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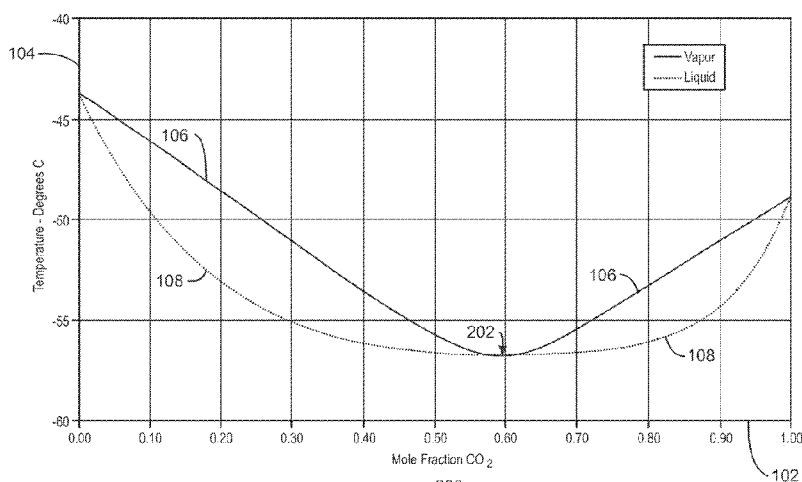
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200
FIG. 2

(57) Abstract: Embodiments described herein provide a method and systems for separating carbon dioxide from heavy hydrocarbons. The method includes cooling a first liquid stream including carbon dioxide and heavy hydrocarbons within an oscillatory crystallization unit to generate carbon dioxide solids and a second liquid stream including the heavy hydrocarbons. The method also includes separating the carbon dioxide solids from the second liquid stream via a solid-liquid separation system.

SEPARATING CARBON DIOXIDE FROM NATURAL GAS LIQUIDS

CROSS-REFERENCE TO RELATED APPLICATION

5 [0001] This application claims the benefit of U.S. Provisional Patent Application 61/711,130 filed October 8, 2012 entitled SEPARATING CARBON DIOXIDE FROM NATURAL GAS LIQUIDS, the entirety of which is incorporated by reference herein.

FIELD OF THE INVENTION

10 [0002] Exemplary embodiments of the present techniques are directed to the separation of carbon dioxide (CO₂) from natural gas liquids (NGLs). More specifically, exemplary embodiments of the present techniques are directed to the separation of CO₂ from a hydrocarbon stream containing NGLs by cooling the hydrocarbon stream below the freezing point of CO₂ and removing the resulting CO₂ solids from the hydrocarbon stream.

15

BACKGROUND

[0003] This section is intended to introduce various aspects of the art, which may be associated with exemplary embodiments of the present techniques. This discussion is believed to assist in providing a framework to facilitate a better understanding of particular
20 aspects of the present techniques. Accordingly, it should be understood that this section should be read in this light, and not necessarily as admissions of prior art.

[0004] Natural gas reservoirs may often contain high levels of acid gases, such as carbon dioxide (CO₂). In these cases, a cryogenic process may provide an efficacious way to separate the acid gases from the methane. The cryogenic process could include a simple bulk
25 fractionation, a Ryan-Holmes process, or a more complex cryogenic fractionation process. The cryogenic processes separate methane from CO₂ by condensation and fractionation, and can produce the acid gas in a liquid phase for efficient disposal via pumping. However, in the cryogenic processes, hydrocarbons heavier than methane, *e.g.*, natural gas liquids (NGLs), are separated with the CO₂ in a single liquid stream. Often, the CO₂ will be
30 immediately reinjected for disposal.

[0005] In some locations, a natural gas reservoir contains high levels of CO₂. In such locations, it may be desirable to use a cryogenic process to separate the CO₂ from the methane. The cryogenic process could be a simple bulk fractionation process, a Ryan-Holmes process, or a Controlled Freeze Zone (CFZ™) process. These processes separate

methane from CO₂ by condensation or fractionation, and can provide the CO₂ as a liquid for efficient disposal. However, in these processes, the NGLs are also condensed and separated with the CO₂. Normally, the CO₂ will be reinjected for disposal. However, the NGLs are valuable. Thus, it may be desirable to recover the NGLs for sale.

5 [0006] Separation of the NGLs can be performed by fractionation. However, ethane forms an azeotropic mixture with CO₂, as discussed with respect to **Fig. 1**. Such an azeotropic mixture may prevent separation by normal techniques.

[0007] **Fig. 1** is a temperature-composition phase plot 100 showing the equilibrium concentrations of CO₂ in a mixture with ethane at 4,137 kilopascals (kPa, 600 psia). The x-axis 102 indicates the mole fraction of CO₂, while the y-axis 104 represents the temperature in degrees Celsius (°C). The concentration of the CO₂ in the vapor phase 106 matches the concentration of the CO₂ in the liquid phase 108 at about 70 % CO₂ / 30 % ethane, as indicated by an arrow 110. This prevents separation-by-fractionation across the azeotrope (left to right, or right to left).

15 [0008] **Fig. 2** is a temperature-composition phase plot 200 showing the equilibrium concentrations of CO₂ in a mixture with ethane at 689.5 kPa (100 psia). Like numbered items are as described with respect to **Fig. 1**. As this plot 200 shows, concentration of the CO₂ in the vapor phase 106 approaches the concentration of the CO₂ in the liquid phase 108 at about 60 % CO₂ / 40 % ethane, as indicated by an arrow 202. This prevents separation-by-fractionation across the azeotrope (left to right, or right to left). As these plots 100 and 200 indicate, complete separation by fractionation cannot be achieved without some additional separation processes.

[0009] Current practices for CO₂ / ethane separation includes various methods. For example, a heavy component (lean oil) can be added, which preferentially absorbs the ethane. 25 This is called “extractive distillation.” As another example, two-pressure fractionation can be used to exploit the small difference in the azeotropic composition between different pressures, for example, using two fractionators to fractionate at both 4,137 kPa and 689.5 kPa. However, this technique utilizes a very large recycle stream and large fractionation systems. Further, the compressors needed to move from the low pressure to the high pressure column make the technique very energy intensive. Methods to exploit other physical and 30 chemical properties can be used in conjunction with fractionation to achieve separation. These methods may include the use of amines in a chemical reaction with CO₂, gas permeation membranes, or molecular sieves.

[0010] For example, U.S. Patent No. 4,246,015, to Styring, discloses a method for separating CO₂ and ethane based on washing ethane from frozen CO₂. The separation is accomplished by freezing the CO₂ in a CO₂ and ethane mixture and washing the ethane from the solid CO₂ with a liquid hydrocarbon, *e.g.*, lean oil, having at least three carbon atoms.

5 The freezing process may be preceded by distillation of a CO₂-ethane mixture to form an azeotropic mixture. A subsequent distillation may be used to separate the wash hydrocarbon from the CO₂. In addition, if desired, the ethane-wash hydrocarbon mixture may be similarly separated in a subsequent distillation stage. However, the use of lean oil results in the contamination of the ethane, and utilizes large amounts of heat for regenerating the lean oil.

10 Further, high lean oil circulation rates are needed, and the ethane is not able to be completely recovered.

[0011] U.S. Patent Application Publication No. 2002/0189443, by McGuire, discloses a method of removing CO₂ or hydrogen sulfide (H₂S) from a high pressure mixture with methane. The high pressure mixture is expanded through a flow channel having a convergent

15 section followed by a divergent section with an intervening throat that functions as an aerodynamic expander. The flow channel is operated at temperatures low enough to result in the formation of solid CO₂ and solid H₂S particles, which increases the efficiency of CO₂ and H₂S removal. However, such techniques rely on the use of a high pressure mixture with a high proportion of methane and a relatively low proportion of CO₂. In some cases, it may be

20 desirable to remove CO₂ from a mixture that contains a large proportion of CO₂, *e.g.*, more than around 40% CO₂.

[0012] International Patent Publication No. WO/2008/095258, by Hart, discloses a method for decreasing the concentration of CO₂ in a natural gas feed stream containing ethane and C₃+ hydrocarbons. The process involves cooling the natural gas feed stream

25 under a first set of conditions to produce a liquid stream including CO₂, ethane, and C₃+ hydrocarbons and a gas stream having a reduced CO₂ concentration. The liquid stream is separated from the gas stream, and C₃+ hydrocarbons may be separated from the liquid stream. The gas stream is then cooled under a second set of conditions to produce a sweetened natural gas stream and a second liquid containing liquid CO₂ and/or CO₂ solids.

30 The sweetened natural gas stream is separated from the second liquid. However, this technique relies on the use of amines, membranes, and molecular sieves, which release the CO₂ as a vapor at low pressure and increase the cost of disposal.

[0013] International Patent Publication No. WO/2009/084945, by Prast, discloses a method and assembly for removing and solidifying CO₂ from a fluid stream. The assembly

has a cyclonic fluid separator with a tubular throat portion arranged between a converging fluid inlet section and a diverging fluid outlet section and a swirl creating device. The separation vessel has a tubular section positioned on and in connection with a collecting tank. A fluid stream with CO₂ is injected into the separation assembly. A swirling motion is
5 imparted to the fluid stream so as to induce outward movement. The swirling fluid stream is then expanded such that components of CO₂ in a meta-stable state within the fluid stream are formed. Subsequently, the outward fluid stream with the components of CO₂ is extracted from the cyclonic fluid separator and provided as a mixture to the separation vessel. The mixture is then guided through the tubular section towards the collecting tank, while
10 providing processing conditions such that solid CO₂ is formed. Finally, solidified CO₂ is extracted. However, this technique may not provide for an acceptable degree of separation of the CO₂, since the CO₂ may form an azeotrope with the other components of the fluid stream as the fluid stream flows through the tubular section towards the collecting tank.

15 **SUMMARY**

[0014] An embodiment described herein provides a method for separating carbon dioxide from heavy hydrocarbons. The method includes cooling a first liquid stream including carbon dioxide and heavy hydrocarbons within an oscillatory crystallization unit to generate carbon dioxide solids and a second liquid stream including the heavy hydrocarbons. The
20 method also includes separating the carbon dioxide solids from the second liquid stream via a solid-liquid separation system.

[0015] Another embodiment provides a system for separating carbon dioxide from heavy hydrocarbons. The system includes an oscillatory crystallization unit configured to cool a first liquid stream including carbon dioxide and heavy hydrocarbons to generate carbon
25 dioxide solids and a second liquid stream including the heavy hydrocarbons. The system also includes a solid-liquid separation system configured to separate the carbon dioxide solids from the second liquid stream.

[0016] Another embodiment provides a system for removing carbon dioxide from natural gas liquids. The system includes a methane separation system configured to separate
30 methane from a liquid stream including carbon dioxide and natural gas liquids. The system includes a heat exchanger configured to cool the liquid stream to a temperature that is slightly above a freezing point of the carbon dioxide and a pressure reducing device configured to reduce a pressure of the liquid stream. The system also includes a continuous oscillatory baffled crystallizer configured to generate carbon dioxide solids and a natural gas liquids

stream by radially cooling the liquid stream to a temperature that is below the freezing point of the carbon dioxide. The system further includes a solid-liquid separation system configured to separate the carbon dioxide solids from the natural gas liquids stream.

5

BRIEF DESCRIPTION OF THE DRAWINGS

[0017] The advantages of the present techniques are better understood by referring to the following detailed description and the attached drawings, in which:

[0018] **Fig. 1** is a temperature-composition phase plot showing the equilibrium concentrations of carbon dioxide (CO₂) in a mixture with ethane at 4,137 kPa;

10 [0019] **Fig. 2** is a temperature-composition phase plot showing the equilibrium concentrations of CO₂ in a mixture with ethane at 689.5 kPa;

[0020] **Fig. 3** is a plot of the freezing conditions used to form solid CO₂ in a mixture with a hydrocarbon;

15 [0021] **Fig. 4** is a block diagram of a system that can be used to separate CO₂ from natural gas liquids (NGLs);

[0022] **Fig. 5** is a block diagram of the system of **Fig. 4** with the addition of an azeotropic distillation system;

[0023] **Fig. 6** is a process flow diagram of a system that can be used to separate CO₂ from NGLs using a continuous oscillatory baffled crystallizer (COBC);

20 [0024] **Fig. 7** is a process flow diagram of the system of **Fig. 6** with the addition of a recirculation system for increasing the degree of separation of the CO₂ and the NGLs;

[0025] **Fig. 8** is a schematic of a circuitous COBC that can be used to form CO₂ solids;

[0026] **Fig. 9** is a schematic of a vertical COBC that can be used to form CO₂ solids;

25 [0027] **Fig. 10** is a schematic of a cyclonic separator that can be used to separate CO₂ solids from NGL; and

[0028] **Fig. 11** is a process flow diagram of a method for separating CO₂ from NGLs.

