



(86) Date de dépôt PCT/PCT Filing Date: 2013/09/12

(87) Date publication PCT/PCT Publication Date: 2014/03/20

(45) Date de délivrance/Issue Date: 2016/01/19

(85) Entrée phase nationale/National Entry: 2015/02/13

(86) N° demande PCT/PCT Application No.: CA 2013/050705

(87) N° publication PCT/PCT Publication No.: 2014/040191

(30) Priorité/Priority: 2012/09/13 (US61/700,421)

(51) Cl.Int./Int.Cl. *F15D 1/02* (2006.01),
G01F 15/00 (2006.01)

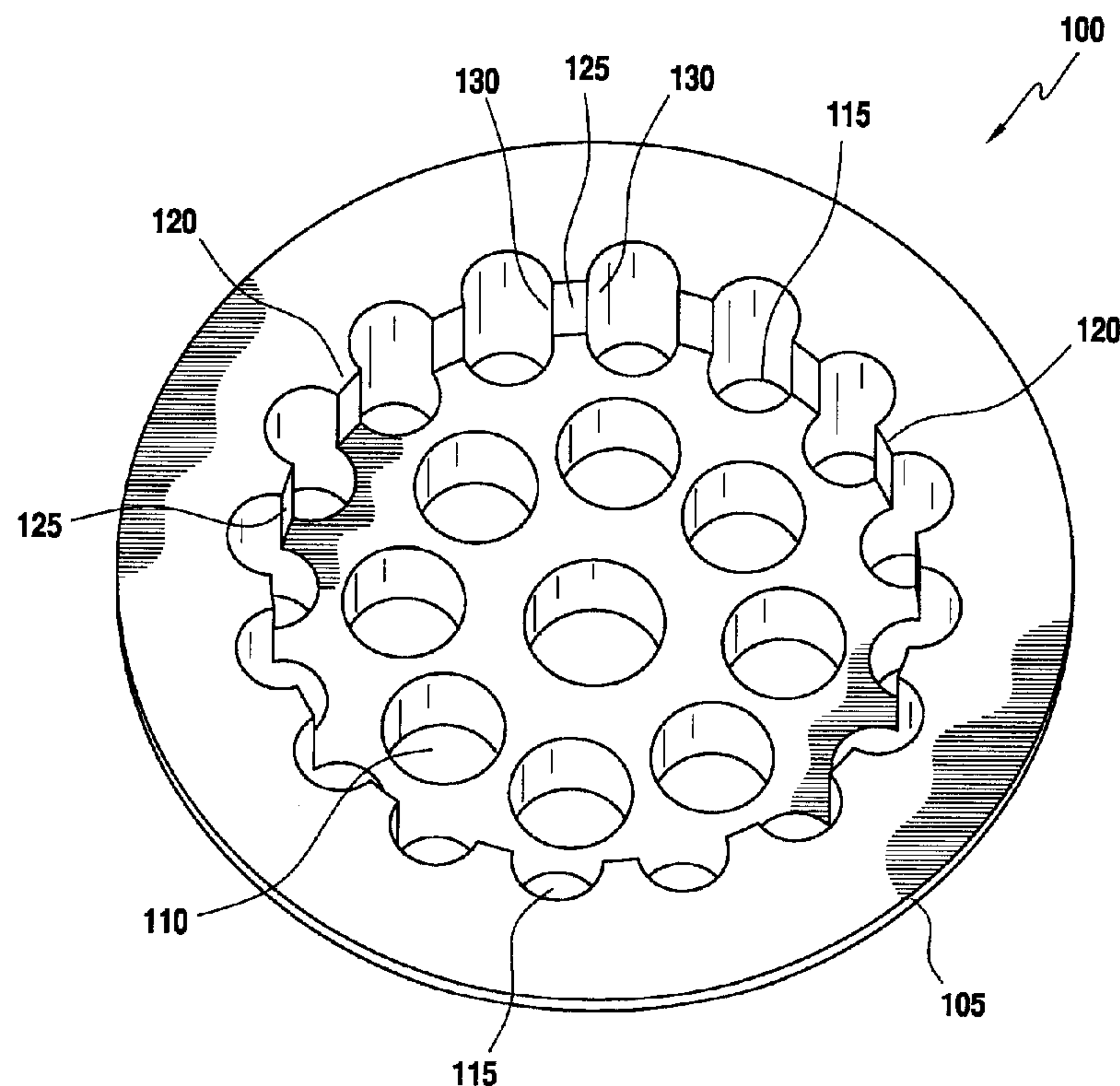
(72) Inventeurs/Inventors:
SAWCHUK, DANIEL, CA;
SELIRIO, REGINALD, CA

