



Remote and Automated Hydraulic Decoking Systems



Experience In Motion

Remote and Automated Hydraulic Decoking



Continuously Advancing Safety, Availability and Profitability

Through its Worthington®, Pacific® and IDP® heritage brands, Flowserve has played a leading role in hydraulic decoking since the technology's inception more than three-quarters of a century ago. From the original combination cutting tools and jet pumps to today's state-of-the-art remotely operated and fully automated systems, Flowserve is the overwhelming

supplier of choice for hydraulic decoking systems, with more than 200 installations globally, comprising over 90% of the world's units. Process licensors, EPC firms and DCU operators alike turn to Flowserve for its proven applications expertise and problem-solving capabilities.

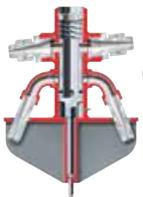


Flowserve Worthington supplies the cutting tools, swivel joints, control valves and jet pumps for the world's first hydraulic decoking installation at Shell Oil's Wood River, Illinois, (USA) refinery.

1938

1940

Flowserve Pacific supplies hydraulic decoking jet pumps at Standard Oil's El Dorado, Kansas, (USA) refinery.



Flowserve Pacific introduces the "combo" design — an axially shifted combination tool incorporating both boring and cutting nozzles within a single body.

1979

1981

Flowserve Pacific introduces the decoking control valve that ensures the jet pump is never in a blocked condition.



Flowserve installs first hydraulic motor-driven winch and rotary joint combination.

1994

1998

The need for higher pressure systems with increased efficiency results in the rotary shifted combination tool.



Patented AutoShift™ rotary actuated and remotely shifted combination tool opens the door to decoking system automation.

2003

2004

Flowserve equips the first remotely operated cutting system. Vibration drum monitoring is introduced.

Flowserve installs electric motor-driven winch and rotary joint with VFD control.

2008

2010

Vibration drum monitoring is updated with improved operator feedback.

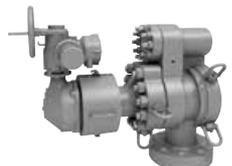


Flowserve designs and ships the first fully automated coke cutting system with coker-specific designs for audio and video monitoring.

2011

2013

Flowserve releases advanced decoking control valve to replace the Pacific decoking control valve. The new valve improves mean time between repair (MTBR) and field maintainability.



Flowserve has pioneered numerous significant advancements in hydraulic decoking, transforming it into an increasingly safe, efficient and automated process.



Continuing to Innovate: Remote and Automated Operation

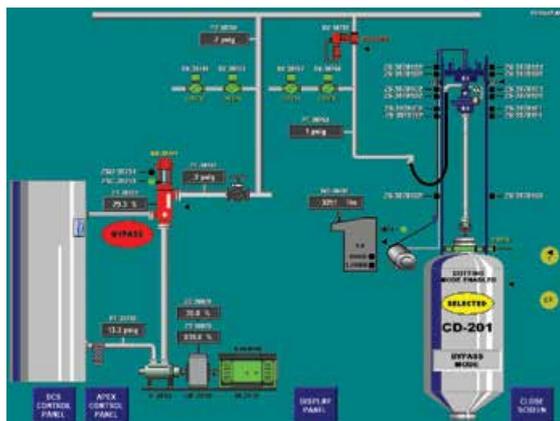
Improving personnel safety has always been the number one goal of DCU managers. Removing operators from the cutting deck would eliminate their exposure to inherent hydraulic decoking dangers, including:

- High-pressure water
- Hot spot steam eruptions
- Hydrogen sulfide (H₂S) vapors
- Fire and mechanical hazards

The introduction of drum monitoring through vibration and the AutoShift tool, along with significant advancements in associated equipment design, now make remote operation possible. The addition of modern instrumentation, controls and software technology can achieve system automation for reduced cutting times with greater throughput, maximum reliability and lowest total cost of ownership.

