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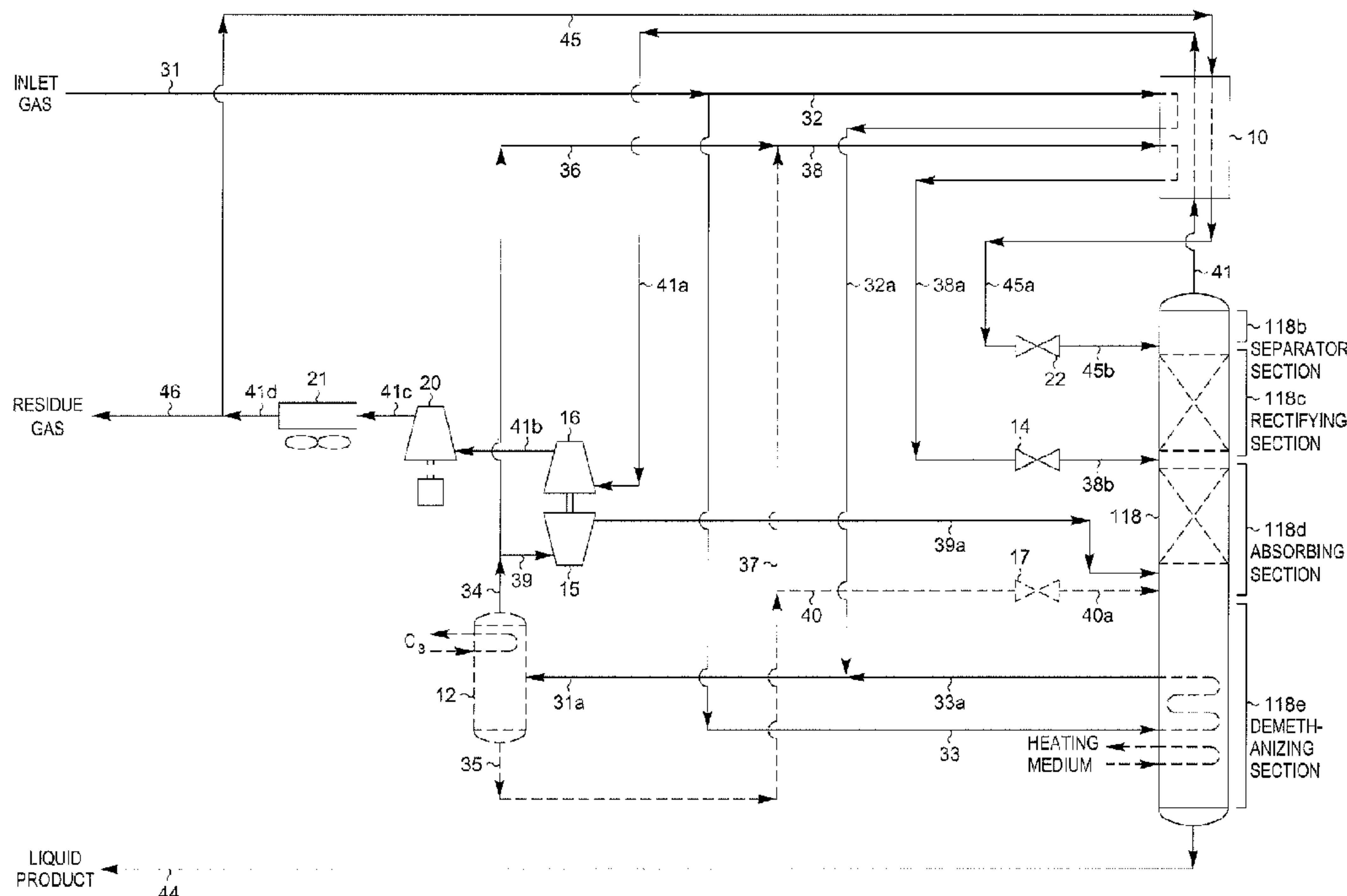
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(57) Abrégé/Abstract:

A process and an apparatus are disclosed for a compact processing assembly to recover C_2 (or C_3) components and heavier hydrocarbon components from a hydrocarbon gas stream. The gas stream is cooled and divided into first and second streams. The first stream is further cooled, expanded to lower pressure, and supplied as a feed between first and second absorbing means. The second stream is expanded to lower pressure and supplied as bottom feed to the second absorbing means. A distillation vapor stream from the first absorbing means is heated, compressed to higher pressure, and divided into a volatile residue gas fraction and a compressed recycle stream. The compressed recycle stream is cooled, expanded to lower pressure, and supplied as top feed to the first absorbing means. A distillation liquid stream from the second absorbing means is heated in a heat and mass

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transfer means to strip out its volatile components.

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HYDROCARBON GAS PROCESSING

SPECIFICATION

BACKGROUND OF THE INVENTION

[0001] Ethylene, ethane, propylene, propane, and/or heavier hydrocarbons can be recovered from a variety of gases, such as natural gas, refinery gas, and synthetic gas streams obtained from other hydrocarbon materials such as coal, crude oil, naphtha, oil shale, tar sands, and lignite. Natural gas usually has a major proportion of methane and ethane, i.e., methane and ethane together comprise at least 50 mole percent of the gas. The gas also contains relatively lesser amounts of heavier hydrocarbons such as propane, butanes, pentanes, and the like, as well as hydrogen, nitrogen, carbon dioxide, and other gases.

[0002] The present invention is generally concerned with the recovery of ethylene, ethane, propylene, propane, and heavier hydrocarbons from such gas

streams. A typical analysis of a gas stream to be processed in accordance with this invention would be, in approximate mole percent, 90.3% methane, 4.0% ethane and other C₂ components, 1.7% propane and other C₃ components, 0.3% iso-butane, 0.5% normal butane, and 0.8% pentanes plus, with the balance made up of nitrogen and carbon dioxide. Sulfur containing gases are also sometimes present.

[0003] The historically cyclic fluctuations in the prices of both natural gas and its natural gas liquid (NGL) constituents have at times reduced the incremental value of ethane, ethylene, propane, propylene, and heavier components as liquid products. This has resulted in a demand for processes that can provide more efficient recoveries of these products and for processes that can provide efficient recoveries with lower capital investment. Available processes for separating these materials include those based upon cooling and refrigeration of gas, oil absorption, and refrigerated oil absorption. Additionally, cryogenic processes have become popular because of the availability of economical equipment that produces power while simultaneously expanding and extracting heat from the gas being processed. Depending upon the pressure of the gas source, the richness (ethane, ethylene, and heavier hydrocarbons content) of the gas, and the desired end products, each of these processes or a combination thereof may be employed.

[0004] The cryogenic expansion process is now generally preferred for natural gas liquids recovery because it provides maximum simplicity with ease of startup, operating flexibility, good efficiency, safety, and good reliability. U.S. Patent Nos. 3,292,380; 4,061,481; 4,140,504; 4,157,904; 4,171,964; 4,185,978; 4,251,249; 4,278,457; 4,519,824; 4,617,039; 4,687,499; 4,689,063; 4,690,702; 4,854,955; 4,869,740; 4,889,545; 5,275,005; 5,555,748; 5,566,554; 5,568,737; 5,771,712; 5,799,507; 5,881,569; 5,890,378; 5,983,664; 6,182,469; 6,578,379; 6,712,880;

6,915,662; 7,191,617; 7,219,513; reissue U.S. Patent No. 33,408; and co-pending application nos. 11/430,412; 11/839,693; 11/971,491; 12/206,230; 12/689,616; 12/717,394; 12/750,862; 12/772,472; 12/781,259; 12/868,993; 12/869,007; 12/869,139; 12/979,563; 13/048,315; and 13/051,682 describe relevant processes (although the description of the present invention in some cases is based on different processing conditions than those described in the cited U.S. Patents).

[0005] In a typical cryogenic expansion recovery process, a feed gas stream under pressure is cooled by heat exchange with other streams of the process and/or external sources of refrigeration such as a propane compression-refrigeration system. As the gas is cooled, liquids may be condensed and collected in one or more separators as high-pressure liquids containing some of the desired C₂+ components. Depending on the richness of the gas and the amount of liquids formed, the high-pressure liquids may be expanded to a lower pressure and fractionated. The vaporization occurring during expansion of the liquids results in further cooling of the stream. Under some conditions, pre-cooling the high pressure liquids prior to the expansion may be desirable in order to further lower the temperature resulting from the expansion. The expanded stream, comprising a mixture of liquid and vapor, is fractionated in a distillation (demethanizer or deethanizer) column. In the column, the expansion cooled stream(s) is (are) distilled to separate residual methane, nitrogen, and other volatile gases as overhead vapor from the desired C₂ components, C₃ components, and heavier hydrocarbon components as bottom liquid product, or to separate residual methane, C₂ components, nitrogen, and other volatile gases as overhead vapor from the desired C₃ components and heavier hydrocarbon components as bottom liquid product.

[0006] If the feed gas is not totally condensed (typically it is not), the vapor remaining from the partial condensation can be split into two streams. One portion of the vapor is passed through a work expansion machine or engine, or an expansion valve, to a lower pressure at which additional liquids are condensed as a result of further cooling of the stream. The pressure after expansion is essentially the same as the pressure at which the distillation column is operated. The combined vapor-liquid phases resulting from the expansion are supplied as feed to the column.

[0007] The remaining portion of the vapor is cooled to substantial condensation by heat exchange with other process streams, e.g., the cold fractionation tower overhead. Some or all of the high-pressure liquid may be combined with this vapor portion prior to cooling. The resulting cooled stream is then expanded through an appropriate expansion device, such as an expansion valve, to the pressure at which the demethanizer is operated. During expansion, a portion of the liquid will vaporize, resulting in cooling of the total stream. The flash expanded stream is then supplied as top feed to the demethanizer. Typically, the vapor portion of the flash expanded stream and the demethanizer overhead vapor combine in an upper separator section in the fractionation tower as residual methane product gas. Alternatively, the cooled and expanded stream may be supplied to a separator to provide vapor and liquid streams. The vapor is combined with the tower overhead and the liquid is supplied to the column as a top column feed.

[0008] In the ideal operation of such a separation process, the residue gas leaving the process will contain substantially all of the methane in the feed gas with essentially none of the heavier hydrocarbon components and the bottoms fraction leaving the demethanizer will contain substantially all of the heavier hydrocarbon components with essentially no methane or more volatile components. In practice,

however, this ideal situation is not obtained because the conventional demethanizer is operated largely as a stripping column. The methane product of the process, therefore, typically comprises vapors leaving the top fractionation stage of the column, together with vapors not subjected to any rectification step. Considerable losses of C₂, C₃, and C₄+ components occur because the top liquid feed contains substantial quantities of these components and heavier hydrocarbon components, resulting in corresponding equilibrium quantities of C₂ components, C₃ components, C₄ components, and heavier hydrocarbon components in the vapors leaving the top fractionation stage of the demethanizer. The loss of these desirable components could be significantly reduced if the rising vapors could be brought into contact with a significant quantity of liquid (reflux) capable of absorbing the C₂ components, C₃ components, C₄ components, and heavier hydrocarbon components from the vapors.

[0009] In recent years, the preferred processes for hydrocarbon separation use an upper absorber section to provide additional rectification of the rising vapors. The source of the reflux stream for the upper rectification section is typically a recycled stream of residue gas supplied under pressure. The recycled residue gas stream is usually cooled to substantial condensation by heat exchange with other process streams, e.g., the cold fractionation tower overhead. The resulting substantially condensed stream is then expanded through an appropriate expansion device, such as an expansion valve, to the pressure at which the demethanizer is operated. During expansion, a portion of the liquid will usually vaporize, resulting in cooling of the total stream. The flash expanded stream is then supplied as top feed to the demethanizer. Typically, the vapor portion of the expanded stream and the demethanizer overhead vapor combine in an upper separator section in the fractionation tower as residual methane product gas. Alternatively, the cooled and

expanded stream may be supplied to a separator to provide vapor and liquid streams, so that thereafter the vapor is combined with the tower overhead and the liquid is supplied to the column as a top column feed. Typical process schemes of this type are disclosed in U.S. Patent Nos. 4,889,545; 5,568,737; and 5,881,569, co-pending application nos. 11/430,412; 11/971,491; and 12/717,394, and in Mowrey, E. Ross, "Efficient, High Recovery of Liquids from Natural Gas Utilizing a High Pressure Absorber", Proceedings of the Eighty-First Annual Convention of the Gas Processors Association, Dallas, Texas, March 11-13, 2002.

[0010] The present invention employs a novel means of performing the various steps described above more efficiently and using fewer pieces of equipment. This is accomplished by combining what heretofore have been individual equipment items into a common housing, thereby reducing the plot space required for the processing plant and reducing the capital cost of the facility. Surprisingly, applicants have found that the more compact arrangement also significantly reduces the power consumption required to achieve a given recovery level, thereby increasing the process efficiency and reducing the operating cost of the facility. In addition, the more compact arrangement also eliminates much of the piping used to interconnect the individual equipment items in traditional plant designs, further reducing capital cost and also eliminating the associated flanged piping connections. Since piping flanges are a potential leak source for hydrocarbons (which are volatile organic compounds, VOCs, that contribute to greenhouse gases and may also be precursors to atmospheric ozone formation), eliminating these flanges reduces the potential for atmospheric emissions that can damage the environment.

[0011] In accordance with the present invention, it has been found that C₂ recoveries in excess of 95% can be obtained. Similarly, in those instances where

recovery of C₂ components is not desired, C₃ recoveries in excess of 95% can be maintained. In addition, the present invention makes possible essentially 100% separation of methane (or C₂ components) and lighter components from the C₂ components (or C₃ components) and heavier components at lower energy requirements compared to the prior art while maintaining the same recovery level. The present invention, although applicable at lower pressures and warmer temperatures, is particularly advantageous when processing feed gases in the range of 400 to 1500 psia [2,758 to 10,342 kPa(a)] or higher under conditions requiring NGL recovery column overhead temperatures of -50°F [-46°C] or colder.

[0012] For a better understanding of the present invention, reference is made to the following examples and drawings. Referring to the drawings:

[0013] FIG. 1 is a flow diagram of a prior art natural gas processing plant in accordance with United States Patent No. 5,568,737;

[0014] FIG. 2 is a flow diagram of a natural gas processing plant in accordance with the present invention; and

[0015] FIGS. 3 through 17 are flow diagrams illustrating alternative means of application of the present invention to a natural gas stream.

[0016] In the following explanation of the above figures, tables are provided summarizing flow rates calculated for representative process conditions. In the tables appearing herein, the values for flow rates (in moles per hour) have been rounded to the nearest whole number for convenience. The total stream rates shown in the tables include all non-hydrocarbon components and hence are generally larger than the sum of the stream flow rates for the hydrocarbon components. Temperatures indicated are approximate values rounded to the nearest degree. It should also be noted that the process design calculations performed for the purpose of comparing the processes

depicted in the figures are based on the assumption of no heat leak from (or to) the surroundings to (or from) the process. The quality of commercially available insulating materials makes this a very reasonable assumption and one that is typically made by those skilled in the art.

[0017] For convenience, process parameters are reported in both the traditional British units and in the units of the Système International d'Unités (SI). The molar flow rates given in the tables may be interpreted as either pound moles per hour or kilogram moles per hour. The energy consumptions reported as horsepower (HP) and/or thousand British Thermal Units per hour (MBTU/Hr) correspond to the stated molar flow rates in pound moles per hour. The energy consumptions reported as kilowatts (kW) correspond to the stated molar flow rates in kilogram moles per hour.

DESCRIPTION OF THE PRIOR ART

[0018] FIG. 1 is a process flow diagram showing the design of a processing plant to recover C₂+ components from natural gas using prior art according to U.S. Pat. No. 5,568,737. In this simulation of the process, inlet gas enters the plant at 110°F [43°C] and 915 psia [6,307 kPa(a)] as stream 31. If the inlet gas contains a concentration of sulfur compounds which would prevent the product streams from meeting specifications, the sulfur compounds are removed by appropriate pretreatment of the feed gas (not illustrated). In addition, the feed stream is usually dehydrated to prevent hydrate (ice) formation under cryogenic conditions. Solid desiccant has typically been used for this purpose.