(73) Propriétaire/Owner:
CANADA PIPELINE ACCESSORIES, CO. LTD., CA

(74) Agent: BLAKE, CASSELS & GRAYDON LLP

(54) Titre : CONDITIONNEUR D'ECOULEMENT DOTE D'AILETTES INTEGREES

(54) Title: FLOW CONDITIONER WITH INTEGRAL VANES



(57) Abrégé/Abstract:

A flow conditioner includes a single disk comprising an array of holes and at least one integral vane, for example a plurality of integral vanes. The at least one integral vane is machined out of the same material as the flow conditioner and is not attached to the flow conditioner via a weld connection or adhesive.

(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property
Organization
International Bureau(10) International Publication Number
WO 2014/040191 A1(43) International Publication Date
20 March 2014 (20.03.2014)

(51) International Patent Classification:

F15D 1/02 (2006.01) *G01F 15/00* (2006.01)

(21) International Application Number:

PCT/CA2013/050705

(22) International Filing Date:

12 September 2013 (12.09.2013)

(25) Filing Language:

English

(26) Publication Language:

English

(30) Priority Data:

61/700,421 13 September 2012 (13.09.2012) US

(71) Applicant: **CANADA PIPELINE ACCESSORIES, CO. LTD.** [CA/CA]; 10653 - 46th Street S.E., Calgary, Alberta T2C 5C2 (CA).(72) Inventors: **SAWCHUK, Daniel**; 328 Oakmere Close, Chestermere, Alberta T1X 1L1 (CA). **SELIRIO, Reginald**; 116 Tuscany Way NW, Calgary, Alberta T3L 2A4 (CA).(74) Agents: **CHARI, Santosh, K.** et al.; Blake, Cassels & Graydon LLP, Box 25, Commerce Court West, 199 Bay Street, Suite 4000, Toronto, Ontario M5L 1A9 (CA).

(81) Designated States (unless otherwise indicated, for every kind of national protection available): AE, AG, AL, AM, AO, AT, AU, AZ, BA, BB, BG, BH, BN, BR, BW, BY, BZ, CA, CH, CL, CN, CO, CR, CU, CZ, DE, DK, DM, DO, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, GT, HN, HR, HU, ID, IL, IN, IS, JP, KE, KG, KN, KP, KR, KZ, LA, LC, LK, LR, LS, LT, LU, LY, MA, MD, ME, MG, MK, MN, MW, MX, MY, MZ, NA, NG, NI, NO, NZ, OM, PA, PE, PG, PH, PL, PT, QA, RO, RS, RU, RW, SA, SC, SD, SE, SG, SK, SL, SM, ST, SV, SY, TH, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, ZA, ZM, ZW.

(84) Designated States (unless otherwise indicated, for every kind of regional protection available): ARIPO (BW, GH, GM, KE, LR, LS, MW, MZ, NA, RW, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, RU, TJ, TM), European (AL, AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HR, HU, IE, IS, IT, LT, LU, LV, MC, MK, MT, NL, NO, PL, PT, RO, RS, SE, SI, SK, SM, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, KM, ML, MR, NE, SN, TD, TG).

Declarations under Rule 4.17:

— as to applicant's entitlement to apply for and be granted a patent (Rule 4.17(ii))

[Continued on next page]

