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(54) Title: FLUIDS AND METHODS FOR MITIGATING SAG AND EXTENDING EMULSION STABILITY

(57) Abstract: A method of drilling a wellbore includes pumping an oleaginous wellbore fluid into a wellbore, the oleaginous wellbore fluid including an oleaginous continuous phase; a non-oleaginous discontinuous phase; an emulsifier stabilizing the non-oleaginous discontinuous phase in the oleaginous continuous phase; an organophilic clay; a weighting agent; and a wetting agent having an HLB ranging from about 4 to 10.5 that it selected such that the oleaginous wellbore fluid has a 600 rpm dial value at 40 °F of less than about 300 and a 10 minute gel strength of less than about 40 lbf/100ft².

FLUIDS AND METHODS FOR MITIGATING SAG AND EXTENDING EMULSION STABILITY

CROSS-REFERENCE TO RELATED APPLICATIONS

[0001] This Application claims priority to U.S. Provisional Patent Application No. 62/463,698 filed on February 26, 2017, which is incorporated herein by reference.

BACKGROUND

[0002] During the drilling of a wellbore, various fluids are typically used in the well for a variety of functions. The fluids may be circulated through a drill pipe and drill bit into the wellbore, and then may subsequently flow upward through the wellbore to the surface. During this circulation, the drilling fluid may act to remove drill cuttings from the bottom of the hole up to the surface, to suspend cuttings and weighting material when circulation is interrupted, to control subsurface pressures, to maintain the integrity of the wellbore until the well section is cased and cemented, to isolate the fluids from the subterranean formation by providing sufficient hydrostatic pressure to prevent the ingress of formation fluids into the wellbore, to cool and lubricate the drill string and bit, and/or to maximize penetration rate when drilling.

[0003] In most rotary drilling procedures, the drilling fluid takes the form of a “mud,” *i.e.*, a liquid having solids suspended therein. The solids function to impart desired rheological properties to the drilling fluid and also to increase the density thereof in order to provide a suitable hydrostatic pressure at the bottom of the well. The drilling mud may be either a water-based or an oil-based mud. As such, the ability to suspend drilling cuttings to reduce wear on the drill bit depends on the rheological properties of the drilling mud related to the viscosity of the drilling fluid.

[0004] Drilling muds may consist of polymers, biopolymers, clays and organic colloids added to a water-based fluid to obtain the desired viscous and filtration properties. Heavy minerals, such as barite or calcium carbonate, may be added to increase density. Solids from the formation are incorporated into the mud and often become dispersed in the mud as a consequence of drilling. Further, drilling muds may contain one or more natural and/or synthetic polymeric additives, including polymeric additives that

increase the rheological properties (e.g., plastic viscosity, yield point value, gel strength) of the drilling mud, and polymeric thinners and flocculants.

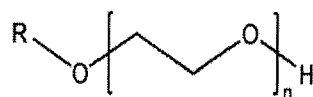
SUMMARY

[0005] This summary is provided to introduce a selection of concepts that are further described below in the detailed description. This summary is not intended to identify key or essential features of the claimed subject matter, nor is it intended to be used as an aid in limiting the scope of the claimed subject matter.

[0006] In one aspect, embodiments disclosed herein relate to a method of drilling a wellbore, that includes pumping an oleaginous wellbore fluid into a wellbore, the oleaginous wellbore fluid including an oleaginous continuous phase; a non-oleaginous discontinuous phase; an emulsifier stabilizing the non-oleaginous discontinuous phase in the oleaginous continuous phase; an organophilic clay; a weighting agent; and a wetting agent having an HLB ranging from about 4 to 10.5 that it selected such that the oleaginous wellbore fluid has a 600 rpm dial value at 40 °F of less than about 300 and a 10 minute gel strength of less than about 40 lbf/100ft².

[0007] In another aspect, embodiments disclosed herein relate to an oleaginous wellbore fluid that includes an oleaginous continuous phase; a non-oleaginous discontinuous phase; an emulsifier stabilizing the non-oleaginous discontinuous phase in the oleaginous continuous phase; an organophilic clay; at least one wetting agent selected from alcohol ethoxylates, amine ethoxylates, or ethylene oxide/propylene oxide copolymers; and a weighting agent; wherein the wellbore fluid has a 600 rpm dial value at 40 °F of less than about 300.

[0008] In yet another aspect, embodiments disclosed herein relate to an oleaginous wellbore fluid that includes an oleaginous continuous phase; a non-oleaginous discontinuous phase; an emulsifier to stabilize the non-oleaginous discontinuous phase in the oleaginous continuous phase; an organophilic clay; an alcohol ethoxylate depicted by Formula I:



Formula I

wherein R is one of an oleyl group, a stearyl group, a tridecyl group, or a lauryl group, and n is between 2 and 5; and a weighting agent; wherein the wellbore fluid has a 600 rpm dial value at 40 °F of less than about 300.

[0009] Other aspects and advantages of the claimed subject matter will be apparent from the following description and the appended claims.

DETAILED DESCRIPTION

[0010] Embodiments disclosed herein relate generally to wellbore fluids that exhibit reduced sag and extended emulsion stability. More specifically, embodiments disclosed herein relate to wellbore fluids that include organophilic clays and have reduced sag at low temperature (~40 °F). Sag is defined as the settling of particles in the annulus of a well. Sag can occur when the wellbore fluid is static or being circulated. Because of the combination of secondary flow and gravitational forces, weighting materials can settle (i.e., sag) in a flowing mud in a high-angle well. If settling is prolonged, the upper part of a wellbore will lose mud density, which lessens the hydrostatic pressure in the hole, so an influx (a kick) of formation fluid can enter the well which may damage the well or lead to the loss of the well. In some instances, operators attempt to increase the viscosity of a fluid to reduce sag. However, this approach can be problematic because the increasing pressures necessary to pump a more viscous fluid can lead to a greater risk for lost circulation when the pumping pressure exceeds that which the formation can withstand. This elevated viscosity is particularly problematic at lower temperatures where the fluid may naturally become more viscous.

[0011] In some embodiments, wellbore fluids disclosed herein may be an oil-based wellbore fluid, such as an invert emulsion containing an aqueous discontinuous phase and an oil-based continuous phase. "Invert emulsion," as used herein, is an emulsion in which a non-oleaginous fluid is the discontinuous phase and an oleaginous fluid is the continuous phase.

[0012] "Oleaginous liquid," as used herein, means an oil which is a liquid at 25°C and is immiscible with water. Oleaginous liquids may include substances such as

hydrocarbons used in the formulation of drilling fluids such as diesel oil, mineral oil, synthetic oil (including linear alpha olefins and internal olefins, polydiorganosiloxanes, siloxanes or organosiloxanes), ester oils, glycerides of fatty acids, aliphatic esters, aliphatic ethers, aliphatic acetals, or other such hydrocarbons and combinations of these fluids. The concentration of the oleaginous fluid should be sufficient so that an invert emulsion forms. The concentration of the oleaginous fluid may be less than about 99% by volume of the invert emulsion. In one embodiment the amount of oleaginous fluid is from about 30% to about 95% by volume and more particularly about 40% to about 90% by volume of the invert emulsion fluid.

[0013] "Non-oleaginous liquid," as used herein, means any substance that is a liquid at 25°C and that is not an oleaginous liquid as defined above. Non-oleaginous liquids are immiscible with oleaginous liquids but capable of forming emulsions therewith. Non-oleaginous liquids may include aqueous substances such as fresh water, sea water, brine containing inorganic or organic dissolved salts, aqueous solutions containing water-miscible organic compounds and mixtures of these. The amount of the non-oleaginous fluid is typically less than the theoretical maximum limit for forming an invert emulsion. Thus, the amount of non-oleaginous fluid is less than about 70% by volume. Preferably, the amount of non-oleaginous fluid ranges from about 1% to about 70% by volume, and more preferably from about 5% to about 60% by volume of the invert emulsion fluid.

