

Rokeby Generating Station Saves 50% in Capital Expense by Using Liqui-Cel® 14x28 Membrane Contactors to Remove CO₂ to Extend Mixed Bed Resin Life

Lincoln Electric Systems (LES) recently commissioned a membrane decarbonation system using Liqui-Cel® 14x28 Membrane Contactors to remove CO₂ prior to their mixed bed deionizers. The system was installed at the Rokeby Generating Station (RGS) in Lincoln, Nebraska.

Background

The Rokeby Generating Station is LES' primary peaking power station, totaling 255 MW and consisting of 3 dual fuel combustion turbines. The existing DI water system consisted of two single-pass, two-stage RO skids followed by a 31 ft³ (0.87 m³) mixed bed deionizer and two 250,000-gallon (943 m³) storage tanks.

LES determined that the mixed bed unit was producing only 30% of its expected capacity (90,000 gallons actual vs. 300,000 gallons expected or 341 m³ actual vs. 1136 m³ expected). It was determined that the cause of the decreased capacity was due to dissolved CO₂ in the water, which was overloading the anion resin. As the power capacity demand increased, LES had to act quickly to update their winter contingency plans.

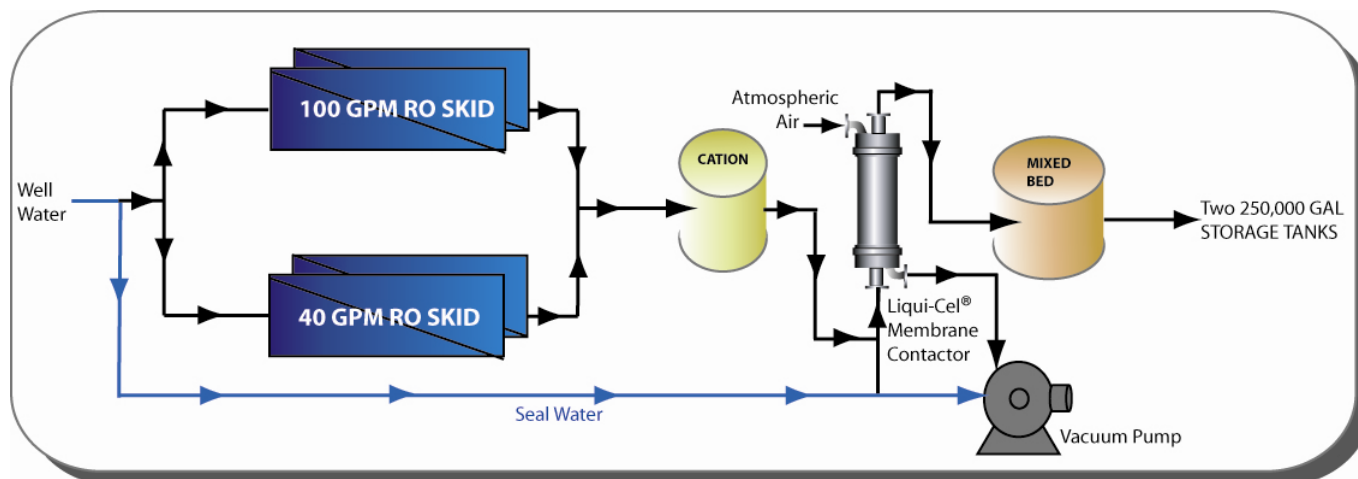
Treatment Options

Multiple treatment options including chemical treatment and the installation of a forced draft degasifier were considered. Ultimately, chemical treatment was considered too risky because of its negative impact on increasing scale on the RO membranes. A forced draft deaerator was also considered impractical due to the large capital expense and size constraints at LES.



System Design

In 2005, LES began engineering a membrane decarbonation system using Liqui-Cel 14x28 Membrane Degasifiers. The system was designed to treat the combined water flow from both RO skids, approximately 150 GPM (0.6 m³). The goal was to achieve approximately 90% reduction of dissolved CO₂. Additionally, the system was designed to operate with vacuum assisted air sweep, using a liquid ring vacuum pump to draw atmospheric air through the Liqui-Cel Contactors.