(54) Title: FLOW CONDITIONER WITH INTEGRAL VANES

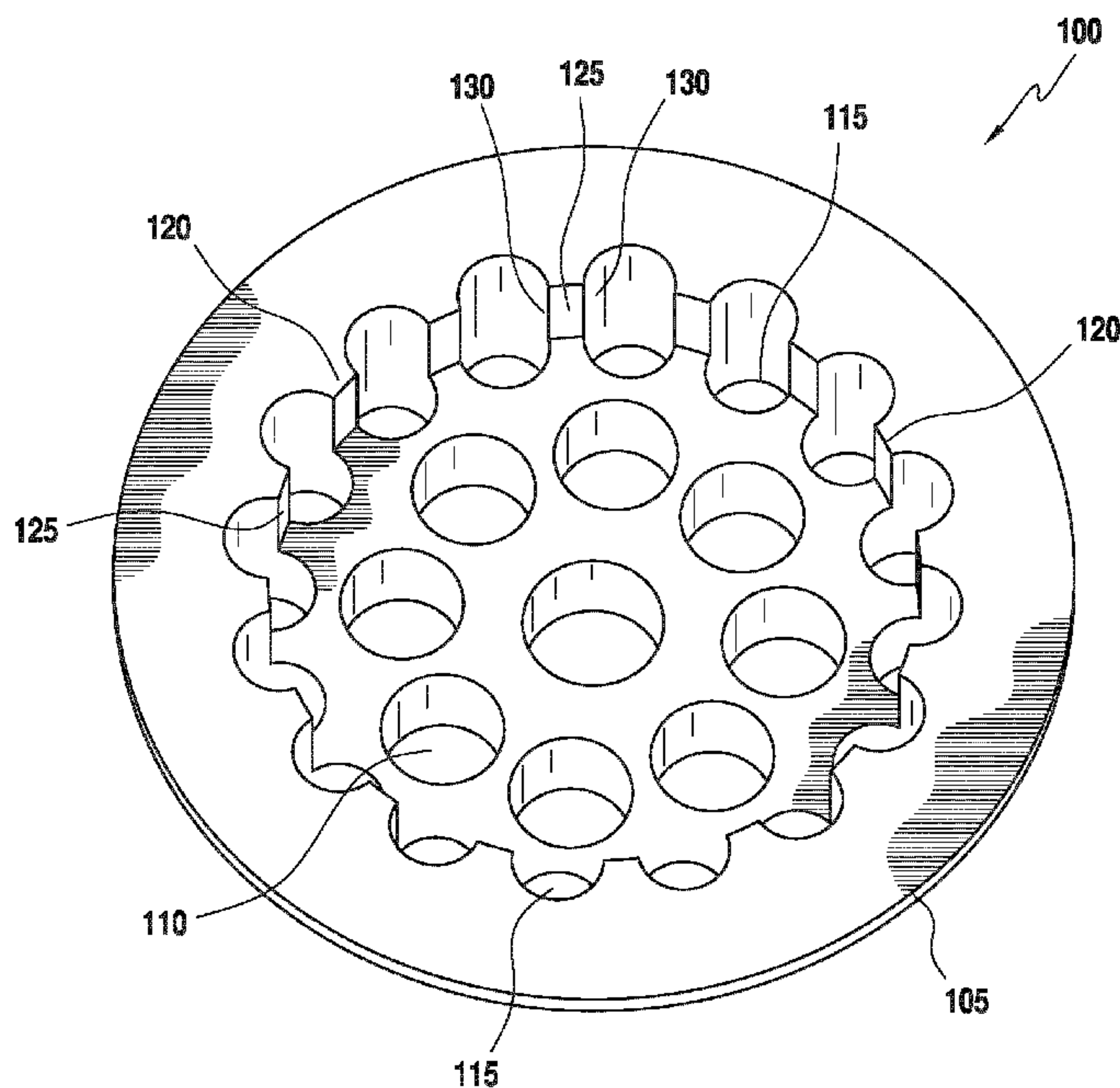


FIG. 1

(57) Abstract: A flow conditioner includes a single disk comprising an array of holes and at least one integral vane, for example a plurality of integral vanes. The at least one integral vane is machined out of the same material as the flow conditioner and is not attached to the flow conditioner via a weld connection or adhesive.

WO 2014/040191 A1



Published:

— *with international search report (Art. 21(3))*

FLOW CONDITIONER WITH INTEGRAL VANES

I. Technical Field

[0001] The present invention relates to fluid flow measurement components used in oil and gas pipelines. More particularly, the present invention relates to a flow conditioner having at least one integral vane, for example a plurality of integral vanes.

II. Background of the Invention

[0002] Pipelines are used to transport fluids in various industries, including chemical, oil and gas, and manufacturing. These industries use processes that require fluid flow rates to be accurately measured. These measurements are performed at locations known as meter stations using a variety of different meter types. These meters function in different ways. They can use differential pressure of the fluid across an obstruction, ultrasonic signal travel times, turbine blade rotational speed, *Coriolis* forces, or even electrical and magnetic fields being generated due to bulk fluid movement. Almost all of these measurement methods require use of the fluid velocity distribution, known as a velocity flow profile (flow profile).