[0014] Suitable oil-based or oleaginous fluids for use in wellbore fluids of the present disclosure may be a natural or a synthetic oil. In one or more embodiments the oleaginous fluid may be selected from the group including diesel oil; mineral oil; a synthetic oil, such as hydrogenated and unhydrogenated olefins including polyalpha olefins, linear and branch olefins and the like, polydiorganosiloxanes, siloxanes, or organosiloxanes, esters of fatty acids, specifically straight chain, branched and cyclical alkyl ethers of fatty acids, mixtures thereof and similar compounds known to one of skill in the art; and mixtures thereof.

[0015] Non-oleaginous liquids may, in some embodiments, include at least one of fresh water, sea water, brine, mixtures of water and water-soluble organic compounds, and mixtures thereof. In various embodiments, the non-oleaginous fluid may be a brine,

which may include seawater, aqueous solutions wherein the salt concentration is less than that of sea water, or aqueous solutions wherein the salt concentration is greater than that of sea water. Salts that may be found in seawater include, but are not limited to, sodium, calcium, aluminum, magnesium, potassium, strontium, and lithium salts of chlorides, bromides, carbonates, iodides, chlorates, bromates, formates, nitrates, oxides, sulfates, silicates, phosphates and fluorides. Salts that may be incorporated in a brine include any one or more of those present in natural seawater or any other organic or inorganic dissolved salts. Additionally, brines that may be used in the drilling fluids disclosed herein may be natural or synthetic, with synthetic brines tending to be much simpler in constitution. In one embodiment, the density of the drilling fluid may be controlled by increasing the salt concentration in the brine (up to saturation). In a particular embodiment, a brine may include halide or carboxylate salts of mono- or divalent cations of metals, such as cesium, potassium, calcium, zinc, and/or sodium.

[0016] In one or more embodiments, the oil-based wellbore fluid of the present disclosure may also contain an emulsifier, organophilic clays, a wetting agent, and a weighting agent. These components will be described in greater detail below. Prior to describing the specific components in detail, it should be understood that an oil-based wellbore fluid described herein and including the components listed above may be formulated such that it has certain rheological properties that lead to reduced sag and in particular reduced low temperature sag. For example, a wellbore fluid according to the present disclosure may have rheological properties including a 600 rpm dial value at 40 °F of less than about 300 or less than about 275, or less than about 250. Thus, at low temperatures (such as the temperature at which a fluid is pumped and exposed to high shear), the viscosity is not too high. Generally, a fluid having too high of high end rheology could be modified to have acceptable values at high shear, but such modifications would likely render the fluid unsuitable at low shear (with too low viscosity), particularly at higher temperatures when a fluid would naturally be less viscous. However, advantageously, the present inventors have found a wellbore fluid according to the present disclosure may also have rheological properties including a 6 rpm dial value at 150 °F of between about 6 and 15. Thus, the fluid of the present disclosure may have both acceptable high end rheology at low temperatures and low end rheology at high temperatures, meeting both ends of the spectrum to avoid sag.

[0017] Gel strength (i.e., measure of the suspending characteristics or thixotropic properties of a fluid) was evaluated by the 10 minute gel strength in pounds per 100 square feet, in accordance with procedures in API Bulletin RP 1313-2, 1990. In one or more embodiments, a wellbore fluid according to the present disclosure may have rheological properties including a 10 minute gel strength value at 40 °F of less than 40 lbf/100ft² or less than 35 lbf/100ft². Thus, as described above, the fluids of the present disclosure may have advantageous rheological properties at a low temperature (40°F) without sacrificing rheological properties at higher temperatures.

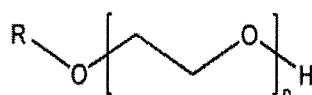
[0018] In fact, one or more embodiments of the present disclosure may be directed to a wellbore fluid having a flat rheology profile. As used herein, “flat rheology profile” means that consistent rheological properties are maintained over temperature ranges from 40° F to 150° F. The rheological properties of focus for a flat rheology profile include 6 rpm, 10 minute gel (10'), Yield Point (YP), and 10 minute-to-10 second gel ratio (10':10" gel ratio). With respect to 6 rpm, 10' gel, and YP, a system is considered to have a flat rheology profile when these values are within +/-20% of the mean values across temperature ranges from 40° F to 150° F. Lower percent variation will yield a more flat rheology profile, so values within +/-15% may be present in some embodiments, and +/-10% is even more particular embodiments. With respect to 10':10" gel ratio, a system is considered to have a flat rheology profile when the ratio is 1.5:1 or less.

[0019] To mitigate sag of the weighting agent within the oleaginous fluid, without creating a rheological profile that is problematic at colder temperatures when the viscosity of the fluid will naturally increase (particularly as the base fluid interacts with the weighting agent particles present in the fluid), the present inventors have determined that addition of particular wetting agents to the fluid may result in a weighted fluid that avoids sag without having excessive viscosity, particularly at colder temperatures. For example, in one or more embodiments, the wetting agent has a hydrophilic-lipophilic-balance (HLB) value of between about 4 to 10.5, or from about 5 to 9, or from about 6 to 8. HLB values are empirical expressions for the relationship of the amount of hydrophilic and hydrophobic groups on a wetting agent. In general, the higher the HLB value, the more water-soluble a wetting agent will be. Further, and as will be demonstrated in the Examples below, after long term exposure to elevated temperatures

a fluid of the present disclosure having a wetting agent with a HLB value higher than about 10.5 may become degraded and destabilized, presumably due to decomposition of the wetting agent. In one or more embodiments, the wetting agent may be present in the wellbore fluid in an amount of about 2 to 6 pounds per barrel (ppb) or 2.25 to 5 ppb. The inventors theorize that the wetting agent may preferentially wet the weighting agent particles present in the fluid so as to reduce sag of the particles within the fluid.

[0020] Thus, in one or more embodiments, the fluid may have minimal sag after a 7 day static period at elevated temperatures such as at least 200°F, 225°F, 250°F, 300°F, or 325°F. When fluid sags, the fluid exhibits a density change over the fluid column. Thus, by having minimal sag, the fluid may have less than a 1.25 or 1.0 ppg change over the static period. Another way of expressing this is through a “sag factor”, which is calculated for a fluid heat aged in a static cell for a period of time of at least 16 hours, by dividing the bottom density by the sum of the top and bottom densities. A sag factor of 0.5 indicates no settlement of weighting agents. In one or more embodiments of the present disclosure, a sag factor of less than 0.54 may be achieved or less than 0.53, 0.52, or 0.51.

[0021] In one or more embodiments, the wetting agent may be at least one selected from alcohol alkoxyates, amine alkoxyates, or ethylene oxide/propylene oxide copolymers. An alcohol ethoxylate according to the present disclosure may be generally depicted by Formula I below.

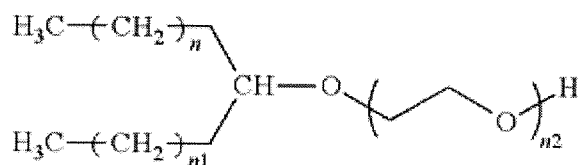


Formula I

whereas an alcohol propoxylate would substitute a propylene oxide for the ethylene oxide used in an alcohol ethoxylate. It is also envisioned that a combination of ethoxylation and propoxylation may be used. In Formula I, R may be a C10-28 alkyl group (either linear or branched, saturated or unsaturated) and n may range between 2 and 6 (or 3 and 5 in some embodiments). Further, it is also envisioned that R and n are not limited to such ranges, but may be selected such that the resulting HLB is within the ranges described herein. In particular embodiments, R may be an oleyl group, a

stearyl group, a tridecyl group, or a lauryl group. For example, in one or more embodiments, the wetting agent may be at least one alcohol ethoxylate selected from group of oleyl alcohol-2-ethoxylate, oleyl alcohol-3-ethoxylate, oleyl alcohol-5-ethoxylate, stearyl alcohol-2-ethoxylate, stearyl alcohol-3-ethoxylate, lauryl alcohol-4-ethoxylate, and tridecyl alcohol-3-ethoxylate.