DETAILED DESCRIPTION

30 [0029] In the following detailed description section, specific embodiments of the present techniques are described. However, to the extent that the following description is specific to a particular embodiment or a particular use of the present techniques, this is intended to be for exemplary purposes only and simply provides a description of the exemplary embodiments. Accordingly, the techniques are not limited to the specific embodiments

described herein, but rather, include all alternatives, modifications, and equivalents falling within the true spirit and scope of the appended claims.

[0030] At the outset, for ease of reference, certain terms used in this application and their meanings as used in this context are set forth. To the extent a term used herein is not defined below, it should be given the broadest definition persons in the pertinent art have given that term as reflected in at least one printed publication or issued patent. Further, the present techniques are not limited by the usage of the terms shown below, as all equivalents, synonyms, new developments, and terms or techniques that serve the same or a similar purpose are considered to be within the scope of the present claims.

[0031] “Acid gases” are contaminants that are often encountered in natural gas streams. Typically, these gases include carbon dioxide (CO₂) and hydrogen sulfide (H₂S), although any number of other contaminants may also form acids. Acid gases are commonly removed by contacting the gas stream with an absorbent, such as an amine, which may react with the acid gas. When the absorbent becomes acid-gas “rich,” a desorption step can be used to separate the acid gases from the absorbent. The “lean” absorbent is then typically recycled for further absorption. As used herein a “liquid acid gas stream” is a stream of acid gases that are condensed into the liquid phase, for example, including CO₂ dissolved in H₂S and vice-versa.

[0032] An “azeotrope” or “azeotropic mixture” is a system of two or more components in which the liquid composition and vapor composition are equal at a certain pressure and temperature. In practice, this means that the components of an azeotropic mixture are constant-boiling at that pressure and temperature and generally cannot be separated during a phase change.

[0033] As used herein, a “column” is a separation vessel in which a counter current flow is used to isolate materials on the basis of differing properties. In an absorbent column, a physical solvent is injected into the top, while a mixture of gases to be separated is flowed through the bottom. As the gases flow upwards through the falling stream of absorbent, one gas species is preferentially absorbed, lowering its concentration in the vapor stream exiting the top of the column. In a fractionation column, liquid and vapor phases are counter-currently contacted to effect separation of a fluid mixture based on boiling points or vapor pressure differences. The high vapor pressure, or lower boiling, component will tend to concentrate in the vapor phase whereas the low vapor pressure, or higher boiling, component will tend to concentrate in the liquid phase.

[0034] “Compressor” refers to a device for compressing a working gas, including gas-vapor mixtures or exhaust gases. Compressors can include pumps, compressor turbines, reciprocating compressors, piston compressors, rotary vane or screw compressors, and devices and combinations capable of compressing a working gas.

5 [0035] As used herein, the term “Controlled Freeze Zone (CFZ) process” generally refers to a process whereby acid gas components are separated by cryogenic distillation through the controlled freezing and melting of CO₂ in a single column, without the use of freeze-suppression additives. The CFZ process uses a cryogenic distillation column with a special internal section (CFZ section) to handle the solidification and melting of CO₂. This CFZ
10 section does not contain packing or trays like conventional distillation columns. Instead, it contains one or more spray nozzles and a melting tray. Solid CO₂ forms in the vapor space in the distillation column and falls into the liquid on the melting tray. Substantially all of the solids that form are confined to the CFZ section. The portions of the distillation tower above and below the CFZ section of the tower are similar to conventional cryogenic demethanizer
15 columns.

[0036] As used herein, “cooling” broadly refers to lowering and/or dropping a temperature and/or internal energy of a substance, such as by any suitable amount. Cooling may include a temperature drop of at least about 1 °C, at least about 5 °C, at least about 10 °C, at least about 15 °C, at least about 25 °C, at least about 50 °C, at least about 100 °C, and/or the
20 like. The cooling may use any suitable heat sink, such as steam generation, hot water heating, cooling water, air, refrigerant, other process streams (integration), and combinations thereof. One or more sources of cooling may be combined and/or cascaded to reach a desired outlet temperature. The cooling step may use a cooling unit with any suitable device and/or equipment. According to one embodiment, cooling may include indirect heat exchange, such
25 as with one or more heat exchangers. Heat exchangers may include any suitable design, such as shell and tube, plate and frame, counter current, concurrent, extended surface, and/or the like. In the alternative, the cooling may use evaporative (heat of vaporization) cooling and/or direct heat exchange, such as a liquid sprayed directly into a process stream.

[0037] “Cryogenic distillation” has been used to separate CO₂ from methane since the
30 relative volatility between methane and CO₂ is reasonably high. The overhead vapor is enriched with methane and the bottoms product is enriched with CO₂ and other heavier hydrocarbons. Cryogenic distillation processing requires the proper combination of pressure and temperature to achieve the desired product recovery.

[0038] “Cryogenic temperature” refers to a temperature that is about -50°C or below.

[0039] A “facility” as used herein is a representation of a tangible piece of physical equipment through which hydrocarbon fluids are either produced from a reservoir or injected into a reservoir. In its broadest sense, the term facility is applied to any equipment that may
5 be present along the flow path between a reservoir and the destination for a hydrocarbon product. Facilities may comprise production wells, injection wells, well tubulars, wellhead equipment, gathering lines, manifolds, pumps, compressors, separators, surface flow lines, and delivery outlets. In some instances, the term “surface facility” is used to distinguish those facilities other than wells. A “facility network” is the complete collection of facilities
10 that are present in the model, which would include all wells and the surface facilities between the wellheads and the delivery outlets.

[0040] The term “gas” is used interchangeably with “vapor,” and means a substance or mixture of substances in the gaseous state as distinguished from the liquid or solid state. Likewise, the term “liquid” means a substance or mixture of substances in the liquid state as
15 distinguished from the gas or solid state.

[0041] “Heat exchanger” refers to any equipment arrangement adapted to allow the passage of heat energy from one or more streams to other streams. The heat exchange may be either direct (*e.g.*, with the streams in direct contact) or indirect (*e.g.*, with the streams separated by a mechanical barrier). The streams exchanging heat energy may be one or more
20 lines of refrigerant, heating, or cooling utilities, one or more feed streams, or one or more product streams. Examples include a shell-and-tube heat exchanger, a cryogenic spool-wound heat exchanger, or a brazed aluminum-plate fin type, among others.

[0042] A “hydrocarbon” is an organic compound that primarily includes the elements hydrogen and carbon, although nitrogen, sulfur, oxygen, metals, or any number of other
25 elements may be present in small amounts. As used herein, hydrocarbons generally refer to organic materials that are harvested from hydrocarbon containing sub-surface rock layers, termed reservoirs. For example, natural gas is normally composed primarily of the hydrocarbon methane.

[0043] The term “natural gas” refers to a multi-component gas obtained from a crude oil
30 well (associated gas) or from a subterranean gas-bearing formation (non-associated gas). The composition and pressure of natural gas can vary significantly. A typical natural gas stream contains methane (C_1) as a significant component. Raw natural gas will also typically contain ethane (C_2), higher molecular weight hydrocarbons, one or more acid gases (such as

CO₂, H₂S, carbonyl sulfide, carbon disulfide, and mercaptans), and minor amounts of contaminants such as water, helium, nitrogen, iron sulfide, wax, and crude oil.

[0044] As used herein, “natural gas liquids” (NGL) refer to mixtures of hydrocarbons whose components are, for example, typically heavier than ethane. Some examples of
5 hydrocarbon components of NGL streams include propane, butane, and pentane isomers, benzene, toluene, and other aromatic compounds.

[0045] As used herein, the term “oscillatory crystallization unit” refers to a cylindrical tube or column containing baffles in which a liquid is oscillated axially by means of a diaphragm, bellows, piston, or other device located at one or both ends of the tube. More
10 specifically, a “continuous oscillatory baffled crystallizer (COBC)” is an oscillatory crystallization unit in which the degree of mixing of the liquid is governed by the frequency and magnitude of the induced oscillations and the size, number, and type of the baffles within the unit. A COBC may be operated horizontally, vertically, or at any angle, and may include a circuitous tube or a single straight tube, for example.

15 [0046] “Pressure” is the force exerted per unit area by the gas on the walls of the volume. Pressure can be shown as pounds per square inch (psi). “Atmospheric pressure” refers to the local pressure of the air. “Absolute pressure” (psia)” refers to the sum of the atmospheric pressure (14.7 psia at standard conditions) plus the gauge pressure (psig). “Gauge pressure” (psig) refers to the pressure measured by a gauge, which indicates only the pressure
20 exceeding the local atmospheric pressure (*i.e.*, a gauge pressure of 0 psig corresponds to an absolute pressure of 14.7 psia). The term “vapor pressure” has the usual thermodynamic meaning. For a pure component in an enclosed system at a given pressure, the component vapor pressure is essentially equal to the total pressure in the system.

[0047] The “Ryan-Holmes process” is a process by which methane and CO₂ are separated
25 in a distillation column. The Ryan-Holmes process involves operation of the distillation column at temperatures, compositions, and pressures that produce a solids potential zone for CO₂ within the column. The term “solids potential zone” is used with the Ryan-Holmes process because, although conditions in the tower are such that CO₂ solids would normally occur, the Ryan-Holmes process prevents actual solids formation from occurring. This is
30 achieved by introducing into the upper portion of the distillation column an additive to suppress formation of acid gas solids. The Ryan-Holmes additive, which is a non-polar material that is miscible with methane, may include ethane, propane, butane, pentane, and mixtures thereof. After the methane/CO₂ separation, the additive is recovered in another distillation column.

[0048] A “separation vessel” is a vessel wherein an incoming feed is separated into individual vapor and liquid fractions. A separation vessel may include a flash drum in which a stream is flashed to form vapor and liquid components. The vapor component is removed from an upper outlet, while the liquid component is removed from a lower outlet.

5 [0049] “Substantial” when used in reference to a quantity or amount of a material, or a specific characteristic thereof, refers to an amount that is sufficient to provide an effect that the material or characteristic was intended to provide. The exact degree of deviation allowable may in some cases depend on the specific context.

10 [0050] “Well” or “wellbore” refers to a hole in the subsurface made by drilling or insertion of a conduit into the subsurface. The terms are interchangeable when referring to an opening in the formation. A well may have a substantially circular cross section, or other cross-sectional shapes (for example, circles, ovals, squares, rectangles, triangles, slits, or other regular or irregular shapes). Wells may be cased, cased and cemented, or open-hole well, and may be any type, including, but not limited to a producing well, an experimental
15 well, an exploratory well, or the like. A well may be vertical, horizontal, or any angle between vertical and horizontal (a deviated well), for example a vertical well may comprise a non-vertical component.

Overview

[0051] Techniques described herein relate to the separation of a liquid hydrocarbon
20 stream including CO₂ and NGLs into its respective components. Specifically, an oscillatory crystallization unit is used to form CO₂ solids, which are then separated from the NGLs using a solid-liquid separation system. The oscillatory crystallization unit may gradually cool the liquid stream via radial mixing. This may provide for a substantially complete separation of the CO₂ from the NGLs by preventing the formation of an azeotrope. This process may be
25 further understood with respect to **Fig. 3**.