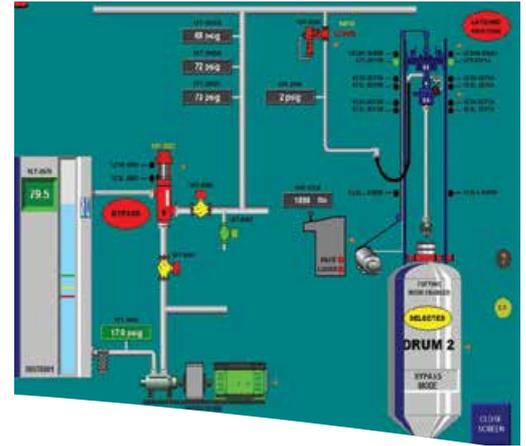


With manual mode shifting, personnel may be exposed to hazards at the drumhead.



Remote and automated systems eliminate these risks.

The result of 80 years of innovation, remote coke cutting delivers increased safety, reliability and profitability.



Remote Cutting: A Leap in Safety

The delayed coker unit (DCU) is among the most dangerous operating areas within the refinery. Compounding the hazards of the process itself are the low visibility, high-noise environment and even the weather. Removing personnel from the cutting deck and operating the system remotely are the keys to greatly improved unit safety.

The AutoShift combination cutting tool, along with remotely operated winch and rotary joint equipment, plus best available vibration, video and acoustic monitoring technologies, make remote coke cutting a practical reality.

Remote Cutting System Requirements

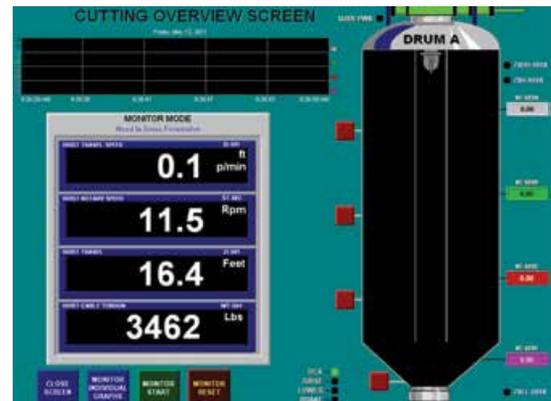
For successful remote coke cutting operation, the following equipment is required:

- AutoShift combination cutting tool
- Remote operator shelter and master control panel
- Automated tool enclosure and drill stem guide
- Remote winch and rotary joint operation
- Automatic top and bottom drum unheading
- Vibration, acoustic and video drum monitoring systems
- Interlocked safety systems for cutting water flow control