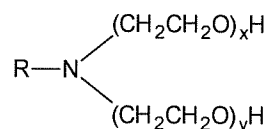
[0022] In one or more embodiments, the alcohol ethoxylate of the present disclosure may be depicted by Formula II below. Formula II represents a secondary alcohol ethoxylate.



Formula II

In one or more embodiments, $n+n1 = 12$ and $n2 = 2-4$. In one or more embodiments, the secondary alcohol ethoxylate of Formula III has an $n2$ value of 2.

[0023] In one or more embodiments, the wetting agent may be at least one amine ethoxylate or amine propoxylate. Amine ethoxylates may have the general formula:



where R may be a C10-C26 alkyl group (either linear or branched, saturated or unsaturated), and $x+y$ ranges from 2 to 15, or from 2 to 10 in more particular embodiments. One of ordinary skill in the art would appreciate that an amine propoxylate substitutes propoxylate groups for the shown ethoxylate groups in the above formula. In one or more embodiments, the amine ethoxylate may be selected from PEG-2 oleylamine, PEG-2 coco amine, PPG 2 cocoamine, PEG 15 cocoamine, PEG 5 tallow diamine, PEG-2 tallow amine, and PEG-5 tallow amine.

[0024] In one or more embodiments, the wetting agent may be at least one ethylene oxide/propylene oxide copolymer that is selected from a poly(ethylene glycol)-*block*-poly(propylene glycol)-*block*-poly(ethylene glycol) or ethylene diamine ethylene oxide/propylene oxide copolymer. The poly(ethylene glycol)-*block*-poly(propylene

glycol)-*block*-poly(ethylene glycol) may have a Mn between about 1000 and 5000. The ethylene diamine ethylene oxide/propylene oxide copolymer may be, for example, ethylenediamine tetrakis(propoxylate-*block*-ethoxylate) tetrol, or an ethylenediamine tetrakis(ethoxylate-*block*-propoxylate) tetrol. Such ethylene diamine ethylene oxide/propylene oxide copolymers may have an Mn ranging, for example from 3000 to 10000.

[0025] Other wetting agents may include alkyl sulfonates, amine ethers (including primary amine ethers such as $\text{ROCH}_2\text{CH}_2\text{CH}_2\text{NH}_2$ and ether diamines such as $\text{ROCH}_2\text{CH}_2\text{CH}_2\text{NHCH}_2\text{CH}_2\text{CH}_2\text{NH}_2$, where R may be selected from C6 to C18 and may be linear or branched, saturated or unsaturated), amide ethoxylates, a polyester condensation polymer (produced, for example, from condensation reaction of a hydroxy- fatty acid), a polyamine condensation polymer, a fatty polycarboxylic acid, polyether siloxanes, or aluminum salts of fatty acids.

[0026] One of the components of wellbore fluids of the present disclosure is an emulsifier that stabilizes the internal aqueous (non-oleaginous) phase within the external oleaginous fluid to form an invert emulsion. Such emulsifiers may comprise paraffins, fatty-acids, amine-based components, amidoamines, polyolefin amides, soaps of fatty acids, polyamides, polyamines, polyolefin amides, polyolefin amide alkeneamines, alkoxyated ether acids (such as an alkoxyated fatty alcohol terminated with a carboxylic acid), oleate esters, such as sorbitan monooleate, sorbitan dioleate, imidazoline derivatives or alcohol derivatives and combinations or derivatives of the above or the like. Blends of these materials as well as other emulsifiers can be used for this application. Examples of such emulsifiers, such as a high internal phase emulsifier, may be SUREMUL PLUS TM available from MI-SWACO (Houston, TX). In particular embodiments, an invert emulsion fluid of the present disclosure may be stabilized by an emulsifier formed from a fatty acid (one or more of a C10-C24 fatty acid, for example, which may include linear and/or branched, and saturated and/or unsaturated fatty acids) reacted with one or more ethyleneamines (e.g., ethylenediamine, diethylenetriamine, triethylenetetraamine, tetraethylenepentaamine) to produce one or more of amides, polyamides, and/or amidoamines, depending, for example, on the mole ratio of the polyamine to the fatty acid. In one or more embodiments, the emulsifier may be a dimer poly-carboxylic C12 to C22 fatty acid, trimer poly-carboxylic C12 to

C22 fatty acid, tetramer poly-carboxylic C12 to C22 fatty acid, mixtures of these acids, or a polyamide wherein the polyamide is the condensation reaction product of a C12-C22 fatty acid and a polyamine selected from the group consisting of diethylenetriamine, triethylenetetramine; and tetraethylenepentamine.

[0027] While many flat rheology fluids avoid organophilic clays, one or more embodiments of the present disclosure achieves the flat rheology profile desired while incorporating at least one organophilic clay into the invert emulsion fluid. An organophilic clay is defined to mean a clay that is treated in any way to have an organophilic coating or surface treatment. In particular embodiments, the organophilic clay may be an organophilic sepiolite.

[0028] In one or more embodiments, untreated clays, including untreated attapulgite clay and untreated sepiolite clay may also be used as viscosifiers in addition to the organophilic clays. Other viscosifiers and gellants, such as oil soluble polymers, styrene-butadiene block polymers, polyamide resins, polycarboxylic acids and soaps may also be used in addition to the organophilic clays. The total amount of viscosifier used in the compositions may vary depending on downhole conditions, as understood by those skilled in the art. However, normally a total amount of about 0.1% to 8% by weight range may be sufficient for most applications.

[0029] Weighting agents or density materials suitable for use in wellbore fluid formulations in accordance with the present disclosure include, but are not limited to, hematite, magnetite, iron oxides, illmenite, barite, siderite, celestite, dolomite, calcite, manganese oxides, halites and the like. In one or more embodiments, the weighting agents may be coated with a dispersant.

[0030] The quantity of the coated or uncoated weighting agent added, if any, may depend upon the desired density of the final composition. Weighting agents may be added to result in a final fluid density of up to about 22 pounds per gallon (ppg). In other embodiments, the weighting agent may be added to achieve a final fluid density of up to 20 ppg or up to 19.5 ppg. In one or more embodiments, weighting agents may be added to result in a final fluid density of at least about 10 ppg.

[0031] In one or more embodiments, the wellbore fluids of the present disclosure may also include at least one particle selected from calcium carbonate or hallyosite.

Hallyosite is an aluminosilicate clay that has a tubular morphology. In one or more embodiments, calcium carbonate or hallyosite may be included in the wellbore fluids of the present disclosure in amounts between about 5 and 30 ppb or amounts from 8 to 25 ppb.

