

## Degassing Boiler Feed Water in China with Liqui-Cel® Membrane Contactors

ShenLan Environment Inc. located in Shanghai China uses Liqui-Cel® Membrane Contactors in their boiler feed water treatment systems. These systems realize lower operating costs with the added benefit of reducing the chemicals added to the boiler feed water.

### Background

Proper treatment of boiler feed water is an important component of a boiler system. As steam is produced, dissolved solids become concentrated and deposit inside the boiler. This leads to poor heat transfer and efficiency reduction of the boiler. Dissolved gasses such as oxygen and carbon dioxide will react with the metal surfaces inside the boiler promoting corrosion. Degassing is an important step for protecting the boiler.

Liqui-Cel Membrane Contactors offer many advantages over forced draft deaerators, vacuum towers, and chemical treatment programs for feed water treatment. Membrane Contactors utilize microporous membranes to create 10X the surface area compared to mechanical technologies. Contactors are highly efficient, compact and can be used inline under pressure.

### Chemical Treatment

Chemical treatment is widely used to control dissolved oxygen in a boiler. The cost of operating a chemical treatment program consists of chemical costs and blow down costs. Periodically the water in the boiler must be flushed out to remove non-volatile compounds. They are flushed out of the boiler in a process called blow down. Chemical addition to the water can increase the frequency of blow down, which increases the operating cost of the boiler.

There are two components of blow down costs. Water and steam that is purged from the boiler during blow down is sent to drain. This water must be replenished by fresh makeup water and there is a cost associated with it. The second cost is heat or energy cost. The water blow down from the boiler is hot. It is replaced with cold water that must be reheated in order to produce steam.



*Membrane Contactor Boiler Deoxygenation System built by Shen Lan*

### Example Using Membrane Contactors

Membrane Contactors can be used to remove the dissolved oxygen from water. By removing the dissolved oxygen the volume of chemicals added to the boiler will be reduced. By reducing the chemicals added to the boiler the frequency of blow down can be potentially reduced. The example in figure 1 compares operating costs of two systems. One system is a chemical only treatment system with a blow down rate of 10%. The other system assumes that the oxygen content of the feed water is reduced to 0.5 ppm and that the blow down rate can be reduced to 5% due to the reduction of chemicals in the boiler.

The boiler specifications used in this example are for reference. These calculations can be modified in order to apply them to boilers with different operating conditions.

**Membrane System Operating Cost**

A Membrane Contactor system can be used to produce feed water with low levels of dissolved oxygen. The operating cost of a membrane degassing system is comprised of electricity and seal water for the vacuum pump.

When comparing this to the chemical treatment system, a \$2,170.00 per year savings can be realized. When the savings associated with blow down is included, the operating costs savings can be more than \$8,500.00 per year. A typical membrane system designed to degas the water outlined in this example can have a payback in less than two years. The details and equations used to calculate the operating savings can be found in the full technical paper on this subject. The paper is available at [www.liqui-cel.com](http://www.liqui-cel.com) in the paper area of the technical resources section.

**Summary**

Dissolved oxygen control in boiler feed water is an important process that protects the boiler from corrosion. Chemical treatment is often used to control the dissolved oxygen. Liqui-Cel<sup>®</sup> Membrane Contactors can be used to replace or supplement the chemical treatment program. The Contactors can minimize the volume of chemicals added to the feed water and offer savings to the end user by reducing chemical as well as energy costs.

Additionally, a membrane-based system is an ecologically friendly system.

If you would like us to size a Liqui-Cel System for your application so that you can evaluate the economic advantages, please visit our website and click contact us or call us at the numbers listed below.

Boiler capacity	10,000 lb/hr		
Pressure	50 psig		
Fuel	Natural Gas		
	Chemically Treated Feed Water	Degassed Feed Water	Savings
Fuel cost	4.5 USD/1000 ft <sup>3</sup>	4.5 USD/1000 ft <sup>3</sup>	
Fuel efficiency	1000 BTU/ft <sup>3</sup>	1000 BTU/ft <sup>3</sup>	
Boiler blow down rate	10%	5%	
Hours of operation	6600 hrs/yr (275 days/yr)	6600 hrs/yr (275 days/yr)	
Feed water costs	1.2 USD/1000 gallons	1.2 USD/1000 gallons	
Sodium Sulfite cost	0.5 USD/lb	0.5 USD/lb	
Feed water temperature	60 F	60 F	
Inlet Dissolved O <sub>2</sub>	9.0 ppm	0.5 ppm	
Chemical cost	\$2,299.00	\$128.00	\$2,171.00
Blow down water costs	\$1055.00	\$500.00	\$555.00
Energy cost due to heat loss in blow down	\$11,095.00	\$5256.00	\$5,839.00
Total yearly costs/savings	\$13,997.00	\$5,669.00	\$8,565.00

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.

©2007 Membrana – Charlotte A Division of Celgard, LLC (TB45 Rev1 \_10-05)

**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](http://www.membrana.com)  
[www.liqui-cel.com](http://www.liqui-cel.com)

A **POLYPORE** Company