[0052] **Fig. 3** is a plot **300** of the freezing conditions used to form solid CO₂ in a mixture with a hydrocarbon. In the plot **300**, the x-axis **302** represents the temperature of the mixture in degrees Fahrenheit, while the y-axis **304** represents the CO₂ content of the liquid phase in mol %. The line **306** on the plot **300** represents a division between a first region **308** in which
30 solid CO₂ forms, and a second region **310** in which solid CO₂ does not form. As shown at point **312** in the plot **300**, at temperatures of about -62° C, solid CO₂ forms from a 70 % / 30 %: CO₂ / ethane mixture. Ethane, however, does not freeze, but will be either a vapor or liquid, depending on the pressure, temperature, and residual CO₂ level. The solid will be nearly pure CO₂, resulting in the separation of the CO₂ and the ethane.

Systems for Separating CO₂ from NGLs

[0053] Fig. 4 is a block diagram of a system 400 that can be used to separate CO₂ 402 from NGLs 404. The resulting NGLs 404, which include ethane and heavier hydrocarbons, may be exported and used as fuel. In addition, the resulting CO₂ 402 may be used for enhanced oil recovery (EOR) operations or commercial sales, for example.

[0054] Within the system 400, a hydrocarbon feed stream 406 may be fed to a separation system 408. The hydrocarbon feed stream 406 may be a raw hydrocarbon feed stream obtained directly from one or more production wells. Alternatively, the hydrocarbon feed stream 406 may be a hydrocarbon feed stream that has been dehydrated within a dehydration unit. Such a dehydration unit may include any system that is capable of removing water vapor from a raw hydrocarbon feed stream using glycol dehydration, desiccants, or pressure swing adsorption (PSA) techniques, among others. The removal of water from the hydrocarbon feed stream 406 may prevent the water from freezing or plugging downstream cryogenic separation systems.

[0055] The separation system 408 may use any number of processes to separate methane 410 from various other components within the hydrocarbon feed stream 406, including heavy hydrocarbons, e.g., C₂ and higher hydrocarbons, CO₂ 402, H₂S, and other acid gases. The separation system 408 may include a methane separation column, a bulk fractionator, a physical solvent system, or a cryogenic distillation unit, such as, for example, a Ryan-Holmes column or a CFZ column. In addition, any number of other systems may be used for the separation process. For example, any type of warm gas processing system may be used.

[0056] The separation of the methane 410 from the other components within the hydrocarbon feed stream 406 may result in the generation of a liquid stream 412 including the CO₂ 402 and the heavy hydrocarbons, which may combine to form NGLs 404, as well as H₂S and other acid gases. The CO₂ 402 and the NGLs 404 within the liquid stream 412 may form an azeotropic mixture, making separation of the two components difficult.

[0057] The methane 410 may be flowed out of the separation system 408 via an overhead line, and the liquid stream 412 may be flowed out of the separation system 408 via a bottoms line. The liquid stream 412 exiting the separation system 408 may be at a temperature that is approaching the boiling point of the CO₂ 402. For example, the liquid stream 412 may be at temperature that is between about -1 °C (about 30 °F) to about 10 °C (about 50 °F).

[0058] From the separation system 408, the liquid stream 412 may be flowed through a heat exchanger 414. The heat exchanger 414 may cool the liquid stream 412 to a temperature that is at least slightly above the freezing point of the CO₂ 402. For example, the heat

exchanger **414** may cool the liquid stream **412** to about -62 °C (about -80 °F). The heat exchanger **414** may be any type of chilling device, such as a shell-and-tube heat exchanger, a brazed aluminum heat exchanger, a double pipe heat exchanger, or a chiller bundle heat exchanger, among others. In addition, the heat exchanger **414** may utilize any suitable type of cooling fluid to cool the liquid stream **412** via indirect heat exchange, such as an ammonia stream, a propane stream, or a process stream for another stage of the process.

[0059] The resulting low-temperature liquid stream **416** may be flowed from the heat exchanger **414** to a pressure reducing device **418**. In various embodiments, the cooling of the liquid stream **412** within the heat exchanger **414** prevents flashing of the resulting low-temperature liquid stream **416** within the pressure reducing device **418**. The pressure reducing device **418** may lower the pressure of the low-temperature liquid stream **416** to prepare for the formation of CO₂ solids, since CO₂ is more likely to undergo a phase change from liquid to solid under low pressures. The pressure reducing device **418** may be any suitable type of throttling valve.

[0060] From the pressure reducing valve **418**, the resulting low-pressure liquid stream **420** may be flowed into an oscillatory crystallization unit **422**. The oscillatory crystallization unit **422** may radially mix the low-pressure liquid stream **420** to gradually cool the low-pressure liquid stream **420** below the freezing point of the CO₂ **402**. For example, the oscillatory crystallization unit **422** may cool the low-pressure liquid stream **420** via indirect heat exchange with any suitable type of cooling fluid. In various embodiments, the oscillatory crystallization unit **422** is a COBC, such as either a circuitous COBC or a simple vertical COBC, as discussed further with respect to Figs. 8 and 9.

[0061] Cooling the low-pressure liquid stream **420** below the freezing point of the CO₂ **402** results in the formation of CO₂ solids within the low-pressure liquid stream **420**. The vibration and mixing of the low-pressure liquid stream **420** in the oscillatory crystallization unit **422** may prevent the CO₂ solids from adhering to the walls, ensuring that the CO₂ solids continue to flow and do not plug the unit.

[0062] From the oscillatory crystallization unit **422**, the multiphase stream **424** may be flowed into a solid-liquid separation system **426**. The solid-liquid separation system **426** may separate the multiphase stream **424** into the CO₂ **402** and the NGLs **404**. This may be accomplished via any of a number of different separation techniques. For example, the solid-liquid separation device **426** may include a gravity separation device, a cyclonic separation device, or a filtering device, among others.

[0063] The CO₂ 402 may be flowed out of the solid-liquid separation system 426 as a bottoms stream in either a liquid phase or a solid phase, depending on the details of the specific implementation. If the CO₂ 402 is in the solid phase, some amount of the NGLs 404 may be used as a carrier fluid for the CO₂ solids. In addition, the NGLs 404 may be flowed
5 out of the solid-liquid separation system 426 as an overhead stream. H₂S and any other acid gases or residual components within the multiphase stream 424 may also be removed with the NGLs 404.

[0064] The block diagram of Fig. 4 is not intended to indicate that the system 400 is to include all the components shown in Fig. 4. Further, any number of additional components
10 not shown in Fig. 4 may be included within the system 400.

[0065] The system 400 discussed herein may be suitable for the removal of an acceptable proportion of the CO₂ from a liquid stream 412 that has an initial concentration of about 60 % CO₂ 402 and about 40 % NGLs 404, or about 70 % CO₂ 402 and about 30 % NGLs 404, for example. However, if the liquid stream 412 has an initial concentration of about 90 % CO₂
15 402 and 10 % NGLs 404, or around 92 % CO₂ 402 and 8 % NGLs 404, the resulting NGLs 404 may still contain an unacceptably high proportion of CO₂. In such cases, additional separation techniques may be employed, as discussed further with respect to Fig. 5. Further, in various embodiments, the degree of separation of the CO₂ 402 from the NGLs 404 is adjusted such that the multiphase stream 424 has a sufficient amount of liquid to carry the
20 solid CO₂ out of the oscillatory crystallization unit 422 and into the solid-liquid separation system 426.

[0066] Fig. 5 is a block diagram of the system 400 of Fig. 4 with the addition of an azeotropic distillation system 500. Like numbered items are as described with respect to Fig. 4. The azeotropic distillation system 500 may separate residual CO₂ from the NGLs 404
25 exiting the solid-liquid separation system 426. More specifically, the azeotropic distillation system 500 may generate purified NGLs 502 and an azeotropic mixture 504 including CO₂ and some amount of the NGLs 404.

[0067] The azeotropic mixture 504 may be flowed back into the system 400 upstream of the oscillatory crystallization unit 422. Thus, the azeotropic mixture 504 may be combined
30 with the low-pressure liquid stream 420, and CO₂ solids may be formed from the combined liquid stream within the oscillatory crystallization unit 422. According to this technique, the NGLs 404 may be continuously purified until they contain an acceptably low proportion of CO₂.

[0068] In some embodiments, the azeotropic mixture **504** is flowed back into the system **400** upstream of the heat exchanger **414**. The azeotropic mixture **504** may be combined with the liquid stream **412** exiting the separation system **408**, and may be used to aid in the cooling of the liquid stream **412** prior to entry into the heat exchanger **414**. This may reduce the heat
5 duty of the heat exchanger **414**, resulting in cost savings.

[0069] The block diagram of **Fig. 5** is not intended to indicate that the system **400** is to include all the components shown in **Fig. 5**. Further, any number of additional components not shown in **Fig. 5** may be included within the system **500**.

[0070] **Fig. 6** is a process flow diagram of a system **600** that can be used to separate CO₂
10 **602** from NGLs **604** using a COBC **606**. A hydrocarbon feed stream **608** may be flowed into the system **600** directly from one or more production wells, or from a dehydration unit, for example. The hydrocarbon feed stream **608** may include methane **610**, ethane and heavier hydrocarbons, CO₂ **602**, H₂S and other acid gases, and any other residual contaminants.

[0071] The hydrocarbon feed stream **608** may be injected into a cryogenic fractionation
15 column **612**. The cryogenic fractionation column **612** may be a CFZ column or a Ryan-Holmes column, for example. The cryogenic fractionation column **612** may separate the methane **610** from the ethane and heavier hydrocarbons, CO₂ **602**, and other components within the hydrocarbon feed stream **608**.

[0072] The methane **610** may be flowed out of the cryogenic distillation column **612** as
20 an overhead stream **614**. The overhead stream **614** may also include other low boiling point or non-condensable gases, such as nitrogen and helium. The overhead stream **614** may be flowed through a condenser **616**, which may condense the overhead stream **614**, producing a cooled methane stream **617**. The cooled methane stream **617** may then be flowed into a reflux drum **618**. From the reflux drum **618** a portion of the cooled methane stream **616** may
25 be flowed out of the system **600** as a methane stream **610**, and the remaining portion of the cooled methane stream **617** may be reinjected into the cryogenic fractionation column **612** as a reflux stream **620** to aid in the separation process.

[0073] The ethane and heavier hydrocarbons, CO₂ **602**, and other components within the hydrocarbon feed stream **608** may be flowed out of the cryogenic fractionation column **612** as
30 a bottoms stream **622**. The bottoms stream **622** may then be heated within a reboiler **624**, and a portion of the heated bottoms stream **622** may be returned to the cryogenic fractionation column **612** to provide heating. The remaining portion of the heated bottoms stream **622** may be a liquid stream **626** from which separate ethane and CO₂ streams are to be generated.

[0074] The liquid stream **626** may be flowed into a heat exchanger **628**. The heat exchanger **628** may be a shell-and-tube heat exchanger, a brazed aluminum heat exchanger, a double pipe heat exchanger, or a chiller bundle heat exchanger, among others. The heat exchanger **628** may pre-cool the liquid stream via indirect heat exchange with a cooling fluid **630**. In some embodiments, the heat exchanger **628** cools the liquid stream **626** to a temperature that is slightly above the freezing point of CO₂.

[0075] The resulting high-temperature liquid stream **632** may be flowed through a pressure reducing device **634**. The pressure reducing device **634** may be any type of device or valve that is capable of decreasing the pressure of the high-temperature liquid stream **632**, producing a low-pressure liquid stream **636**.

[0076] The low-pressure liquid stream **636** may be flowed into the COBC **606**. The COBC **606** may radially cool the high-temperature liquid stream **636** to a temperature that is below the freezing point of the CO₂ **602** via indirect heat exchange with a cooling fluid **640**. Further, the COBC **606** may use vibrations to prevent the CO₂ solids from freezing on the sides, agglomerating, or plugging the COBC **606**. The COBC **606** provides a multiphase stream **644** including CO₂ solids and NGLs.

