
Naftna industrija in proizvodi - Določevanje sestave rafinerijskega kurilnega plina in izračunavanje vsebnosti ogljika in kalorične vrednosti - Plinska kromatografska metoda

Petroleum industry and products - Determination of composition of refinery heating gas and calculation of carbon content and calorific value - Gas chromatography method

Mineralölindustrie und -produkte - Bestimmung der Zusammensetzung von Heizgas für Raffinerien und Berechnung des Kohlenstoffgehaltes und des Heizwertes - Gaschromatographisches Verfahren

Industries et produits pétroliers - Détermination de la composition des gaz combustibles de raffinerie, de leur pouvoir calorifique et de leur teneur en carbone - Méthode par chromatographie en phase gazeuse

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Petroleum industry and products - Determination of composition
of refinery heating gas and calculation of carbon content and
calorific value - Gas chromatography method

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This European Standard was approved by CEN on 9 March 2011.

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Foreword

This document (EN 15984:2011) has been prepared by Technical Committee CEN/TC 19 “Gaseous and liquid fuels, lubricants and related products of petroleum, synthetic and biological origin”, the secretariat of which is held by NEN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by October 2011, and conflicting national standards shall be withdrawn at the latest by October 2011.

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1 Scope

This European Standard defines a gas chromatographic analysis for the determination of the composition of fuel gases, as used in refinery heating gas. These results are used to calculate the carbon content and the lower calorific value.

With this gas chromatographic analysis, an overall of 23 refinery heating gas components are determined in concentrations as typically found in refineries (see Table 1 for further details).

Water is not analysed. The results represent dry gases.

NOTE 1 Depending on the equipment used, there is a possibility to determine higher hydrocarbons as well.

NOTE 2 For the purposes of this European Standard, the terms “% (V/V)” is used to represent the volume fraction (φ).

IMPORTANT — This standard does not purport to address all of the safety problems associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations.

2 Principle

This standard defines a procedure that is used to determine all components that are present in a typical refinery heating gas, as indicated in Table 1.

NOTE The composition range in which each component can be analyzed does depend on the actual sample composition as higher amounts of a certain component may affect the detection range of other components eluting close by. The general ranges which apply to all the individual components are:

- Hydrocarbons from 0,01 (mol/100 mol) up to 100 (mol/100 mol);
- Non-condensable gases from 0,02 (mol/100 mol) up to 100 (mol/100 mol);
- For hydrogen sulfide a range between 0,1 (mol/100 mol) up to 10 (mol/100 mol) has been found applicable.

Three different analysis systems are necessary; they may be built in three separate gas chromatographs, or be integrated into one.

Depending on the configuration, hydrocarbons with more than five carbon atoms are reported as a sum parameter. The composition of the refinery heating gas is used to calculate the carbon content and the calorific value. A typical procedure is described hereafter. A configuration is acceptable when the determination gives the precision as described in Clause 9.

3 Reagents and materials

3.1 Gases.

- 3.1.1 **Hydrogen**, with a minimum purity of 99,995 % (V/V).
- 3.1.2 **Helium**, with a minimum purity of 99,995 % (V/V).
- 3.1.3 **Nitrogen**, with a minimum purity of 99,995 % (V/V).
- 3.1.4 **Air**, free of oil and water.
- 3.1.5 **Argon**, as alternative for analysis system 2, with a minimum purity of 99,995 % (V/V).

3.2 Calibration sample.

A certified reference gas mixture in concentrations that allow the determination of the necessary response factors (see 6.1) and retention times is required.