[0019] The feed stream 31 is divided into two portions, streams 32 and 33. Stream 32 is cooled to -26°F [-32°C] in heat exchanger 10 by heat exchange with cool

distillation vapor stream **41a**, while stream **33** is cooled to -32°F [-35°C] in heat exchanger **11** by heat exchange with demethanizer reboiler liquids at 41°F [5°C] (stream **43**) and side reboiler liquids at -49°F [-45°C] (stream **42**). Streams **32a** and **33a** recombine to form stream **31a**, which enters separator **12** at -28°F [-33°C] and 893 psia [6,155 kPa(a)] where the vapor (stream **34**) is separated from the condensed liquid (stream **35**).

[0020] The vapor (stream **34**) from separator **12** is divided into two streams, **36** and **39**. Stream **36**, containing about 27% of the total vapor, is combined with the separator liquid (stream **35**), and the combined stream **38** passes through heat exchanger **13** in heat exchange relation with cold distillation vapor stream **41** where it is cooled to substantial condensation. The resulting substantially condensed stream **38a** at -139°F [-95°C] is then flash expanded through expansion valve **14** to the operating pressure (approximately 396 psia [2,730 kPa(a)]) of fractionation tower **18**. During expansion a portion of the stream is vaporized, resulting in cooling of the total stream. In the process illustrated in FIG. 1, the expanded stream **38b** leaving expansion valve **14** reaches a temperature of -140°F [-95°C] and is supplied to fractionation tower **18** at a first mid-column feed point.

[0021] The remaining 73% of the vapor from separator **12** (stream **39**) enters a work expansion machine **15** in which mechanical energy is extracted from this portion of the high pressure feed. The machine **15** expands the vapor substantially isentropically to the tower operating pressure, with the work expansion cooling the expanded stream **39a** to a temperature of approximately -95°F [-71°C]. The typical commercially available expanders are capable of recovering on the order of 80-85% of the work theoretically available in an ideal isentropic expansion. The work

recovered is often used to drive a centrifugal compressor (such as item 16) that can be used to re-compress the heated distillation vapor stream (stream 41b), for example. The partially condensed expanded stream 39a is thereafter supplied as feed to fractionation tower 18 at a second mid-column feed point.

[0022] The recompressed and cooled distillation vapor stream 41e is divided into two streams. One portion, stream 46, is the volatile residue gas product. The other portion, recycle stream 45, flows to heat exchanger 10 where it is cooled to -26°F [-32°C] by heat exchange with cool distillation vapor stream 41a. The cooled recycle stream 45a then flows to exchanger 13 where it is cooled to -139°F [-95°C] and substantially condensed by heat exchange with cold distillation vapor stream 41. The substantially condensed stream 45b is then expanded through an appropriate expansion device, such as expansion valve 22, to the demethanizer operating pressure, resulting in cooling of the total stream to -147°F [-99°C]. The expanded stream 45c is then supplied to fractionation tower 18 as the top column feed. The vapor portion (if any) of stream 45c combines with the vapors rising from the top fractionation stage of the column to form distillation vapor stream 41, which is withdrawn from an upper region of the tower.

[0023] The demethanizer in tower 18 is a conventional distillation column containing a plurality of vertically spaced trays, one or more packed beds, or some combination of trays and packing. As is often the case in natural gas processing plants, the fractionation tower may consist of two sections. The upper section 18a is a separator wherein the partially vaporized top feed is divided into its respective vapor and liquid portions, and wherein the vapor rising from the lower distillation or demethanizing section 18b is combined with the vapor portion of the top feed to form the cold demethanizer overhead vapor (stream 41) which exits the top of the tower at

-144°F [-98°C]. The lower, demethanizing section **18b** contains the trays and/or packing and provides the necessary contact between the liquids falling downward and the vapors rising upward. The demethanizing section **18b** also includes reboilers (such as the reboiler and the side reboiler described previously) which heat and vaporize a portion of the liquids flowing down the column to provide the stripping vapors which flow up the column to strip the liquid product, stream **44**, of methane and lighter components.

[0024] The liquid product stream **44** exits the bottom of the tower at 64°F [18°C], based on a typical specification of a methane to ethane ratio of 0.010:1 on a mass basis in the bottom product. The demethanizer overhead vapor stream **41** passes countercurrently to the incoming feed gas and recycle stream in heat exchanger **13** where it is heated to -40°F [-40°C] (stream **41a**) and in heat exchanger **10** where it is heated to 104°F [40°C] (stream **41b**). The distillation vapor stream is then re-compressed in two stages. The first stage is compressor **16** driven by expansion machine **15**. The second stage is compressor **20** driven by a supplemental power source which compresses the residue gas (stream **41d**) to sales line pressure. After cooling to 110°F [43°C] in discharge cooler **21**, stream **41e** is split into the residue gas product (stream **46**) and the recycle stream **45** as described earlier. Residue gas stream **46** flows to the sales gas pipeline at 915 psia [6,307 kPa(a)], sufficient to meet line requirements (usually on the order of the inlet pressure).

[0025] A summary of stream flow rates and energy consumption for the process illustrated in FIG. 1 is set forth in the following table:

Table I

(FIG. 1)

Stream Flow Summary - Lb. Moles/Hr [kg moles/Hr]

<u>Stream</u>	<u>Methane</u>	<u>Ethane</u>	<u>Propane</u>	<u>Butanes+</u>	<u>Total</u>
31	12,398	546	233	229	13,726
32	8,431	371	159	156	9,334
33	3,967	175	74	73	4,392
34	12,195	501	179	77	13,261
35	203	45	54	152	465
36	3,317	136	49	21	3,607
38	3,520	181	103	173	4,072
39	8,878	365	130	56	9,654
41	13,765	30	0	0	13,992
45	1,377	3	0	0	1,400
46	12,388	27	0	0	12,592
44	10	519	233	229	1,134

Recoveries*

Ethane	94.99%
Propane	99.99%
Butanes+	100.00%

Power

Residue Gas Compression	6,149 HP	[10,109 kW]
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* (Based on un-rounded flow rates)

DESCRIPTION OF THE INVENTION

[0026] FIG. 2 illustrates a flow diagram of a process in accordance with the present invention. The feed gas composition and conditions considered in the process presented in FIG. 2 are the same as those in FIG. 1. Accordingly, the FIG. 2 process can be compared with that of the FIG. 1 process to illustrate the advantages of the present invention.

[0027] In the simulation of the FIG. 2 process, inlet gas enters the plant as stream **31** and is divided into two portions, streams **32** and **33**. The first portion, stream **32**, enters a heat exchange means in the upper region of feed cooling section **118a** inside processing assembly **118**. This heat exchange means may be comprised of a fin and tube type heat exchanger, a plate type heat exchanger, a brazed aluminum type heat exchanger, or other type of heat transfer device, including multi-pass and/or multi-service heat exchangers. The heat exchange means is configured to provide heat exchange between stream **32** flowing through one pass of the heat exchange means and a distillation vapor stream arising from separator section **118b** inside processing assembly **118** that has been heated in a heat exchange means in the lower

region of feed cooling section **118a**. Stream **32** is cooled while further heating the distillation vapor stream, with stream **32a** leaving the heat exchange means at -25°F [-32°C].

[0028] The second portion, stream **33**, enters a heat and mass transfer means in demethanizing section **118e** inside processing assembly **118**. This heat and mass transfer means may also be comprised of a fin and tube type heat exchanger, a plate type heat exchanger, a brazed aluminum type heat exchanger, or other type of heat transfer device, including multi-pass and/or multi-service heat exchangers. The heat and mass transfer means is configured to provide heat exchange between stream **33** flowing through one pass of the heat and mass transfer means and a distillation liquid stream flowing downward from absorbing section **118d** inside processing assembly **118**, so that stream **33** is cooled while heating the distillation liquid stream, cooling stream **33a** to -47°F [-44°C] before it leaves the heat and mass transfer means. As the distillation liquid stream is heated, a portion of it is vaporized to form stripping vapors that rise upward as the remaining liquid continues flowing downward through the heat and mass transfer means. The heat and mass transfer means provides continuous contact between the stripping vapors and the distillation liquid stream so that it also functions to provide mass transfer between the vapor and liquid phases, stripping the liquid product stream **44** of methane and lighter components.

[0029] Streams **32a** and **33a** recombine to form stream **31a**, which enters separator section **118f** inside processing assembly **118** at -32°F [-36°C] and 900 psia [6,203 kPa(a)], whereupon the vapor (stream **34**) is separated from the condensed liquid (stream **35**). Separator section **118f** has an internal head or other means to divide it from demethanizing section **118e**, so that the two sections inside processing assembly **118** can operate at different pressures.

[0030] The vapor (stream 34) from separator section 118f is divided into two streams, 36 and 39. Stream 36, containing about 27% of the total vapor, is combined with the separated liquid (stream 35, via stream 37), and the combined stream 38 enters a heat exchange means in the lower region of feed cooling section 118a inside processing assembly 118. This heat exchange means may likewise be comprised of a fin and tube type heat exchanger, a plate type heat exchanger, a brazed aluminum type heat exchanger, or other type of heat transfer device, including multi-pass and/or multi-service heat exchangers. The heat exchange means is configured to provide heat exchange between stream 38 flowing through one pass of the heat exchange means and the distillation vapor stream arising from separator section 118b, so that stream 38 is cooled to substantial condensation while heating the distillation vapor stream.

[0031] The resulting substantially condensed stream 38a at -138°F [-95°C] is then flash expanded through expansion valve 14 to the operating pressure (approximately 400 psia [2,758 kPa(a)]) of rectifying section 118c (an absorbing means) and absorbing section 118d (another absorbing means) inside processing assembly 118. During expansion a portion of the stream may be vaporized, resulting in cooling of the total stream. In the process illustrated in FIG. 2, the expanded stream 38b leaving expansion valve 14 reaches a temperature of -139°F [-95°C] and is supplied to processing assembly 118 between rectifying section 118c and absorbing section 118d. The liquids in stream 38b combine with the liquids falling from rectifying section 118c and are directed to absorbing section 118d, while any vapors combine with the vapors rising from absorbing section 118d and are directed to rectifying section 118c.

[0032] The remaining 73% of the vapor from separator section **118f** (stream **39**) enters a work expansion machine **15** in which mechanical energy is extracted from this portion of the high pressure feed. The machine **15** expands the vapor substantially isentropically to the operating pressure of absorbing section **118d**, with the work expansion cooling the expanded stream **39a** to a temperature of approximately -99°F [-73°C]. The partially condensed expanded stream **39a** is thereafter supplied as feed to the lower region of absorbing section **118d** inside processing assembly **118**.

[0033] The recompressed and cooled distillation vapor stream **41c** is divided into two streams. One portion, stream **46**, is the volatile residue gas product. The other portion, recycle stream **45**, enters a heat exchange means in the feed cooling section **118a** inside processing assembly **118**. This heat exchange means may also be comprised of a fin and tube type heat exchanger, a plate type heat exchanger, a brazed aluminum type heat exchanger, or other type of heat transfer device, including multi-pass and/or multi-service heat exchangers. The heat exchange means is configured to provide heat exchange between stream **45** flowing through one pass of the heat exchange means and the distillation vapor stream arising from separator section **118b**, so that stream **45** is cooled to substantial condensation while heating the distillation vapor stream.

[0034] The substantially condensed recycle stream **45a** leaves the heat exchange means in feed cooling section **118a** at -138°F [-95°C] and is flash expanded through expansion valve **22** to the operating pressure of rectifying section **118c** inside processing assembly **118**. During expansion a portion of the stream is vaporized, resulting in cooling of the total stream. In the process illustrated in FIG. 2, the expanded stream **45b** leaving expansion valve **22** reaches a temperature of -146°F

[-99°C] and is supplied to separator section **118b** inside processing assembly **118**.

The liquids separated therein are directed to rectifying section **118c**, while the remaining vapors combine with the vapors rising from rectifying section **118c** to form the distillation vapor stream that is heated in cooling section **118a**.

[0035] Rectifying section **118c** and absorbing section **118d** each contain an absorbing means consisting of a plurality of vertically spaced trays, one or more packed beds, or some combination of trays and packing. The trays and/or packing in rectifying section **118c** and absorbing section **118d** provide the necessary contact between the vapors rising upward and cold liquid falling downward. The liquid portion of the expanded stream **39a** commingles with liquids falling downward from absorbing section **118d** and the combined liquid continues downward into demethanizing section **118e**. The stripping vapors arising from demethanizing section **118e** combine with the vapor portion of the expanded stream **39a** and rise upward through absorbing section **118d**, to be contacted with the cold liquid falling downward to condense and absorb most of the C₂ components, C₃ components, and heavier components from these vapors. The vapors arising from absorbing section **118d** combine with any vapor portion of the expanded stream **38b** and rise upward through rectifying section **118c**, to be contacted with the cold liquid portion of expanded stream **45b** falling downward to condense and absorb most of the C₂ components, C₃ components, and heavier components remaining in these vapors. The liquid portion of the expanded stream **38b** commingles with liquids falling downward from rectifying section **118c** and the combined liquid continues downward into absorbing section **118d**.

[0036] The distillation liquid flowing downward from the heat and mass transfer means in demethanizing section **118e** inside processing assembly **118** has

been stripped of methane and lighter components. The resulting liquid product (stream **44**) exits the lower region of demethanizing section **118e** and leaves processing assembly **118** at 65°F [18°C]. The distillation vapor stream arising from separator section **118b** is warmed in feed cooling section **118a** as it provides cooling to streams **32**, **38**, and **45** as described previously, and the resulting distillation vapor stream **41** leaves processing assembly **118** at 105°F [40°C]. The distillation vapor stream is then re-compressed in two stages, compressor **16** driven by expansion machine **15** and compressor **20** driven by a supplemental power source. After stream **41b** is cooled to 110°F [43°C] in discharge cooler **21** to form stream **41c**, recycle stream **45** is withdrawn as described earlier, forming residue gas stream **46** which thereafter flows to the sales gas pipeline at 915 psia [6,307 kPa(a)].

[0037] A summary of stream flow rates and energy consumption for the process illustrated in FIG. 2 is set forth in the following table:

Table II

(FIG. 2)

Stream Flow Summary - Lb. Moles/Hr [kg moles/Hr]

<u>Stream</u>	<u>Methane</u>	<u>Ethane</u>	<u>Propane</u>	<u>Butanes+</u>	<u>Total</u>
31	12,398	546	233	229	13,726
32	8,679	382	163	160	9,608
33	3,719	164	70	69	4,118
34	12,164	495	174	72	13,213
35	234	51	59	157	513
36	3,248	132	46	19	3,528
37	234	51	59	157	513
38	3,482	183	105	176	4,041
39	8,916	363	128	53	9,685
40	0	0	0	0	0
41	13,863	30	0	0	14,095
45	1,475	3	0	0	1,500
46	12,388	27	0	0	12,595
44	10	519	233	229	1,131

Recoveries*

Ethane	95.03%
Propane	99.99%
Butanes+	100.00%

Power

Residue Gas Compression	5,787 HP	[9,514 kW]
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* (Based on un-rounded flow rates)

[0038] A comparison of Tables I and II shows that the present invention maintains essentially the same recoveries as the prior art. However, further comparison of Tables I and II shows that the product yields were achieved using significantly less power than the prior art. In terms of the recovery efficiency (defined by the quantity of ethane recovered per unit of power), the present invention represents more than a 6% improvement over the prior art of the FIG. 1 process.

[0039] The improvement in recovery efficiency provided by the present invention over that of the prior art of the FIG. 1 process is primarily due to two factors. First, the compact arrangement of the heat exchange means in feed cooling section **118a** and the heat and mass transfer means in demethanizing section **118e** in processing assembly **118** eliminates the pressure drop imposed by the interconnecting piping found in conventional processing plants. The result is that the portion of the feed gas flowing to expansion machine **15** is at higher pressure for the present invention compared to the prior art, allowing expansion machine **15** in the present invention to produce as much power with a higher outlet pressure as expansion machine **15** in the prior art can produce at a lower outlet pressure. Thus, rectifying

section **118c** and absorbing section **118d** in processing assembly **118** of the present invention can operate at higher pressure than fractionation column **18** of the prior art while maintaining the same recovery level. This higher operating pressure, plus the reduction in pressure drop for the distillation vapor stream due to eliminating the interconnecting piping, results in a significantly higher pressure for the distillation vapor stream entering compressor **20**, thereby reducing the power required by the present invention to restore the residue gas to pipeline pressure.

