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(71) Applicant: **HALLIBURTON ENERGY SERVICES, INC.** [US/US]; 3000 N. Sam Houston Parkway E., Houston, TX 77032-3219 (US).

(72) Inventors: **WARREN, Wesley, John**; 800 County Road 1610, Marlow, OK 73055 (US). **LEWIS, Bryan, John**; 2910 Wiloaks Drive, Duncan, OK 73533 (US). **HUNTER, Tim, H.**; 275919 East Co. Road 1740, Duncan, OK 73533 (US).

(74) Agents: **MORICO, Paul** et al.; Baker Botts LLP, 910 Louisiana Street, Houston, TX 77002 (US).

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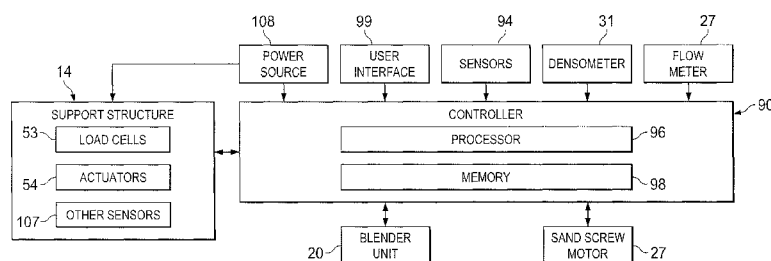


FIG. 4

(57) Abstract: In accordance with presently disclosed embodiments, systems and methods for determining the amount of bulk material being choke-fed into an inlet of a blender from one or more bulk material containers placed on a support structure are disclosed. The system includes sensors placed on the support structure beneath the one or more containers for determining the amount of bulk material contained within the container at any given time. By monitoring the change in the mass of the material in the containers overtime the amount of material being fed into the blender can be determined. The material is metered into a mixer within the blender using a metering mechanism, such as a sand screw, which supplies a fixed capacity of bulk material into the blender. The ability to precisely measure the amount of bulk material being choke-fed into the blender enables operators to calibrate the sand screw continuously.

SYSTEM AND METHOD FOR DETERMINING SLURRY SAND CONCENTRATION
AND CONTINUOUS CALIBRATION OF METERING MECHANISMS FOR
TRANSFERRING SAME

5

TECHNICAL FIELD

The present disclosure relates generally to transferring bulk materials for use in downhole treatment fluids, and more particularly, to accurate measurement of bulk materials during operation at a well site.

BACKGROUND

10 During the drilling and completion of oil and gas wells, various wellbore treating fluids are used for a number of purposes. For example, high viscosity gels are used to create fractures in oil and gas bearing formations to increase production. High viscosity and high density gels are also used to maintain positive hydrostatic pressure in the well while limiting flow of well fluids into earth formations during installation of completion equipment. High
15 viscosity fluids are used to flow sand into wells during gravel packing operations. Hydraulic fracturing operations may use a wide range of fluid viscosities and characteristics also to transport proppant into natural and induced fractures in the petroleum bearing formation. The wellbore treating fluids are normally produced by mixing dry powder and/or granular materials and agents with water at the well site as they are needed for the particular treatment.
20 Systems for metering and mixing the various materials are normally portable, e.g., skid- or truck-mounted, since they are needed for only short periods of time at a well site.

The powder or granular treating material is normally transported to a well site in a commercial or common carrier tank truck. Once the tank truck and mixing system are at the well site, the powder material (bulk material) must be transferred or conveyed from the tank
25 truck into a supply tank for metering into a blender as needed. The bulk material is usually transferred from the tank truck pneumatically. More specifically, the bulk material is blown pneumatically from the tank truck into an on-location storage/delivery system (e.g., silo). The storage/delivery system may then deliver the bulk material onto a conveyor or into a hopper, which meters the bulk material by means of an auger screw into a blender tub.

30 Recent developments in bulk material handling operations involve the use of portable containers for transporting dry material about a well location. The containers can be brought in on trucks, unloaded, stored on location, and manipulated about the well site when the material is needed. The containers are generally easier to manipulate on location than a large

supply tank trailer. The containers are eventually emptied by dumping the contents thereof onto a mechanical conveying system (e.g., conveyor belt, auger, bucket lift, etc.). The conveying system then moves the bulk material in a metered fashion to a desired destination at the well site.

5 An important aspect of delivering bulk dry material and liquid materials used in forming sand slurries and other downhole treatment and completion fluids is the accurate measurement of the amount of bulk dry and liquid materials used in the production of such slurries and fluids. Accurate measure is important for a number of reasons other than the physical properties of the slurry, an important one of which being for accounting and billing
10 purposes. In today's downhole operations, there are a wide variety of measurement methods used, each having its own level of accuracy and unique sources of error.

 Fluid additive tanks are most commonly measured volumetrically with a depth stick or strap. Each container has a unique measurement strap that is calibrated to the varying cross-sectional area of the container. This method is prone to a high degree of subjectivity
15 due to the fact that the operator is reading the depth measured on the strap. This method also generally does not account for changes in the fluid volume due to thermal expansion or contraction as may occur with temperature changes. As the fluids are drawn from the bulk tanks it is passed through expensive, generally highly accurate, coriolis flow meters before
20 being mixed with the treatment slurry. However, any air entrainment in the fluid significantly impacts the accuracy of the coriolis measurements. As a result, great efforts in personnel time are taken to reconcile discrepancies caused by such inaccuracies.