[0077] The multiphase stream **644** may be flowed into a solid-liquid separation system **644**. The solid-liquid separation system **644** may be a cyclonic separator or a separation column, among others. The solid-liquid separation system **644** may remove the CO₂ solids from the NGLs. The CO₂ **602** may be flowed out of the solid-liquid separation system **644** via a bottoms line **646**, and the NGLs **604** may be flowed out of the solid-liquid separation system **644** via an overhead line **648**. In addition, H₂S or other acid gases within the multiphase stream **644** may be flowed out of the overhead line **648** along with the NGLs **604**.

[0078] The process flow diagram of **Fig. 6** is not intended to indicate that the system **600** is to include all the components shown in **Fig. 6**. Further, any number of additional components not shown in **Fig. 6** may be included within the system **600**. For example, the system **600** may include a recirculation system, as discussed further with respect to **Fig. 6**.

[0079] **Fig. 7** is a process flow diagram of the system **600** of **Fig. 6** with the addition of a recirculation system for increasing the degree of separation of the CO₂ **602** and the NGLs **604**. Like numbered items are as described with respect to **Fig. 6**. The recirculation system may be useful for instances in which the proportion of CO₂ in the low-pressure liquid stream **636** is high. In such instances, the COBC **606** may not be able to crystallize all of the CO₂ in the low-pressure liquid stream **636** in one pass. Therefore, it may be desirable to reduce the

proportion of CO₂ in the low-pressure liquid stream **636** by flowing a portion of the NGLs **604** within the overhead line **648** back into the system **600** upstream of the COBC **606**.

[0080] Specifically, a portion of the NGLs **604**, *e.g.*, a recycle stream **650**, may be pumped back into the system **600** upstream of the COBC **606** via a pump **652**. In addition,
5 the pressure of the recycle stream **650** may be reduced via a pressure reducing device **654**. The recycle stream **650** may then be combined with the low-pressure liquid stream **636**. This may reduce the proportion of CO₂ in the low-pressure liquid stream **636**. As a result, the COBC **606** may be able to more effectively handle the low-pressure liquid stream **636**, since the weight percentage of the resulting CO₂ solids may not be as high.

10 [0081] Further, in some embodiments, CO₂ seeds **656** may be added to the low-pressure liquid stream **636** prior to entry into the COBC **606**. The CO₂ seeds **656** may aid in the crystallization of the CO₂ within the low-pressure liquid stream **636**.

[0082] Fig. 8 is a schematic of a circuitous COBC **800** that can be used to form CO₂ solids. The circuitous COBC **800** may be implemented within any of the systems **400** or **500**
15 discussed with respect to Figs. 4, 5, 6, or 7. In various embodiments, the circuitous COBC **800** may produce CO₂ solids within a liquid stream **802** that includes CO₂ and NGLs.

[0083] The liquid stream **802** may be flowed into an inner tube **804** of the circuitous COBC **800** from a pressure reducing device **806**, for example. In addition, a cooling fluid **808** may be flowed into an outer tube **810** of the circuitous COBC **800**. The cooling fluid
20 **808** within the outer tube **810** of the circuitous COBC **800** may be in indirect thermal contact with the liquid stream **802** within the inner tube **804** of the circuitous COBC **800**.

[0084] The circuitous COBC **800** may include a pump **812**. The pump **812** may produce a pulsating flow of the liquid stream **802** within the circuitous COBC **800**. In addition, the circuitous COBC **800** may include a number of baffles **814**. The baffles **814** may produce a
25 turbulent flow of the liquid stream **802** as the liquid stream **802** contacts each baffle **814** on its path through the circuitous COBC **800**. Each baffle **814** may also include a hole **815** in the center that induces a shear force on the liquid stream **802**. The size and shape of each baffle **814** may be adjusted according to the flow rate of the liquid stream **802** and the particular characteristics of the circuitous COBC **800**.

30 [0085] The pulsations, turbulence, and shear forces may cause the liquid stream **802** to undergo radial mixing as it travels through the circuitous COBC **800**. Further, as the liquid stream **802** travels through the circuitous COBC **800**, CO₂ solids may be formed due to the cooling of the liquid stream **802** via indirect heat exchange with the cooling fluid **808**. The radial mixing of the liquid stream **802** may aid in the formation of the CO₂ solids. In

addition, the radial mixing of the liquid stream **802** may prevent the CO₂ solids from adhering to the baffles **814** or the walls of the circuitous COBC **800**.

[0086] The liquid stream **802** including the CO₂ solids may be flowed out of the inner tube **804** of the circuitous COBC **800** as a multiphase stream **816**. In addition, the warmed
5 cooling fluid **808** may be flowed out of the outer tube **810** of the circuitous COBC **800**, and may be cooled and recycled to the circuitous COBC **800**.

[0087] The multiphase stream **816** may be flowed into a solid-liquid separation system **818**, which may remove the CO₂ solids from the NGLs within the multiphase stream **814**. In various embodiments, the solid-liquid separation system **818** is a cyclonic separation, as
10 discussed further with respect to Fig. 10.

[0088] Fig. 9 is a schematic of a vertical COBC **900** that can be used to form CO₂ solids. Like numbered items are as described with respect to Fig. 8. The vertical COBC **900** may be similar to the circuitous COBC **800** discussed with respect to Fig. 8. However, as shown in Fig. 9, the vertical COBC **900** may include a single vertical structure, rather than a circuitous
15 structure.

[0089] Further, in various embodiments, the pump **812** of the vertical COBC **900** may be replaced with a thermoacoustic generator. The thermoacoustic generator may produce a pulsating flow of the liquid stream **802** using a resonant frequency in the COBC **900**. In addition, the thermoacoustic generator may aid in the cooling of the liquid stream **802**.

[0090] Fig. 10 is a schematic of a cyclonic separation **1000** that can be used to separate CO₂ **1002** from NGLs **1004**. The cyclonic separation **1000** may be any of the solid-liquid separation systems **426**, **644**, or **818** discussed with respect to Figs. 4-9. The cyclonic separation system **1000** may include a cyclonic separator **1006** and a separation vessel **1008**.

[0091] A multiphase stream **1010** may be flowed into the cyclonic separator **1006** from
25 an oscillatory crystallization unit **1012**. The oscillatory crystallization unit **1012** may be the oscillatory crystallization unit **422** discussed with respect to Figs. 4 and 5, the circuitous COBC **800** discussed with respect to Fig. 6, or the vertical COBC discussed with respect to Fig. 7. The multiphase stream **1010** may include CO₂ solids **1014** and NGLs.

[0092] As the multiphase stream **1010** enters the cyclonic separator **1006**, the location of
30 the inlet line within the cyclonic separator **1006** may impart a radial acceleration and a tangential velocity component to the multiphase stream **1010**. A swirl element may be added to impart a further radial acceleration through the rotation of twisted swirl vanes. The swirl vanes may be arranged parallel or in series on the swirl element. The tangential velocity of the multiphase stream **1010** may cause the CO₂ solids **1014**, which are heavier and denser

than the NGLs **1004** within the multiphase stream **1010**, to migrate to the outer rim of the cyclonic separator **1006** and begin traveling in a wide circular path. The NGLs **1004** may migrate towards the center of the cyclonic separator **1006** and begin traveling in a narrow circular path. As the multiphase stream **1010** nears the end of the cyclonic separator **1006**,
5 the CO₂ solids **1014** may be captured and sent out of the bottom of the cyclonic separator **1006**, along with a small amount of the NGLs **1004**. The majority of the NGLs **1004** may be sent out of the top of the cyclonic separator **1006**.

[0093] In various embodiments, the CO₂ solids **1014** include some amount of residual NGLs. Thus, the CO₂ solids **1014** may be flowed into the separation vessel **1008**. Within the
10 separation vessel **1008**, the CO₂ solids **1014** may settle on the bottom of the separation vessel **1008**, while the NGLs may settle on the top of the separation vessel **1008** along with some amount of CO₂ that was been incorporated into the NGLs.

[0094] The NGLs and incorporated CO₂ **1016** may be flowed out of the separation vessel via an overhead line **1018**. The NGLs and incorporated CO₂ **1016** may then be combined
15 with a liquid stream upstream of the oscillatory crystallization unit **1012**.

[0095] The CO₂ solids **1014** that have settled on the bottom of the separation vessel **1008** may be converted to a liquid phase using a heating coil **1019** or other heating device. The liquid CO₂ **1002** may then be flowed out of a bottoms line **1020** of the separation vessel **1008**.

20 Method for Separating CO₂ from NGLs

[0096] Fig. **11** is a process flow diagram of a method **1100** for separating CO₂ from NGLs. The method **1100** may be implemented within any of the systems 400 or 600 discussed with respect to Figs. **4**, **5**, **6**, or **7**. In various embodiments, the temperature and pressure of a liquid stream including CO₂ and heavy hydrocarbons are reduced prior to the
25 beginning of the method **1100**. For example, a heat exchanger may be used to cool the liquid stream to a temperature that is slightly higher than the freezing point of CO₂, and a pressure reducing device may be used to reduce the pressure of the liquid stream.

[0097] The method **1100** begins at block **1102**, at which the liquid stream including the CO₂ and the heavy hydrocarbons is cooled within an oscillatory crystallization unit to
30 generate CO₂ solids and a liquid stream including the heavy hydrocarbons. This may be accomplished by flowing the liquid stream into a tube including a number of baffles, radially mixing the liquid stream via contact with the baffles and a production of pulsations within the liquid stream, and radially cooling the liquid stream within the tube via indirect heat

exchange with a cooling medium. The radial cooling of the liquid stream may result in the generation of the CO₂ solids.

[0100] At block **1104**, the CO₂ solids are separated from the liquid stream including the heavy hydrocarbons via a solid-liquid separation system. The CO₂ solids may then be flowed
5 out of the solid-liquid separation system in either a solid or liquid phase, and the heavy hydrocarbons may be flowed out of the solid-liquid separation system as a NGL stream. In addition, H₂S or any other acid gases within the liquid stream may also be flowed out of the solid-liquid separation system along with the NGL stream.

[0101] The process flow diagram of **Fig. 11** is not intended to indicate that the steps of
10 the method **1100** are to be executed in any particular order, or that all steps of the method **1100** are to be included in every case. Further, any number of additional steps may be included within the method **1100**, depending on the details of the specific implementation. For example, in some embodiments, a separation system may be used to separate a methane stream from the liquid stream upstream of the oscillatory crystallization unit. The methane
15 stream may then be flowed from the separation system to a heat exchanger that is upstream of the oscillatory crystallization unit, and may be used to cool the liquid stream within the heat exchanger. The methane stream may be flowed from the separation system to the oscillatory crystallization unit, and may be used to cool the liquid stream within the oscillatory crystallization unit. Further, in some embodiments, the methane is recycled to an upstream
20 CO₂ separation system, such as a bulk fractionator, a physical solvent system, or a cryogenic distillation unit, such as, for example, a Ryan-Holmes column or a CFZ column.

[0102] In some embodiments, residual CO₂ is separated from the NGL stream to generate a purified NGL stream and an azeotropic mixture including CO₂ and NGL. The azeotropic mixture may then be used to cool the liquid stream upstream of the oscillatory crystallization
25 unit. Alternatively, the azeotropic mixture may be recycled to the oscillatory crystallization unit. The oscillatory crystallization unit may cool the azeotropic mixture, generating CO₂ solids and a third liquid stream including the NGLs.

Embodiments

[0103] Embodiments of the invention may include any combinations of the methods and
30 systems shown in the following numbered paragraphs. This is not to be considered a complete listing of all possible embodiments, as any number of variations can be envisioned from the description herein.