[0040] Second, using the heat and mass transfer means in demethanizing section **118e** to simultaneously heat the distillation liquid leaving absorbing section **118d** while allowing the resulting vapors to contact the liquid and strip its volatile components is more efficient than using a conventional distillation column with external reboilers. The volatile components are stripped out of the liquid continuously, reducing the concentration of the volatile components in the stripping vapors more quickly and thereby improving the stripping efficiency for the present invention.

[0041] The present invention offers two other advantages over the prior art in addition to the increase in processing efficiency. First, the compact arrangement of processing assembly **118** of the present invention replaces five separate equipment items in the prior art (heat exchangers **10**, **11**, and **13**; separator **12**; and fractionation tower **18** in FIG. 1) with a single equipment item (processing assembly **118** in FIG. 2). This reduces the plot space requirements and eliminates the interconnecting piping, reducing the capital cost of a process plant utilizing the present invention over that of the prior art. Second, elimination of the interconnecting piping means that a processing plant utilizing the present invention has far fewer flanged connections compared to the prior art, reducing the number of potential leak sources in the plant.

Hydrocarbons are volatile organic compounds (VOCs), some of which are classified as greenhouse gases and some of which may be precursors to atmospheric ozone formation, which means the present invention reduces the potential for atmospheric releases that can damage the environment.

Other Embodiments

[0042] Some circumstances may favor eliminating feed cooling section **118a** from processing assembly **118**, and using a heat exchange means external to the processing assembly for feed cooling, such as heat exchanger **10** shown in FIGS. 10 through 17. Such an arrangement allows processing assembly **118** to be smaller, which may reduce the overall plant cost and/or shorten the fabrication schedule in some cases. Note that in all cases exchanger **10** is representative of either a multitude of individual heat exchangers or a single multi-pass heat exchanger, or any combination thereof. Each such heat exchanger may be comprised of a fin and tube type heat exchanger, a plate type heat exchanger, a brazed aluminum type heat exchanger, or other type of heat transfer device, including multi-pass and/or multi-service heat exchangers.

[0043] Some circumstances may favor supplying liquid stream **35** directly to the lower region of absorbing section **118d** via stream **40** as shown in FIGS. 2, 4, 6, 8, 10, 12, 14, and 16. In such cases, an appropriate expansion device (such as expansion valve **17**) is used to expand the liquid to the operating pressure of absorbing section **118d** and the resulting expanded liquid stream **40a** is supplied as feed to the lower region of absorbing section **118d** (as shown by the dashed lines). Some circumstances may favor combining a portion of liquid stream **35** (stream **37**) with the vapor in stream **36** (FIGS. 2, 6, 10, and 14) or with cooled second portion **33a**

(FIGS. 4, 8, 12, and 16) to form combined stream **38** and routing the remaining portion of liquid stream **35** to the lower region of absorbing section **118d** via streams **40/40a**. Some circumstances may favor combining the expanded liquid stream **40a** with expanded stream **39a** (FIGS. 2, 6, 10, and 14) or expanded stream **34a** (FIGS. 4, 8, 12, and 16) and thereafter supplying the combined stream to the lower region of absorbing section **118d** as a single feed.

[0044] If the feed gas is richer, the quantity of liquid separated in stream **35** may be great enough to favor placing an additional mass transfer zone in demethanizing section **118e** between expanded stream **39a** and expanded liquid stream **40a** as shown in FIGS. 3, 7, 11, and 15, or between expanded stream **34a** and expanded liquid stream **40a** as shown in FIGS. 5, 9, 13, and 17. In such cases, the heat and mass transfer means in demethanizing section **118e** may be configured in upper and lower parts so that expanded liquid stream **40a** can be introduced between the two parts. As shown by the dashed lines, some circumstances may favor combining a portion of liquid stream **35** (stream **37**) with the vapor in stream **36** (FIGS. 3, 7, 11, and 15) or with cooled second portion **33a** (FIGS. 5, 9, 13, and 17) to form combined stream **38**, while the remaining portion of liquid stream **35** (stream **40**) is expanded to lower pressure and supplied between the upper and lower parts of the heat and mass transfer means in demethanizing section **118e** as stream **40a**.

[0045] Some circumstances may favor not combining the cooled first and second portions (streams **32a** and **33a**) as shown in FIGS. 4, 5, 8, 9, 12, 13, 16, and 17. In such cases, only the cooled first portion **32a** is directed to separator section **118f** inside processing assembly **118** (FIGS. 4, 5, 12, and 13) or separator **12** (FIGS. 8, 9, 16, and 17) where the vapor (stream **34**) is separated from the condensed liquid (stream **35**). Vapor stream **34** enters work expansion machine **15** and is

expanded substantially isentropically to the operating pressure of absorbing section **118d**, whereupon expanded stream **34a** is supplied as feed to the lower region of absorbing section **118d** inside processing assembly **118**. The cooled second portion **33a** is combined with the separated liquid (stream **35**, via stream **37**), and the combined stream **38** is directed to the heat exchange means in the lower region of feed cooling section **118a** inside processing assembly **118** (or in heat exchanger **10** external to processing assembly **118**) and cooled to substantial condensation. The substantially condensed stream **38a** is flash expanded through expansion valve **14** to the operating pressure of rectifying section **118c** and absorbing section **118d**, whereupon expanded stream **38b** is supplied to processing assembly **118** between rectifying section **118c** and absorbing section **118d**. Some circumstances may favor combining only a portion (stream **37**) of liquid stream **35** with the cooled second portion **33a**, with the remaining portion (stream **40**) supplied to the lower region of absorbing section **118d** via expansion valve **17**. Other circumstances may favor sending all of liquid stream **35** to the lower region of absorbing section **118d** via expansion valve **17**.

[0046] In some circumstances, it may be advantageous to use an external separator vessel to separate cooled feed stream **31a** or cooled first portion **32a**, rather than including separator section **118f** in processing assembly **118**. As shown in FIGS. 6, 7, 14, and 15, separator **12** can be used to separate cooled feed stream **31a** into vapor stream **34** and liquid stream **35**. Likewise, as shown in FIGS. 8, 9, 16, and 17, separator **12** can be used to separate cooled first portion **32a** into vapor stream **34** and liquid stream **35**.

[0047] Depending on the quantity of heavier hydrocarbons in the feed gas and the feed gas pressure, the cooled feed stream **31a** entering separator section **118f** in

FIGS. 2, 3, 10, and 11 or separator **12** in FIGS. 6, 7, 14, and 15 (or the cooled first portion **32a** entering separator section **118f** in FIGS. 4, 5, 12, and 13 or separator **12** in FIGS. 8, 9, 16, and 17) may not contain any liquid (because it is above its dewpoint, or because it is above its cricondenbar). In such cases, there is no liquid in streams **35** and **37** (as shown by the dashed lines), so only the vapor from separator section **118f** in stream **36** (FIGS. 2, 3, 10, and 11), the vapor from separator **12** in stream **36** (FIGS. 6, 7, 14, and 15), or the cooled second portion **33a** (FIGS. 4, 5, 8, 9, 12, 13, 16, and 17) flows to stream **38** to become the expanded substantially condensed stream **38b** supplied to processing assembly **118** between rectifying section **118c** and absorbing section **118d**. In such circumstances, separator section **118f** in processing assembly **118** (FIGS. 2 through 5 and 10 through 13) or separator **12** (FIGS. 6 through 9 and 14 through 17) may not be required.

[0048] Feed gas conditions, plant size, available equipment, or other factors may indicate that elimination of work expansion machine **15**, or replacement with an alternate expansion device (such as an expansion valve), is feasible. Although individual stream expansion is depicted in particular expansion devices, alternative expansion means may be employed where appropriate. For example, conditions may warrant work expansion of the substantially condensed portion of the feed stream (stream **38a**) or the substantially condensed recycle stream (stream **45a**).

[0049] In accordance with the present invention, the use of external refrigeration to supplement the cooling available to the inlet gas from the distillation vapor and liquid streams may be employed, particularly in the case of a rich inlet gas. In such cases, a heat and mass transfer means may be included in separator section **118f** (or a gas collecting means in such cases when the cooled feed stream **31a** or the cooled first portion **32a** contains no liquid) as shown by the dashed lines in FIGS. 2

through 5 and 10 through 13, or a heat and mass transfer means may be included in separator **12** as shown by the dashed lines in FIGS. 6 through 9 and 14 through 17. This heat and mass transfer means may be comprised of a fin and tube type heat exchanger, a plate type heat exchanger, a brazed aluminum type heat exchanger, or other type of heat transfer device, including multi-pass and/or multi-service heat exchangers. The heat and mass transfer means is configured to provide heat exchange between a refrigerant stream (e.g., propane) flowing through one pass of the heat and mass transfer means and the vapor portion of stream **31a** (FIGS. 2, 3, 6, 7, 10, 11, 14, and 15) or stream **32a** (FIGS. 4, 5, 8, 9, 12, 13, 16, and 17) flowing upward, so that the refrigerant further cools the vapor and condenses additional liquid, which falls downward to become part of the liquid removed in stream **35**. Alternatively, conventional gas chiller(s) could be used to cool stream **32a**, stream **33a**, and/or stream **31a** with refrigerant before stream **31a** enters separator section **118f** (FIGS. 2, 3, 10, and 11) or separator **12** (FIGS. 6, 7, 14, and 15) or stream **32a** enters separator section **118f** (FIGS. 4, 5, 12, and 13) or separator **12** (FIGS. 8, 9, 16, and 17).

[0050] Depending on the temperature and richness of the feed gas and the amount of C₂ components to be recovered in liquid product stream **44**, there may not be sufficient heating available from stream **33** to cause the liquid leaving demethanizing section **118e** to meet the product specifications. In such cases, the heat and mass transfer means in demethanizing section **118e** may include provisions for providing supplemental heating with heating medium as shown by the dashed lines in FIGS. 2 through 17. Alternatively, another heat and mass transfer means can be included in the lower region of demethanizing section **118e** for providing supplemental heating, or stream **33** can be heated with heating medium before it is supplied to the heat and mass transfer means in demethanizing section **118e**.

[0051] Depending on the type of heat transfer devices selected for the heat exchange means in the upper and lower regions of feed cooling section **118a**, it may be possible to combine these heat exchange means in a single multi-pass and/or multi-service heat transfer device. In such cases, the multi-pass and/or multi-service heat transfer device will include appropriate means for distributing, segregating, and collecting stream **32**, stream **38**, stream **45**, and the distillation vapor stream in order to accomplish the desired cooling and heating.

[0052] Some circumstances may favor providing additional mass transfer in the upper region of demethanizing section **118e**. In such cases, a mass transfer means can be located below where expanded stream **39a** (FIGS. 2, 3, 6, 7, 10, 11, 14, and 15) or expanded stream **34a** (FIGS. 4, 5, 8, 9, 12, 13, 16, and 17) enters the lower region of absorbing section **118d** and above where cooled second portion **33a** leaves the heat and mass transfer means in demethanizing section **118e**.

[0053] A less preferred option for the FIGS. 2, 3, 6, 7, 10, 11, 14, and 15 embodiments of the present invention is providing a separator vessel for cooled first portion **32a**, a separator vessel for cooled second portion **33a**, combining the vapor streams separated therein to form vapor stream **34**, and combining the liquid streams separated therein to form liquid stream **35**. Another less preferred option for the present invention is cooling stream **37** in a separate heat exchange means inside feed cooling section **118a** in FIGS. 2, 3, 4, 5, 6, 7, 8, and 9 or a separate pass in heat exchanger **10** in FIGS. 10, 11, 12, 13, 14, 15, 16, and 17 (rather than combining stream **37** with stream **36** or stream **33a** to form combined stream **38**), expanding the cooled stream in a separate expansion device, and supplying the expanded stream to an intermediate region in absorbing section **118d**.

[0054] It will be recognized that the relative amount of feed found in each branch of the split vapor feed will depend on several factors, including gas pressure, feed gas composition, the amount of heat which can economically be extracted from the feed, and the quantity of horsepower available. More feed above absorbing section **118d** may increase recovery while decreasing power recovered from the expander and thereby increasing the recompression horsepower requirements. Increasing feed below absorbing section **118d** reduces the horsepower consumption but may also reduce product recovery.

[0055] The present invention provides improved recovery of C₂ components, C₃ components, and heavier hydrocarbon components or of C₃ components and heavier hydrocarbon components per amount of utility consumption required to operate the process. An improvement in utility consumption required for operating the process may appear in the form of reduced power requirements for compression or re-compression, reduced power requirements for external refrigeration, reduced energy requirements for supplemental heating, or a combination thereof.

[0056] While there have been described what are believed to be preferred embodiments of the invention, those skilled in the art will recognize that other and further modifications may be made thereto, e.g. to adapt the invention to various conditions, types of feed, or other requirements.

WE CLAIM:

1. A process for the separation of a gas stream containing methane, C₂ components, C₃ components, and heavier hydrocarbon components into a volatile residue gas fraction and a relatively less volatile fraction containing a major portion of said C₂ components, C₃ components, and heavier hydrocarbon components or said C₃ components and heavier hydrocarbon components wherein

(1) said gas stream is divided into first and second portions;

(2) said first portion is cooled;

(3) said second portion is cooled;

(4) said cooled first portion is combined with said cooled second portion to form a cooled gas stream;

(5) said cooled gas stream is divided into first and second streams;

(6) said first stream is cooled to condense substantially all of said first stream and is thereafter expanded to lower pressure whereby said first stream is further cooled;

(7) said expanded cooled first stream is supplied as a feed between first and second absorbing means housed in a single equipment item processing assembly, said first absorbing means being located above said second absorbing means;

(8) said second stream is expanded to said lower pressure and is supplied as a bottom feed to said second absorbing means;

(9) a distillation vapor stream is collected from an upper region of said first absorbing means and heated;

(10) said heated distillation vapor stream is compressed to higher pressure and thereafter divided into said volatile residue gas fraction and a compressed recycle stream;

(11) said compressed recycle stream is cooled to condense substantially all of said compressed recycle stream;

(12) said substantially condensed compressed recycle stream is expanded to said lower pressure and supplied as a top feed to said first absorbing means;

(13) said heating of said distillation vapor stream is accomplished in one or more heat exchange means, thereby to supply at least a portion of the cooling of steps (2), (6), and (11);

(14) a distillation liquid stream is collected from a lower region of said second absorbing means and heated in a heat and mass transfer means housed in said processing assembly, thereby to supply at least a portion of the cooling of step (3) while simultaneously stripping the more volatile components from said distillation liquid stream, and thereafter discharging said heated and stripped distillation liquid stream from said processing assembly as said relatively less volatile fraction; and

(15) the quantities and temperatures of said feed streams to said first and second absorbing means are effective to maintain the temperature of said upper region of said first absorbing means at a temperature whereby the major portions of the components in said relatively less volatile fraction are recovered.

2. The process according to claim 1 wherein

- (a) said cooled first portion is combined with said cooled second portion to form a partially condensed gas stream;
- (b) said partially condensed gas stream is supplied to a separating means and is separated therein to provide a vapor stream and at least one liquid stream;
- (c) said vapor stream is divided into said first and second streams; and
- (d) at least a portion of said at least one liquid stream is expanded to said lower pressure and is supplied as an additional bottom feed to said second absorbing means.

3. The process according to claim 2 wherein

- (a) said first stream is combined with at least a portion of said at least one liquid stream to form a combined stream;
- (b) said combined stream is cooled to condense substantially all of said combined stream and is thereafter expanded to lower pressure whereby said combined stream is further cooled;
- (c) said expanded cooled combined stream is supplied as said feed between said first and second absorbing means; and
- (d) any remaining portion of said at least one liquid stream is expanded to said lower pressure and is supplied as said additional bottom feed to said second absorbing means.

4. The process according to claim 1 wherein

- (a) said first portion is cooled and is thereafter expanded to lower pressure;
- (b) said second portion is cooled to condense substantially all of said second portion and is thereafter expanded to said lower pressure whereby said second portion is further cooled;
- (c) said expanded cooled second portion is supplied as said feed between said first and second absorbing means; and
- (d) said expanded cooled first portion is supplied as said bottom feed to said second absorbing means.