[0032] Optionally, a rheology modifier may be included in the fluid of the present disclosure to reduce the increase in viscosity, i.e. flatten the rheological characteristics, of the drilling fluid over a temperature range from about 40° F to about 150° F. The rheology modifier may be polyamides, polyamines, amidoamines, polyetheramines, or mixtures thereof. Polyamides may be derived from reacting a polyamine with the reaction product of an alcoholamine and a fatty acid, for example. Generally, the alcoholamine-fatty acid reaction is based on a one equivalent of fatty acid for each equivalent of alcoholamine present. This reaction product is then reacted on a 1:1 equivalent ratio with the polyamine, and then quenched with a propylenecarbonate to remove any free unreacted amines. With respect to the rheology modifier, alcoholamines of the present disclosure may be selected from the group consisting of monoethanolamine, diethanolamine, triethanolamine, and mixtures thereof. Fatty acids may include tall oil or other similar unsaturated long chain carboxylic acids having from about 12 to about 22 carbon atoms. The fatty acids may be dimer or trimer fatty acids, or combinations thereof. As previously mentioned, once the alcoholamine has been reacted with the fatty acid, the reaction product is then further reacted with a polyamine. With respect to the rheology modifier, polyamines may be selected from the group consisting of diethylene triamine, triethylene tetramine, tetraethylene pentamine, and combinations thereof. Commercially available rheology modifiers that provide flat rheology wellbore fluids include EMI-1005, available from M-I SWACO (Houston, Tex.), and TECHWAX™ LS-10509 and LS-20509, both available from International Specialty Products (Wayne, N.J.).

[0033] It is conventional in many invert emulsions to include an alkali reserve so that the overall fluid formulation is basic (i.e. pH greater than 7). Typically, this is in the form of lime or alternatively mixtures of alkali and alkaline earth oxides and hydroxides. One of skill in the art should understand and appreciate that the lime content of a well bore fluid will vary depending upon the operations being undertaken and the formations being drilled. Further it should be appreciated that the lime content,

also known as alkalinity or alkaline reserve, is a property that is typically measured in accordance with the applicable API standards which utilize methods that should be well known to one of skill in the art of fluid formulation.

[0034] Fluid loss control agents typically act by coating the walls of the borehole as the well is being drilled. Suitable fluid loss control agents which may find utility in this invention include modified lignites, asphaltic compounds, gilsonite, organophilic humates prepared by reacting humic acid with amides or polyalkylene polyamines, and other non-toxic fluid loss additives. Typically, fluid loss control agents are added in amounts less than about 10% and preferably less than about 5% by weight of the fluid.

[0035] The method used in preparing wellbore fluids described herein is not critical. For example, conventional methods can be used to prepare the wellbore fluids in a manner analogous to those normally used, to prepare conventional oil-based drilling fluids. In one representative procedure, a desired quantity of oleaginous fluid such as a base oil and a suitable amount of the remaining components are added sequentially with continuous mixing. An invert emulsion of the present disclosure is formed by vigorously agitating, mixing or shearing the oleaginous fluid with a non-oleaginous fluid.

[0036] The disclosed wellbore fluids are especially useful in the drilling, completion and working over of subterranean oil and gas wells. In particular, the fluids are useful in formulating drilling fluids and completion fluids for use in high deviation wells, and long reach wells. Such fluids are especially useful in the drilling of horizontal wells into hydrocarbon bearing formations. Thus, the present fluids may be pumped into a wellbore and circulated therethrough.

[0037] EXAMPLES

[0038] In the first example a 14.96 pound per gallon (ppg) seed mud was formulated using the RHELIANT drilling fluid system, available from M-I LLC, Houston TX. Two samples of this seed mud were treated with a 50/50 dilution as shown in Table 1.

Table 1

Treatment (g)	Ex. 1	Ex.2
14.96ppg seed mud	471.4	471.4
IO 1618	46.6	46.6
EMI-3203	5.0	5.0
Alcohol Ethoxylate 1	4.0	-
Alcohol Ethoxylate 2	-	4.0
SURETROL	0.50	0.50
DURAMOD	8.0	8.0
LDP 2026	1.00	1.00
MICROBAR	51.0	51.0

[0039] In this set of examples Alcohol Ethoxylate 1 had an HLB value of 6.6 and was according to Formula I above with an oleyl group as the R group and an n value of 3. Alcohol Ethoxylate 2 had an HLB value of 4.9 and was according to Formula I above with a stearyl group as the R group and an n value of 2.

[0040] The rheology of the initial seed mud and the muds of Example 1 and Example 2 are shown in Table 2 below.

Table 2

Heat Aging Temp. Heat Aging Time Aging Condition	14.96 RHELIANT SEED MUD					Example 1					Example 2				
	INITIAL		325°F			INITIAL		325°F			INITIAL		325°F		
			160 hr					160 hr					160 hr		
	Static			Static			Static			Static					
Rheology Temp, °F	40	150	40	100	150	40	150	40	100	150	40	150	40	100	150
R600, °VG	270	77	337	147	98	225	86	217	104	72	348	89	346	106	79
R300, °VG	147	44	172	87	60	124	56	119	60	45	180	56	175	62	46
R200, °VG	104	33	126	65	46	88	44	84	44	35	132	44	126	46	39
R100, °VG	58	21	73	42	32	52	31	49	28	24	81	30	72	28	27
R6, °VG	12	6	16	16	15	11	12	8	8	11	21	12	13	8	13
R3, °VG	10	5	14	15	14	9	11	6	6	11	18	11	11	7	13
PV, cP	123	33	14	60	38	101	30	98	44	27	168	33	171	44	33
YP, lb/100ft ²	24	11	165	27	22	23	26	21	16	18	12	23	4	18	13
LSYP, lb/100ft ²	8	4	12	14	13	7	10	4	4	11	15	10	9	6	13
10-sec Gel, lb/100ft ²	13	9	37		27	16	17	7	14	24	47	20	27	15	24
10-min Gel, lb/100ft ²	32	17	48		30	35	30	12	26	29	66	32	55	33	33
E.S. @150°F, V		559			593		1123			1005		1164			983
7day Sag, ΔMW, ppg (325F)					2.50					2.88					2.69

[0041] While there was no appreciable reduction in 7 day sag factor measured at 325°F with the treatment above, a significant reduction in sag was seen at lower temperature (210- 250°F) in later data for Example 1.

[0042] In another set of examples, a 15.03 ppg seed mud (EMS 4720 fluid available from M-I SWACO Houston, Texas) was treated as shown in Table 3 and Table 4.

Table 3

Example 3		
15.03ppg Seed Mud	g	315.8
IO 1618	g	64.4
EMI-3203	g	10.0
Alcohol Ethoxylate 1	g	4.0
LIME	g	3.0
CaCl2 Brine (25%)	g	32.7
SURETROL (EMI-2487)	g	1.0
DURAMOD	g	8.0
RHEFLAT	g	1.0
EMI-1776	g	181.6

Table 4

Example 4		
15.03ppg Seed Mud	g	315.8
IO 1618	g	58.7
EMI-3203	g	10.0
Alcohol Ethoxylate 1	g	4.00
LIME	g	3.00
CaCl2 Brine (25%)	g	30.3
SURETROL (EMI-2487)	g	1.00
DURAMOD	g	8.0
RHEFLAT	g	1.0
EMI-1776	g	169.8
API EVAL CLAY	g	20.0

[0043] The rheology of the initial seed mud and the muds of Example 3 and Example 4 are shown in Table 5 below.