1. A method for separating carbon dioxide from heavy hydrocarbons, including:
cooling a first liquid stream including carbon dioxide and heavy hydrocarbons within
an oscillatory crystallization unit to generate carbon dioxide solids and a
second liquid stream including the heavy hydrocarbons; and
5 separating the carbon dioxide solids from the second liquid stream via a solid-liquid
separation system.
2. The method of paragraph 1, including cooling the first liquid stream within a
heat exchanger upstream of the oscillatory crystallization unit.
3. The method of paragraph 2, wherein the first liquid stream is cooled to a
10 temperature that is slightly higher than a freezing point of the carbon dioxide within the heat
exchanger.
4. The method of any of paragraphs 1 or 2, including reducing a pressure of the
first liquid stream via a pressure reducing device upstream of the oscillatory crystallization
unit.
- 15 5. The method of any of paragraphs 1, 2 or 4, wherein the first liquid stream is
cooled to a temperature that is below a freezing point of the carbon dioxide within the
oscillatory crystallization unit to generate the carbon dioxide solids.
6. The method of any of paragraphs 1, 2, 4, or 5, including separating the first
liquid stream from a methane stream within a separation system upstream of the oscillatory
20 crystallization unit.
7. The method of paragraph 6, including:
flowing the methane stream from the separation system to a heat exchanger that is
upstream of the oscillatory crystallization unit; and
using the methane stream to cool the first liquid stream within the heat exchanger.
- 25 8. The method of any of paragraphs 6 or 7, including:
flowing the methane stream from the separation system to the oscillatory
crystallization unit; and
using the methane stream to cool the first liquid stream within the oscillatory
crystallization unit.
- 30 9. The method of any of paragraphs 6, 7, or 8, including recycling the methane
stream to an upstream carbon dioxide separation system.
10. The method of any of paragraphs 1, 2, or 4-6, including separating hydrogen
sulfide from the carbon dioxide solids along with the second liquid stream within the solid-
liquid separation system.

11. The method of any of paragraphs 1, 2, 4-6, or 10, including:
separating residual carbon dioxide from the second liquid stream to generate a
purified heavy hydrocarbon stream and an azeotropic mixture including
carbon dioxide and heavy hydrocarbons; and
5 using the azeotropic mixture to cool the first liquid stream upstream of the oscillatory
crystallization unit.
12. The method of any of paragraphs 1, 2, 4-6, 10, or 11, including:
separating residual carbon dioxide from the second liquid stream to generate a
purified heavy hydrocarbon stream and an azeotropic mixture including
10 carbon dioxide and heavy hydrocarbons; and
recycling the azeotropic mixture to the oscillatory crystallization unit, wherein the
oscillatory crystallization unit cools the azeotropic mixture to generate carbon
dioxide solids and a third liquid stream including the heavy hydrocarbons.
13. The method of any of paragraphs 1, 2, 4-6, or 10-12, wherein cooling the first
15 liquid stream within the oscillatory crystallization unit includes:
flowing the first liquid stream into a tube including a number of baffles;
radially mixing the first liquid stream via contact with the number of baffles and a
production of pulsations within the first liquid stream; and
radially cooling the first liquid stream within the tube via indirect heat exchange with
20 a cooling medium, wherein the radial cooling of the first liquid stream results
in the generation of the carbon dioxide solids.
14. The method of paragraph 13, including producing pulsations within the first
liquid stream via a pump.
15. The method of any of paragraphs 13 or 14, including producing pulsations
25 within the first liquid stream via thermoacoustics.
16. A system for separating carbon dioxide from heavy hydrocarbons, including:
an oscillatory crystallization unit configured to cool a first liquid stream including
carbon dioxide and heavy hydrocarbons to generate carbon dioxide solids and
a second liquid stream including the heavy hydrocarbons; and
30 a solid-liquid separation system configured to separate the carbon dioxide solids from
the second liquid stream.
17. The system of paragraph 16, including a heat exchanger configured to cool the
first liquid stream upstream of the oscillatory crystallization unit.

18. The system of paragraph 17, wherein the heat exchanger is configured to cool the first liquid stream to a temperature that is slightly higher than a freezing point of the carbon dioxide.

19. The system of any of paragraphs 17 or 18, wherein the heat exchanger
5 includes a shell-and-tube heat exchanger, a brazed aluminum heat exchanger, a double pipe heat exchanger, or a chiller bundle heat exchanger, or any combinations thereof.

20. The system of any of paragraphs 16 or 17, including a pressure reducing device configured to reduce a pressure of the first liquid stream upstream of the oscillatory crystallization unit.

10 21. The system of any of paragraphs 16, 17, or 20, wherein the oscillatory crystallization unit is configured to cool the first liquid stream to a temperature that is below a freezing point of the carbon dioxide.

22. The system of any of paragraphs 16, 17, 20, or 21, including a separation system configured to produce the first liquid stream and a methane stream from a
15 hydrocarbon feed stream.

23. The system of paragraph 22, wherein the separation system includes a methane separation system, controlled freeze zone (CFZ) column, a bulk fractionator, a Ryan-Holmes column, or a physical solvent system, or any combinations thereof.

24. The system of any of paragraphs 22 or 23, wherein the oscillatory
20 crystallization unit is configured to use the methane stream to cool the first liquid stream.

25. The system of any of paragraphs 16, 17, or 20-22, wherein the solid-liquid separation system is configured to separate hydrogen sulfide from the carbon dioxide solids along with the second liquid stream.

26. The system of any of paragraphs 16, 17, 20-22, or 25, wherein the oscillatory
25 crystallization unit includes a continuous oscillatory baffled crystallizer.

27. The system of any of paragraphs 16, 17, 20-22, 25, or 26, including an azeotropic distillation system configured to separate residual carbon dioxide from the second liquid stream to generate a purified heavy hydrocarbon stream and an azeotropic mixture including carbon dioxide and heavy hydrocarbons.

30 28. The system of paragraph 27, wherein the azeotropic mixture is used to cool the first liquid stream upstream of the oscillatory crystallization unit.

29. The system of any of paragraphs 27 or 28, wherein the solid-liquid separation system includes a cyclonic separator.

30. A system for removing carbon dioxide from natural gas liquids, including:
a methane separation system configured to separate methane from a liquid stream
including carbon dioxide and natural gas liquids;
a heat exchanger configured to cool the liquid stream to a temperature that is slightly
5 above a freezing point of the carbon dioxide;
a pressure reducing device configured to reduce a pressure of the liquid stream;
a continuous oscillatory baffled crystallizer configured to generate carbon dioxide
solids and a natural gas liquids stream by radially cooling the liquid stream to
a temperature that is below the freezing point of the carbon dioxide; and
10 a solid-liquid separation system configured to separate the carbon dioxide solids from
the natural gas liquids stream.

31. The system of paragraph 30, wherein the continuous oscillatory baffled
crystallizer includes a number of baffles configured to produce a turbulent flow of the liquid
stream as the liquid stream travels through the continuous oscillatory baffled crystallizer.

15 32. The system of any of paragraphs 30 or 31, wherein the continuous oscillatory
baffled crystallizer includes a pump configured to produce a pulsating flow of the liquid
stream within the continuous oscillatory baffled crystallizer.

33. The system of any of paragraphs 30-32, wherein the continuous oscillatory
baffled crystallizer includes a thermoacoustic generator configured to produce a pulsating
20 flow of the liquid stream within the continuous oscillatory baffled crystallizer.

34. The system of any of paragraphs 30-33, wherein a cooling medium flowing
through the continuous oscillatory baffled crystallizer cools the liquid stream via indirect heat
exchange.

[0104] While the present techniques may be susceptible to various modifications and
25 alternative forms, the exemplary embodiments discussed herein have been shown only by
way of example. However, it should again be understood that the techniques is not intended
to be limited to the particular embodiments disclosed herein. Indeed, the present techniques
include all alternatives, modifications, and equivalents falling within the true spirit and scope
of the appended claims.

30

CLAIMS

What is claimed is:

1. A method for separating carbon dioxide from heavy hydrocarbons, comprising:
cooling a first liquid stream comprising carbon dioxide and heavy hydrocarbons within an oscillatory crystallization unit to generate carbon dioxide solids and a second liquid stream comprising the heavy hydrocarbons; and
separating the carbon dioxide solids from the second liquid stream via a solid-liquid separation system.
2. The method of claim 1, comprising cooling the first liquid stream within a heat exchanger upstream of the oscillatory crystallization unit.
3. The method of claim 2, wherein the first liquid stream is cooled to a temperature that is slightly higher than a freezing point of the carbon dioxide within the heat exchanger.
4. The method of claim 1, comprising reducing a pressure of the first liquid stream via a pressure reducing device upstream of the oscillatory crystallization unit.
5. The method of claim 1, wherein the first liquid stream is cooled to a temperature that is below a freezing point of the carbon dioxide within the oscillatory crystallization unit to generate the carbon dioxide solids.
6. The method of claim 1, comprising separating the first liquid stream from a methane stream within a separation system upstream of the oscillatory crystallization unit.
7. The method of claim 6, comprising:
flowing the methane stream from the separation system to a heat exchanger that is upstream of the oscillatory crystallization unit; and
using the methane stream to cool the first liquid stream within the heat exchanger.

8. The method of claim 6, comprising:
flowing the methane stream from the separation system to the oscillatory crystallization unit; and
using the methane stream to cool the first liquid stream within the oscillatory crystallization unit.
9. The method of claim 1, comprising separating hydrogen sulfide from the carbon dioxide solids along with the second liquid stream within the solid-liquid separation system.
10. The method of claim 1, comprising:
separating residual carbon dioxide from the second liquid stream to generate a purified heavy hydrocarbon stream and an azeotropic mixture comprising carbon dioxide and heavy hydrocarbons; and
using the azeotropic mixture to cool the first liquid stream upstream of the oscillatory crystallization unit.
11. The method of claim 1, comprising:
separating residual carbon dioxide from the second liquid stream to generate a purified heavy hydrocarbon stream and an azeotropic mixture comprising carbon dioxide and heavy hydrocarbons; and
recycling the azeotropic mixture to the oscillatory crystallization unit, wherein the oscillatory crystallization unit cools the azeotropic mixture to generate carbon dioxide solids and a third liquid stream comprising the heavy hydrocarbons.
12. The method of claim 1, comprising producing pulsations within the first liquid stream.
13. A system for separating carbon dioxide from heavy hydrocarbons, comprising:
an oscillatory crystallization unit configured to cool a first liquid stream comprising carbon dioxide and heavy hydrocarbons to generate carbon dioxide solids and a second liquid stream comprising the heavy hydrocarbons; and
a solid-liquid separation system configured to separate the carbon dioxide solids from the second liquid stream.

14. The system of claim 13, comprising a heat exchanger configured to cool the first liquid stream upstream of the oscillatory crystallization unit.

15. The system of claim 14, wherein the heat exchanger is configured to cool the first liquid stream to a temperature that is slightly higher than a freezing point of the carbon dioxide.

16. The system of claim 13, comprising a pressure reducing device configured to reduce a pressure of the first liquid stream upstream of the oscillatory crystallization unit.

17. The system of claim 13, wherein the oscillatory crystallization unit is configured to cool the first liquid stream to a temperature that is below a freezing point of the carbon dioxide.

18. The system of claim 13, comprising a separation system configured to produce the first liquid stream and a methane stream from a hydrocarbon feed stream.

19. The system of claim 18, wherein the separation system comprises a methane separation system, controlled freeze zone (CFZ) column, a bulk fractionator, a Ryan-Holmes column, or a physical solvent system, or any combinations thereof.

20. The system of claim 13, wherein the solid-liquid separation system is configured to separate hydrogen sulfide from the carbon dioxide solids along with the second liquid stream.

21. The system of claim 13, comprising an azeotropic distillation system configured to separate residual carbon dioxide from the second liquid stream to generate a purified heavy hydrocarbon stream and an azeotropic mixture comprising carbon dioxide and heavy hydrocarbons.