5. The process according to claim 4 wherein

- (a) said first portion is cooled sufficiently to partially condense said first portion;
- (b) said partially condensed first portion is supplied to a separating means and is separated therein to provide a vapor stream and at least one liquid stream;
- (c) said vapor stream is expanded to said lower pressure and is supplied as said first bottom feed to said second absorbing means; and
- (d) at least a portion of said at least one liquid stream is expanded to said lower pressure and is supplied as an additional bottom feed to said second absorbing means.

6. The process according to claim 5 wherein

- (a) said second portion is cooled and is thereafter combined with at least a portion of said at least one liquid stream to form a combined stream;
- (b) said combined stream is cooled to condense substantially all of said combined stream and is thereafter expanded to lower pressure whereby said combined stream is further cooled;
- (c) said expanded cooled combined stream is supplied as said feed between said first and second absorbing means; and
- (d) any remaining portion of said at least one liquid stream is expanded to said lower pressure and is supplied as said additional bottom feed to said second absorbing means.

7. The process according to claim 2 wherein

- (1) said heat and mass transfer means is arranged in upper and lower regions; and

(2) said expanded at least a portion of said at least one liquid stream is supplied to said processing assembly to enter between said upper and lower regions of said heat and mass transfer means.

8. The process according to claim 3 wherein

(1) said heat and mass transfer means is arranged in upper and lower regions; and

(2) said expanded any remaining portion of said at least one liquid stream is supplied to said processing assembly to enter between said upper and lower regions of said heat and mass transfer means.

9. The process according to claim 5 wherein

(1) said heat and mass transfer means is arranged in upper and lower regions; and

(2) said expanded at least a portion of said at least one liquid stream is supplied to said processing assembly to enter between said upper and lower regions of said heat and mass transfer means.

10. The process according to claim 6 wherein

(1) said heat and mass transfer means is arranged in upper and lower regions; and

(2) said expanded any remaining portion of said at least one liquid stream is supplied to said processing assembly to enter between said upper and lower regions of said heat and mass transfer means.

11. The process according to claim 7, 8, 9, 10, 2, 3, 5, or 6 wherein said separating means is housed in said processing assembly.

12. The process according to claim 1 wherein

(1) a gas collecting means is housed in said processing assembly;

(2) an additional heat and mass transfer means is included inside said gas collecting means, said additional heat and mass transfer means including one or more passes for an external refrigeration medium;

(3) said cooled gas stream is supplied to said gas collecting means and directed to said additional heat and mass transfer means to be further cooled by said external refrigeration medium; and

(4) said further cooled gas stream is divided into said first and second streams.

13. The process according to claim 4 wherein

(1) a gas collecting means is housed in said processing assembly;

(2) an additional heat and mass transfer means is included inside said gas collecting means, said additional heat and mass transfer means including one or more passes for an external refrigeration medium;

(3) said cooled first portion is supplied to said gas collecting means and directed to said additional heat and mass transfer means to be further cooled by said external refrigeration medium; and

(4) said further cooled first portion is expanded to said lower pressure and is thereafter supplied as said bottom feed to said second absorbing means.

14. The process according to claim 7, 8, 9, 10, 2, 3, 5, or 6 wherein

(1) an additional heat and mass transfer means is included inside said separating means, said additional heat and mass transfer means including one or more passes for an external refrigeration medium;

(2) said vapor stream is directed to said additional heat and mass transfer means to be cooled by said external refrigeration medium to form additional condensate; and

(3) said condensate becomes a part of said at least one liquid stream separated therein.

15. The process according to claim 11 wherein

(1) an additional heat and mass transfer means is included inside said separating means, said additional heat and mass transfer means including one or more passes for an external refrigeration medium;

(2) said vapor stream is directed to said additional heat and mass transfer means to be cooled by said external refrigeration medium to form additional condensate; and

(3) said condensate becomes a part of said at least one liquid stream separated therein.

16. The process according to claim 1, 7, 8, 9, 10, 12, 13, 2, 3, 4, 5, or 6 wherein said heat and mass transfer means includes one or more passes for an external heating medium to supplement the heating supplied by said second portion for said stripping of said more volatile components from said distillation liquid stream.

17. The process according to claim 11 wherein said heat and mass transfer means includes one or more passes for an external heating medium to supplement the heating supplied by said second portion for said stripping of said more volatile components from said distillation liquid stream.

18. The process according to claim 14 wherein said heat and mass transfer means includes one or more passes for an external heating medium to supplement the heating supplied by said second portion for said stripping of said more volatile components from said distillation liquid stream.

19. The process according to claim 15 wherein said heat and mass transfer means includes one or more passes for an external heating medium to supplement the heating supplied by said second portion for said stripping of said more volatile components from said distillation liquid stream.

20. An apparatus for the separation of a gas stream containing methane, C₂ components, C₃ components, and heavier hydrocarbon components into a volatile residue gas fraction and a relatively less volatile fraction containing a major portion of said C₂ components, C₃ components, and heavier hydrocarbon components or said C₃ components and heavier hydrocarbon components comprising

(1) first dividing means to divide said gas stream into first and second portions;

(2) heat exchange means connected to said first dividing means to receive said first portion and cool said first portion;

(3) heat and mass transfer means housed in a single equipment item processing assembly and connected to said first dividing means to receive said second portion and cool said second portion;

(4) combining means connected to said heat exchange means and said heat and mass transfer means to receive said cooled first portion and said cooled second portion and form a cooled gas stream;

(5) second dividing means connected to said combining means to receive said cooled gas stream and divide said cooled gas stream into first and second streams;

(6) said heat exchange means being further connected to said second dividing means to receive said first stream and cool said first stream sufficiently to substantially condense said first stream;

(7) first expansion means connected to said heat exchange means to receive said substantially condensed first stream and expand said substantially condensed first stream to lower pressure;

(8) first and second absorbing means housed in said processing assembly and connected to said first expansion means to receive said expanded cooled first stream as a feed thereto between said first and second absorbing means, said first absorbing means being located above said second absorbing means;

(9) second expansion means connected to said second dividing means to receive said second stream and expand said second stream to said lower pressure, said second expansion means being further connected to said second absorbing means to supply said expanded second stream as a bottom feed thereto;

(10) vapor collecting means housed in said processing assembly and connected to said first absorbing means to receive a distillation vapor stream from an upper region of said first absorbing means;

(11) said heat exchange means being further connected to said vapor collecting means to receive said distillation vapor stream and heat said distillation vapor stream, thereby to supply at least a portion of the cooling of steps (2) and (6);

(12) compressing means connected to said heat exchange means to receive said heated distillation vapor stream and compress said heated distillation vapor stream to higher pressure;

(13) cooling means connected to said compressing means to receive said compressed distillation vapor stream and cool said compressed distillation vapor stream;

(14) third dividing means connected to said cooling means to receive said cooled

compressed distillation vapor stream and divide said cooled compressed distillation vapor stream into said volatile residue gas fraction and a compressed recycle stream;

(15) said heat exchange means being further connected to said third dividing means to receive said compressed recycle stream and cool said compressed recycle stream sufficiently to substantially condense said compressed recycle stream, thereby to supply at least a portion of the heating of step (11);

(16) third expansion means connected to said heat exchange means to receive said substantially condensed compressed recycle stream and expand said substantially condensed compressed recycle stream to said lower pressure, said third expansion means being further connected to said first absorbing means to supply said expanded recycle stream as a top feed thereto;

(17) liquid collecting means housed in said processing assembly and connected to said second absorbing means to receive a distillation liquid stream from a lower region of said second absorbing means;

(18) said heat and mass transfer means being further connected to said liquid collecting means to receive said distillation liquid stream and heat said distillation liquid stream, thereby to supply at least a portion of the cooling of step (3) while simultaneously stripping the more volatile components from said distillation liquid stream, and thereafter discharging said heated and stripped distillation liquid stream from said processing assembly as said relatively less volatile fraction; and

(19) control means adapted to regulate the quantities and temperatures of said feed streams to said first and second absorbing means to maintain the temperature of said upper region of said first absorbing means at a temperature whereby the major portions of the components in said relatively less volatile fraction are recovered.

21. the apparatus according to claim 20 wherein

(a) said combining means is connected to said heat exchange means and said heat and mass transfer means to receive said cooled first portion and said cooled second portion and form a partially condensed gas stream;

(b) a separating means is connected to said combining means to receive said partially

condensed gas stream and separate said partially condensed gas stream into a vapor stream and at least one liquid stream;

(c) said second dividing means is connected to said separating means to receive said vapor stream and divide said vapor stream into said first and second streams; and

(d) a fourth expansion means is connected to said separating means to receive at least a portion of said at least one liquid stream and expand said at least one liquid stream to said lower pressure, said fourth expansion means being further connected to said second absorbing means to supply said expanded liquid stream as an additional bottom feed thereto.

22. The apparatus according to claim 21 wherein

(a) an additional combining means is connected to said second dividing means and said separating means to receive said first stream and at least a portion of said at least one liquid stream and form a combined stream;

(b) said heat exchange means is further connected to said additional combining means to receive said combined stream and cool said combined stream sufficiently to substantially condense it;

(c) said first expansion means is connected to said heat exchange means to receive said substantially condensed combined stream and expand said substantially condensed combined stream to lower pressure;

(d) said first and second absorbing means is connected to said first expansion means to receive said expanded cooled combined stream as said feed thereto between said first and second absorbing means; and

(e) said fourth expansion means is connected to said separating means to receive any remaining portion of said at least one liquid stream and expand said any remaining portion of said at least one liquid stream to said lower pressure, said fourth expansion mean being further connected to said second absorbing means to supply said expanded liquid stream as said additional second bottom feed there.

23. The apparatus according to claim 20 wherein

(a) said heat exchange means is further connected to said heat and mass transfer means to

receive said cooled second portion, and further cool said cooled second portion sufficiently to substantially condense said cooled second portion;

(b) said first expansion means is connected to said heat exchange means to receive said substantially condensed second portion and expand said substantially condensed second portion to lower pressure;

(c) said first and second absorbing means is connected to said first expansion means to receive said expanded cooled second portion as said feed thereto between said first and second absorbing means; and

(d) said second expansion means is connected to said heat exchange means to receive said cooled first portion and expand said cooled first portion to said lower pressure, said second expansion means being further connected to said second absorbing means to supply said expanded cooled first portion as said bottom feed thereto.

24. The apparatus according to claim 23 wherein

(a) said heat exchange means is connected to said first dividing means to receive said first portion and cool said first portion sufficiently to partially condense said first portion;

(b) a separating means is connected to said heat exchange means to receive said partially condensed first portion and to separate said partially condensed first portion into a vapor stream and at least one liquid stream;

(c) said second expansion means is connected to said separating means to receive said vapor stream and expand said vapor stream to said lower pressure, said second expansion means being further connected to said second absorbing means to supply said expanded vapor stream as said first bottom feed thereto; and

(d) a fourth expansion means is connected to said separating means to receive at least a portion of said at least one liquid stream and expand said at least one liquid stream to said lower pressure, said fourth expansion means being further connected to said second absorbing means to supply said expanded liquid stream as an additional bottom feed thereto.

25. The apparatus according to claim 24 wherein

(a) an additional combining means is connected to said heat and mass transfer means and

said separating means to receive said cooled second portion and at least a portion of said at least one liquid stream and form a combined stream;

(b) said heat exchange means is further connected to said additional combining means to receive said combined stream and cool said combined stream sufficiently to substantially condense it;

(c) said first expansion means is connected to said heat exchange means to receive said substantially condensed combined stream and expand said substantially condensed combined stream to lower pressure;

(d) said first and second absorbing means is connected to said first expansion means to receive said expanded cooled combined stream as said feed thereto between said first second absorbing means; and

(e) said fourth expansion means is connected to said separating means to receive any remaining portion of said at least one liquid stream and expand said any remaining portion of said at least one liquid stream to said lower pressure, said fourth expansion means being further connected to said second absorbing means to supply said expanded liquid stream as said additional bottom feed thereto.

26. The apparatus according to claim 21 wherein

(1) said heat and mass transfer means is arranged in upper and lower regions; and

(2) said processing assembly is connected to said third expansion means to receive said expanded liquid stream and direct said expanded liquid stream between said upper and lower regions of said heat and mass transfer means.

27. The apparatus according to claim 22 wherein

(1) said heat and mass transfer means is arranged in upper and lower regions; and

(2) said processing assembly is connected to said third expansion means to receive said expanded liquid stream and direct said expanded liquid stream between said upper and lower regions of said heat and mass transfer means.

28. The apparatus according to claim 24 wherein

(1) said heat and mass transfer means is arranged in upper and lower regions; and

(2) said processing assembly is connected to said third expansion means to receive said expanded liquid stream and direct said expanded liquid stream between said upper and lower regions of said heat and mass transfer means.

29. The apparatus according to claim 25 wherein

(1) said heat and mass transfer means is arranged in upper and lower regions; and

(2) said processing assembly is connected to said third expansion means to receive said expanded liquid stream and direct said expanded liquid stream between said upper and lower regions of said heat and mass transfer means.

30. The apparatus according to claims 21, 22, 24, 25, 26, 27, 28, or 29 wherein said separating means is housed in said processing assembly.

31. The apparatus according to claim 20 wherein

(1) a gas collecting means is housed in said processing assembly;

(2) an additional heat and mass transfer means is included inside said gas collecting means, said additional heat and mass transfer means including one or more passes for an external refrigeration medium;

(3) said gas collecting means is connected to said combining means to receive said cooled gas stream and direct said cooled gas stream to said additional heat and mass transfer means to be further cooled by said external refrigeration medium; and

(4) said second dividing means is adapted to be connected to said gas collecting means to receive said further cooled gas stream and divide said further cooled gas stream into said first and second streams.

32. The apparatus according to claim 23 wherein

(1) a gas collecting means is housed in said processing assembly;

(2) an additional heat and mass transfer means is included inside said gas collecting means, said additional heat and mass transfer means including one or more passes for an external

refrigeration medium;

(3) said gas collecting means is connected to said heat exchange means to receive said cooled first portion and direct said cooled first portion to said additional heat and mass transfer means to be further cooled by said external refrigeration medium; and

(4) said second expansion means is adapted to be connected to said gas collecting means to receive said further cooled first portion and expand said further cooled first portion to said lower pressure, said second expansion means being further connected to said second absorbing means to supply said expanded further cooled first portion as said bottom feed thereto.

33. The apparatus according to claims 21, 22, 24, 25, 26, 27, 28, or 29 wherein

(1) an additional heat and mass transfer means is included inside said separating means, said additional heat and mass transfer means including one or more passes for an external refrigeration medium;

(2) said vapor stream is directed to said additional heat and mass transfer means to be cooled by said external refrigeration medium to form additional condensate; and

(3) said condensate becomes a part of said at least one liquid stream separated therein.

34. The apparatus according to claim 30 wherein

(1) an additional heat and mass transfer means is included inside said separating means, said additional heat and mass transfer means including one or more passes for an external refrigeration medium;

(2) said vapor stream is directed to said additional heat and mass transfer means to be cooled by said external refrigeration medium to form additional condensate; and

(3) said condensate becomes a part of said at least one liquid stream separated therein.

35. The apparatus according to claim 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 31, or 32 wherein said heat and mass transfer means includes one or more passes for an external heating medium to supplement the heating supplied by said second portion for said stripping of said more volatile components from said distillation liquid stream.

36. The apparatus according to claim 30 wherein said heat and mass transfer means includes one or more passes for an external heating medium to supplement the heating supplied by said second portion for said stripping of said more volatile components from said distillation liquid stream.

37. The apparatus according to claim 33 wherein said heat and mass transfer means includes one or more passes for an external heating medium to supplement the heating supplied by said second portion for said stripping of said more volatile components from said distillation liquid stream.

38. The apparatus according to claim 34 wherein said heat and mass transfer means includes one or more passes for an external heating medium to supplement the heating supplied by said second portion for said stripping of said more volatile components from said distillation liquid stream.