Table 5

Heat Aging Temp. Heat Aging Time Aging Condition	15.03ppg EMS 4720 Total LGS= 2.9%		Example 3 Total LGS= 1.4%		Example 4 Total LGS= 3.6%	
	INITIAL	210°F	INITIAL	210°F	INITIAL	210°F
		160		160		160
		S		Static		Static

Rheology Temp, °F	40	150	40	100	150	40	150	40	100	150	40	150	40	100	150
R600, °VG	225	65	230	96	59	261	92	250	122	84	355	129	335	168	115
R300, °VG	122	38	125	53	33	143	56	137	70	49	197	81	191	97	70
R200, °VG	86	29	88	37	24	102	43	97	51	37	141	63	137	72	54
R100, °VG	48	19	49	21	15	58	29	54	31	23	84	44	80	46	36
R6, °VG	10	8	10	6	5	13	14	10	8	7	41	23	17	15	14
R3, °VG	8	7	8	5	4	11	13	7	7	6	38	22	13	13	12
PV, cP	103	27	105	43	26	118	36	113	52	35	158	48	159	71	45
YP, lb/100ft ²	19	11	20	10	7	25	20	24	18	14	39	33	32	26	25
LSYP, lb/100ft ²	6	6	6	4	3	9	12	4	6	5	35	21	9	11	10
10-sec Gel, lb/100ft ²	10	12	9	7	7	15	28	11	11	12	28	52	18	20	23
10-min Gel, lb/100ft ²	28	25	21	15	15	36	45	21	21	23	68	117	37	36	36
E.S. @150°F, V		328			428		1080			613		1419			918
7day Sag, ΔMW, ppg (210°F)					3.06					1.21					0.81

[0044] In another example, a 15 pound per gallon (ppg) seed mud was formulated using the RHELIANT drilling fluid system, available from M-I LLC, Houston TX. The seed mud was treated as shown in Table 6 below to create a 14 ppg fluid of Example 5.

Table 6

Example 5		
15.00ppg seed mud	g	315.0
IO 1618	g	74.4
EMI-3203	g	10.0
Alcohol Ethoxylate 1	g	4.00
LIME	g	3.00
CaCl ₂ Brine (25%)	g	32.50
SURETROL (EMI-2487)	g	1.00
DURAMOD	g	8.0
DRAGONITE XR	g	20.0
LDP 2026 (RHEOLOGY MODIFIER)	g	1.0
MICROBAR	g	146.6

[0045] The rheology of the initial seed mud and the mud of Example 5 is shown in Table 7 below.

[0046] In another set of examples, two muds were formulated as shown in Table 8 below, where Example 6 was formulated as a Comparative Sample equivalent to U.S. Patent No. 8,476,206.

Table 8

Treatment (g)		Ex. 6	Ex. 7
IO 1618	bbbl	0.519	0.5235
EMI-3203	lb/bbl	--	16
Alcohol Ethoxylate 1	lb/bbl	--	4
SUREMUL	lb/bbl	16	--
SURETROL	lb/bbl	--	1
DURAMOD	lb/bbl	4	8.0
Lime	lb/bbl	4	4
MICROBAR	lb/bbl	--	330.23
Water	bbbl	0.152	0.1451
CaCl ₂	lb/bbl	19.04	18.13
ECOTROL RD	lb/bbl	2	--
SAFECARB 2	lb/bbl	10	10
PANGEL B-5	lb/bbl	--	0.5
M-I GEL SUPREME	lb/bbl	4	--
RHEFLAT	lb/bbl	--	1
SUREMOD	lb/bbl	1	--
M-I WATE	lb/bbl	333	--

[0047] The rheology of the muds of Examples 6 and Example 7 are shown in Table 9 below.

Table 9

	Example 6 14.15 ppg						Example 7 14.11 ppg					
	INITIAL			200°F			INITIAL			210°F		
				62						72		
				Static						Static		
Rheology Temp, °F	40	100	150	40	100	150	40	100	150	40	100	150
R600, °VG				TTM	76	55	242	107	73	208	94	63
R300, °VG				242	43	32	134	61	43	114	52	37
R200, °VG				175	33	24	94	44	33	81	38	28
R100, °VG				105	22	16	52	27	21	44	22	18
R6, °VG				30	8	6	8	7	8	7	6	6
R3, °VG				23	7	5	6	6	7	5	4	5

PV, cP				TTTM	33	23	108	46	30	94	42	26	
YP, lb/100ft ²				TTTM	10	9	26	15	13	20	10	11	
LSYP, lb/100ft ²					16	6	4	4	5	6	3	2	4
10-sec Gel, lb/100ft ²					50	9	6	8	9	14	6	7	7
10-min Gel, lb/100ft ²					51	19	22	16	21	43	12	15	21
E.S. @120°F, V					659			1013			580		
ΔMW on bottom, lbm/gal					0.56-0.62						0.34-0.69		
HTHP @ 250°F, mL					2.0						3.2		
Water in HTHP Filtrate, mL					0						0		

TTTM – Too Turbulent to Measure

[0048] In another example, a 11.25 pound per gallon (ppg) seed mud was treated as shown in Table 10 below to create 14.5 ppg fluids of Example 8 and Example 9. In Example 9, the combination of an Alcohol Ethoxylate 3 according to Formula I above with an HLB of about 5 and an oleyl group as the R group and an n value of 2 and an Alcohol Ethoxylate 4 according to Formula I above with an HLB of about 9 and an oleyl group as the R group and an n value of 5. This combination has a calculated HLB value of about the same value for Alcohol Ethoxylate 1 alone.

Table 10

	Example 8 (g)	Example 9 (g)
EMS4720, Sevan LA, 11.25ppg	240.0	240.0
IO 1618	50.0	50.0
Suremul, amine #20	10.0	10.0
Surewet	0.0	0.0
Alcohol Ethoxylate 3	0.0	2.0
Alcohol Ethoxylate 1	4.0	0.0
Alcohol Ethoxylate 4	0.0	2.0
LIME	0.0	0.0
25% CaCl ₂ Brine	12.0	12.0
ECOTROL HT	3.0	3.0
ONE TROL HT	0.0	0.0
DURAMOD	4.0	4.0
RHEFLAT	0.0	0.0
EMI-1776	250.0	250.0
API EVAL CLAY	25.0	25.0

[0049] The rheology of the mud of Example 8 are shown in Table 11 below.

Table 11

Heat Aging Temp, °F	INITIAL			325			325		
Heat Aging, hr				16			160		
Static/Rolling				Dynamic			Static		
Mud Weight, lb/gal	14.50			14.50			14.50		
Rheology Temp, °F	40	100	150	40	100	150	40	100	150
R600, °VG	278		88	286	141	96	280	141	98
R300, °VG	152		53	160	83	59	156	83	61
R200, °VG	110		40	115	61	46	112	62	47
R100, °VG	64		26	67	39	31	65	40	32
R6, °VG	12		8	13	13	12	13	13	13
R3, °VG	10		7	11	11	12	11	12	12
PV, cP	126	0	35	126	58	37	124	58	37
YP, lb/100ft ²	26	0	18	34	25	22	32	25	24
LSYP, lb/100ft ²	8	0	6	9	9	12	9	11	11
10-sec Gel, lb/100ft ²	12		9	14	14	16	14	15	16
10-min Gel, lb/100ft ²	22		20	31	30	33	28	32	27
Static Shear, lb/100ft ²									
E.S. @150°F, V			1065			1008			1019
HTHP Temp, °F						325			325
HTHP FL, ml						7.4			8.6
Water in HTHP Filtrate, ml						0			0

[0050] The rheology of the mud of Example 9 are shown in Table 12 below.