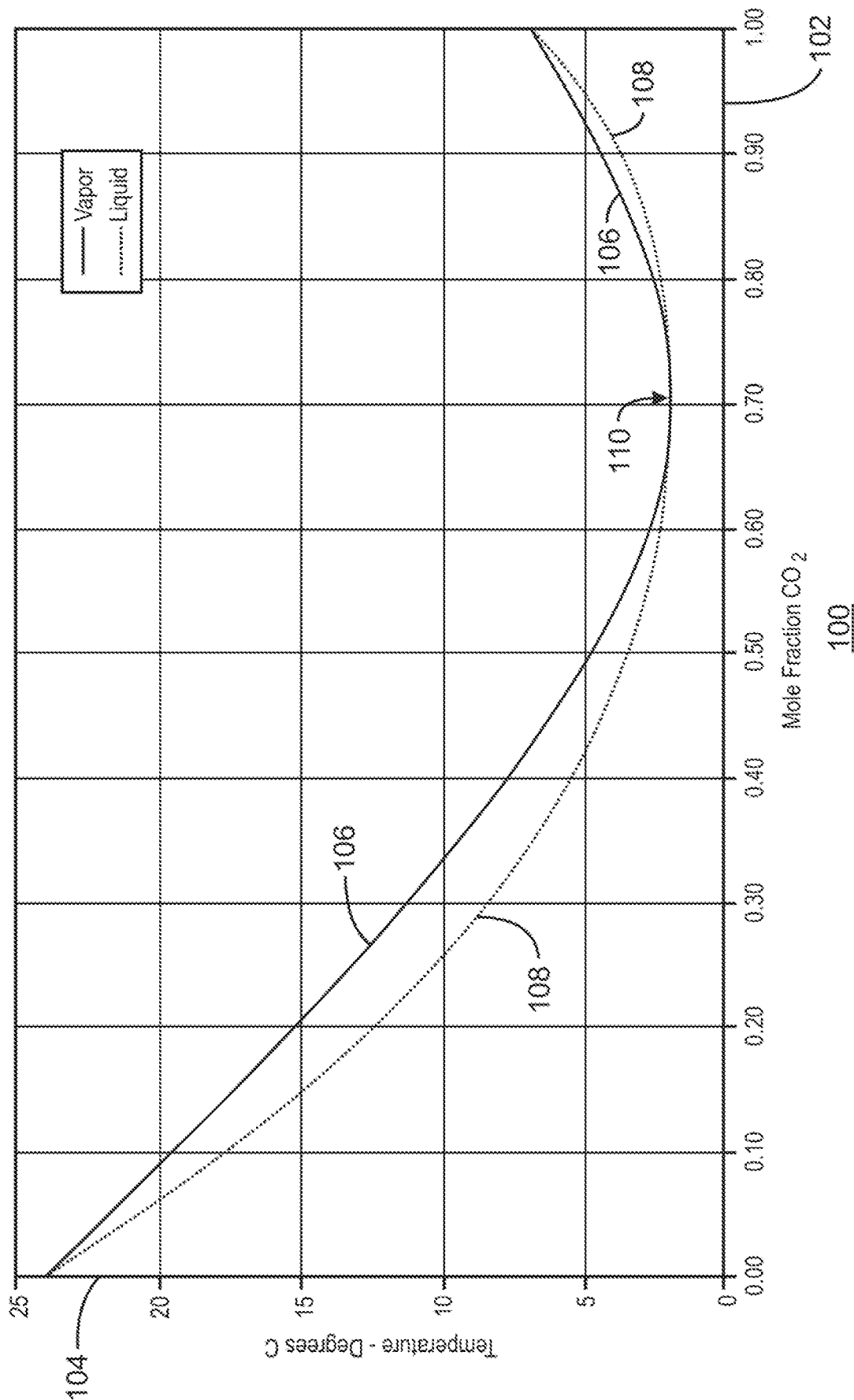


FIG. 1

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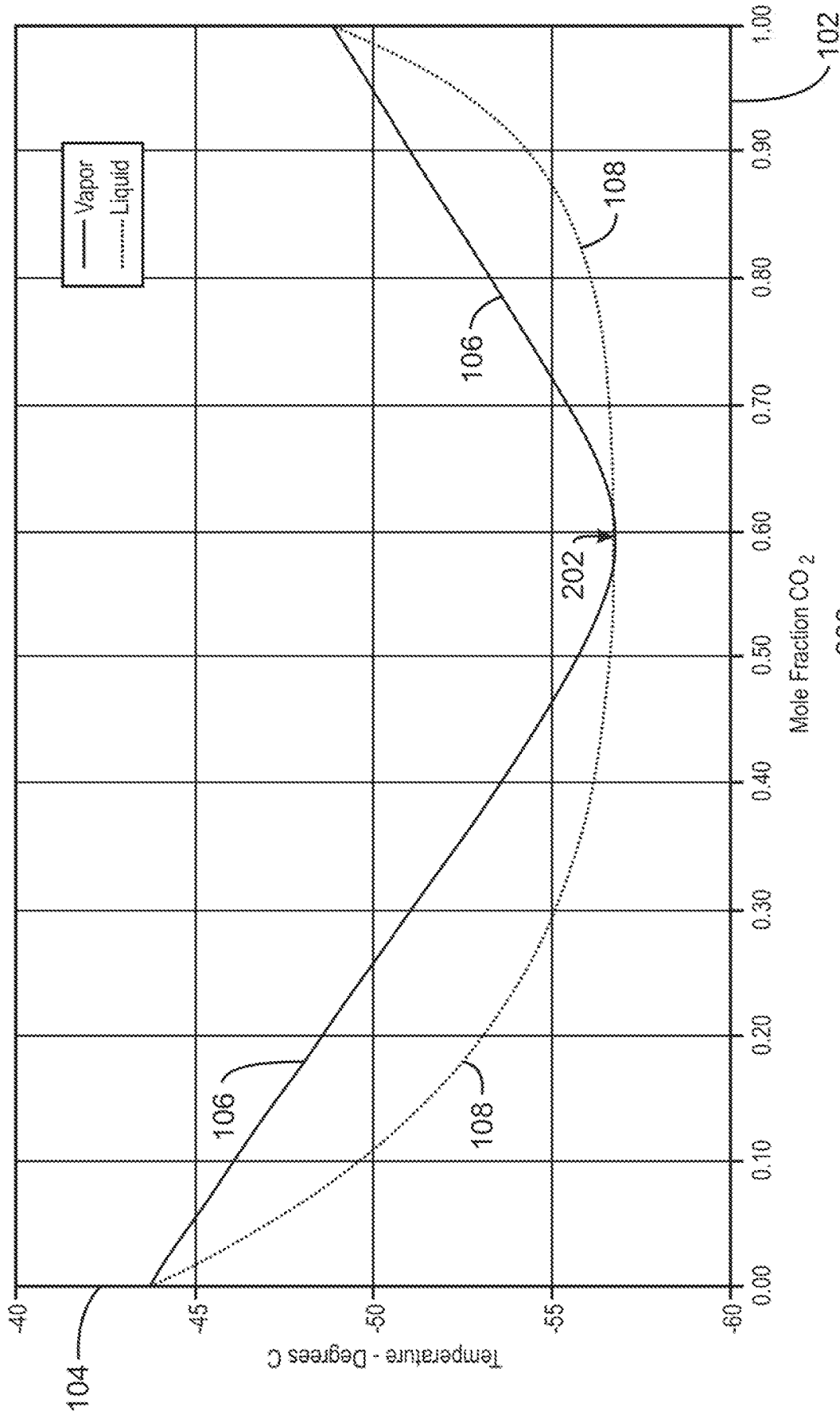
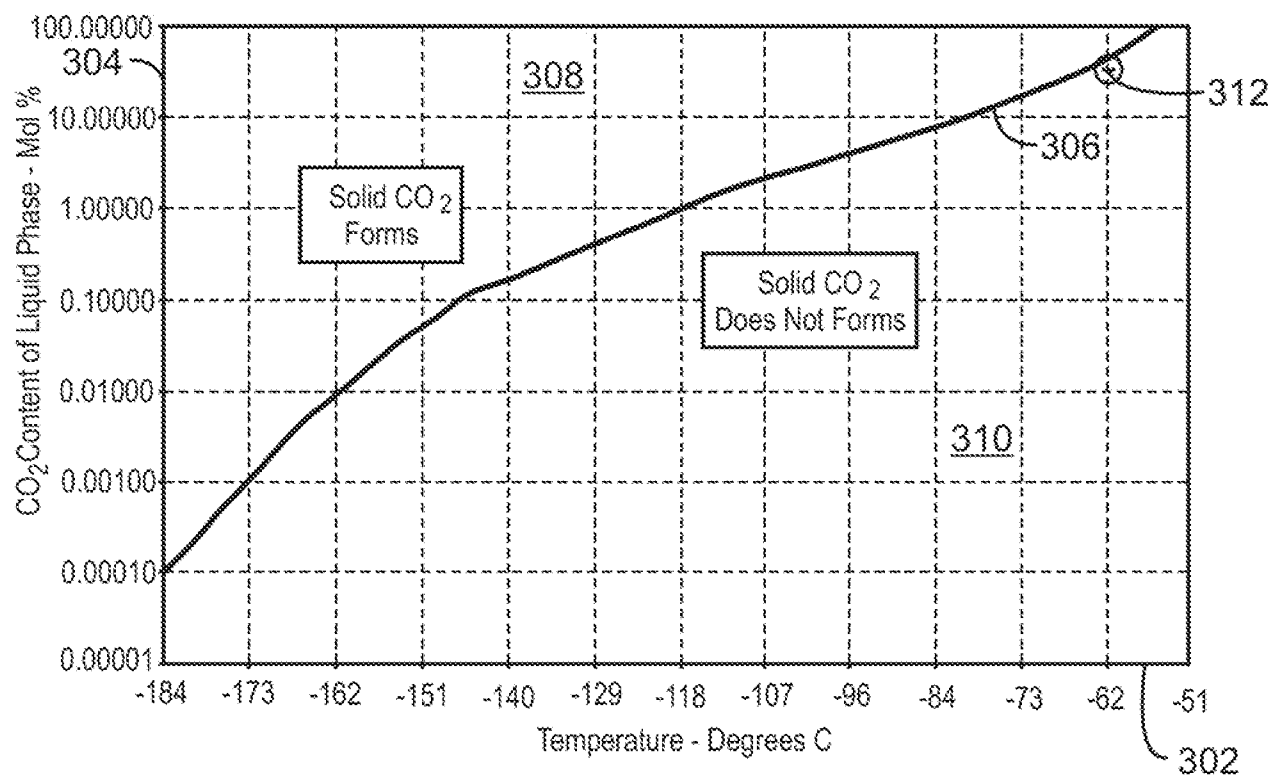