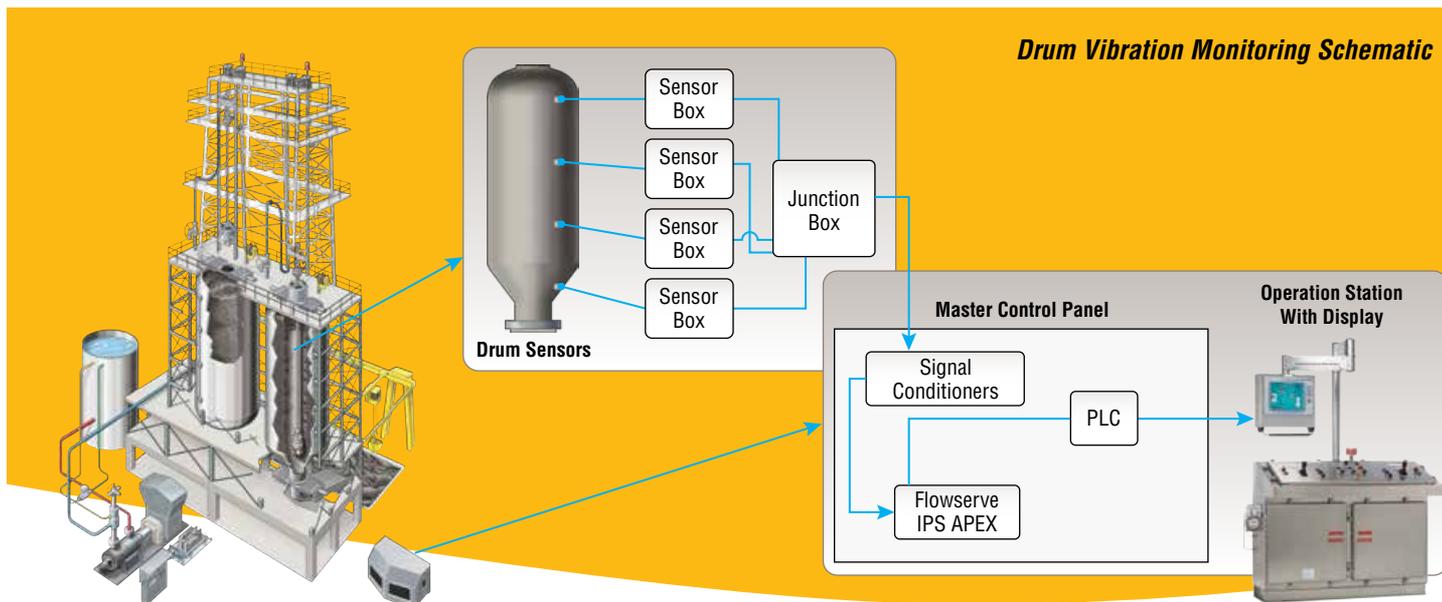
Operator Information Needs

Located in the remote operator's shelter, the master control panel displays the process information critical to safe and efficient remote cutting.

- In-drum cutting status and cleaning progress
- Drum selection and in-drum indication
- Crosshead position and latch/unlatch status
- Winch and rotary joint speed control and position
- Decoking valve position selection switch and valve status
- Cutting water pressure and pump condition
- Cable tension



Critical process information is displayed in real-time on the operator's control panel.



Drum Monitoring Systems

Vibration, acoustic and video drum monitoring devices inform operators of cutting progress, while enabling them to see and hear cutting deck, chute and pit activities.

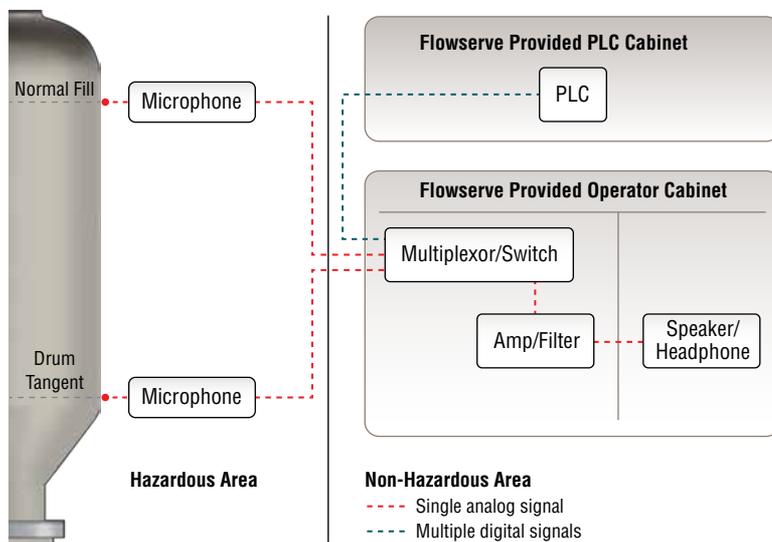
Drum Vibration Monitoring

A key element in remote system operation is establishing with certainty the position of the tool within the drum during the cutting process. High-temperature vibration probes monitor drum wall vibration to determine tool location and coke-cutting states. The information is relayed to the operator's control panel in the remote operating shelter.