 Dry additives (e.g., sand, proppant, gel, diverters, etc.) are generally measured using auger screws. The dry material is typically delivered to a hopper and metered/conveyed from the hopper to the mixer with an auger screw. The volume or mass flow rate of dry material is
25 determined from the rotational speed, or revolutions per minute (RPM) of the screw and a calibration factor (weight or volume of material moved per revolution of the auger, which may be measured in lbs/rev or via a drive signal measured in lb/mA) for that particular material, screw size, and screw orientation. For example, the sand screws are placed at an angle to lift the sand from the hopper to the top of the mixing tub. Each sand type (100 mesh,
30 20/40 mesh, resin coated, etc.) will have different transfer efficiencies through the screw, and require a different calibration curve. However, the calibration factor may vary if additional humidity is present in the sand, or if liquid additives/coatings are being mulled into the sand in the screw, such as is the case with the SandWedge[®] or FinesWedge[®] systems, provided by

Halliburton, the assignee of the present application. The depth of material covering the auger inlet and dimensional changes caused by wear also affect the calibration curve. In addition, the testing required to calibrate the screws for each material is not trivial. Accordingly, only a small number of the various sand types have measured calibration curves, and calibration factors are often assumed by the blender operators.

Due to the inaccuracies in these measures, many customers of service companies require that additional measurements be taken to determine, in particular, the sand concentration of the treatment slurry being delivered to the wellhead. The sand concentration is indirectly measured using a radioactive densometer placed downstream and proximate an outlet of the mixing tub. If the base fluid density is accurately known, then the bulk density measurement from the densometer can be reliably used to provide the sand concentration in lbm sand per gallon of fluid. However, the exact base fluid density is often unknown due to the variety of water sources that are used, the variation in salt concentration in the water through the job, and the various additives being introduced to the fluid before the densometer.

Accordingly, a direct and precise measurement of the bulk material being added to the mixing tub prior to mixing with the liquid additives is desired.

BRIEF DESCRIPTION OF THE DRAWINGS

For a more complete understanding of the present disclosure and its features and advantages, reference is now made to the following description, taken in conjunction with the accompanying drawings, in which:

FIG. 1 is a schematic block diagram of a system for delivering bulk material from a container disposed on a portable support structure into a blender, in accordance with an embodiment of the present disclosure;

FIG. 2 is a perspective view of a portable support structure used to support and weigh a plurality of containers of bulk material, in accordance with an embodiment of the present disclosure;

FIG. 3 is a schematic diagram of the mechanisms for delivering bulk material and clean fluids into a mixer in accordance with the present disclosure; and

FIG. 4 is a schematic block diagram of an embodiment of an electronics control system that measures the amount of dry bulk material being choke-fed into the blender and calibrates a sand screw used to meter the dry bulk material into the mixing tub of the blender in accordance with an embodiment of the present disclosure.

DETAILED DESCRIPTION

Illustrative embodiments of the present disclosure are described in detail herein. In the interest of clarity, not all features of an actual implementation are described in this specification. It will of course be appreciated that in the development of any such actual
5 embodiment, numerous implementation specific decisions must be made to achieve developers' specific goals, such as compliance with system related and business related constraints, which will vary from one implementation to another. Moreover, it will be appreciated that such a development effort might be complex and time consuming, but would nevertheless be a routine undertaking for those of ordinary skill in the art having the benefit
10 of the present disclosure. Furthermore, in no way should the following examples be read to limit, or define, the scope of the disclosure.

The method according to the present disclosure will now be described. Electronic load cells (scales) are placed under each bulk material container (dry or liquid) so that the mass of the material in the container can be directly measured continuously. By observing
15 the change in total mass over time, the mass flow rate may be accurately obtained, irrespective of air entrainment in the fluid or along the flow lines or changes in density due to thermal expansion. The present disclosure's approach of using a mass measurement will eliminate the need for expensive micro-motion flowmeters, which will result in a capital cost savings. Also, this will minimize any discrepancy between volume measurements of the
20 material in the container, liquid volume flow rates to the blender, and the amount of product to be billed to the customer.

The present disclosure also provides for placing the portable sand containers (*e.g.*, on the containers used in the XpressTM Sand Delivery System provided by Halliburton, the assignee of the present application) on load cells. The mass of proppant in each container can
25 be continuously measured to produce the mass flow rate of proppant to the blender. Even though the proppant is generally first delivered to the blender hopper before being lifted/metered by the sand screws to the mixing tub, under steady operation, the choked gravity feed between the XpressTM Sand container and the hopper will require that the volume of sand in the hopper remain constant. So the mass flow rate leaving the container
30 will be equal to the mass flow rate being passed through the sand screws. Due to this configuration, the calibration factors for the sand screws can be regularly updated as the sand properties and sand screw RPM vary throughout the job. A similar process can be used for the other dry additive measurements, transfer and calibrated mass flow control.

The reason for updating the sand screw calibration factors is that these calibration factors are used in the blender control algorithms to set the screw speeds to achieve the desired product flow rate. Details of these automatic control systems for the sand screws can be found in U.S. Patent Nos. 4,779,186 and 5,335,166. Thus, rather than using the post
5 blender bulk density measurement from the densometer to provide the feedback to the control system to automatically adjust the sand screw speed to achieve the expected bulk density of the slurry for the assumed base fluid density and desired sand concentration, the control system can directly regulate the screw speed to achieve the desired sand mass flow rate. In order to provide an accurate calibration measure, the sand screw speed must be held constant
10 for a given amount of time to ensure steady operation. As such, the control system for the screws will need to be modified to periodically not automatically update the screw speed to achieve the desired/programmed post blender sand concentration and allow for an accurate calibration run.

Alternatively, a control algorithm for the sand screws, or other dry material transfer,
15 may be implemented that does not require a calibration factor. Such a control algorithm may take as inputs the measured mass flow rate leaving the container, the desired mass flow rate, and the current sand screw RPM. The output of the control algorithm may be the change in sand screw RPM required to achieve the desired mass flow rate. The necessary change of RPM may be calculated using various methods, depending on the type of feedback control
20 method being applied (e.g., proportional control, proportional-integral-derivative control, etc.). With the mass flow rate being measured for each material additive source making up the treatment slurry, the total mass flow rate of additives is directly known. In order to extract the sand concentrations per volume of clean fluid, an additional measurement is needed, namely the volume flow rate from the clean water source. By measuring the volume
25 flow rate of the clean water source, and comparing to the sand mass flow rate, the sand concentration per volume of clean fluid can be directly calculated as the ratio of these two measurements. This is the primary value required to meet typical job designs in the field.