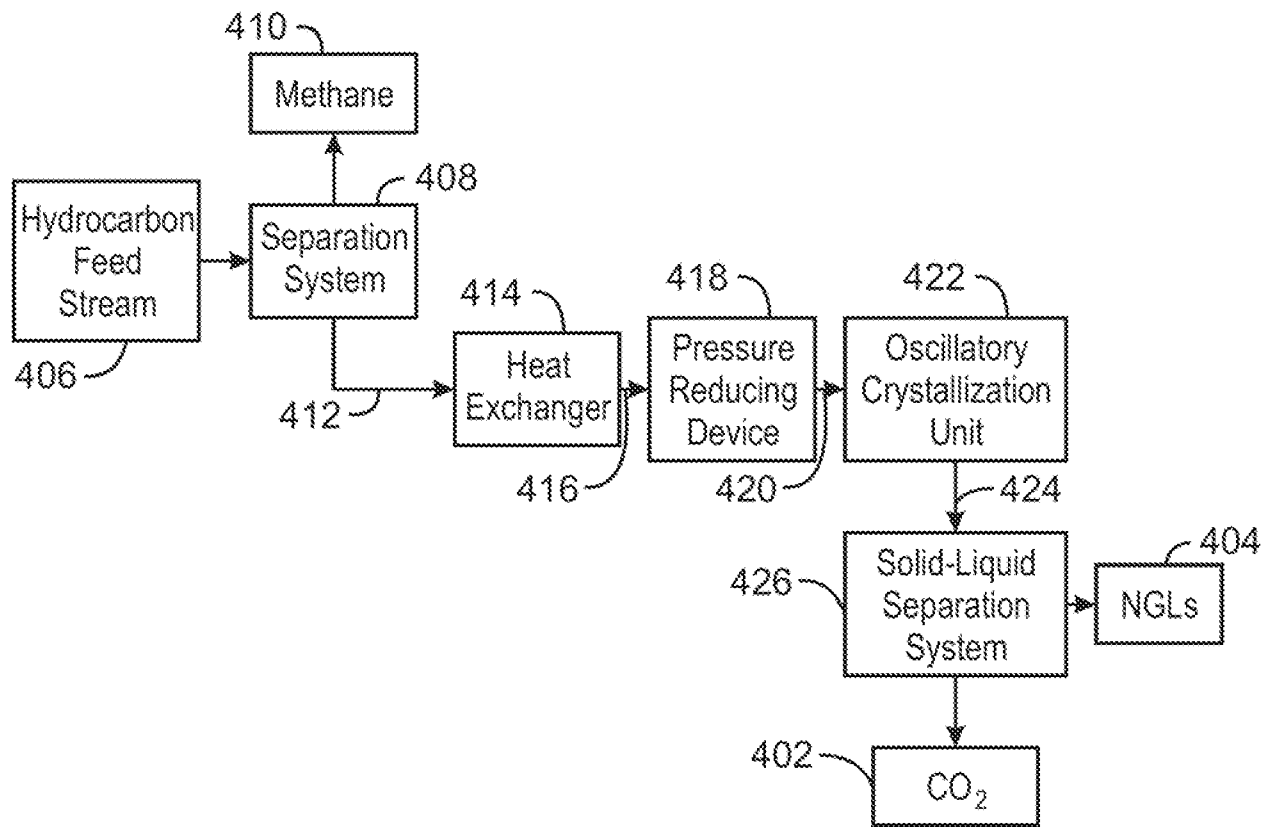
FIG. 2

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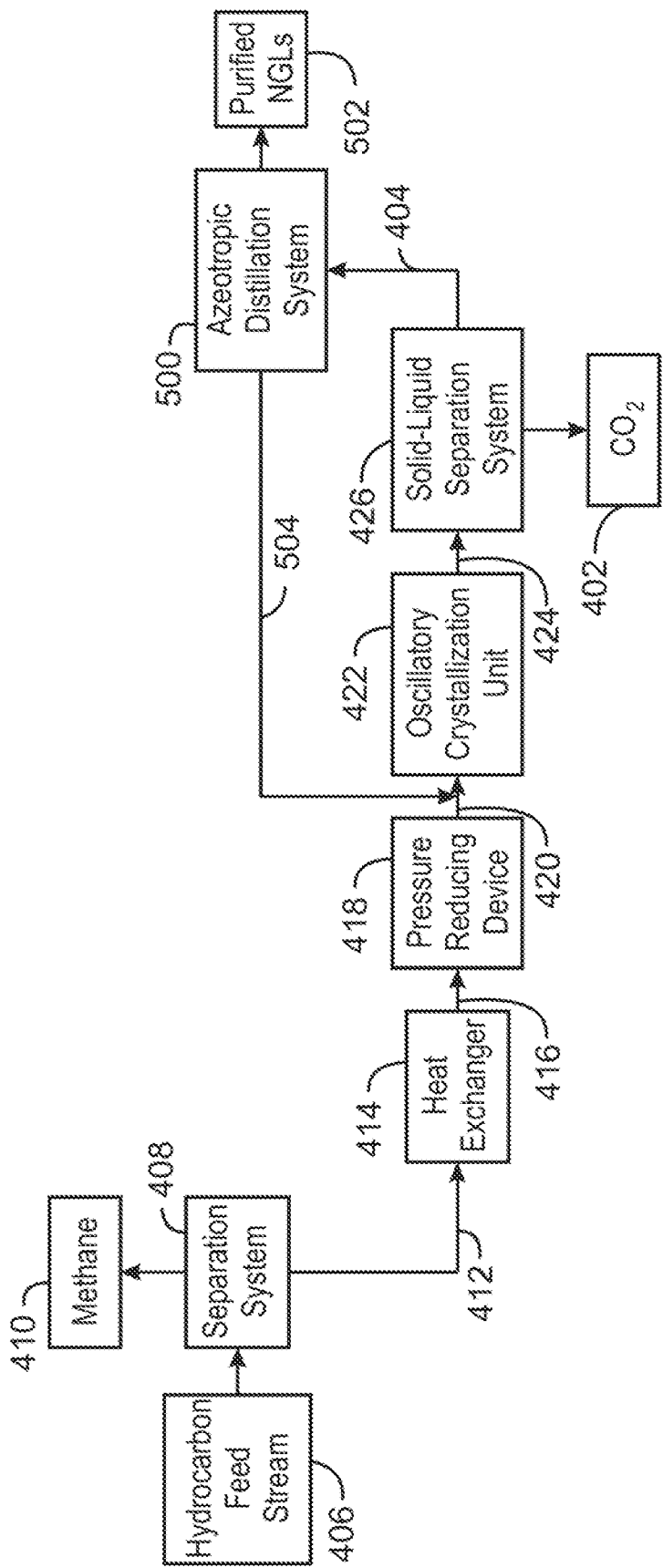


300
FIG. 3

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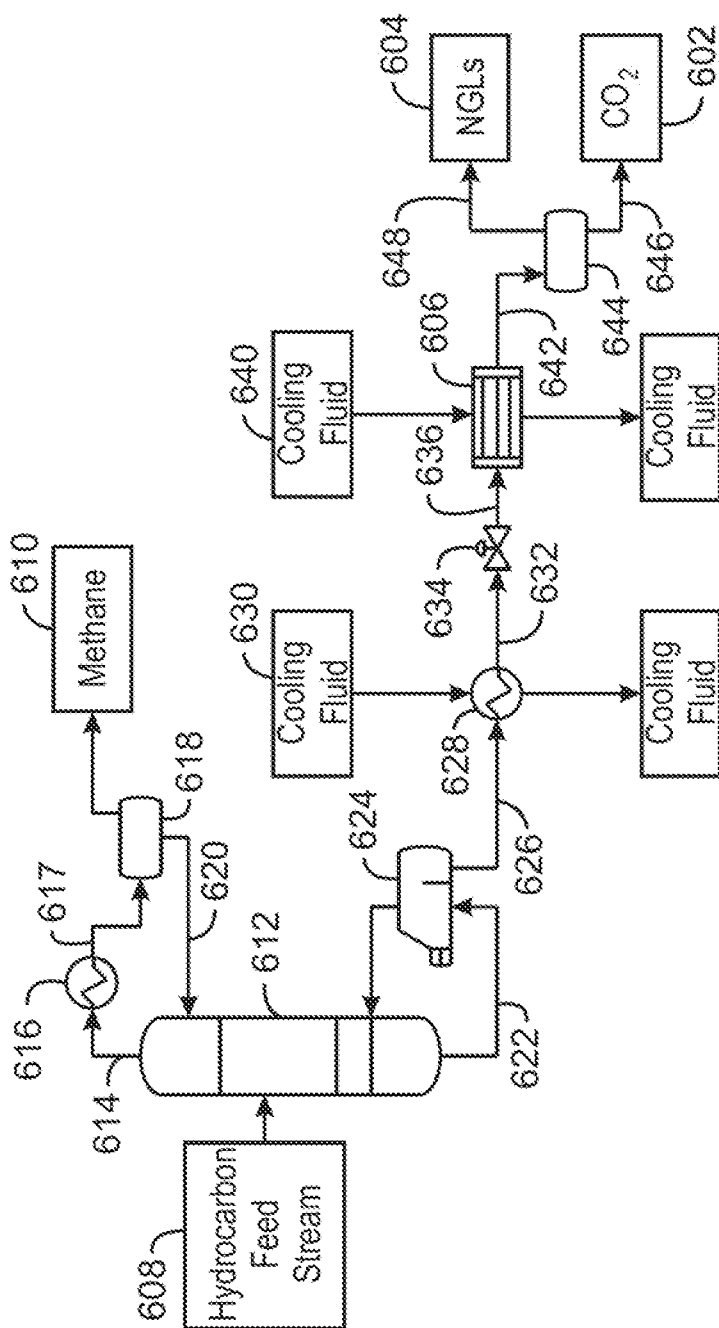