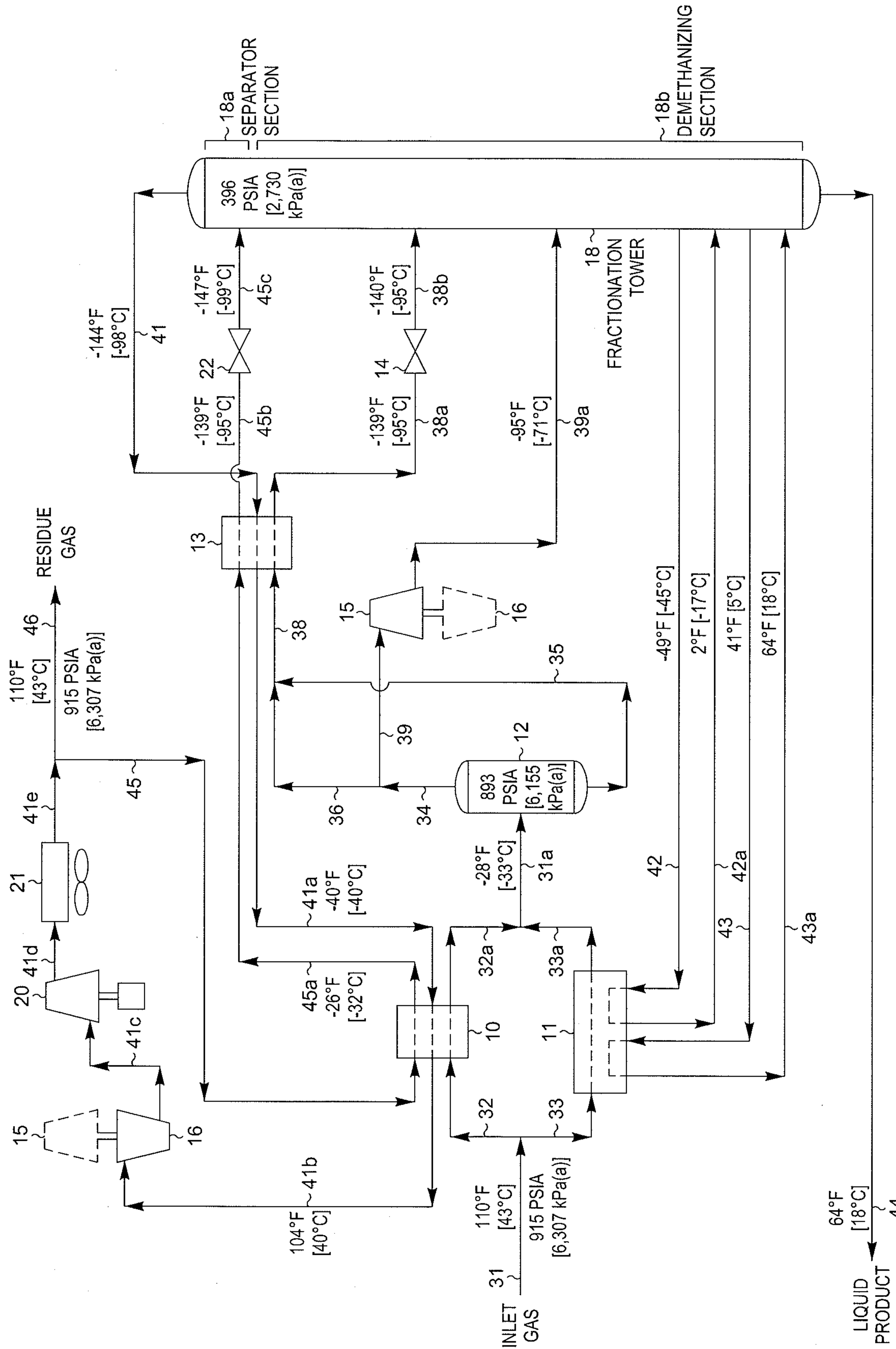
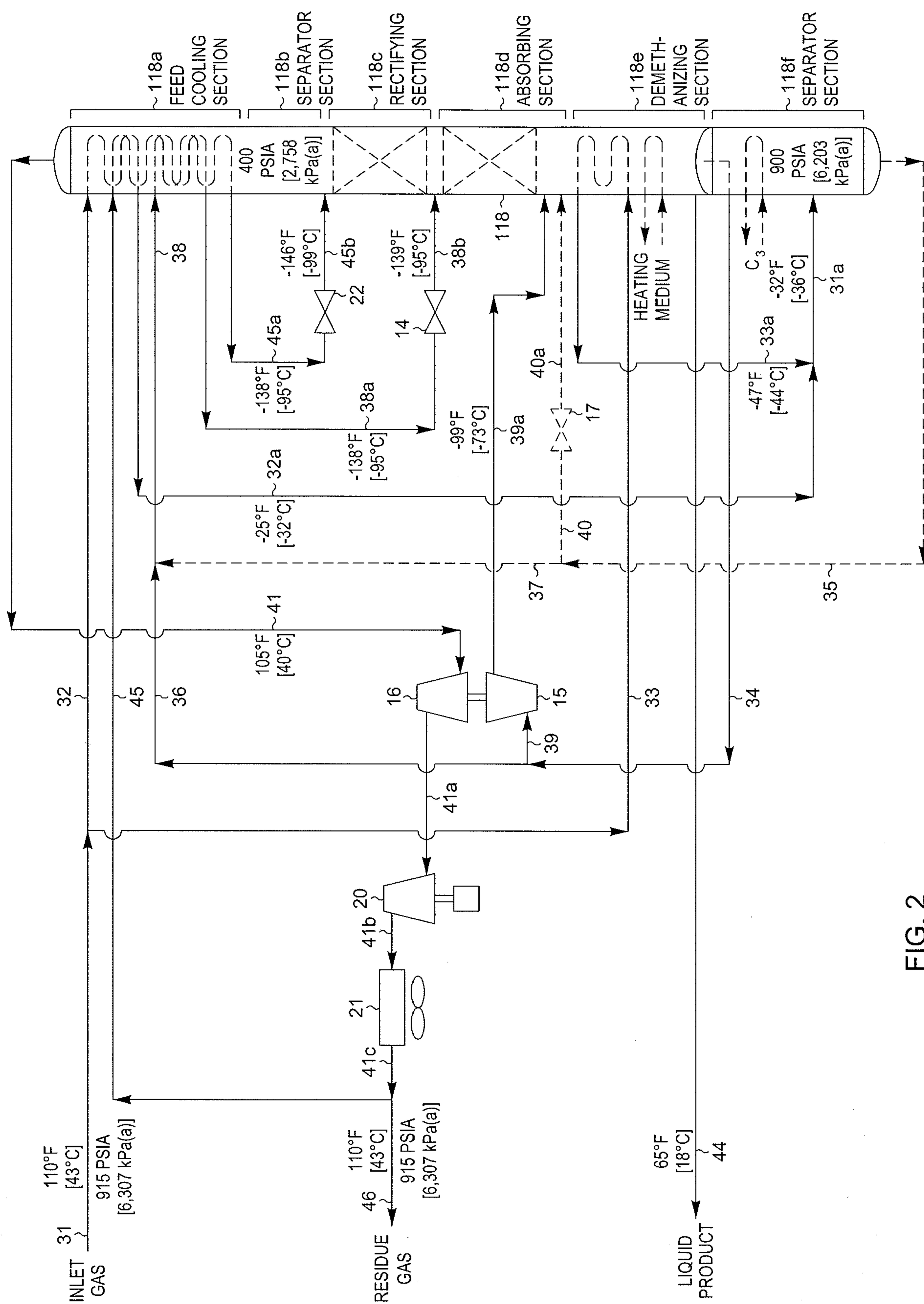
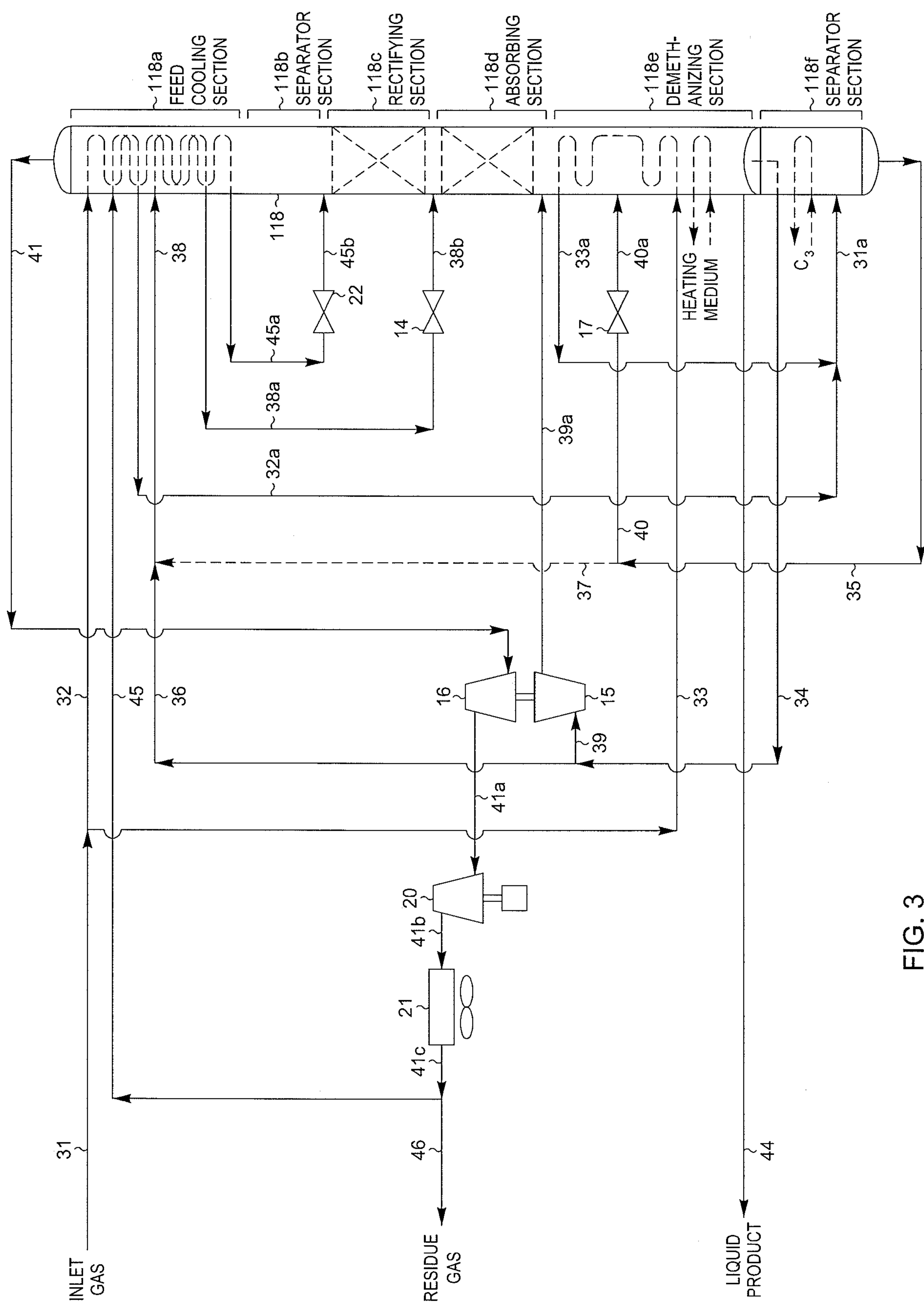
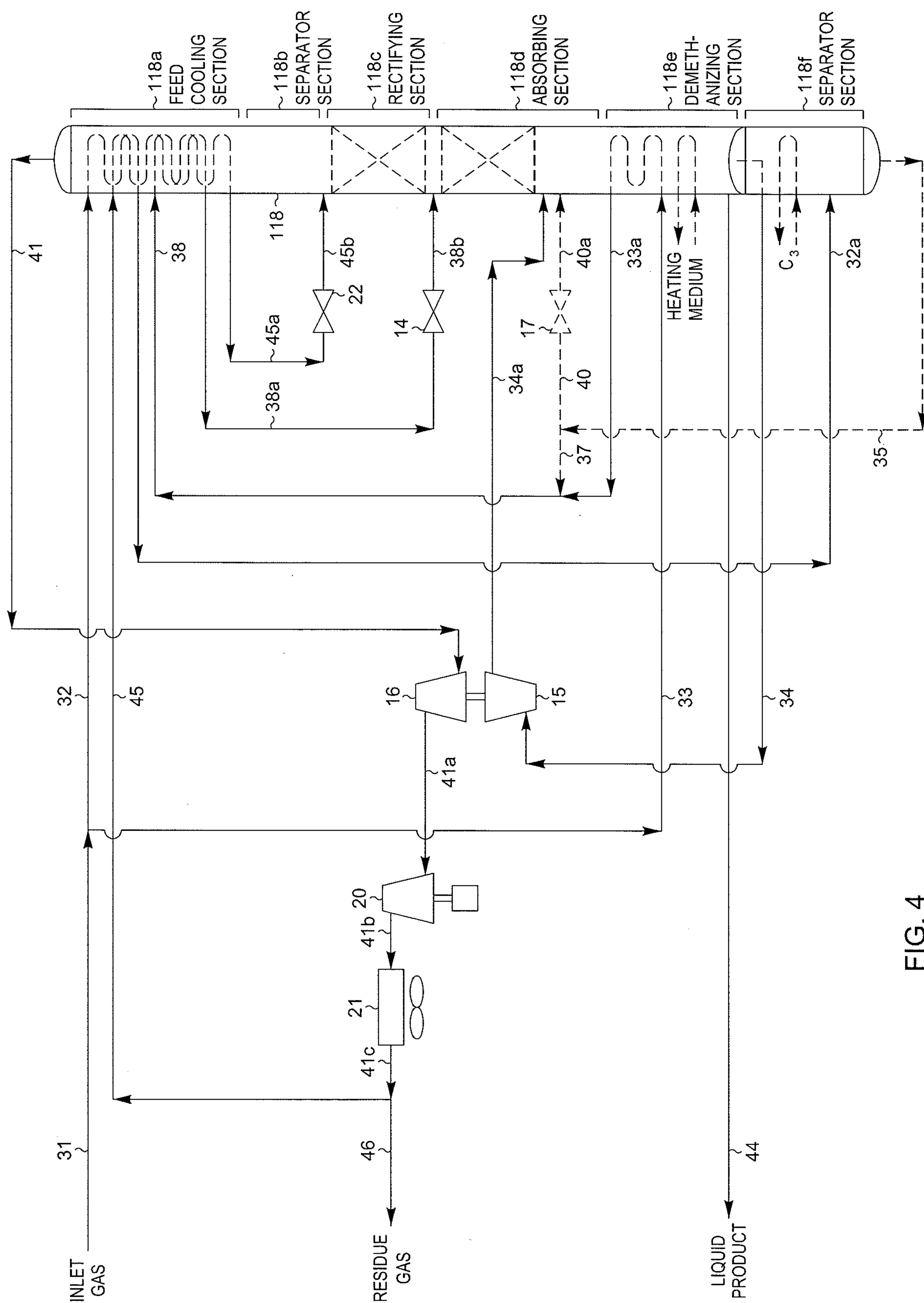