In another aspect of the present disclosure, the control system monitors changes in the calibration factor over time, such that a decreasing trend in the calibration factor generally
30 indicates that the metering mechanism needs replacement. The control system can be programmed to warn the operator to make such a change.

Turning now to the drawings, the system in accordance with present disclosure will now be described. FIG. 1 is a block diagram of a bulk material handling system 10 in

accordance with the present disclosure. The system 10 includes a container 12 elevated on a portable support structure 14 and holding a quantity of bulk material (*e.g.*, solid or liquid treating material). The portable support structure 14 may include a frame 16 for receiving and holding the container 12 and a gravity feed outlet 18 for directing bulk material away from the container 12. The outlet 18 may be coupled to and extending from the frame 16. The outlet 18 may utilize a gravity feed to provide a controlled, *i.e.*, metered, flow of bulk material from the container 12 to a blender unit 20.

As illustrated, the blender unit 20 may include a hopper 22 and a mixing tub or mixer 24. The blender unit 20 may also include a metering mechanism 26 for providing a controlled, *i.e.*, metered, flow of bulk material from the hopper 22 to the mixer 24. An exemplary metering mechanism 26 is a sand screw, which has the shape of an auger and permits discrete quantities of bulk material to be conveyed over a unit of time.

Water and other additives may be supplied to the mixer 24 through a fluid inlet flow line 28. As those of ordinary skill in the art will appreciate, the fluid inlet flow line 28 may comprise more than the one input flow line illustrated in Fig. 1. A flow meter 29 (shown in FIG. 3) may optionally be installed in the fluid inlet flow line 28 for measuring the flow rate of the fluid being injected into the mixer 24. It is connected either via a wired connection or wirelessly to the controller 90, as described in further detail below. The bulk material and water may be mixed in the mixer 24 to produce (at an outlet flow line 30) a fracing fluid, a mixture combining multiple types of proppant, proppant/dry-gel particulate mixture, sand/sand-diverting agents mixture, cement slurry, drilling mud, a mortar or concrete mixture, or any other fluid mixture for use on location. The outlet flow line 30 may be coupled to a pump for conveying the treating fluid to a desired location (*e.g.*, a hydrocarbon recovery well) for a treating process. A densometer 31 (shown in FIG. 3) may optionally be installed in the outlet flow line 30 to measure the sand concentration exiting the mixer 24. The densometer 31 is connected to the controller 90 either via a wired connection or wirelessly, as described in further detail below.

It should be noted that the disclosed container 12 may be utilized to provide bulk material for use in a variety of treating processes. For example, the disclosed systems and methods may be utilized to provide proppant materials into fracture treatments performed on a hydrocarbon recovery well. In other embodiments, the disclosed techniques may be used to provide other materials (*e.g.*, non-proppant) for diversions, conductor-frac applications, cement mixing, drilling mud mixing, and other fluid mixing applications.

As illustrated, the container 12 may be elevated above an outlet location via the frame 16. The support structure 14 is designed to elevate the container 12 above the level of the blender inlet (*e.g.*, blender hopper 22 and/or mixing tub 24) to allow the bulk material to gravity feed from the container 12 to the blender unit 20. This way, the container 12 is able to sit on the frame 16 of the support structure 14 and output bulk material directly into the blender unit 20 via the gravity feed outlet 18 of the support structure 14.

Although shown as supporting a single container 12, other embodiments of the frame 16 may be configured to support multiple containers 12. The exact number of containers 12 that the support structure 14 can hold may depend on a combination of factors such as, for example, the volume, width, and weight of the containers 12 to be disposed thereon.

In any case, the container(s) 12 may be completely separable and transportable from the frame 16, such that any container 12 may be selectively removed from the frame 16 and replaced with another container 12. That way, once the bulk material from the container 12 runs low or empties, a new container 12 may be placed on the frame 16 to maintain a steady flow of bulk material to an outlet location. In some instances, the container 12 may be closed before being completely emptied, removed from the frame 16, and replaced by a container 12 holding a different type of bulk material to be provided to the outlet location.

A portable bulk storage system 32 may be provided at the site for storing one or more additional containers 12 of bulk material to be positioned on the frame 16 of the support structure 14. The bulk material containers 12 may be transported to the desired location on a transportation unit (*e.g.*, truck). The bulk storage system 32 may be the transportation unit itself or may be a skid, a pallet, or some other holding area. One or more containers 12 of bulk material may be transferred from the storage system 32 onto the support structure 14, as indicated by arrow 34. This transfer may be performed by lifting the container 12 via a hoisting mechanism, such as a forklift, a crane, or a specially designed container management device.

When the one or more containers 12 are positioned on the support structure 14, discharge gates on one or more of the containers 12 may be opened, allowing bulk material to flow from the containers 12 into the outlet 18 of the support structure 14. The outlet 18 may then route the flow of bulk material directly into a blender inlet (*e.g.*, into the hopper 22 or mixer 24) of the blender unit 20.

After one or more of the containers 12 on the support structure 14 are emptied, the empty container(s) 12 may be removed from the support structure 14 via a hoisting

mechanism. In some embodiments, the one or more empty containers 12 may be positioned on another bulk storage system 32 (*e.g.*, a transportation unit, a skid, a pallet, or some other holding area) until they can be removed from the site and/or refilled. In other embodiments, the one or more empty containers 12 may be positioned directly onto a transportation unit for transporting the empty containers 12 away from the site. It should be noted that the same transportation unit used to provide one or more filled containers 12 to the location may then be utilized to remove one or more empty containers 12 from the site.