Table 12

Heat Aging Temp, °F	INITIAL			325			325		
Heat Aging, hr				16			160		
Static/Rolling				D			S		
Mud Weight, lb/gal	14.50			14.50			14.50		
Rheology Temp, °F	40	100	150	40	100	150	40	100	150
R600, °VG	288		90	281	132	92	300+	155	101
R300, °VG	160		53	153	79	57	180	93	64
R200, °VG	115		40	110	60	44	127	70	50
R100, °VG	65		25	63	38	31	74	45	35
R6, °VG	14		8	13	12	13	15	15	15
R3, °VG	11		7	11	11	11	13	14	14
PV, cP	128	0	37	128	53	35	#####	62	37
YP, lb/100ft ²	32	0	16	25	26	22	#####	31	27
LSYP, lb/100ft ²	8	0	6	9	10	9	11	13	13
10-sec Gel, lb/100ft ²	13		9	15	15	16	15	18	17
10-min Gel, lb/100ft ²	23		16	25	26	29	25	25	23
Static Shear, lb/100ft ²									

E.S. @150°F, V						1030			880
HTHP Temp, °F						325			325
HTHP FL, ml						8.5			12.6
Water in HTHP Filtrate, ml						0			0

[0051] Example 10 is a fluid with the same composition as that for Example 8 (shown in Table 10 above), with the exception being that 4 ppb of a secondary alcohol ethoxylate according to Formula II, where $n+n_1=12$ and $n_2 = 2$ was used instead of Alcohol Ethoxylate 1. This secondary alcohol ethoxylate has an HLB of about 8. The rheology of the mud of Example 3 is shown in Table 13 below.

Table 13

Heat Aging Temp, °F	INITIAL			325			325		
Heat Aging, hr				16			160		
Static/Rolling				Dynamic			Static		
Mud Weight, lb/gal	14.50			14.50			14.50		
Rheology Temp, °F	40	100	150	40	100	150	40	100	150
R600, °VG	300		98	>300	152	104	>300	158	111
R300, °VG	171		61	172	91	65	185	96	71
R200, °VG	123		47	124	69	51	133	73	56
R100, °VG	74		32	73	45	35	79	49	40
R6, °VG	18		12	18	17	17	20	20	20
R3, °VG	15		10	15	16	16	17	18	18
PV, cP	129	0	37	#####	61	39	#####	62	40
YP, lb/100ft ²	42	0	24	#####	30	26	#####	34	31
LSYP, lb/100ft ²	12	0	8	12	15	15	14	16	16
10-sec Gel, lb/100ft ²	18		14	22	25	23	25	28	26
10-min Gel, lb/100ft ²	37		27	47	39	31	48	42	33
Static Shear, lb/100ft ²									
E.S. @150°F, V			1080			886			903
HTHP Temp, °F						325			325
HTHP FL, ml						12.4			11.6
Water in HTHP Filtrate, ml						0			0

[0052] Comparative Example 1 is a fluid with the same composition as that for Example 8 (shown in Table 10 above), with the exception being that 4 ppb of a secondary alcohol ethoxylate according to Formula II, where $n+n_1=12$ and $n_2 = 6$ was used instead of Alcohol Ethoxylate 1. This secondary alcohol ethoxylate has an HLB value of about 12 and an n_2 value outside of the range discussed above for being

appropriate for a wetting agent. The rheology of the mud of Comparative Example 1 is shown in Table 14 below.

Table 14

Heat Aging Temp, °F	INITIAL			325			325		
Heat Aging, hr				16			160		
Static/Rolling				Dynamic			Static		
Mud Weight, lb/gal	14.50			14.50			14.50		
Rheology Temp, °F	40	100	150	40	100	150	40	100	150
R600, °VG	300		89	>300	154	107	>300	218	165
R300, °VG	172		54	172	93	66	287	131	108
R200, °VG	130		41	121	71	52	211	99	85
R100, °VG	78		27	68	45	35	129	65	60
R6, °VG	20		9	12	17	15	34	24	29
R3, °VG	16		8	9	15	14	30	22	27
PV, cP	128	0	35	#####	61	41	#####	87	57
YP, lb/100ft ²	44	0	19	#####	32	25	#####	44	51
LSYP, lb/100ft ²	12	0	7	6	13	13	26	20	25
10-sec Gel, lb/100ft ²	20		10	10	20	19	44	28	29
10-min Gel, lb/100ft ²	39		19	18	32	28	75	37	39
Static Shear, lb/100ft ²									
E.S. @150°F, V			514			537			692
HTHP Temp, °F						325			325
HTHP FL, ml						10			16.6
Water in HTHP Filtrate, ml						0			0

[0053] Comparative Example 2 is a fluid with the same composition as that for Example 8 (shown in Table 10 above), with the exception being that 4 ppb of a secondary alcohol ethoxylate according to Formula II, where $n+n_1=12$ and $n_2 = 8$ was used instead of Alcohol Ethoxylate 1. This secondary alcohol ethoxylate has an HLB value of about 13 and an n_2 value outside of the range discussed above for being appropriate for a wetting agent. The rheology of the mud of Comparative Example 2 is shown in Table 15 below.

Table 15

Heat Aging Temp, °F	INITIAL			325			325		
Heat Aging, hr				16			160		
Static/Rolling				Dynamic			Static		
Mud Weight, lb/gal	14.50			14.50			14.50		
Rheology Temp, °F	40	100	150	40	100	150	40	100	150
R600, °VG	300+		95	300+	155	110	300+	175	139

R300, °VG	180		60	210	92	70	235	105	92
R200, °VG	132		45	154	70	54	177	79	74
R100, °VG	79		30	90	45	37	110	52	54
R6, °VG	20		10	20	16	16	35	20	29
R3, °VG	18		10	15	15	16	32	17	26
PV, cP	#####	0	35	#####	63	40	#####	70	47
YP, lb/100ft ²	#####	0	25	#####	29	30	#####	35	45
LSYP, lb/100ft ²	16	0	10	10	14	16	29	14	23
10-sec Gel, lb/100ft ²	24		14	27	21	24	50	25	32
10-min Gel, lb/100ft ²	38		24	50	37	30	85	37	39
Static Shear, lb/100ft ²									
E.S. @150°F, V						350			370
HTHP Temp, °F						325			325
HTHP FL, ml						10			14
Water in HTHP Filtrate, ml						0			0

[0054] Comparative Example 3 is a fluid with the same composition as that for Example 1 (shown in Table 10 above), with the exception being that 4 ppb of tristyrylphenol with 14 ethoxylate groups was used instead of Alcohol Ethoxylate 1. This compound has an HLB value of about 13. The rheology of the mud of Comparative Example 3 is shown in Table 16 below.

Table 16

Heat Aging Temp, °F	INITIAL			325			325		
Heat Aging, hr				16			160		
Static/Rolling				Dynamic			Static		
Mud Weight, lb/gal	14.50			14.50			14.50		
Rheology Temp, °F	40	100	150	40	100	150	40	100	150
R600, °VG	300+		130	300+	179	138	300+	220	155
R300, °VG	200		80	199	110	91	225	137	109
R200, °VG	150		60	146	89	75	167	109	90
R100, °VG	92		40	90	60	54	105	75	71
R6, °VG	20		16	24	25	32	31	35	48
R3, °VG	16		15	22	24	32	30	34	47
PV, cP	#####	0	50	#####	69	47	#####	83	46
YP, lb/100ft ²	#####	0	30	#####	41	44	#####	54	63
LSYP, lb/100ft ²	12	0	14	20	23	32	29	33	46
10-sec Gel, lb/100ft ²	17		24	24	40	41	41	45	48
10-min Gel, lb/100ft ²	46		38	38	53	44	85	62	52
Static Shear, lb/100ft ²									
E.S. @150°F, V						850			900

HTHP Temp, °F						325			325
HTHP FL, ml						16			19
Water in HTHP Filtrate, ml						0.1			0.2

[0055] Example 11 – Evaluation of Amount of Additive Needed

[0056] Table 17 below shows a wellbore fluid formulation used to test the amount of non-ionic additive composition needed to achieve desirable low temperature rheology and high temperature stability.