[0003] To achieve the most accurate measurements, the flow profile of the fluid entering a meter should be stable, non-rotating, and symmetric. This type of velocity distribution is known as a fully developed flow profile, and it forms naturally in very long lengths of uninterrupted straight pipe. However, having long lengths of straight pipe is impractical and cost prohibitive. As a result, meter station piping often contains elbows, tees, valves and/or other assemblies that distort the flow profile into an asymmetric, unstable, and distorted configuration. This makes it very difficult to measure the fluid flow rate in a consistently accurate and repeatable manner.

[0004] Under these conditions, flow conditioners are needed to correct the flow profile of the fluid such that it forms a fully developed flow profile which allows accurate, repeatable measurements to be made.

[0005] Several types of flow conditioners exist, including those having straightening vanes, tube bundles, or perforated plates. These flow conditioners are placed within the pipe upstream of a flow meter. A typical perforated plate flow conditioner comprises a perforated metal plate that is arranged within a pipe orthogonal to the fluid flow (e.g., across the entire cross section of

1 pipe). The perforations or holes in the flow conditioner cause the fluid flow to be redistributed
2 such that it forms a fully developed flow profile. The placement of a flow conditioner upstream
3 of the flow meter ensures that the flow is fully developed before it reaches the meter. This
4 allows the meter to perform significantly more accurate and repeatable fluid flow measurements.

5 **[0006]** Currently, vanes or vane assemblies may be welded onto flow conditioners or may
6 comprise an assembly placed within a pipeline upstream of a flow conditioner. Due to the
7 extreme forces in pipelines, such vanes typically fail, in particular where vanes are welded onto
8 a flow conditioner plate. Thus, the vanes may be significantly damaged or broken into pieces,
9 thereby damaging the pipeline and/or a downstream flow meter.

10 III. Summary of the Invention

11 **[0007]** The present invention, in at least one embodiment, provides a flow conditioner
12 including a single disk having an array of holes and at least one integral vane.

13 **[0008]** According to another embodiment of the present invention, a flow conditioner
14 includes a single disk having an array of holes and a plurality of integral vanes.

15 **[0009]** The present invention, in at least another embodiment, provides a pipe assembly for
16 flow measurement including a fluid flow pipe; and a flow conditioner disposed within the fluid
17 flow pipe in an orientation substantially perpendicular to an axis of the fluid flow pipe and
18 comprising a disk having an array of holes and at least one integral vane.

19 **[0010]** The present invention, in yet another embodiment, provides a fluid flow
20 measurement system including a fluid flow pipe; a flow conditioner disposed within the fluid flow
21 pipe in an orientation substantially perpendicular to an axis of the fluid flow pipe and comprising
22 a disk having an array of holes and at least one integral vane; and a flow meter.

23 **[0011]** As used herein "substantially", "relatively", "generally", "about", and "approximately"
24 are relative modifiers intended to indicate permissible variation from the characteristic so
25 modified. They are not intended to be limited to the absolute value or characteristic which it
26 modifies but rather approaching or approximating such a physical or functional characteristic.

27 **[0012]** In the detailed description, references to "one embodiment", "an embodiment", or "in
28 embodiments" mean that the feature being referred to is included in at least one embodiment of

the invention. Moreover, separate references to "one embodiment", "an embodiment", or "in embodiments" do not necessarily refer to the same embodiment; however, neither are such embodiments mutually exclusive, unless so stated, and except as will be readily apparent to those skilled in the art. Thus, the invention can include any variety of combinations and/or integrations of the embodiments described herein.

[0013] Given the following enabling description of the drawings, the methods and systems should become evident to a person of ordinary skill in the art.

IV. Brief Description of the Drawings

[0014] FIG. 1 illustrates an elevated perspective view of a flow conditioner having integral vanes partially following the contours of an outer ring of holes.

[0015] FIG. 2A illustrates a rear perspective view of a flow conditioner having a flange surrounding the flow conditioner and integral vanes on an outer ring of holes on both sides of the flow conditioner.

[0016] FIG. 2B illustrates a front view of the flow conditioner of FIG. 2A.

[0017] FIG. 2C illustrates a side view of the flow conditioner of FIG. 2A.

[0018] FIG. 3A illustrates a rear perspective view of a flow conditioner having a flange flush with an end of the flow conditioner and integral vanes on a downstream side of the flow conditioner.

[0019] FIG. 3B illustrates a front view of the flow conditioner of FIG. 3A.

[0020] FIG. 3C illustrates a side view of the flow conditioner of FIG. 3A.

[0021] FIG. 4A illustrates a rear perspective view of flow conditioner having a flange surrounding the flow conditioner and integral vanes on an upstream side of the flow conditioner.