Since the LES staff was able to design, fabricate, and install the Liqui-Cel degassing system, the total capital cost was approximately 50% less than the cost of a forced draft degasifier. The compact design also allowed LES to build the system inside of an existing building with minimal modification. The low system pressure drop through a Liqui-Cel Membrane Contactor system also eliminated the need for a re-pressurization pump further lowering operating costs for LES.

The degas skid was installed downstream of the RO skids and before the mixed bed. In order to maximize efficiency, a cation bottle was installed between the RO skids and the degas skid to reduce the pH and convert the HCO₃ to free CO₂ gas. (See Fig. 1)

Test Set Up

LES temporarily installed three 3.3 ft³ (0.09 m³) mixed bed bottles downstream of the degas skid. The bottles were installed in parallel for a total capacity of 9.9 ft³ (0.28 m³). During the test, only one of the RO units was operated, resulting in water flow of 40 GPM.

LES expected to achieve 138,000 to 168,000 gallons (522 m³ – 636 m³) throughput with this design. They actually achieved 191,000 gallons (725 m³). Specific conductivity was 0.5 μS/cm and silica was 7.5 ppb. LES estimates the full-scale capacity will be approximately 617,000 gallons [(32 ft³ / 9.9 ft³) * 191,000 = 617,374 gallons (2337 m³)]. This represents an increase in the total capacity of the system by a factor of 5.9.

Summary

Liqui-Cel Membrane Contactors offer a cost-effective, efficient option for removal of carbon dioxide from process water. Removal of carbon dioxide prior to the mixed bed resins *significantly* improves regeneration times, thereby reducing operating costs and improving overall efficiency by minimizing downtime.

If you would like a Membrana representative to size a Liqui-Cel Membrane Contactor system for your application, please visit www.liquicel.com and click "contact us", or call us at the numbers listed below.

This product is to be used only by persons familiar with its use. It must be maintained within the stated limitations. All sales are subject to Seller's terms and conditions. Purchaser assumes all responsibility for the suitability and fitness for use as well as for the protection of the environment and for health and safety involving this product. Seller reserves the right to modify this document without prior notice. Check with your representative to verify the latest update. To the best of our knowledge the information contained herein is accurate. However, neither Seller nor any of its affiliates assumes any liability whatsoever for the accuracy or completeness of the information contained herein. Final determination of the suitability of any material and whether there is any infringement of patents, trademarks, or copyrights is the sole responsibility of the user. Users of any substance should satisfy themselves by independent investigation that the material can be used safely. We may have described certain hazards, but we cannot guarantee that these are the only hazards that exist.

Liqui-Cel, Celgard, SuperPhobic and MiniModule are registered trademarks and NB is a trademark of Membrana-Charlotte, A division of Celgard, LLC and nothing herein shall be construed as a recommendation or license to use any information that conflicts with any patent, trademark or copyright of Seller or others.



ISO 9001:2000
ISO 14001:2004

©2007 Membrana – Charlotte A Division of Celgard, LLC (TB57 07/06)

Membrana – Charlotte
A Division of Celgard, LLC
13800 South Lakes Drive
Charlotte, North Carolina 28273
USA
Phone: (704) 587 8888
Fax: (704) 587 8585

Membrana GmbH
Oehder Strasse 28
42289 Wuppertal
Germany
Phone: +49 6126 2260 - 41
Fax: +49 202 6099 -750

Japan Office
Shinjuku Mitsui Building, 27F
1-1, Nishishinjuku 2-chome
Shinjuku-ku, Tokyo 163-0427
Japan
Phone: 81 3 5324 3361
Fax: 81 3 5324 3369

MEMBRANA
MEMBRANA
Underlining Performance

www.membrana.com
www.liqui-cel.com

A **POLYPORE** Company