FIG. 2 illustrates an embodiment of the support structure 14 that may be designed to receive multiple containers. Specifically, the support structure 14 includes a frame 16 sized to receive and support up to three portable containers. The frame 16 may include several beams connected together (*e.g.*, via welds, rivets or bolts) to form a continuous group of cubic or rectangular shaped supports 50 coupled end to end. For example, in the illustrated embodiment the frame 16 generally includes one continuous, elongated rectangular body broken into three distinct cubic/rectangular supports 50A, 50B, and 50C. Each cubic/rectangular support 50 may be used to support a single container. The frame 16 may include additional beams that function as trusses to help support the weight of the filled containers disposed on the frame 16. Other shapes, layouts, and constructions of the frame 16 may be used in other embodiments. In addition, other embodiments of the support structure 14 may include a frame 16 sized to receive other numbers (*e.g.*, 1, 2, 4, 5, 6, 7, or more) portable containers. As those of ordinary skill in the art will appreciate, the exact number of containers on the frame 14 is not critical to the present disclosure.

As illustrated, the support structure 14 may be equipped with a plurality of container mounts 52 disposed on top of the frame 16 for positioning and holding the containers on the frame 16. The containers may include complementary engagement features designed to interface with the mounts 52, thus enabling a precise placement of the containers into desired locations on the frame 16. In the illustrated embodiment, the mounts 52 are generally disposed at the corners on the upper face of each cubic/rectangular support 50. However, other placements of the mounts 52 along the upper surface of the support structure 16 may be utilized in other embodiments.

Beneath each mount 52 is disposed a micro-scale load cell 53. Exemplary micro-scale load cells 53, include, but are not limited to strain gauges, piezoelectric gauges, hydraulic or pneumatic gauges, or similar devices. Each micro-scale load-cell 53 is connected via a wired or wireless connection to a controller 90, as shown in FIG. 4. Each

micro-scale load cell 53 communicates a signal indicative of the weight of the container and its contents sensed by the load cell. With knowledge of the mass of each container, an algorithm stored in the memory 98 and executed by the processor 96, can determine the mass of bulk material in each of the containers 12. Furthermore, by monitoring the change in the weight of the bulk material being fed from the containers into the blender 20 per unit of time the flow rate of the bulk material into the blender can be determined. Since there is no loss of the bulk material being delivered to the blender 20 given the closed nature of the system and the fixed capacity of the sand screw, the flow rate determined using this technique results in a highly accurate determination of the amount of bulk material being utilized. This in turn allows for accurate accounting and thus accurate billing for the amount of bulk product being consumed.

The support structure 14 may also include one or more actuators 54 designed to aid in actuation of a discharge gate of the one or more containers disposed on the frame 16. In the illustrated embodiment, the actuators 54 may be rotary actuators designed to rotate into engagement with a discharge gate of a container to transition the gate between a closed position and an open position. In other embodiments, the actuators 54 may be linear actuators designed to interface with the gates of the containers to selectively open and close the gates. In some embodiments, the actuators 54 may include a set of two actuators (disposed on opposite sides of the frame 16) for actuating the discharge gate of a single container disposed on the frame 16. In such an arrangement, one of the actuators 54 may transition the gate from closed to open, while the opposite actuator 54 may transition the gate from open to closed.

As described above, the support structure 14 may include several gravity feed outlets 18 for routing bulk material directly from one or more containers disposed on the frame 16 into a blender inlet. The blender inlet may be a blender hopper (*e.g.*, hopper 22 of FIG. 1) used to provide bulk material to a metering system that meters the bulk material into a mixer. In another embodiment, the blender inlet may be the sand screw or other similar metering mechanism 26 of FIG. 1. Other embodiments may utilize other types of blender inlets for receiving the bulk material from the containers disposed on the support structure 14. The blender 20 of the present disclosure, however, contemplates use of a sand screw 26 or other similar metering mechanism (such as a metering gate or valve positioned above the mixer) 26 for metering the bulk material into the mixer 24. A close up of the blender 20 employing a metering mechanism 26 such as a sand screw in connection with the present disclosure can be

seen in FIG. 3. An electric motor 27 which controls the rotation of the sand screw is attached via gears to the main shaft of the sand screw onto which is affixed an auger. The electric motor 27 is connected to the controller 90 via a wired connection or wirelessly as further explained below. Alternatively, a hydraulic motor could also be used for driving the auger.

5 The gravity feed outlets 18A, 18B, and 18C may be used to deliver a flow of bulk material to the blender hopper 22 (or other blender inlet) from each of three respective containers disposed on the frame 16. In some embodiments, the support structure 14 may also include individual hoppers 60A, 60B, and 60C at the top of the frame 16 for funneling bulk material from the discharge gate of the corresponding containers into the gravity feed
10 outlets 18A, 18B, and 18C, respectively.

 The gravity feed outlets 18A, 18B, and 18C may be chutes positioned so that the upper end of each chute is disposed beneath a discharge gate of a corresponding container (or one of the hoppers 60) on the frame 16. The gravity feed outlets 18 may be positioned such that the lower end of each chute is disposed fully within the blender hopper 22. This allows
15 the gravity feed outlets 18 to provide bulk material from all of the containers positioned on the frame 16 into the same blender inlet (e.g., blender hopper 22) at the same time. The outlets 18 are able to provide a gravity feed where an angle of repose of the bulk material exiting the chutes is able to choke the flow of bulk material through the chutes. As bulk material is metered from the blender hopper 22 into another portion of the blender (e.g.,
20 mixer), additional bulk material is able to flow via gravity into the hopper 22 directly from the one or more outlets 18. In embodiments where the gravity feed outlets 18 are positioned to route bulk material directly from the containers into an inlet of the mixer of the blender unit, the outlets 18 and/or the blender inlet may feature a metering gate/valve used to regulate the amount of bulk material provided into the mixer (e.g., instead of separate sand screws)

25 The disclosed gravity feed outlets 18 provide a more controlled output of bulk material to the blender inlet (e.g., blender hopper 22) than would be available through the use of mechanical conveying systems to drop bulk material into the hopper. In addition, the choke feed of bulk material through the outlets 18 and into the blender inlet may reduce an amount of dust generated at a well site, as compared to existing pneumatic or mechanical
30 conveying systems. Further, the gravity feed outlets 18 are able to route the bulk material directly into the blender inlet from the containers without the use of pneumatic or mechanical conveyance equipment operating on auxiliary power. This makes the process of moving the bulk material more efficient than would be possible using a separate pneumatic or mechanical

conveyor between the containers and the blender. Finally, use of the gravity feed/choke-feed outlets 18 allows for a fixed capacity of bulk material to be delivered into the blender inlet.