400
FIG. 4



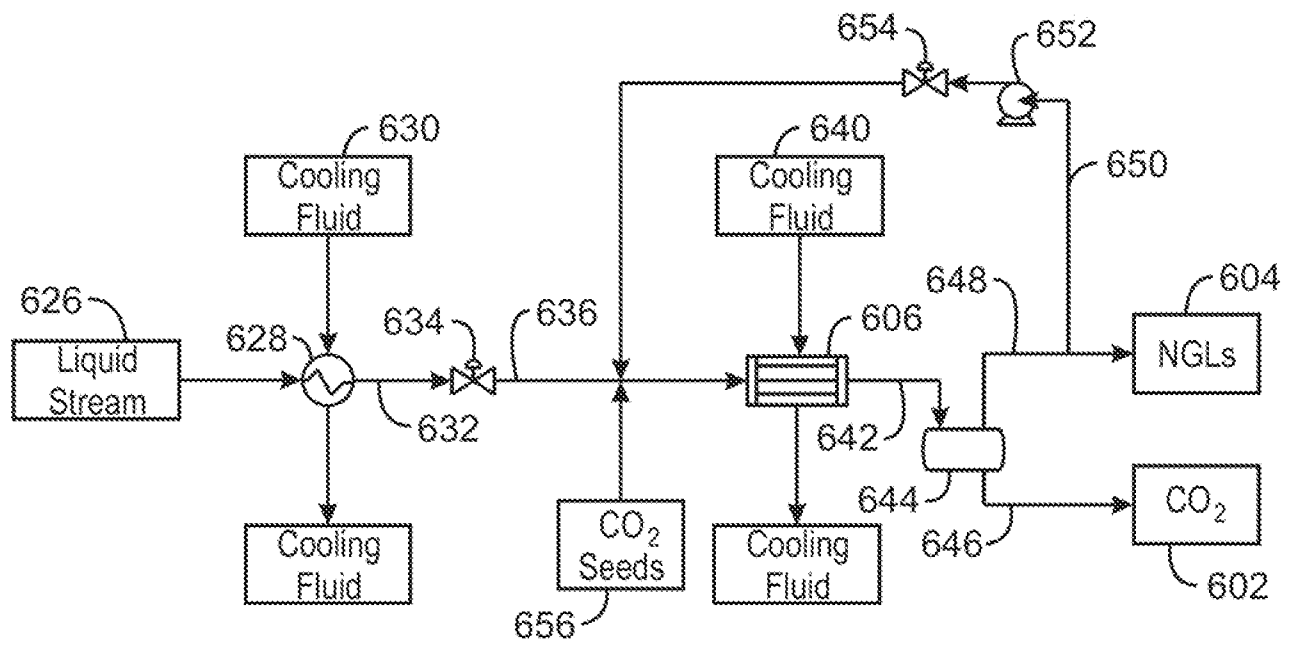
400
FIG. 5

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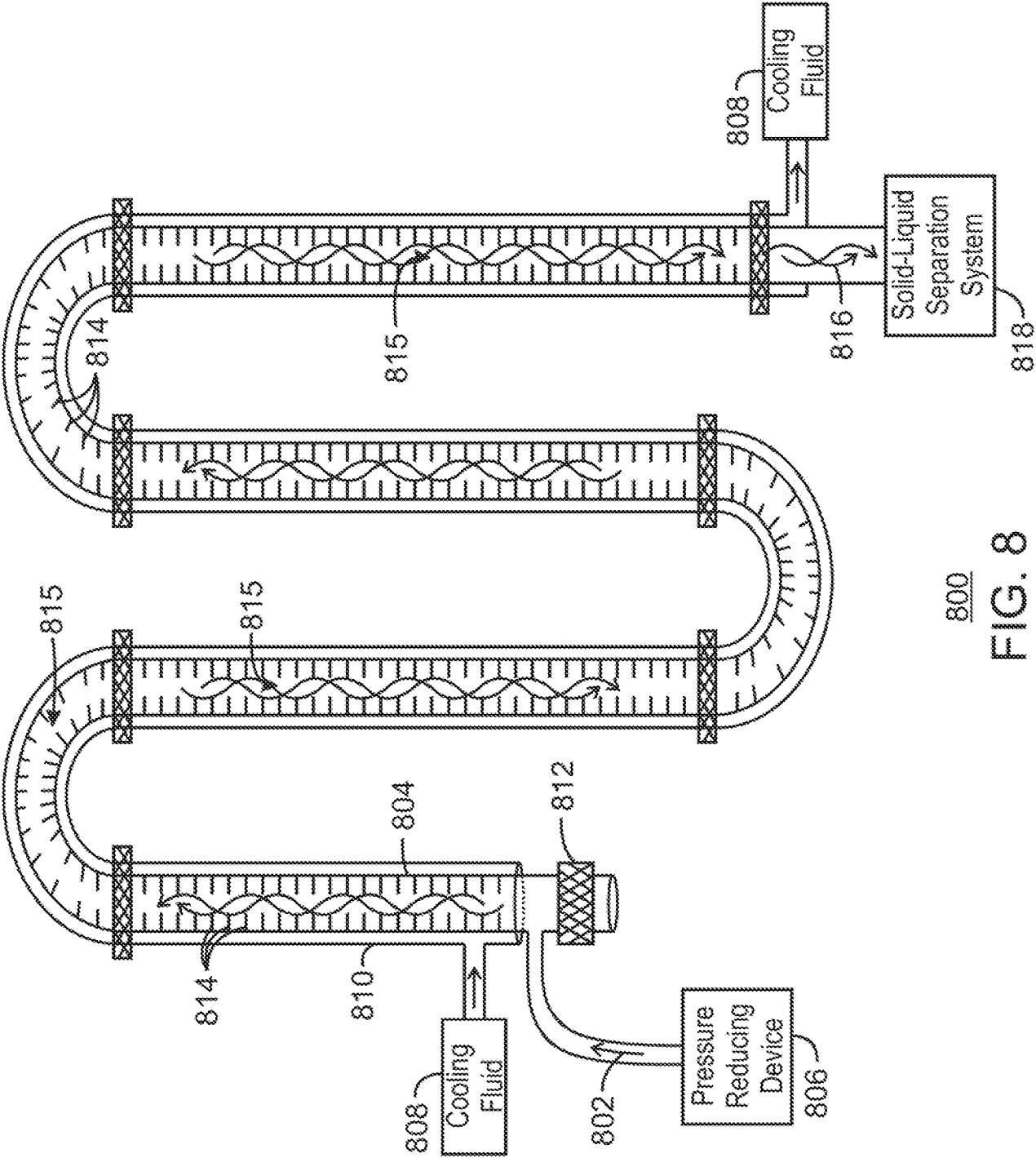
600
FIG. 6

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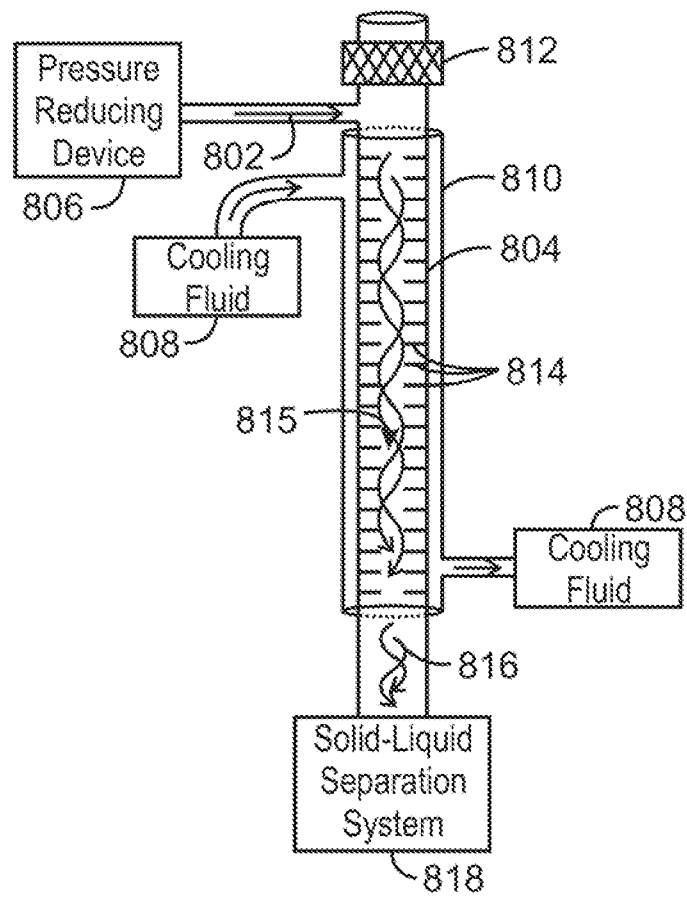
600
FIG. 7

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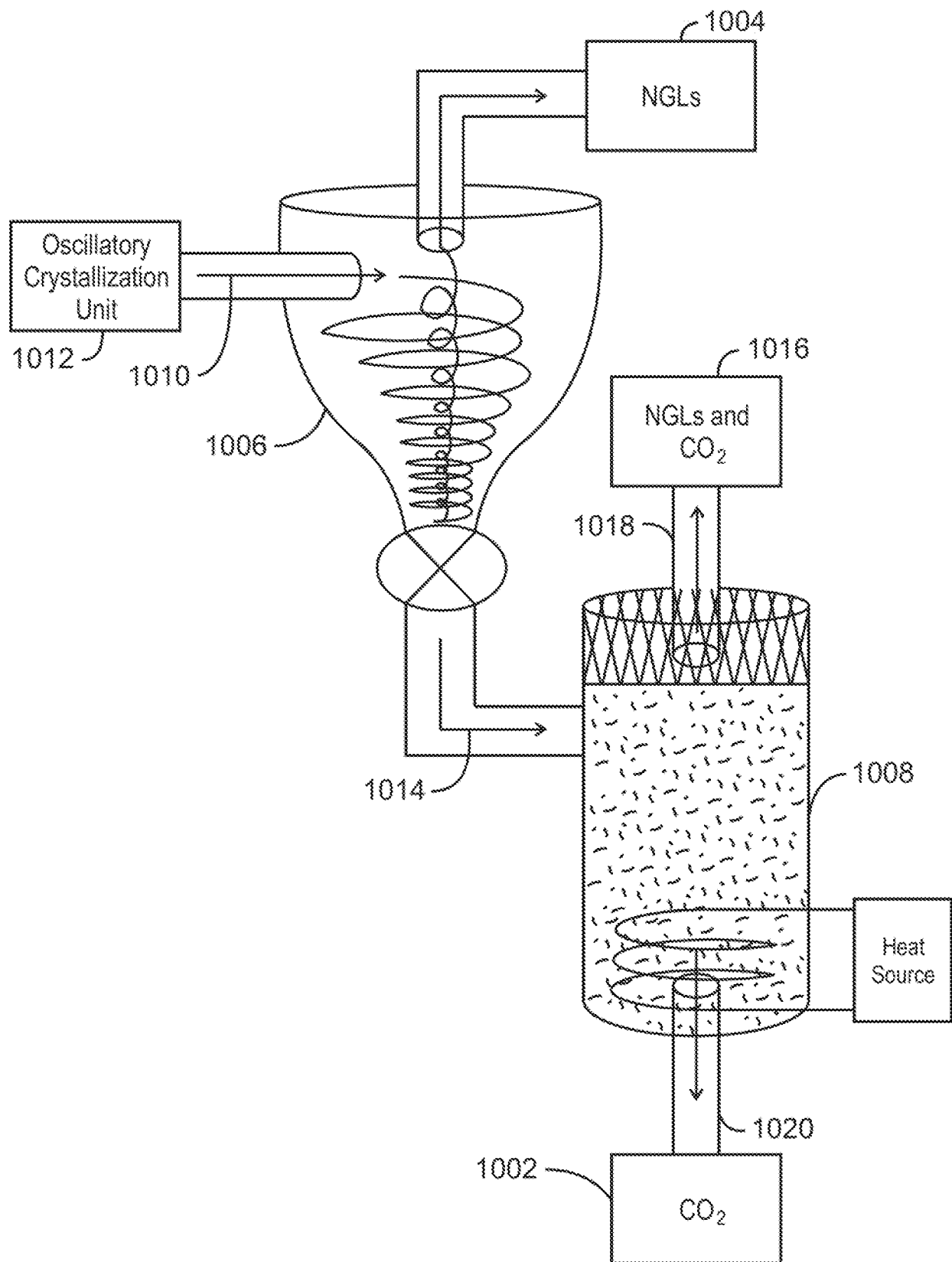
800
FIG. 8

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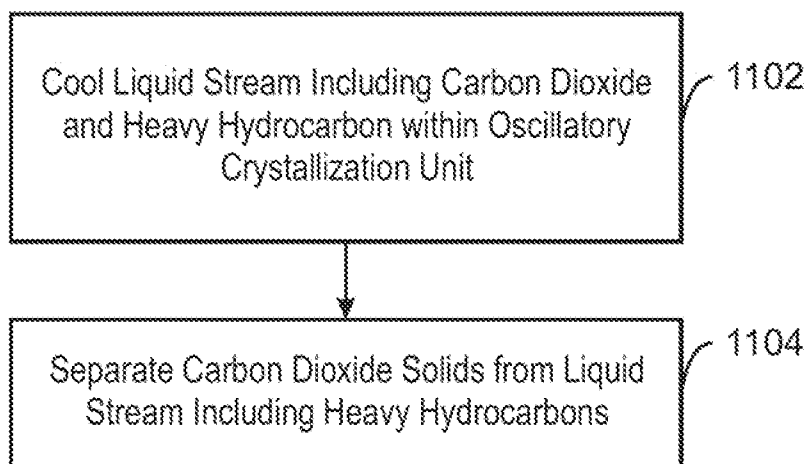
900
FIG. 9

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1000
FIG. 10

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1100
FIG. 11

INTERNATIONAL SEARCH REPORT

International application No.

PCT/US13/62686

A. CLASSIFICATION OF SUBJECT MATTER

IPC(8) - F25J 1/00, 1/02, 3/00 (2014.01)

USPC - 62/600, 602, 611

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)

IPC(8) - F25J 1/00, 1/02, 3/00 (2014.01)

USPC - 62/600, 602, 611

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

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

MicroPatent (US-G, US-A, EP-A, EP-B, WO, JP-bib, DE-C,B, DE-A, DE-T, DE-U, GB-A, FR-A); Google Scholar; IP.com; ProQuest Dialog; carbon dioxide, CO₂, crystalli*, H₂S, hydrogen, sulfide, sulphide, LNG, natural gas, azeotrop*, recycl*, return*

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	US 2010/0186446 A1 (TURNER, TD et al.) 29 July 2010; figure 2; paragraphs [0021], [0041], [0053]-[0054], [0057], [0064]	1-21
Y	LAWTON, S et al. Continuous Crystallization of Pharmaceuticals Using a Continuous Oscillatory Baffled Crystallizer. Organic Process Research & Development, 2009, Vol. 13, No. 6, pp. 1357-1363 [online], [retrieved on 2014-01-21]. Retrieved from the Internet <URL: http://nitechsolutions.co.uk/wp-content/uploads/2012/06/AZ.pdf> <DOI: 10.1021/op900237x>; page 1359, column 1, paragraph 5; page 1360, column 2, paragraph 3	1-21
Y	US 5,615,561 A (HOUSHMAND, M et al.) 01 April 1997; abstract; figure 1; column 5, lines 44-50, 64-67; column 9, lines 50-54	6-8, 18-19
Y	US 2012/0125043 A1 (CULLINANE, JT et al.) 24 May 2012; paragraph [0148]	9, 20
Y	US 4,351,655 A (STYRING, JR., RE) 28 September 1982; figure 1; column 2, lines 55-68; column 3, lines 9-15	10-11, 21

☐ Further documents are listed in the continuation of Box C.

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"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

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"&" document member of the same patent family

Date of the actual completion of the international search

31 January 2014 (31.01.2014)

Date of mailing of the international search report

18 FEB 2014

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