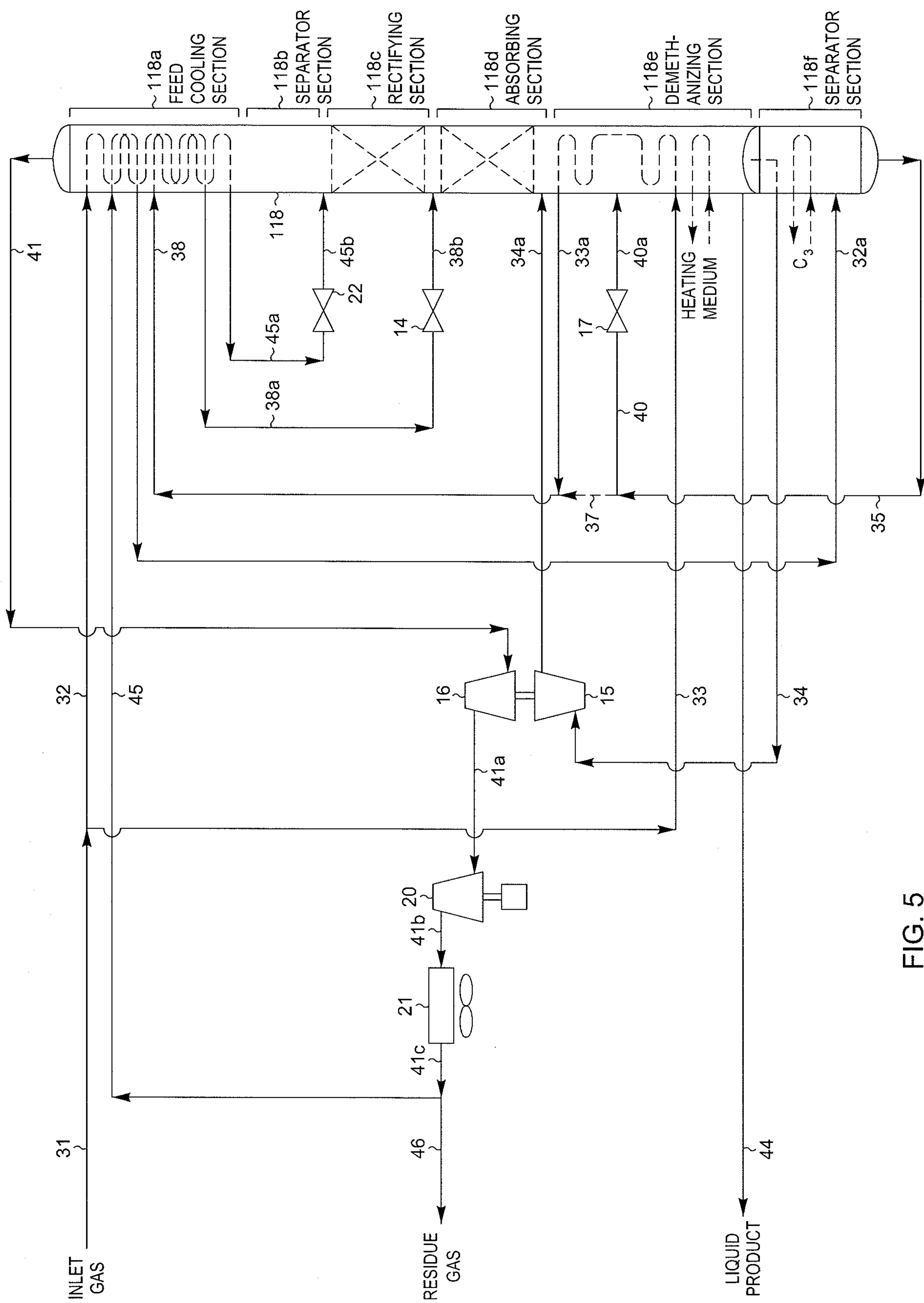
FIG. 1
(PRIOR ART)



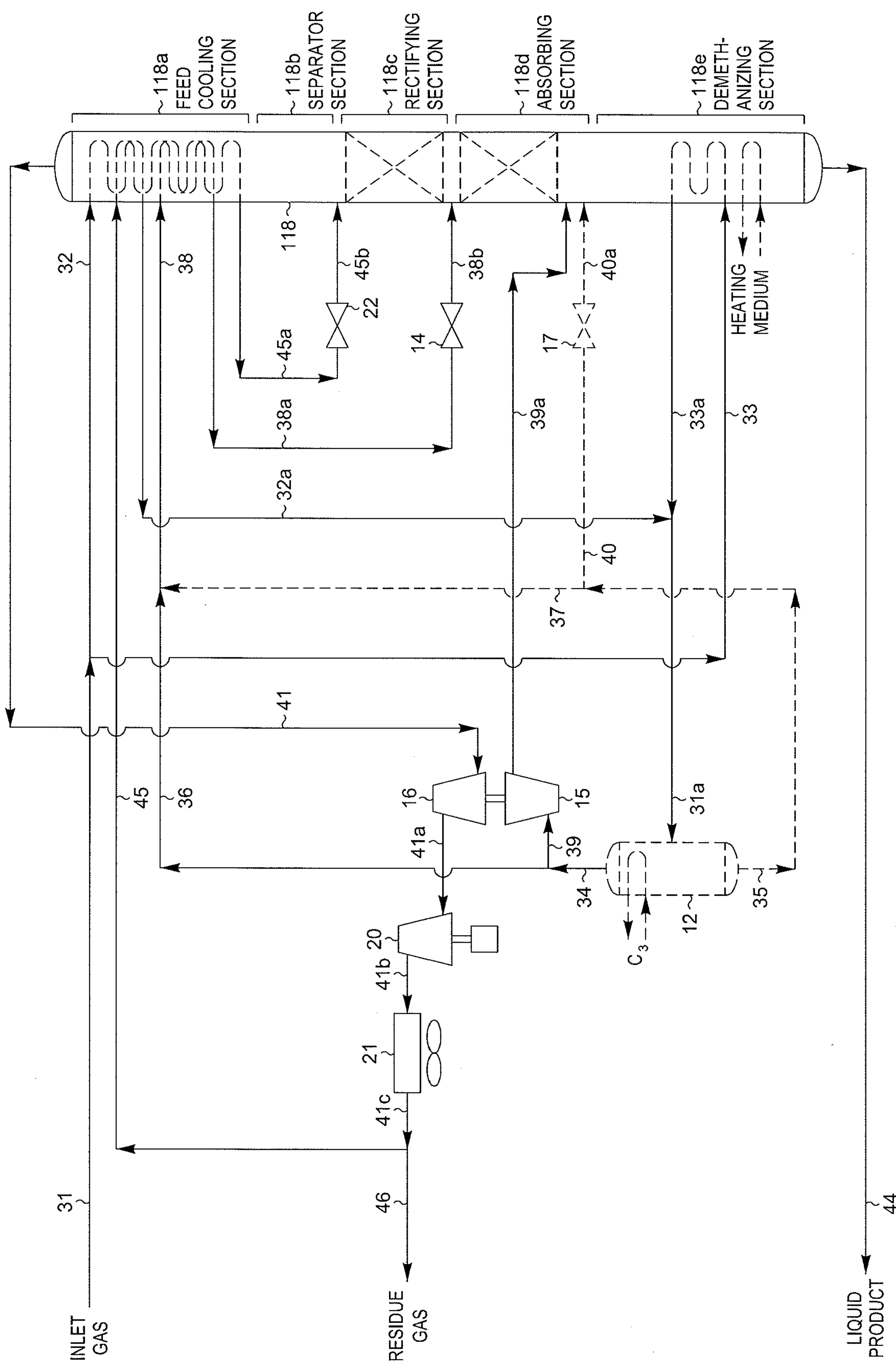


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FIG.





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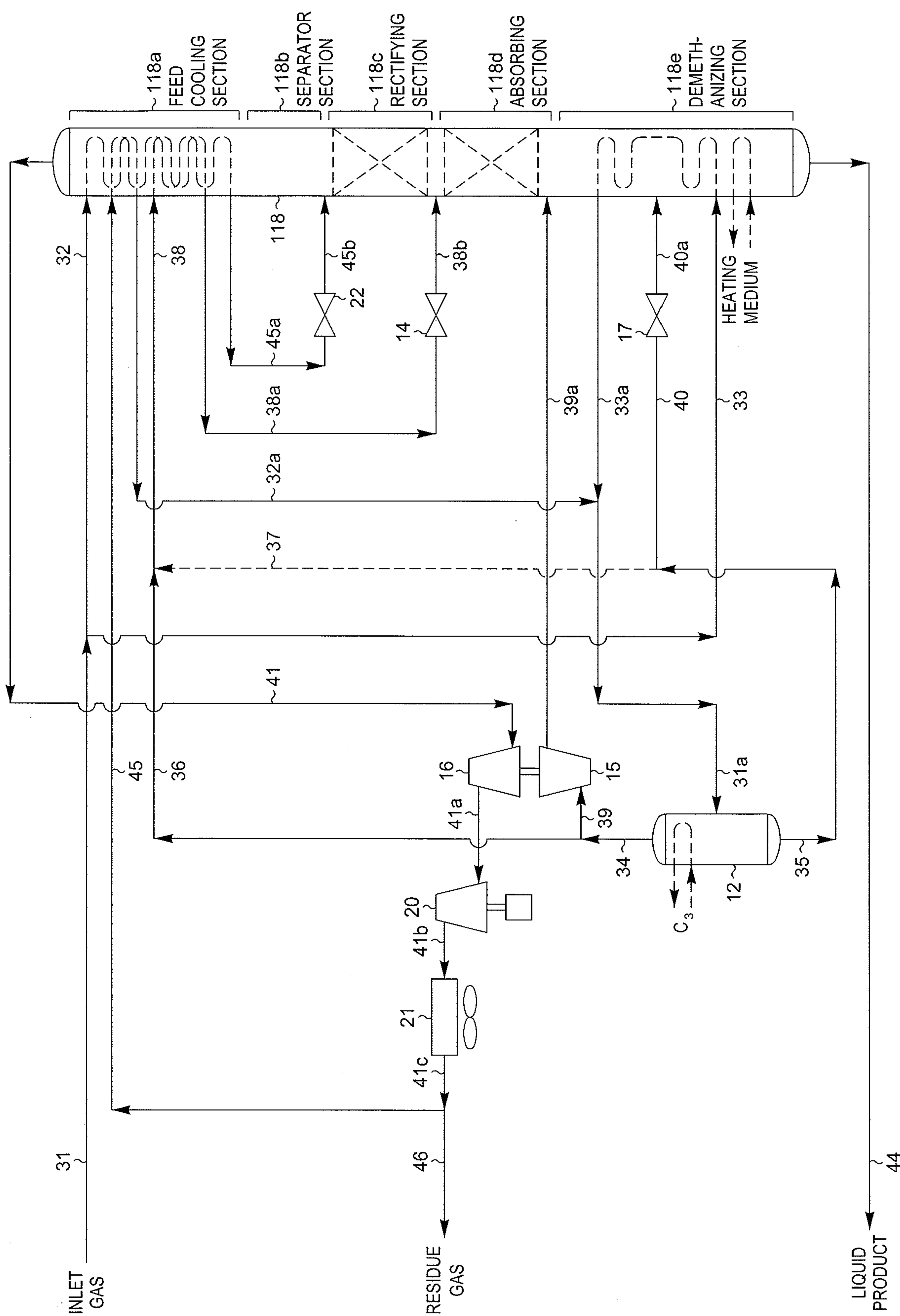
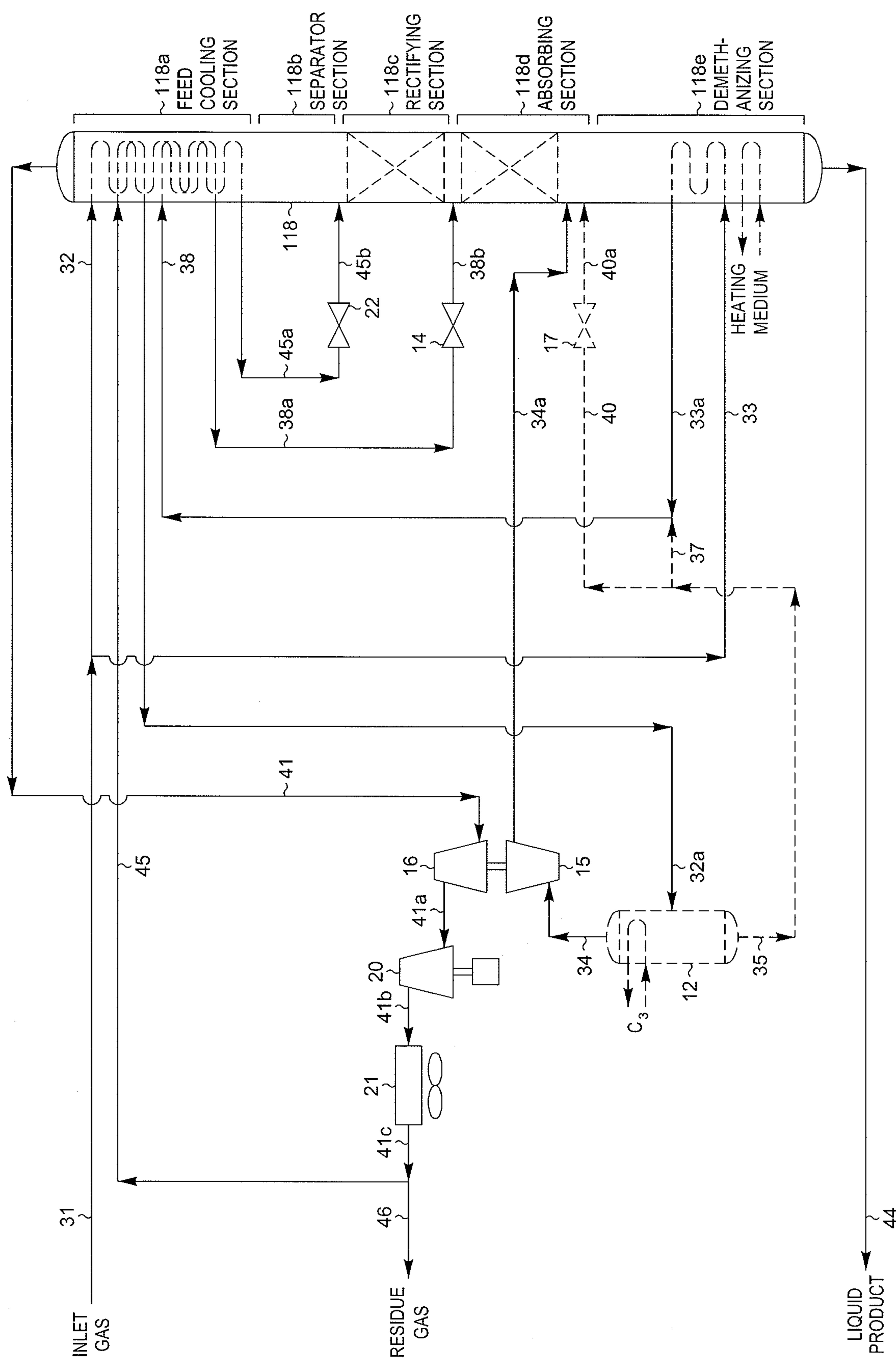
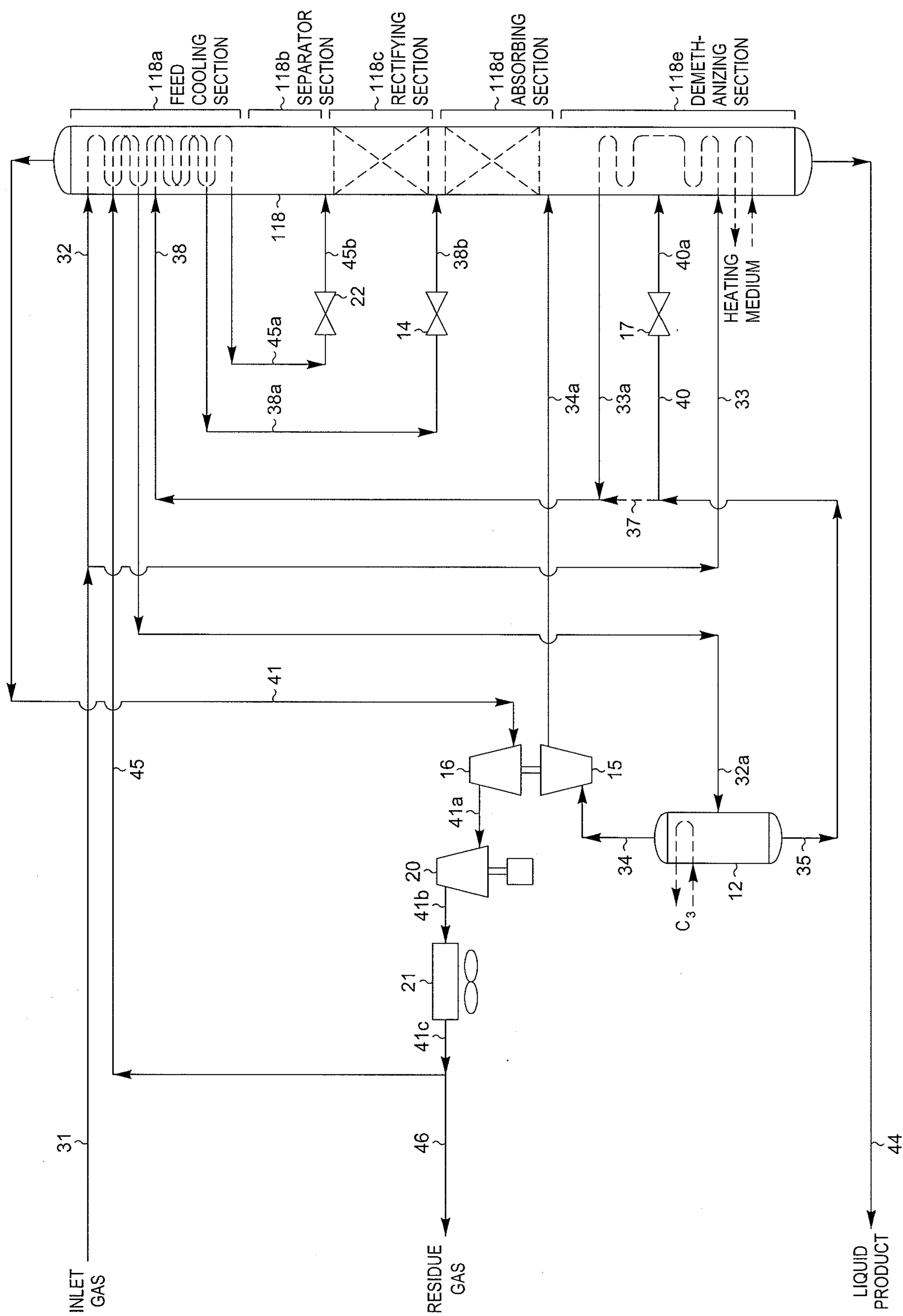


FIG.