Table 1 — Refinery heating gas components

Number	Description	Chemical formula
1	Hydrogen	H ₂
2	Oxygen/Argon	O ₂ /Ar
3	Nitrogen	N ₂
4	Carbon monoxide	CO
5	Carbon dioxide	CO ₂
6	Hydrogen sulfide	H ₂ S
7	Methane	CH ₄
8	Ethane	C ₂ H ₆
9	Ethene	C ₂ H ₄
10	Ethyne (Acetylene)	C ₂ H ₂
11	Propane	C ₃ H ₈
12	Propene	C ₃ H ₆
13	Propyne (Methylacetylene)	C ₃ H ₄
14	Propadiene	C ₃ H ₄
15	<i>iso</i> -Butane	C ₄ H ₁₀
16	<i>n</i> -Butane	C ₄ H ₁₀
17	<i>trans</i> -2-Butene	C ₄ H ₈
18	1-Butene	C ₄ H ₈
19	2-Methyl-Propene	C ₄ H ₈
20	<i>cis</i> -2-Butene	C ₄ H ₈
21	1,3-Butadiene	C ₄ H ₆
22	<i>iso</i> -Pentane	C ₅ H ₁₂
23	<i>n</i> -Pentane	C ₅ H ₁₂
24	Other components with 5 or more Carbon atoms, excluding <i>iso</i> - and <i>n</i> -Pentane (C ₅₊)	

4 Apparatus

4.1 Usual laboratory apparatus and glassware.

4.2 Gas chromatographic apparatus, consisting of at least three separation systems able to work simultaneously in one gas chromatograph, with a Thermal Conductivity Detector (TCD) and Flame Ionization Detector (FID) that should be available, and confirming to the requirements as given in Clause 5.

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5 Gas chromatographic analysis

5.1 Analysis systems

The gas chromatographic system consist of the following three parts:

1) Analysis system 1

All components except hydrogen (see Table 1) are retained on a porous polymer and a molecular sieve column and back flushed.

NOTE HayeSep[®] and Molsieve[®] are examples of such commercially available columns.

Hydrogen is determined on a TCD with nitrogen (3.1.3) as the carrier gas (see Figure A.4).

2) Analysis system 2

The second analysis system separates non-condensable gases, carbon dioxide, and hydrocarbons with two carbon atoms and hydrogen sulfide with helium (3.1.2) as the carrier gas and a TCD as a detector. After a pre-separation on a porous polymer column (column 3) propane and higher hydrocarbons are back flushed and vented. See Figure A.5 for details..

When the inert gases (O₂/Ar, N₂, CH₄ and CO) are on the molecular sieve 13X column, this column is isolated. Carbon dioxide, the C₂-hydrocarbons and hydrogen sulfide are eluted from the porous polymer column (column 4) and are detected. The C₂-hydrocarbons from this fraction are not used for quantification. After this the molecular sieve 13X column (column 6) is eluted and the components are determined on the TCD. Methane is quantified on Analysis System 3.

3) Analysis system 3

The third analysis system separates and quantifies all hydrocarbons by an FID and hydrogen (3.1.1) or helium (3.1.2) as the carrier gas. Two columns are used in series. From the methyl silicone column (column 1), the components above a certain cut point e.g. *n*-pentane are back flushed and determined as a summed peak. The hydrocarbons from the alumina oxide column, column 2, are then separated and quantified. See Figure A.6 for details.

5.2 System configuration

The gas chromatographic system may consist of one or more gas chromatographs, with the possibility for isothermal or temperature programmed runs or both depending on the selected system configuration. A TCD and an FID shall be available.

A gas flow control system and gas sampling valves and switching valves are used.

Means for quantification shall be provided.

NOTE Optionally a vaporizer may be used.

5.3 Columns

A combination of packed and capillary columns is possible.

It shall be ascertained that a quantitative separation of all the components that need to be determined (see Table 1) is possible and that the summed total of C₅₊ is quantitative. Adequate separation is required between the components on all three separation systems.

If cyclopropane can be determined, it shall be summed to propene.

An example for a typical configuration is given in Annex A.

6 Calibration

6.1 General

Depending on the production procedure of the reference gas mixture, it might be necessary to convert the concentration units of the components in the calibration gas to (mol/mol) %.

Linearity of the detectors shall be checked according to Annex B.

If calibration is necessary, e.g. daily or for an analysis series, a reference gas mixture shall be analysed. For each analysis system (see 5.1) at least one component, the reference component, needs to be calibrated. For example, for analysis system 1 hydrogen, for analysis system 2 nitrogen and for analysis system 3 propane. With these three components, an external calibration is done. The absolute response factor is calculated.

For all the other components, relative response factors will be used (see 6.3).