Having discussed the mechanical components that make up system for determining the amount of bulk material being fed into a blender 20, a more detailed discussion of various electronics and controls that may be used within or communicatively coupled to the support structure 14 will be provided. FIG. 4 is a block diagram illustrating the various electronic and control components that may be used throughout a well site with the disclosed portable support structure 14.

The portable support structure 14 may include a number of electronic components, and these components may be communicatively coupled (*e.g.*, via a wired connection or wirelessly) to one or more controllers 90 (*e.g.*, automated control system) at the well site. For purposes of the present disclosure, the plurality of load cells 53 is connected to the controller. Furthermore, the fluid flow meter 29 is also connected to controller. The densometer 31 may optionally be connected to the controller. Also, the sand screw motor 27 is connected to the controller 90. In the alternative embodiment where a hydraulic motor is used, the controller 90 would be connected to a hydraulic pump or valve that would control the flow rate of fluid to the hydraulic motor. The control system 90 may be communicatively coupled to several other well site components including, but not limited to, the blender unit 20, the actuators 54, and various other sensors 107.

The control system 90 utilizes at least a processor component 96 and a memory component 98 to monitor and/or control various operations and bulk material inventory at the well site and perform other calculations. For example, one or more processor components 96 may be designed to execute instructions encoded into the one or more memory components 98. Upon executing these instructions, the processors 96 may execute one or more algorithms to determine the amount of bulk material flowing into the blender 20 from the one or more containers 12. They may also determine the sand concentration exiting the mixer 24 using the weight measurements communicated from the load cells 53 and the fluid flow rate information communicated from the flow meter(s) 29. This information can be compared to the sand concentration measured by the densometer 31. Furthermore, the densometer 31 measurements can be used to indirectly determine the amount of bulk material entering into the mixer 24 and compared against the calculations made by the processor 96 using the signals and measurements made by the load cells 53. Any discrepancies can be used to alter the calibration factor for the sand screw 26. The processor 96 can also control the sand screw

speed via signals sent to the electric motor 27 (or alternatively to a hydraulic pump or valve controlling fluid flow to a hydraulic motor). The amount of bulk material contained within the containers 12 as determined using the micro-scale load cells 53 can also be compared to the weight ticket supplied from the load station where the containers 12 were filled.

Furthermore, the calibration factor of the sand screw can be continuously updated based on the measurements obtained from the micro-scale load cells independent of any measurements taken from the densometer 31. The calibration values could be monitored over time to determine condition or amount of wear on the auger, the lbs/rev output will decrease with wear.

Furthermore, the controller 90 can be used for controlling passive logging of certain operations at the well site, as well as the amount, type, and location of bulk materials at the well site. In some embodiments, the one or more processors 96 may execute instructions for controlling operations of certain well site components (e.g., support structure electronics, blender unit 20, hoisting mechanism 92, etc.). This may help to control transportation and placement of the support structure 14 relative to the blender inlet, as well as bulk material transfer at the well site. For example, the processors 96 may output signals at a user interface 99 for instructing operators to remove an empty container from the support structure 14 and replace the container with a new container holding a certain type of bulk material needed for the well treatment. Other types of instructions for inventory control/monitoring may be provided through the disclosed systems.

As shown, the support structure 14 itself may include a number of electronic components such as, for example, the automated actuators 54 described above with reference to FIG. 2. These actuators 54 may be controlled to open and/or close a discharge gate of one or more containers elevated on the support structure 14.

Other sensors 107 may be present throughout the support structure 14 for monitoring other operations in the delivery of the bulk material and fluids to the mixer 24 and the discharge of the sand concentration or other product of the mixer 24 out of the mixer and downhole.

The controller 90, the support structure electronics, or both, may utilize power from an external power source 108, as shown. In other embodiments, the support structure 14 may include its own power source 108 for operating the onboard electronics and sensors.

As mentioned above, the controller 90 may be communicatively coupled to various other sensors 94 disposed about the well site. In some embodiments, these sensors 94 may

include one or more load cells or bin full switches for tracking a level of bulk material in a portable container and indicating whether the container is empty, full, or partially full. Such sensors 94 may be used for any given container, the blender hopper, a silo (not shown), or any other component at the well site. In addition, in some embodiments the sensors 94 may
5 include RFID tags used to provide an indication of the particle size, bulk volume, weight, type, material, and/or supplier of the bulk material disposed in a certain container. In such instances, the controller 90 may be communicatively coupled to an RFID reader disposed in proximity to the containers being moved about the well site.

Although the present disclosure and its advantages have been described in detail, it
10 should be understood that various changes, substitutions and alterations can be made herein without departing from the spirit and scope of the disclosure as defined by the following claims.

WHAT IS CLAIMED IS:

1. A system, comprising:

a portable support structure for holding at least one portable container of bulk material at a position proximate a blender inlet, wherein the support structure comprises:

5 a frame for receiving and holding the at least one portable container thereon;
at least one sensor disposed in a position to sense the at least one portable container; and

a choke-feed outlet coupled to the frame for routing the bulk material from the at least one portable container directly into the blender inlet; and

10 a controller in communication with the at least one sensor programmed to determine the amount of bulk material contained within the at least one portable container and being routed into the blender inlet.

2. The system of claim 1, wherein the at least one sensor comprise a plurality of micro-scale load cells.

15 3. The system of claim 2, further comprising a hopper disposed at the blender inlet, a metering mechanism coupled to the hopper and a mixer coupled to an outlet of the metering mechanism.