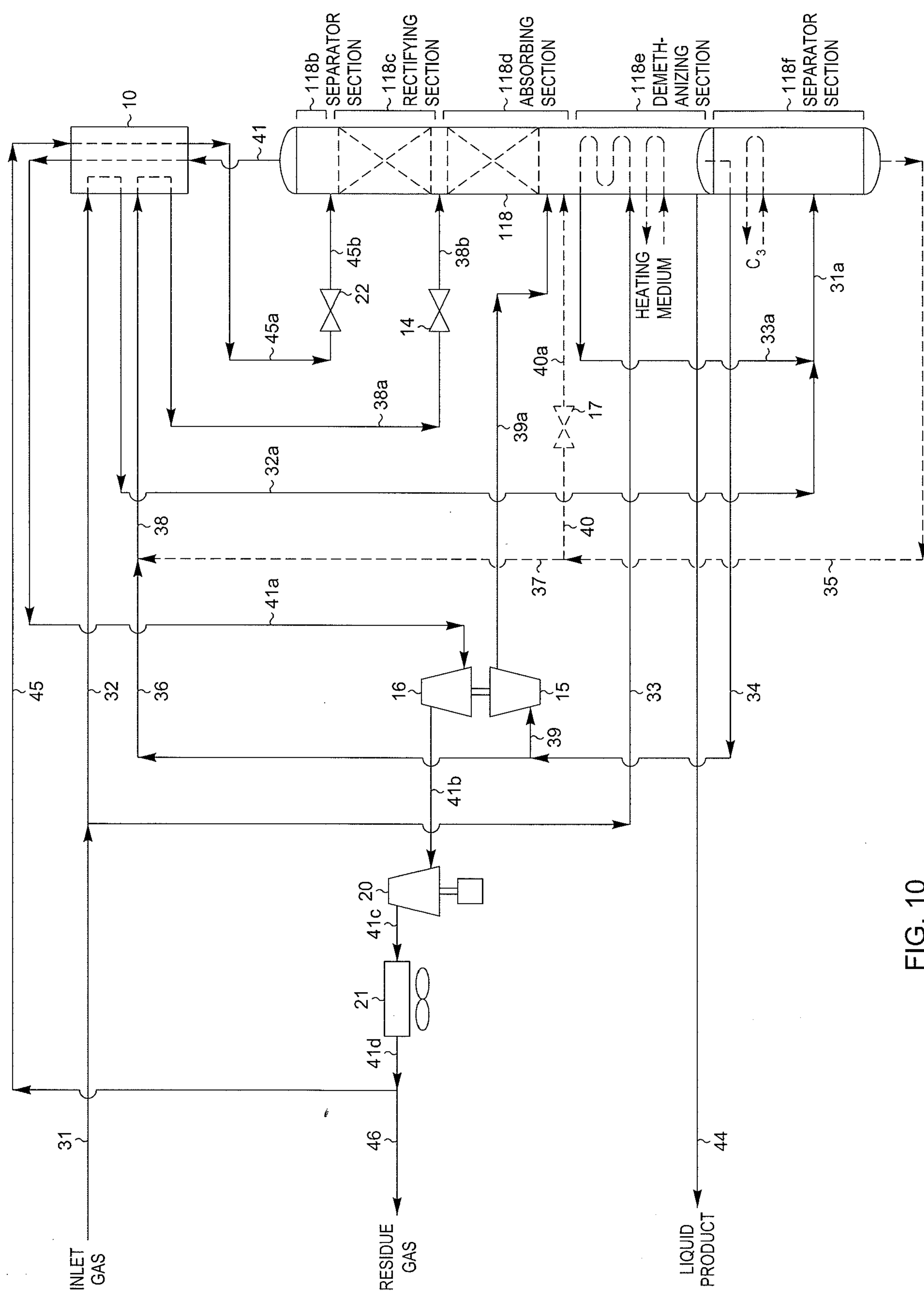


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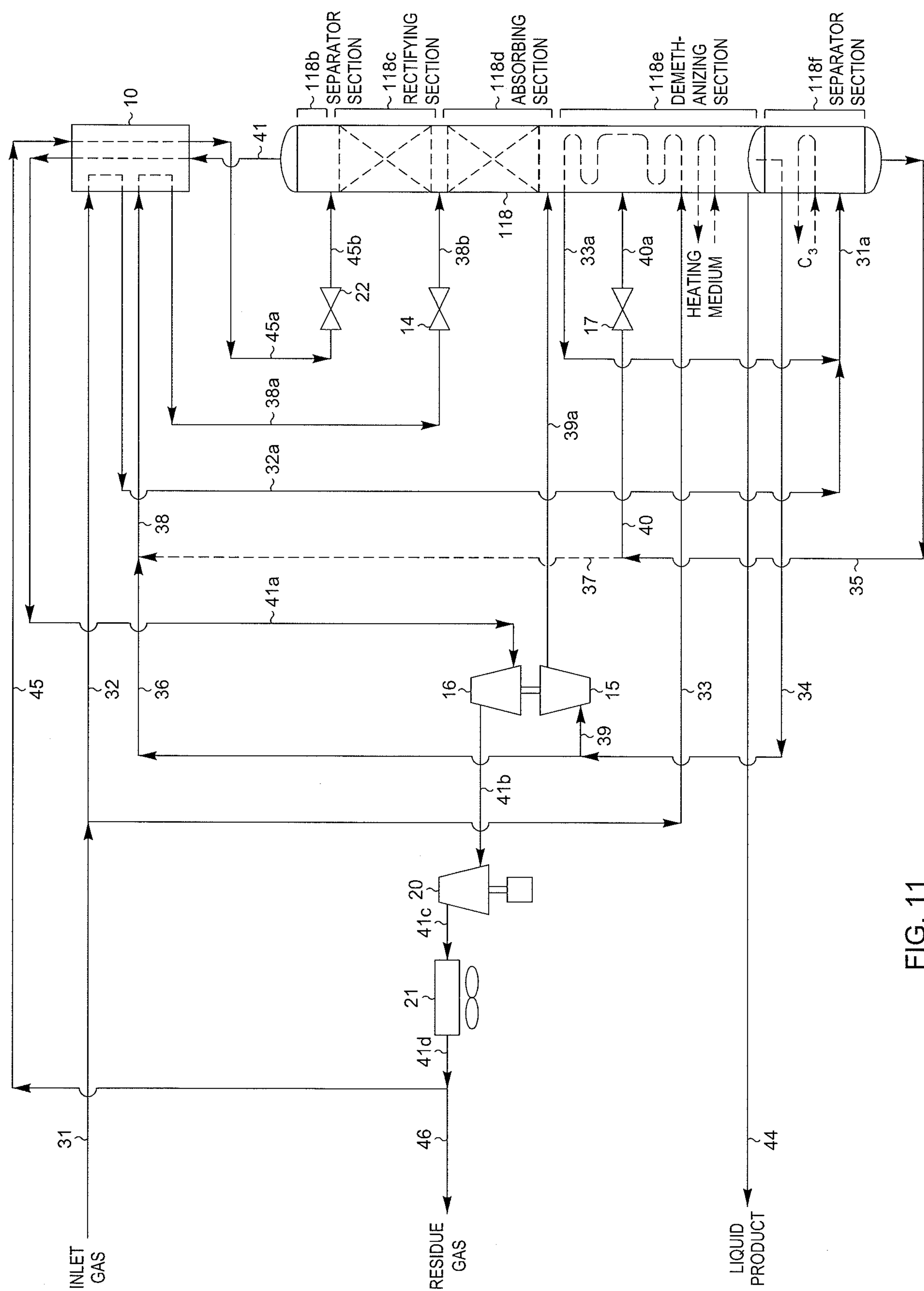
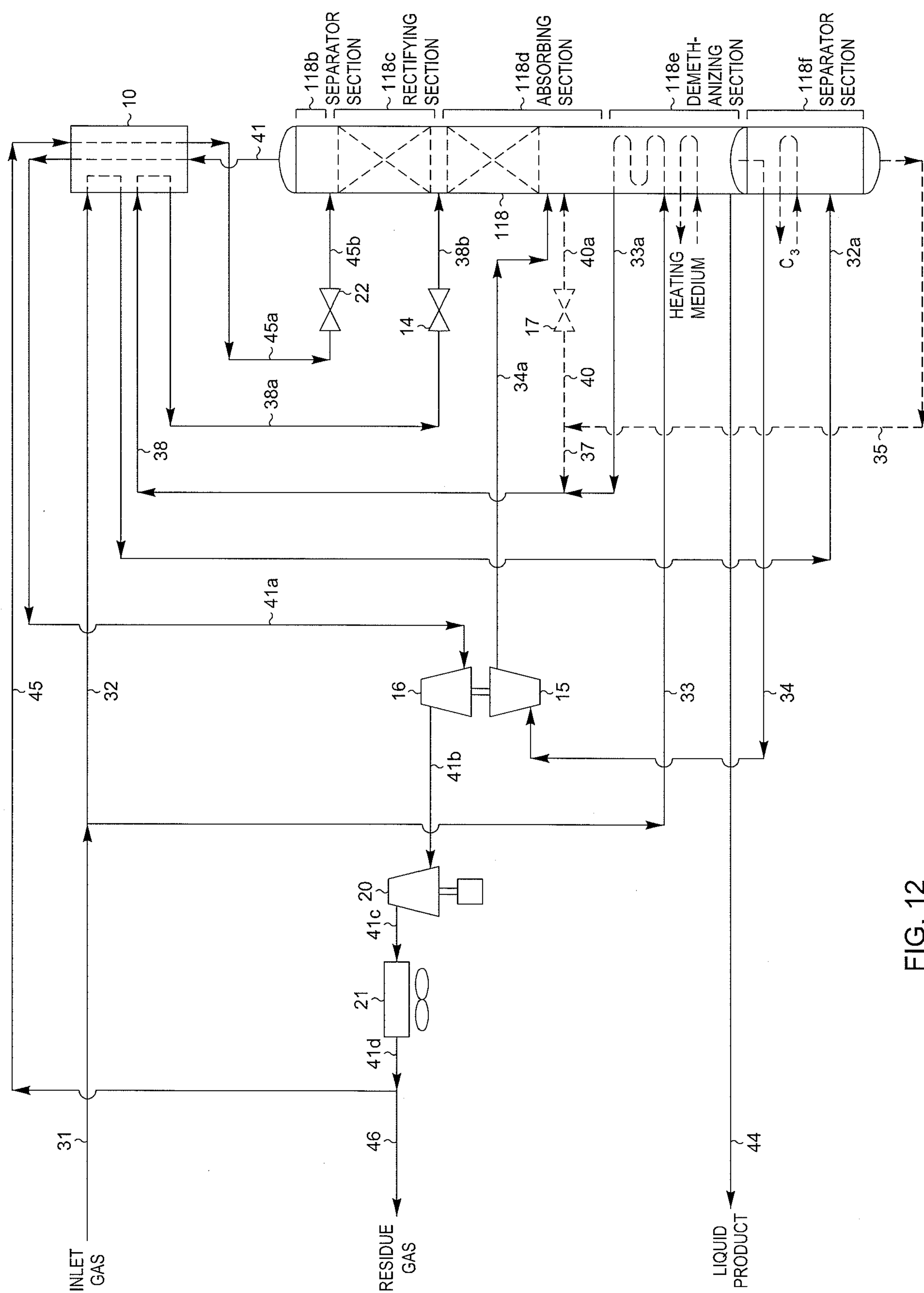
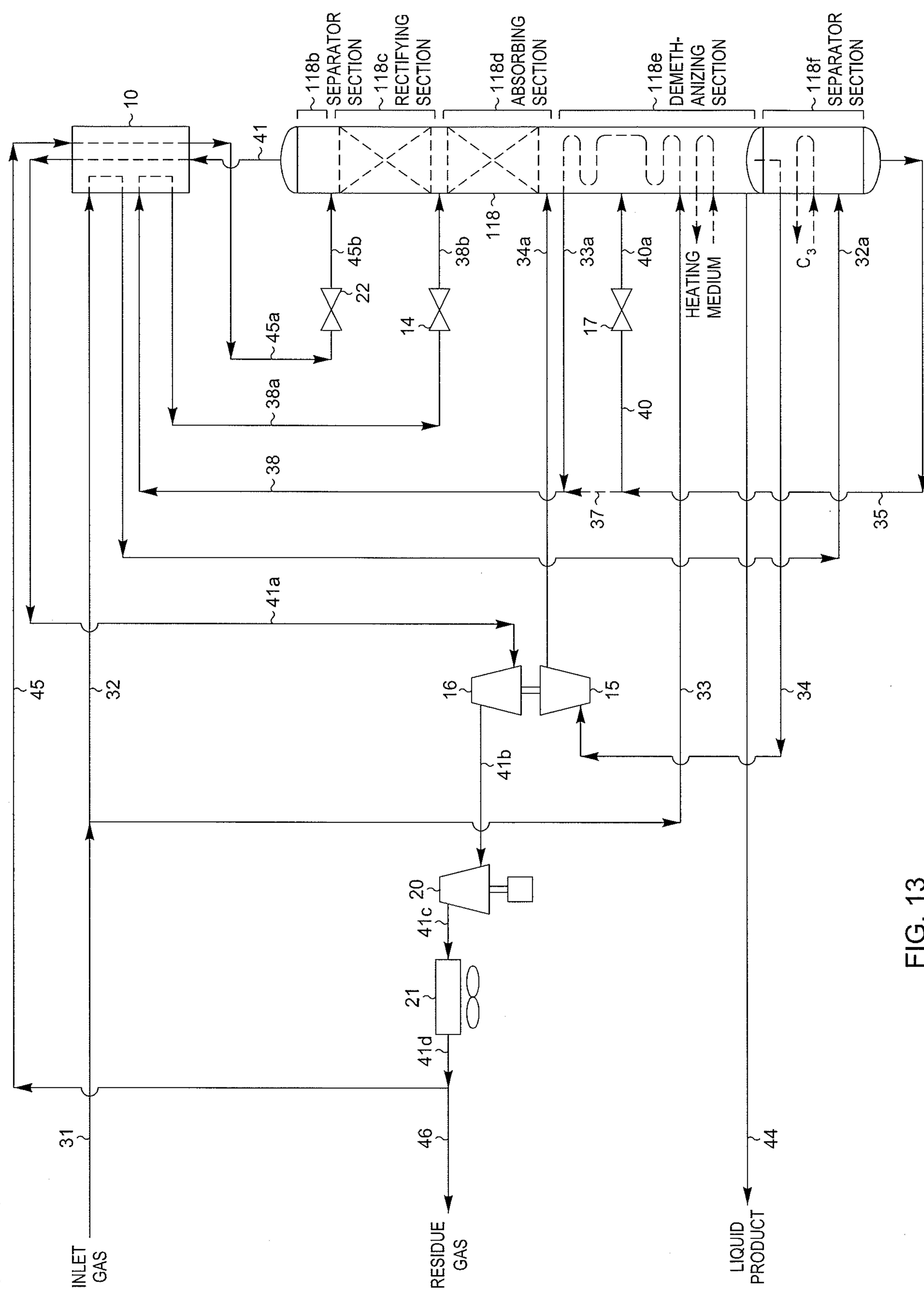


