLAS analyzers have an exceptionally fast response to changes in H₂O concentration, an important performance characteristic for monitoring and controlling H₂O levels in refinery CCR units. Laser and detector components of a TDLAS analyzer are isolated and protected from HCl in the process gas stream that leads to corrosion and frequent replacement of devices using direct contact sensors.

Application data

Target component (Analyte)	Water in continuous catalytic reformer hydrogen recycle gas
Typical measurement ranges	0-50 ppmv*
Typical repeatability	±1 ppmv (control) and ±10% of reading (trend)*
Measurement response time	1 to ~60 seconds*
Principle of measurement	Non-differential tunable diode laser absorption spectroscopy (TDLAS)
Validation	Certified blend of H ₂ O in pure N ₂ or integrated permeation system

*Consult factory for alternate ranges.

Typical stream composition

Component	Minimum (Mol%)	Typical (Mol%)	Maximum (Mol%)
Hydrogen (H ₂)	70	80	90
Methane (C1)	8	12	20
Ethane (C2)	3	5	10
Propane (C3)	0	2	5
i-butane (C ₄ H ₁₀)	0	1	2
n-butane (C ₄ H ₁₀)	0	<1	2
Pentane (C5)	0	0	1

The background stream composition must be specified for proper assessment, calibration and measurement performance. Specify the normal composition, along with the minimum expected values for each component, especially H₂O, the measured component. Other stream components may be allowable with approval from Endress+Hauser.