Audio and Video Drum Monitoring

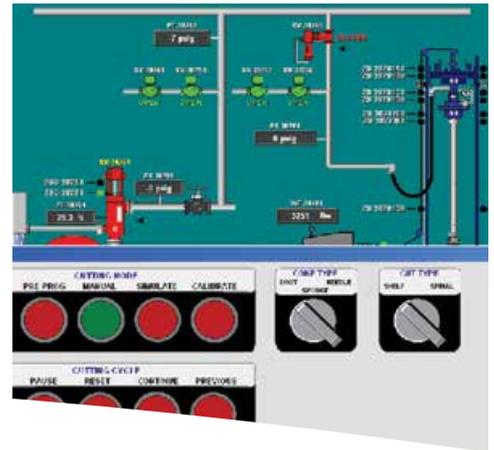
Feedback on cutting progress and activities is enhanced by acoustic and video systems designed to help the operator determine the progress of coke removal. As coke is cut from the drum, the sound of the impinging water changes, thus allowing the operator to "hear" when a section of the drum is clean. Simultaneously, a video monitoring system enables the operator to view the cutting deck, winch, cutting tool assembly, the coke chute and pit, all from the safety of the remote shelter. Cutting mechanism problems can be quickly addressed, while chute and pit observations confirm when coke removal is complete for each cutting step.

Audio Monitoring Schematic



High-temperature accelerometers monitor vibrations on the coke drum wall. The resulting signals provide the operator with information regarding drum cleanliness status.

Flowserve automated decoking systems take remote cutting to its ultimate destination: A new standard for DCU safety, availability and efficiency.



Coke Cutting Automation

The Next Level in Reliability and Productivity

Flowserve automated decoking technology combines the capabilities of its remotely operated cutting equipment and drum monitoring systems with the embedded intelligence and advanced algorithms of its IPS APEX™ to control the cutting process. Controlled by the PLC, operator intervention is only required in the event of sequence exceptions. The preprogrammed cutting operations are customized to minimize cycle times while maximizing safety and reliability. The result is safer, faster, more efficient coke cutting.

Automation Benefits

Improved personnel safety

- Automated cutting system with integrated PLC interlocks minimizes the probability of operator error and eliminates potentially hazardous shortcuts
- Standardized cutting procedures reduce risk of aggressive cutting practices

Improved equipment reliability

- Intelligently monitors condition/controls of critical cutting equipment
- Provides diagnostics for preventive maintenance to extend MTBR intervals and increase equipment life

Improved process efficiency and consistency

- Optimizes cycle times by advancing program and cutting tool as soon as possible
- Achieves consistent cutting times with standardized cutting procedures

Data recording for process optimization or troubleshooting

Advanced Control With Flowserve IPS APEX

Automated hydraulic decoking is made possible with the advanced monitoring, diagnostics, control and instrumentation capabilities of the Flowserve IPS APEX. Flowserve will custom design and commission the requisite computer software and algorithms, instrumentation and embedded intelligence to automatically operate the decoking system while protecting it from unanticipated downtime.

Real-time data can be shared with experts worldwide through a Web-based management portal. Predictive and proactive maintenance improves system reliability and throughput.

Automation System Capabilities

In addition to the IPS APEX-integrated technology platform, Flowserve and its proven sub-vendors can provide all the equipment necessary for delayed coker unit hydraulic decoking automation, including:

- AutoShift coke cutting tool
- Remotely operated winch, rotary joint and unheading valves
- Automatic guide plate and tool enclosure
- Drum vibration monitors to determine tool position and cutting progress
- Cutting equipment sensors to monitor tool rotational speed, wire rope system tension, etc.
- Interlocked safety systems for cutting water flow control
- Remote operator enclosure with master control panel
- Video and acoustic equipment to observe cutting deck activities, as well as coke chute and pit status



Coke Cutting System Upgrades and Services

Most Flowserve decoking units installed after 2005 can be upgraded easily to remotely operated or automated systems by adding drum monitoring instrumentation and equipment. Older systems require a customized and comprehensive review to identify the most cost-effective safety and performance upgrades.

Regardless of OEM, Flowserve offers replacement of vintage decoking equipment with all-new or significantly redesigned models, including:

- Cutting tools
- Decoking control valves
- Rotary joints
- Jet pumps
- Control systems

Upgrade Experts

A global network of Flowserve decoking specialists will help evaluate and specify the equipment and components required to upgrade an existing hydraulic cutting operation into the most cost-effective, state-of-the-art remotely operated or automated system possible.