The relative response factor of the reference component will be set at 1,0.

As alternative all absolute response factors can be determined for all the components that need to be analyzed in a reference gas mixture. A check of this calibration can take place with a gas mixture with fewer components.

6.2 Absolute response factors

The determination of absolute response factors is possible when a repeatable injection is possible under constant analysis conditions. The ratio between concentration and peak area is determined and the absolute response factor is calculated with the following equation:

$$RF_i = \frac{x_i}{A_i} \quad \text{SIST EN 15984:2011} \quad (1)$$

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where

RF_i is the absolute response factor of component i ;

x_i is the concentration of component i in (mol/100 mol) in the calibration gas;

A_i is the peak area of component i in the calibration gas.

6.3 Relative response factors

For quantification relative response factors can be used too. In one analysis system, one component is used as a reference (reference component).

The relative response factor is calculated with the following equation:

$$RRF_i = \frac{RF_i}{RF_{St}} \quad (2)$$

where

RRF_i is the relative response factor of component i ;

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RF_i is the absolute response factor of component i ;

RF_{St} is the absolute response factor of the reference component St .

7 Calculation

7.1 General

For the calculation of parameters of gas mixtures, as described in this standard, the molar composition of the gas mixture is necessary.

NOTE A more accurate result may be obtained by analyzing the C5 olefins separately and not adding them to the sum of all heavier components.

7.2 Calculation of the non normalized mole fractions

The concentrations of the components, $x_{i, sample}$, mentioned in Table 1 are calculated as mole fractions. The calculation of these follows Equation (3):

$$x_{i, sample} = A_{i, sample} \times RRF_{i, St} \times RF_{StK} \quad (3)$$

where

$A_{i, sample}$ is the area of component i in the sample;

$RRF_{i, St}$ is the relative response factor of component i relative to the reference component St ;

RF_{StK} is the absolute response factor of the reference component St in the reference gas mixture K .

NOTE If only absolute response factors are used, then reference component St and component i are identical. Therefore, in Equation (3) $RRF = 1$ and each RF represents the individual component i .

7.3 Validation of normalized composition (reference components)

The results can be normalized, when the sum of all the mole fractions of the components are not smaller than 0,98 or greater than 1,02. If not, the analysis should be repeated. If the duplicate analysis does not improve this result, the calibration and the apparatus shall be checked.

Normalization is done according to:

$$x_i^* = \frac{x_{i, sample}}{\sum_{i=1}^k x_{i, sample}} * 100 \quad (4)$$

where

x_i^* is the corrected concentration of component i in the sample in mol/100 mol;

$x_{i, sample}$ is the uncorrected concentration of component i in the sample;

$\sum_{i=1}^k x_{i, sample}$ is the sum of the non normalized mol fractions of the sample;

k is the number of components.

7.4 Calculation of carbon content

The determined and normalized concentrations of each component, calculated according to Equations (3) and (4) are independent of pressure and temperature. By multiplying the concentration of each component with their respective molar mass and normalizing the results, the (mol/100 mol) fractions are converted to (g/100 g) of gas, $w_{x_i}^*$ according to:

$$w_{x_i}^* = \frac{x_i^* M_i}{\sum_{i=1}^k (x_i^* M_i)} * 100 \quad (5)$$

where

x_i^* is the corrected concentration of the component i in the sample in (mol/100 mol);

M_i is the molar mass of the component i in g/mol;

$\sum_{i=1}^k (x_i^* M_i)$ is the sum of the normalized molar fractions of the sample multiplied by the molar mass;

k is the number of components.

The carbon content of the individual components, w_{C_i} , are given in Table D.1.

The calculation is according to Equation (6):

$$w_{C_i} = \frac{n_{C_i} M_C}{M_i} \quad (6)$$

where

n_{C_i} is the number of carbon atoms in the component i ;

M_C is the molar mass of carbon in g/mol;

M_i is the molar mass of the component i in g/mol.

The sum of the values found by multiplication of the concentration w_i in (g/100g gas) with the molar carbon concentration w_{C_i} of component i results in the carbon content of the mixture (g C/100g gas), C_c .