

Contents

Preface — VII

Preface to the 2nd edition — IX

Preface to the 3rd edition — XI

1 Engineering projects — 1

- 1.1 Process engineering activities — 1
- 1.2 Realization of a plant — 8
- 1.3 Cost estimation — 19

2 Thermodynamic models in process simulation — 25

- 2.1 Phase equilibria — 27
- 2.2 φ - φ -approach — 33
- 2.3 γ - φ -approach — 41
 - 2.3.1 Activity coefficients — 41
 - 2.3.2 Vapor pressure and liquid density — 51
 - 2.3.3 Vapor phase association — 57
- 2.4 Electrolytes — 60
- 2.5 Liquid-liquid equilibria — 63
- 2.6 Solid-liquid equilibria — 67
- 2.7 φ - φ -approach with g^E mixing rules — 68
- 2.8 Enthalpy calculations — 70
- 2.9 Model choice and data management — 76
- 2.10 Binary parameter estimation — 79
- 2.11 Model changes — 82
- 2.12 Transport properties — 83

3 Working on a process — 87

- 3.1 Flowsheet setup — 89
- 3.2 PID discussion — 98
- 3.3 Heat integration options — 103
- 3.4 Batch processes — 113
- 3.5 Equipment design — 117
- 3.6 Troubleshooting — 118
- 3.7 Dynamic process simulation — 121
 - 3.7.1 Basic considerations for dynamic models — 123
 - 3.7.2 Basics of process control for dynamic simulations — 127
- 3.8 Patents — 133
 - 3.8.1 Novelty — 134

- 3.8.2 Inventiveness — **135**
- 3.8.3 Industrial applicability — **136**
- 3.8.4 Exceptions from patentability [334, 339] — **136**
- 3.8.5 Patent research and patent monitoring — **144**
- 3.8.6 Inventor's bonus — **146**

4 Heat exchange — 148

- 4.1 Thermal conduction — **149**
- 4.2 Convective heat transfer — **151**
- 4.3 Heat transition — **157**
- 4.4 Shell-and-tube heat exchangers — **160**
- 4.5 Heat exchangers without phase change — **161**
- 4.6 Condensers — **174**
- 4.7 Evaporators — **176**
- 4.8 Plate heat exchangers — **186**
- 4.9 Double pipes — **190**
- 4.10 Air coolers — **190**
- 4.11 Fouling — **191**
- 4.12 Vibrations — **194**
- 4.13 Heat transfer by radiation — **196**

5 Distillation and absorption — 204

- 5.1 Thermodynamics of distillation and absorption columns — **207**
- 5.2 Packed columns — **210**
- 5.3 Maldistribution in packed columns — **221**
- 5.4 Tray columns — **223**
- 5.5 Comparison between packed and tray columns — **243**
- 5.6 Distillation column control — **245**
- 5.7 Constructive issues in column design — **251**
- 5.8 Separation of azeotropic systems — **255**
- 5.9 Rate-based approach — **258**
- 5.10 Dividing wall columns — **261**
- 5.11 Batch distillation — **264**
- 5.12 Troubleshooting in distillation — **265**

6 Two liquid phases — 268

- 6.1 Liquid-liquid separators — **268**
- 6.2 Extraction — **271**
 - 6.2.1 Mixer-settler arrangement — **275**
 - 6.2.2 Extraction columns — **275**
 - 6.2.3 Centrifugal extractors — **278**

7	Alternative separation processes — 280
7.1	Membrane separations — 280
7.2	Adsorption — 288
7.3	Crystallization — 295
8	Fluid flow engines — 300
8.1	Pumps — 300
8.2	Compressors — 308
8.3	Jet pumps — 320
8.4	Vacuum generation — 323
9	Vessels and separators — 328
9.1	Agitators — 337
10	Chemical reactions — 342
10.1	Reaction basics — 342
10.2	Reactors — 350
11	Mechanical strength and material choice — 357
12	Piping and measurement — 362
12.1	Pressure drop calculation — 362
12.1.1	Single-phase flow-through pipes — 362
12.1.2	Pressure drops in special piping elements — 367
12.1.3	Pressure drop calculation for compressible fluids — 367
12.1.4	Two-phase pressure drop — 370
12.2	Pipe specification — 377
12.3	Valves — 380
12.3.1	Isolation valves — 380
12.3.2	Control valves — 382
12.4	Pressure surge — 384
12.5	Measurement devices — 386
13	Utilities and waste streams — 390
13.1	Steam and condensate — 390
13.2	Heat transfer oil — 397
13.3	Cooling media — 397
13.4	Exhaust air treatment — 403
13.4.1	Condensation — 406
13.4.2	Combustion — 409
13.4.3	Absorption — 415
13.4.4	Biological exhaust air treatment — 416

- 13.4.5 Exhaust air treatment with membranes — 417
- 13.4.6 Adsorption processes — 418
- 13.5 Waste water treatment — 419
- 13.6 Biological waste water treatment — 422

14 Process safety — 426

- 14.1 HAZOP procedure — 430
- 14.2 Pressure relief — 435
 - 14.2.1 Introduction — 435
 - 14.2.2 Mass flow to be discharged — 440
 - 14.2.3 Fire case — 442
 - 14.2.4 Actuation cases — 447
 - 14.2.5 Safety valve peculiarities — 454
 - 14.2.6 Maximum relief amount — 458
 - 14.2.7 Two-phase-flow safety valves — 468
- 14.3 Flame arresters — 470
- 14.4 Explosions — 472

15 Digitalization — 479

- 15.1 Digital transformation — 479
- 15.2 Digitalization and sustainability — 480
- 15.3 Digitalization in process industry and green transformation — 481
- 15.4 Key terms explained — 482
- 15.5 Models for digitalization — 490
- 15.6 Data science vs. domain expertise — 494
- 15.7 Digitalization trends in process industry — 496
- 15.8 Catching up with the times — 505

Glossary — 509

List of Symbols — 517

Bibliography — 521

A Some numbers to remember — 537

B Pressure drop coefficients — 541

Index — 545