Table 17

VG-HT	0.20
IO 1618	144.0
Heated Suremul	12.0
Alcohol Ethoxylate 1	variable
LIME	6.0
25% CaCl ₂ Brine	65.0
Pexatrol 932	3.0
ONE TROL HT	0.0
DURAMOD	6.0
Rheflat	2.0
EMI-1776	325.0
API EVAL CLAY	25.0

[0057] The rheology of the mud of Example 11 when no Alcohol Ethoxylate 1 has been added is shown in Table 18 below.

Table 18

Heat Aging Temp, °F	INITIAL			325			325		
Heat Aging, hr				16			160		
Static/Rolling				Dynamic			Static		
Mud Weight, lb/gal	13.97			13.97			13.97		
Rheology Temp, °F	40	100	150	40	100	150	40	100	150
R600, °VG	300+		66	300+	111	69	262	95	63
R300, °VG	177		42	187	63	40	143	53	38
R200, °VG	127		34	130	45	30	99	39	29
R100, °VG	75		24	73	29	20	55	24	19
R6, °VG	19		10	20	9	8	12	9	10
R3, °VG	19		9	19	8	7	12	9	10
PV, cP	#####	0	24	#####	48	29	119	42	25
YP, lb/100ft ²	#####	0	18	#####	15	11	24	11	13
LSYP, lb/100ft ²	19	0	8	18	7	6	12	9	10
10-sec Gel, lb/100ft ²	22		15	28	14	16	17	20	19

10-min Gel, lb/100ft ²	73		28	48	28	24	40	29	26
Static Shear, lb/100ft ²									
E.S. @150°F, V						700			1020
HTHP Temp, °F						325			325
HTHP FL, ml						9.6			13.4
Water in HTHP Filtrate, ml						0			0
Sag value ΔMW, ppg									2.83
Free oil, mL									86

[0058] The rheology of the mud of Example 11 when 0.9 ppb Alcohol Ethoxylate 1 has been added is shown in Table 19 below.

Table 139

Heat Aging Temp, °F	INITIAL			325			325		
Heat Aging, hr				16			160		
Static/Rolling				Dynamic			Static		
Mud Weight, lb/gal	13.97			13.97			13.97		
Rheology Temp, °F	40	100	150	40	100	150	40	100	150
R600, °VG	300+		59	298	104	67	251	99	67
R300, °VG	167		35	164	56	39	136	55	39
R200, °VG	119		26	115	40	29	95	39	29
R100, °VG	67		17	64	24	17	51	24	19
R6, °VG	17		7	15	6	6	10	7	9
R3, °VG	16		6	13	5	6	9	7	8
PV, cP	#####	0	24	134	48	28	115	44	28
YP, lb/100ft ²	#####	0	11	30	8	11	21	11	11
LSYP, lb/100ft ²	15	0	5	11	4	6	8	7	7
10-sec Gel, lb/100ft ²	17		10	19	10	15	13	17	20
10-min Gel, lb/100ft ²	61		28	40	28	24	34	20	28
Static Shear, lb/100ft ²									
E.S. @150°F, V						670			650
HTHP Temp, °F						325			325
HTHP FL, ml						8.8			17
Water in HTHP Filtrate, ml						0			0.4
Sag value ΔMW, ppg									2.83
Free oil, mL									82

[0059] The rheology of the mud of Example 11 when 1.8 ppb Alcohol Ethoxylate 1 has been added is shown in Table 20 below.

Table 20

Heat Aging Temp, °F	INITIAL	325	325
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Heat Aging, hr				16			160		
Static/Rolling				Dynamic			Static		
Mud Weight, lb/gal	13.97			13.97			13.97		
Rheology Temp, °F	40	100	150	40	100	150	40	100	150
R600, °VG	285		61	284	106	69	251	99	67
R300, °VG	157		35	154	58	39	136	56	39
R200, °VG	112		27	107	41	30	96	40	29
R100, °VG	63		17	58	24	19	52	25	20
R6, °VG	12		7	9	6	7	10	8	10
R3, °VG	11		7	9	6	7	9	8	10
PV, cP	128	0	26	130	48	30	115	43	28
YP, lb/100ft ²	29	0	9	24	10	9	21	13	11
LSYP, lb/100ft ²	10	0	7	9	6	7	8	8	10
10-sec Gel, lb/100ft ²	15		12	11	10	14	13	17	24
10-min Gel, lb/100ft ²	45		30	25	29	28	28	30	29
Static Shear, lb/100ft ²									
E.S. @150°F, V						610			620
HTHP Temp, °F						325			325
HTHP FL, ml						9			17
Water in HTHP Filtrate, ml						0			0.6
Sag value ΔMW, ppg									2.53
Free oil, mL									73

[0060] The rheology of the mud of Example 11 when 2.8 ppb Alcohol Ethoxylate 1 has been added is shown in Table 21 below.

Table 141

Heat Aging Temp, °F	INITIAL			325			325		
Heat Aging, hr				16			160		
Static/Rolling				Dynamic			Static		
Mud Weight, lb/gal	13.97			13.97			13.97		
Rheology Temp, °F	40	100	150	40	100	150	40	100	150
R600, °VG	235		60	265	102	71	232	110	77
R300, °VG	124		34	142	55	40	127	60	45
R200, °VG	85		25	98	39	29	87	43	34
R100, °VG	46		15	53	22	17	48	26	23
R6, °VG	6		5	8	5	7	8	9	12
R3, °VG	4		5	6	5	7	7	8	11
PV, cP	111	0	26	123	47	31	105	50	32
YP, lb/100ft ²	13	0	8	19	8	9	22	10	13
LSYP, lb/100ft ²	2	0	5	4	5	7	6	7	10
10-sec Gel, lb/100ft ²	7		12	8	8	12	10	19	24

10-min Gel, lb/100ft ²	24		32	20	26	35	25	33	32
Static Shear, lb/100ft ²									
E.S. @150°F, V						570			940
HTHP Temp, °F						325			325
HTHP FL, ml						8.8			17
Water in HTHP Filtrate, ml						0			0.2
Sag value ΔMW, ppg									2.13
Free oil, mL									68

[0061] The rheology of the mud of Example 11 when 3.7 ppb Alcohol Ethoxylate 1 has been added is shown in Table 21 below.

Table 21

Heat Aging Temp, °F	INITIAL			325			325		
Heat Aging, hr				16			160		
Static/Rolling				Dynamic			Static		
Mud Weight, lb/gal	13.97			13.97			13.97		
Rheology Temp, °F	40	100	150	40	100	150	40	100	150
R600, °VG	235		65	260	104	72	216	111	75
R300, °VG	127		37	141	56	42	119	61	45
R200, °VG	87		27	98	40	30	83	43	34
R100, °VG	47		16	53	24	19	45	26	23
R6, °VG	6		5	8	6	7	8	9	13
R3, °VG	4		5	6	5	7	7	9	13
PV, cP	108	0	28	119	48	30	97	50	30
YP, lb/100ft ²	19	0	9	22	8	12	22	11	15
LSYP, lb/100ft ²	2	0	5	4	4	7	6	9	13
10-sec Gel, lb/100ft ²	7		12	8	8	13	10	21	27
10-min Gel, lb/100ft ²	20		37	19	29	41	28	36	34
Static Shear, lb/100ft ²									
E.S. @150°F, V						670			1150
HTHP Temp, °F						325			325
HTHP FL, ml						8.8			17
Water in HTHP Filtrate, ml						0			0.1
Sag value ΔMW, ppg									2.13
Free oil, mL									62

[0062] Example 12 – Evaluating Wetting Agent Addition After Hot Roll

[0063] In this example, a fluid is formulated as shown above in Table 17 and an insufficient amount of wetting agent is added prior to hot rolling the fluid at 325 °F for 16 hours. The wetting agent added was 0.9 ppb Alcohol Ethoxylate 1. After the hot rolling 3 more ppb of Alcohol Ethoxylate 1 was added to the hot rolled fluid and mixed for 5 minutes. The rheology of the two muds mentioned above and the mud with 3.9 ppb of Alcohol Ethoxylate 1 added after 12 hours of aging is shown in Table 22 Below