4. The system of claim 3, wherein the at least one sensor measures a mass of bulk material contained within the at least one portable container and being routed into the blender inlet.

20 5. The system of claim 3, wherein the metering mechanism has a fixed capacity.

6. The system of claim 5, further comprising an actuator coupled to the metering mechanism and the controller and wherein the controller is programmed to control operation of the actuator.

25 7. The system of claim 6, wherein the controller is programmed to adjust its control of the metering mechanism based on the amount of bulk material being fed into the blender as measured by the micro-scale load cells.

8. The system of claim 6, wherein the controller is programmed to calculate a calibration factor for the metering mechanism.

30 9. The system of claim 7, wherein the controller is further programmed to monitor changes of the calibration factor over time and to determine when the metering mechanism needs to be replaced based on a trend of a decreasing calibration factor.

10. The system of claim 1, wherein the controller receives an output from the at least one sensor and an output from a flowmeter coupled to a fluid inlet flow line to the blender to calculate a concentration of the material in the blender.

11. A method, comprising:

5 receiving one or more portable containers of bulk material onto a frame of a portable support structure disposed proximate a blender inlet;

choke-feeding bulk material from the one or more portable containers into the blender inlet;

10 sensing the amount of bulk material in the one or more portable containers received on the frame of the portable support structure; and

determining the amount of bulk material being choke-fed into the blender based on the amount of bulk material sensed in the one of more portable containers.

12. The method of claim 11, further comprising comparing the amount of bulk material sensed to be in the one or more portable containers received on the frame of the portable support structure to an amount of bulk material recorded on a weight ticket which was
15 determined to be in the one or more portable containers at a location where the one or more portable container were filled with bulk material.

13. The method of claim 11, further comprising metering a fixed capacity of bulk material from the blender inlet into an inlet of a mixing chamber.

20 14. The method of claim 11, wherein sensing the amount of bulk material in the one or more portable containers received on the frame includes sensing the mass of bulk material in the one or more portable containers using a plurality of micro-scale load cells placed on the support structure beneath the one or more containers.

25 15. The method of claim 14, wherein sensing the mass of bulk material in the one or more portable containers comprises measuring the mass of the bulk material using a plurality of strain gauges.

30 16. The method of claim 11, wherein determining the amount of bulk material being choke-fed into the blender unit comprises sensing the amount of bulk material in the one or more containers at discrete time intervals and determining the difference in the amount of bulk material sensed between those discrete time intervals.

17. The method of claim 11, further comprising determining a concentration of the material in the blender based on the determined amount of bulk material being choke-fed into the blender and an amount of fluid being fed into the blender measured by a flowmeter coupled to a fluid inlet flow line into the blender.
- 5 18. The method of claim 11, further comprising calibrating a metering mechanism which meters a fixed capacity of bulk material from the blender inlet into an inlet of a mixing chamber based on the amount of bulk material determined to be choke-fed into the blender unit.
- 10 19. The method of claim 18, further comprising determining a calibration factor of the metering mechanism and monitoring changes in the calibration factor over time.
20. The method of claim 19, further comprising determining when the metering mechanism needs to be replaced based on a trend of the calibration factor decreasing over time.