FIG. 11



12
FIG.



13
FIG.

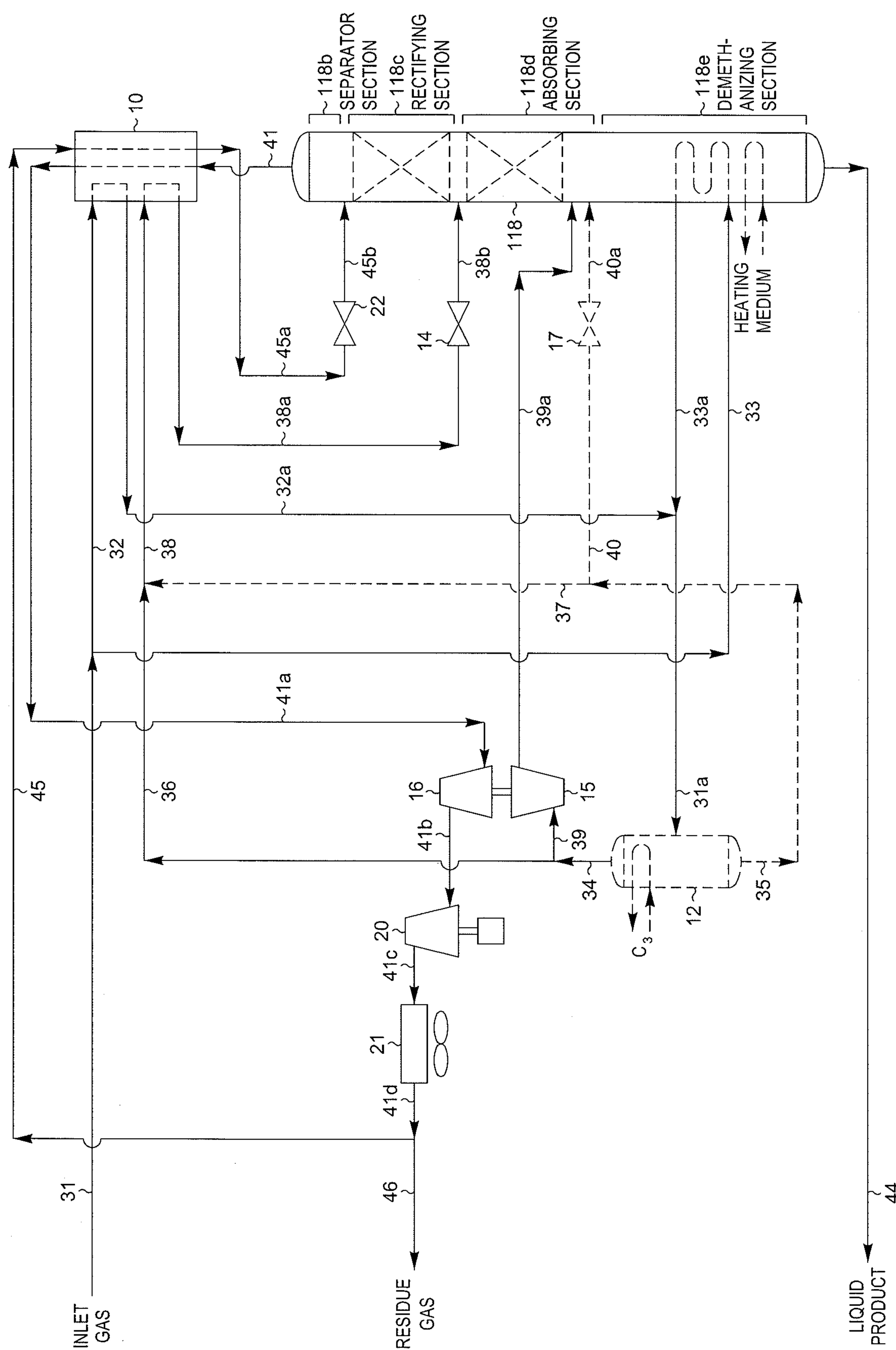


FIG. 14

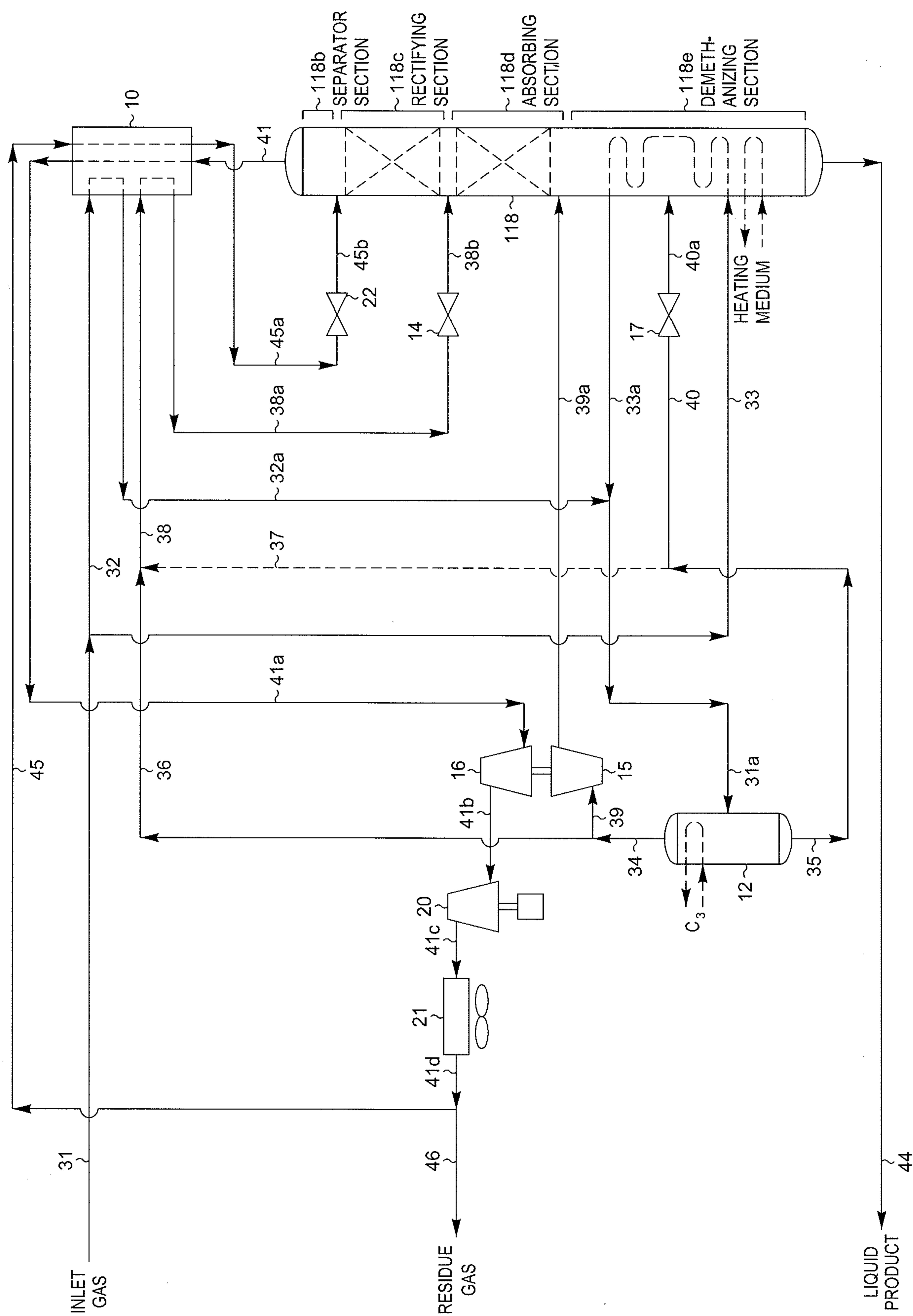


FIG. 15

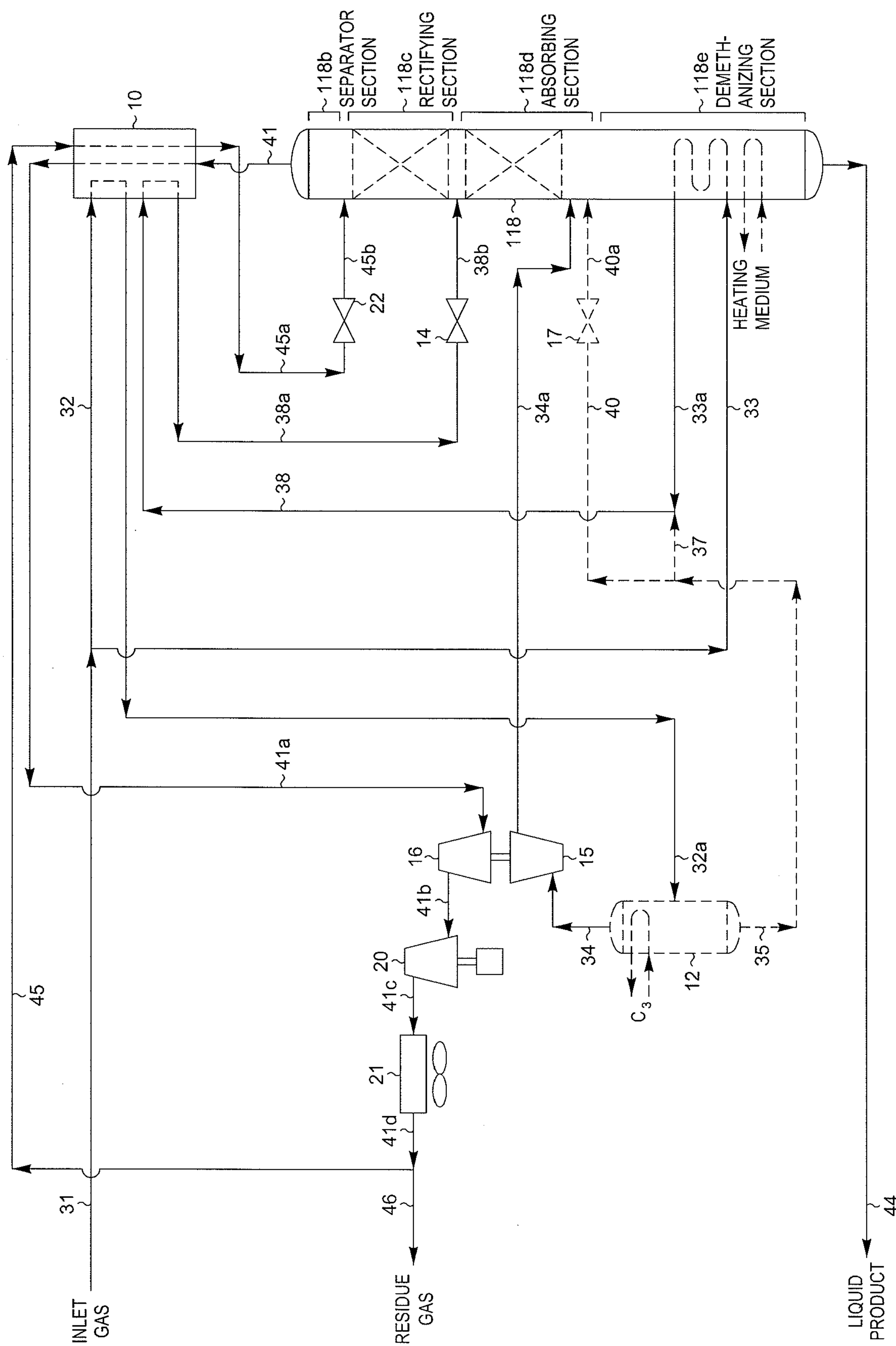


FIG. 16

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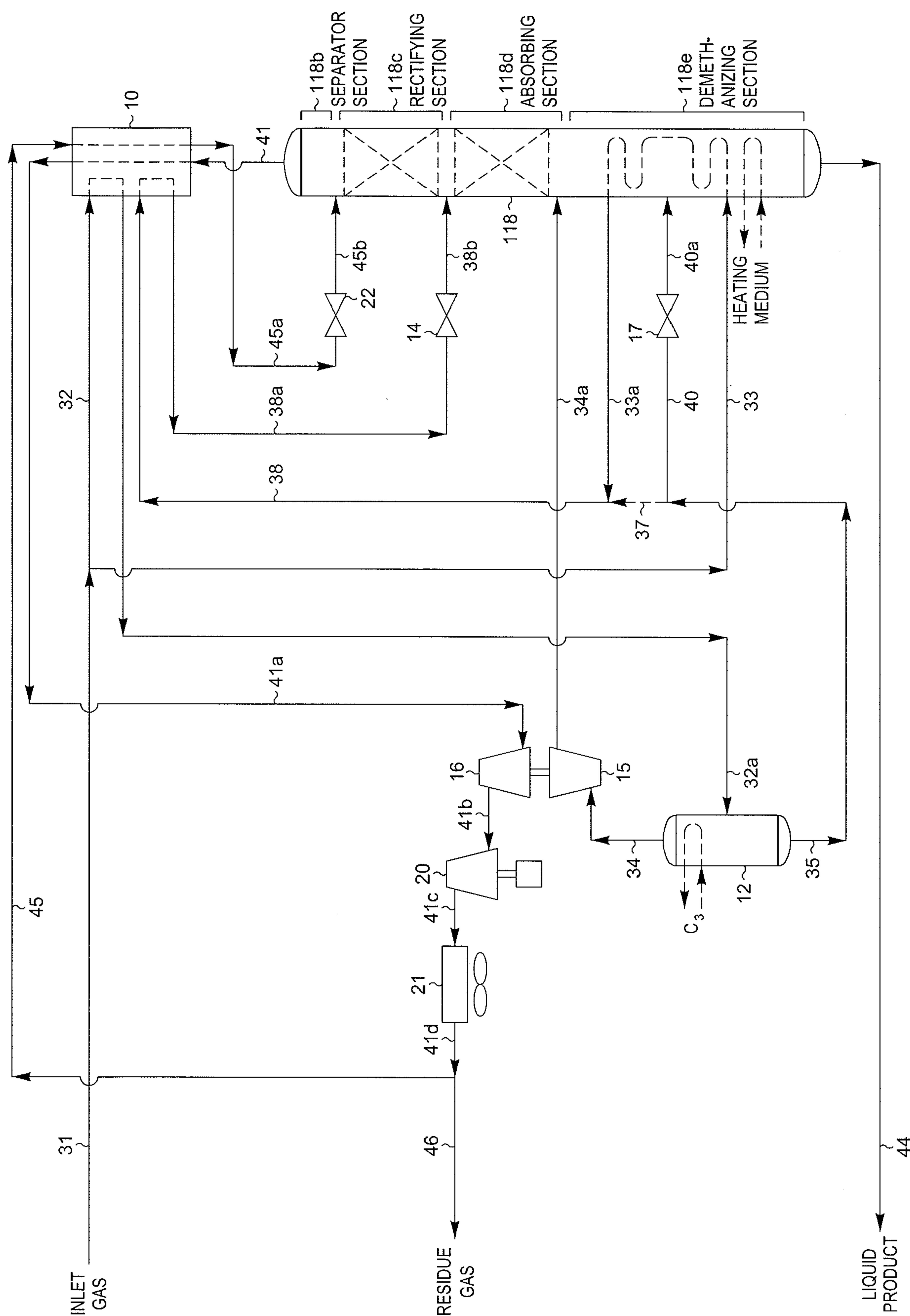


FIG. 17