Table 22

Heat Aging Temp, °F	0.9 ppb Alcohol Ethoxylate 1			3.9 ppb Alcohol Ethoxylate 1 (After mixing for 5 minutes)			3.9 ppb Alcohol Ethoxylate 1 (After aging for 12 hours and mixing for 5 minutes)		
	40	100	150	40	100	150	40	100	150
Heat Aging, hr	16						12		
Static/Rolling	Dynamic						Dynamic		
Mud Weight, lb/gal	13.97			13.97			13.97		
Rheology Temp, °F	40	100	150	40	100	150	40	100	150
R600, °VG	300+	105	66	215	89	59	212	87	60
R300, °VG	170	58	38	118	48	33	115	47	34
R200, °VG	122	41	29	83	33	24	80	33	24
R100, °VG	70	25	19	45	19	14	43	19	14
R6, °VG	18	7	7	7	4	5	6	4	4
R3, °VG	15	6	7	5	4	4	5	4	4
PV, cP	###	47	28	97	41	26	97	40	26
YP, lb/100ft ²	###	11	10	21	7	7	18	7	8
LSYP, lb/100ft ²	12	5	7	3	4	3	4	4	4
10-sec Gel, lb/100ft ²	24	10	12	8	5	7	6	5	7
10-min Gel, lb/100ft ²	48	25	30	11	11	19	10	11	20

[0064] Although only a few example embodiments have been described in detail above, those skilled in the art will readily appreciate that many modifications are possible in the example embodiments without materially departing from this invention. Accordingly, all such modifications are intended to be included within the scope of this disclosure as defined in the following claims.

CLAIMS

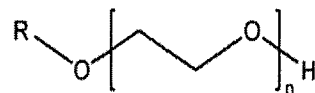
What is claimed:

1. A method of drilling a wellbore, comprising:
 - pumping an oleaginous wellbore fluid into a wellbore, the oleaginous wellbore fluid comprising:
 - an oleaginous continuous phase;
 - a non-oleaginous discontinuous phase;
 - an emulsifier stabilizing the non-oleaginous discontinuous phase in the oleaginous continuous phase;
 - an organophilic clay;
 - a weighting agent; and
 - a wetting agent having an HLB ranging from about 4 to 10.5 that is selected such that the oleaginous wellbore fluid has a 600 rpm dial value at 40 °F of less than about 300 and a 10 minute gel strength of less than about 40 lbf/100ft².
2. The method of claim 1, wherein the wetting agent is present in the oleaginous wellbore fluid in an amount ranging from about 2 to 6 pounds per barrel.
3. The method of claim 1, wherein the oleaginous wellbore fluid has a 6 rpm dial value at 150 °F ranging from about 6 to 15.
4. The method of claim 1, wherein the wetting agent is selected from alcohol ethoxylates, amine ethoxylates, or ethylene oxide/propylene oxide copolymers.
5. An oleaginous wellbore fluid comprising:
 - an oleaginous continuous phase;
 - a non-oleaginous discontinuous phase;
 - an emulsifier stabilizing the non-oleaginous discontinuous phase in the oleaginous continuous phase;
 - an organophilic clay;
 - at least one wetting agent selected from alcohol ethoxylates, amine ethoxylates, or ethylene oxide/propylene oxide copolymers; and

a weighting agent;

wherein the wellbore fluid has a 600 rpm dial value at 40 °F of less than about 300.

6. The wellbore fluid of claim 5, further comprising:
an untreated clay.
7. The wellbore fluid of claim 5, wherein the wellbore fluid has a 10 minute gel strength value at 40 °F of less than 40 lbf/100ft².
8. The wellbore fluid of claim 5, wherein the wellbore fluid has a 6 rpm value at 150 °F of between about 6 and 15.
9. The wellbore fluid of claim 5, wherein the wetting agent has a hydrophilic-lipophilic-balance (HLB) value of between about 4 to 10.5.
10. The wellbore fluid of claim 5, wherein the wetting agent is present in an amount ranging from about 2 to 6 pounds per barrel.
11. The wellbore fluid of claim 5, wherein the wetting agent is an alcohol ethoxylate depicted by Formula I:

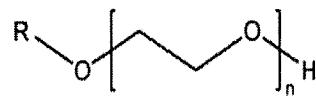


Formula I

wherein R is one of an oleyl group, a stearyl group, a tridecyl group, or a lauryl group, and n is between 2 and 5.

12. The wellbore fluid of claim 5, further comprising:
at least one component selected from calcium carbonate or hallyosite in an amount between about 5 and 30 ppb.
13. The wellbore fluid of claim 5, wherein the organophilic clay comprises an organophilic sepiolite.
14. An oleaginous wellbore fluid comprising:
an oleaginous continuous phase;

a non-oleaginous discontinuous phase;
 an emulsifier to stabilize the non-oleaginous discontinuous phase in the oleaginous continuous phase;
 an organophilic clay;
 an alcohol ethoxylate depicted by Formula I:



Formula I

wherein R is one of an oleyl group, a stearyl group, a tridecyl group, or a lauryl group, and n is between 2 and 5; and

a weighting agent;

wherein the wellbore fluid has a 600 rpm dial value at 40 °F of less than about 300.

15. The wellbore fluid of claim 14, wherein the wellbore fluid has a 10 minute gel strength value at 40 °F of less than 40 lbf/100ft².
16. The wellbore fluid of claim 14, wherein the wellbore fluid has a 6 rpm value at 150 °F of between about 6 and 15.
17. The wellbore fluid of claim 14, wherein the wetting agent is present in an amount ranging from about 2 to 6 pounds per barrel.
18. The wellbore fluid of claim 14, further comprising:
 at least one component selected from calcium carbonate or hallyosite in an amount between about 5 and 30 ppb.
19. The wellbore fluid of claim 14, wherein the organophilic clay comprises an organophilic sepiolite.

A. CLASSIFICATION OF SUBJECT MATTER**C09K 8/18(2006.01)i, C09K 8/48(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)

C09K 8/18; C09K 8/03; E21B 43/04; C09K 8/40; E21B 43/16; C09K 8/48; C09K 8/08; C09K 8/36; C09K 8/52; C09K 8/50

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), STN (Registry, Caplus) & Keywords: wellbore, organophilic clay, alcohol ethoxylate

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 2010-0258313 A1 (BALLARD, D. A.) 14 October 2010 See paragraphs [0033]-[0034]; and claims 10, 12.	1-10, 12, 13
Y		11, 14-19
Y	WO 2016-010518 A1 (HALLIBURTON ENERGY SERVICES, INC.) 21 January 2016 See abstract; and claim 4.	11, 14-19
X	WO 2013-095934 A2 (AMYRIS, INC.) 27 June 2013 See paragraphs [020], [022], [033]-[037], [042], [043]; and claims 1-27.	1-10, 12, 13
Y	CN 103555304 A (SHENYANG UNIVERSITY OF TECHNOLOGY) 05 February 2014 See claims 1, 2.	11, 14-19
Y	US 2013-0048281 A1 (VAN ZANTEN, R. et al.) 28 February 2013 See abstract; and paragraph [0024].	11, 14-19

 Further documents are listed in the continuation of Box C. See patent family annex.

* Special categories of cited documents:

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"&" document member of the same patent family

Date of the actual completion of the international search

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Name and mailing address of the ISA/KR

International Application Division

Korean Intellectual Property Office

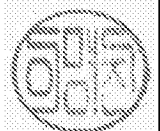
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INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No.

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