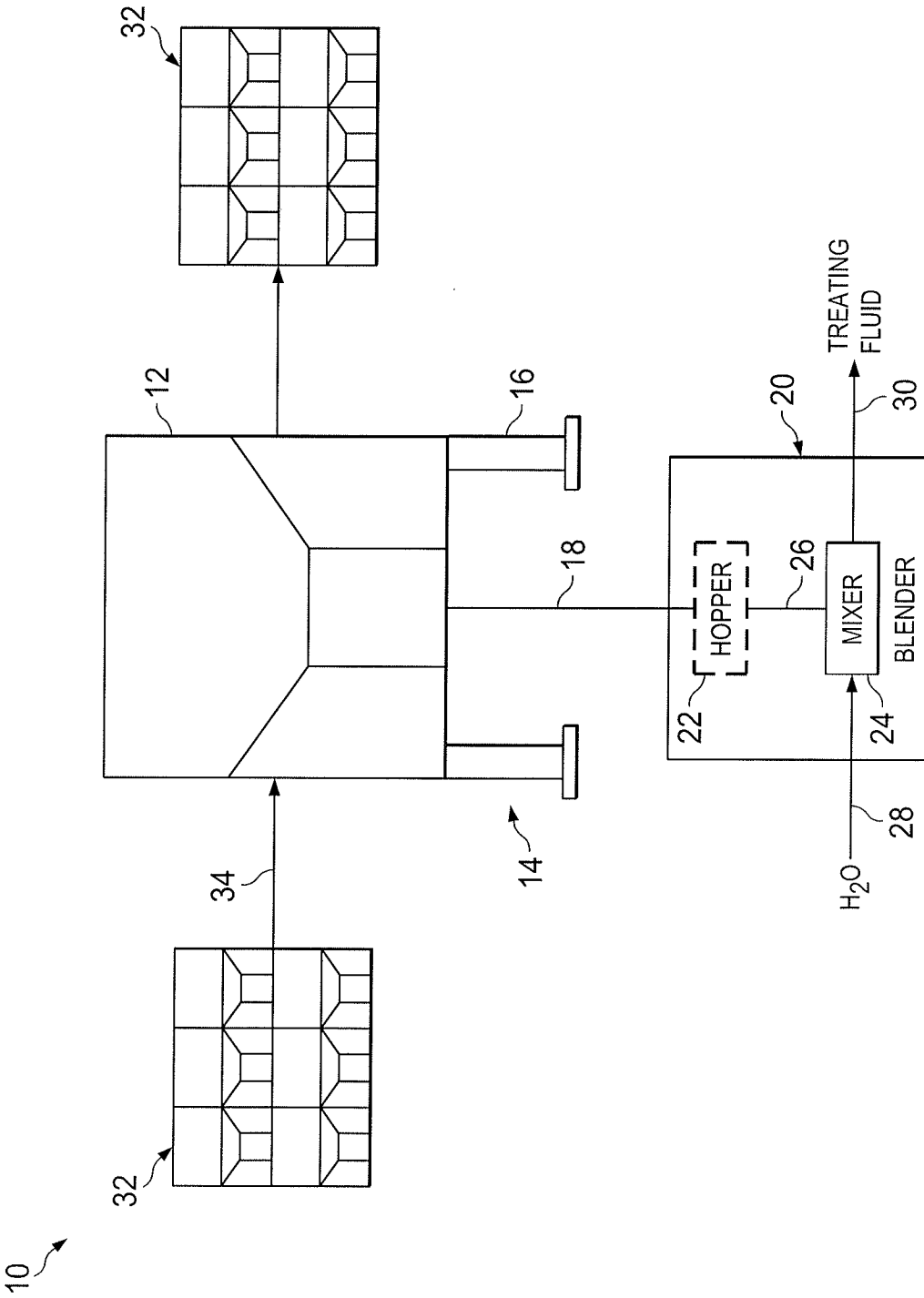


FIG. 1

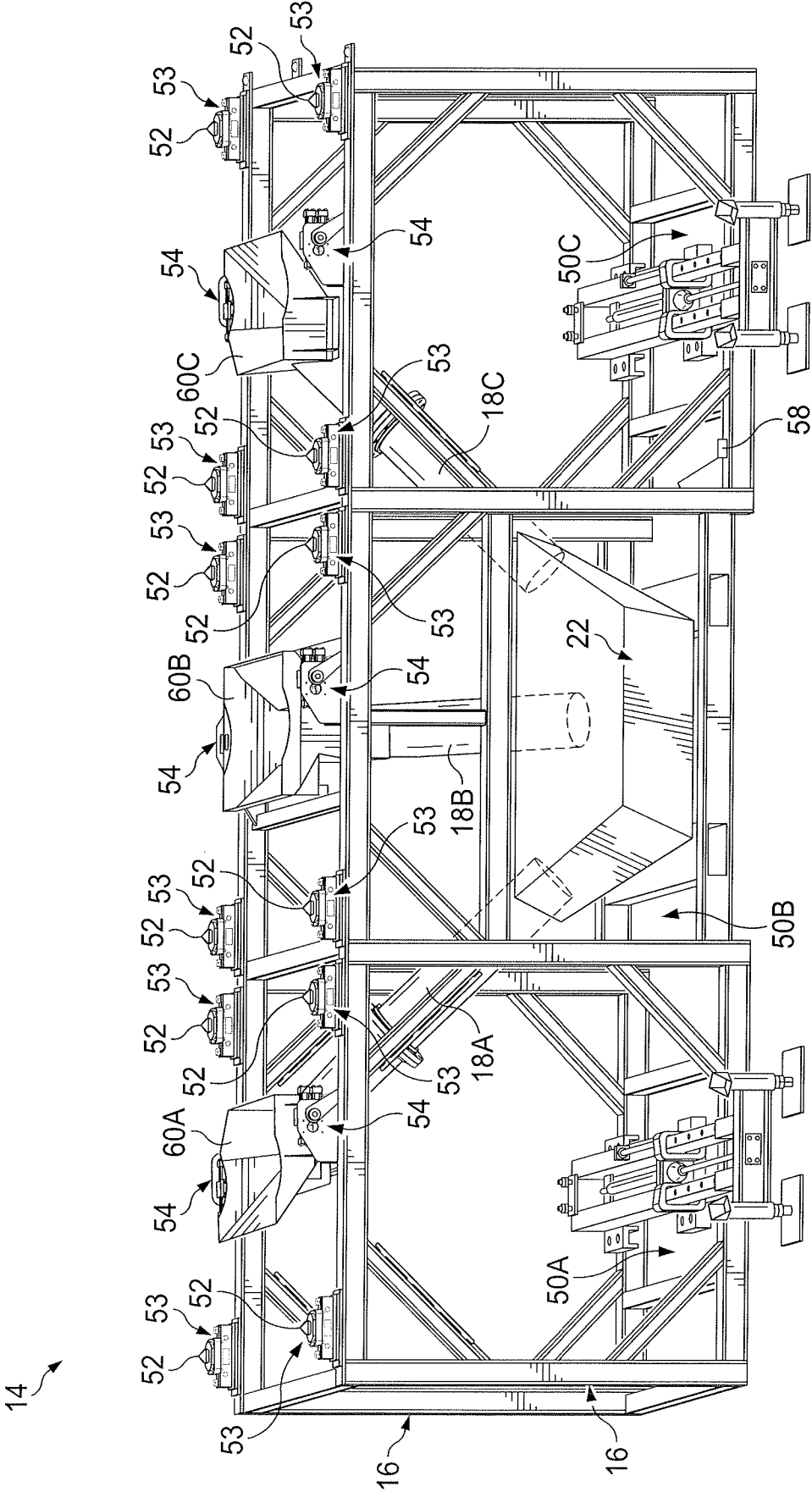


FIG. 2

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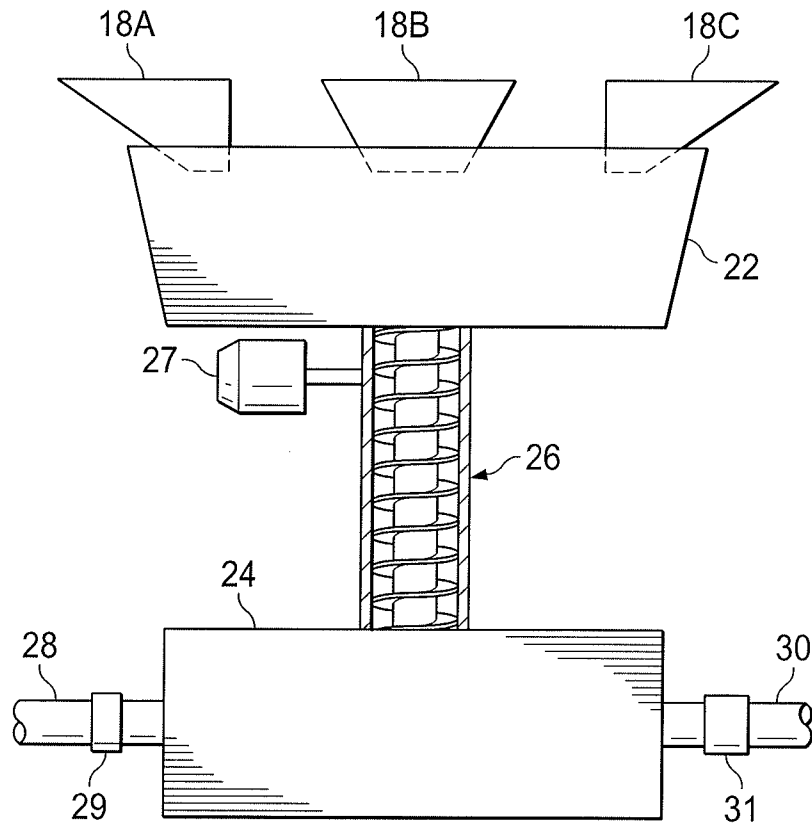


FIG. 3

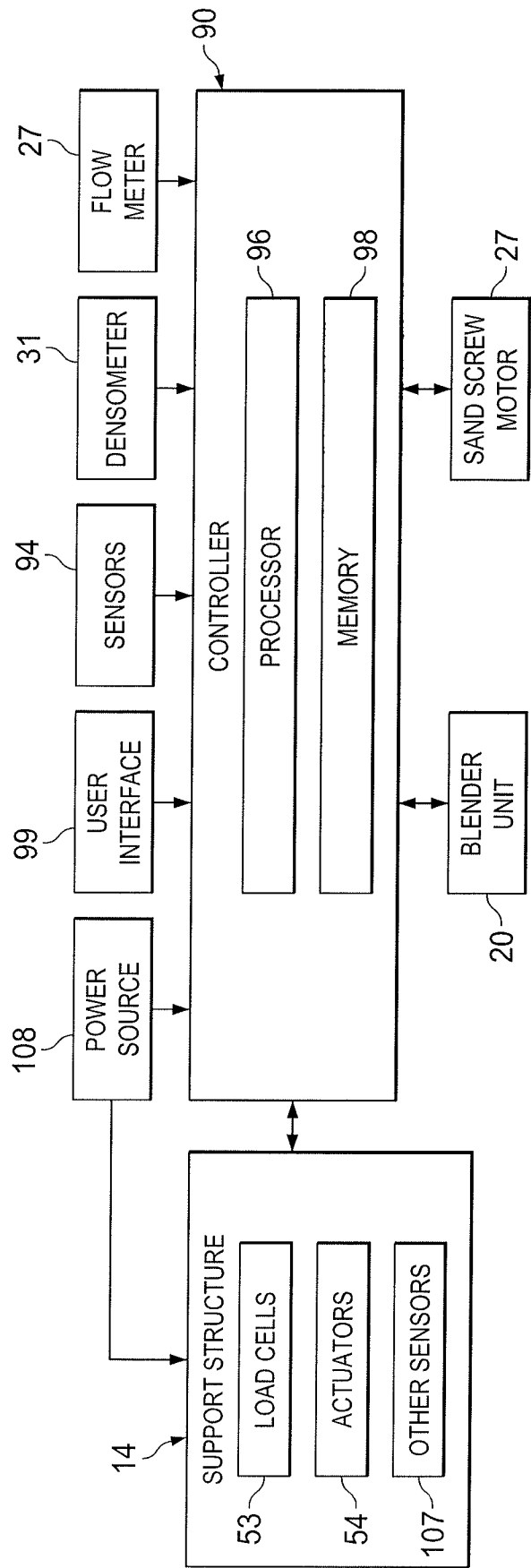


FIG. 4

A. CLASSIFICATION OF SUBJECT MATTER**E21B 41/00(2006.01)i, E21B 43/26(2006.01)i, E21B 43/22(2006.01)i, E21B 21/06(2006.01)i**

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

E21B 41/00; E04H 7/22; G01M 3/28; C04B 38/00; B28C 9/00; G05D 11/02; B60P 1/00; E21B 43/26; E21B 43/22; E21B 21/06

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Korean utility models and applications for utility models

Japanese utility models and applications for utility models

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

eKOMPASS(KIPO internal) & Keywords: portable, support, container, bulk material, blender, chock-feed

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 2014-0041322 A1 (SCHLUMBERGER TECHNOLOGY CORPORATION) 13 February 2014 See paragraphs [0004], [0026], [0034]–[0048] and figures 1–3, 7.	1–6, 8, 11–15
Y		7, 9–10, 16–20
Y	US 2015-0013436 A1 (HALLIBURTON ENERGY SERVICES, INC.) 15 January 2015 See paragraphs [0022]–[0026], [0035] and figures 1–2.	7, 9–10, 16–20
A	US 2011-0063942 A1 (HAGAN et al.) 17 March 2011 See paragraphs [0020]–[0033] and figures 1–4.	1–20
A	WO 2011-126723 A2 (WELKER et al.) 13 October 2011 See paragraphs [0011]–[0013], [0037]–[0049] and figures 1–2, 3A–3B.	1–20
A	US 2014-0234059 A1 (SCHLUMBERGER TECHNOLOGY CORPORATION) 21 August 2014 See paragraphs [0039]–[0050] and figures 1–4.	1–20



Further documents are listed in the continuation of Box C.



See patent family annex.

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Name and mailing address of the ISA/KR

International Application Division

Korean Intellectual Property Office

189 Cheongsa-ro, Seo-gu, Daejeon, 35208, Republic of Korea

Facsimile No. +82-42-481-8578

Authorized officer

LEE, Se Gyoung

Telephone No. +82-42-481-8740



INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No.

PCT/US2015/067520

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