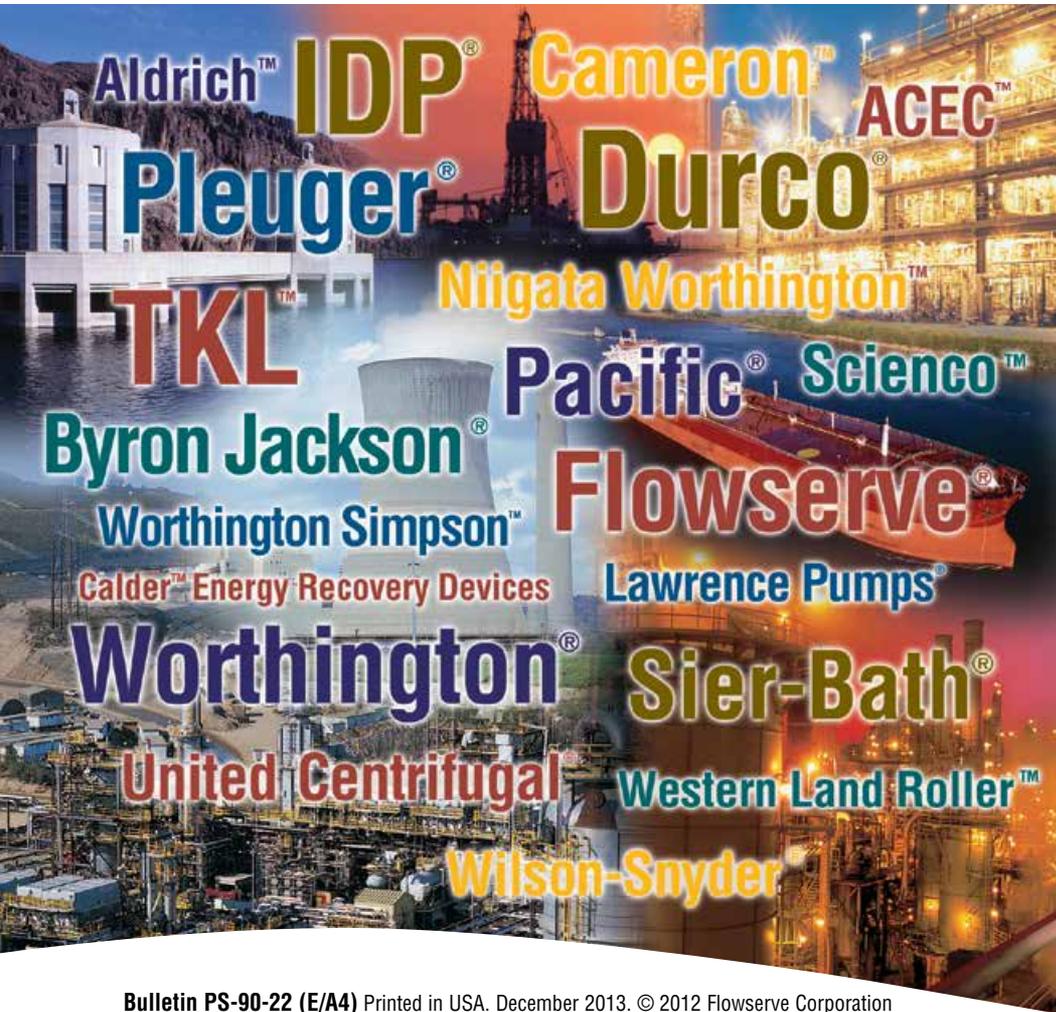
With improved safety and efficiency as the goals, the Flowserve decoking specialists will:

- Assess each component of the system for proper functionality
- Audit the control system for hardware and software technology improvements
- Analyze the unit's structural and civil integrity, including the decoking tower
- Provide recommendations and actions steps for system conversion



Field Service and Technical Support

Flowserve customer service technicians are on call 24 hours a day, seven days a week to respond to scheduled or unscheduled outages, construction, installation and start-up service needs. Technicians are specifically trained to evaluate and troubleshoot problems with decoking systems and equipment. Backed by Flowserve design and engineering groups, technicians have access to manufacturing drawings, bills of material and performance data so they can develop practical and reliable solutions to decoking problems.



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