[0022] FIG. 4B illustrates a front view of the flow conditioner of FIG. 4A. FIG. 4C illustrates a side view of the flow conditioner of FIG. 4A.

[0023] FIG. 5 illustrates a cut-away partial view of a flow conditioner with integral vanes on an outer ring on an upstream side of the flow conditioner.

1 **[0024]** FIG. 6 illustrates a cut-away partial view of a flow conditioner with integral vanes on
2 an outer ring on a downstream side of the flow conditioner.

3 **[0025]** FIG. 7 illustrates a cut-away partial view of a flow conditioner with integral vanes on
4 an outer ring on both sides of the flow conditioner.

5 **[0026]** FIG. 8 illustrates an elevated perspective view of a flow conditioner having integral
6 vanes following the contours of an outer ring of holes and an inner ring of holes.

7 **[0027]** FIG. 9A illustrates a rear perspective view of a flow conditioner having a flange flush
8 with an end of the flow conditioner and integral vanes on an outer ring and an inner ring on a
9 downstream side of the flow conditioner.

10 **[0028]** FIG. 9B illustrates a front view of the flow conditioner of FIG. 9A.

11 **[0029]** FIG. 9C illustrates a side view of the flow conditioner of FIG. 9A.

12 **[0030]** FIG. 10 illustrates a cut-away partial view of a flow conditioner with integral vanes on
13 an outer ring and an inner ring on an upstream side of the flow conditioner.

14 **[0031]** FIG. 11 illustrates a cut-away partial view of a flow conditioner with integral vanes on
15 an outer ring and an inner ring on a downstream side of the flow conditioner.

16 **[0032]** FIG. 12 illustrates a cut-away partial view of a flow conditioner with integral vanes on
17 an outer ring and an inner ring on both sides of the flow conditioner.

18 **[0033]** FIG. 13 illustrates a cut-away partial perspective view of a vane ring having vanes on
19 an outer ring.

20 **[0034]** FIG. 14 is a graph showing a flow profile in a straight pipe with the flow conditioner of
21 FIGS. 3A-C.

22 **[0035]** FIG. 15 is a graph showing a flow profile in a straight pipe with the flow conditioner of
23 FIGS. 4A-C.

24 **[0036]** FIG. 16 is a graph showing a flow profile in an empty pipe, the fluid having 30
25 degrees of swirl.

1 [0037] FIG. 17 is a graph showing a flow profile of the flow profile with the flow conditioner
2 of FIGS. 3A-C, the fluid having 30 degrees of swirl.

3 [0038] FIG. 18 is a graph showing the crossflow (swirl) significance with a flow conditioner
4 of FIGS. 3A-C, the fluid having 30 degrees of swirl.

5 [0039] FIG. 19 is a graph showing flow profiles in an empty pipe having upstream piping.

6 [0040] FIG. 20 is a graph showing flow profiles with the vane ring of FIG. 13 in the upstream
7 piping of FIG. 19.

8 [0041] FIG. 21 is a graph showing the crossflow significance with a vane ring of FIG. 13, the
9 fluid having 30 degrees of swirl.

10 V. Detailed Description of the Invention

11 [0042] According to the present invention, a flow conditioner has at least one integral vane,
12 for example a plurality of integral vanes, that is machined out of the same material as the flow
13 conditioner itself. Thus, the at least one integral vane is physically part of the flow conditioner
14 (e.g., physically machined out of the original flow conditioner). The at least one vane is not
15 separately attached or connected to the flow conditioner, for example, via a weld or adhesive
16 connection. The at least one integral vane does not extend radially on and/or linearly from a
17 surface of a flow conditioner. The at least one integral vane reduces fluid swirl entering and/or
18 leaving the flow conditioner, thereby improving flow conditioner performance without being torn
19 or ripped from the flow conditioner due to pipeline forces.

20 [0043] The at least one integral vane at least partially follows a hole layout (e.g., the
21 contours or pattern of the holes) of a flow conditioner. In a specific embodiment, the at least
22 one integral vane may follow at least part of a hole pattern of an outer ring and/or inner ring of
23 holes. The at least one integral vane may at least partly follow a hole contour or pattern of the
24 flow conditioner, for example, from a first surface of the flow conditioner to a second surface of
25 the flow conditioner.

26 [0044] As shown in FIG. 1, a flow conditioner 100 according an embodiment of the present
27 invention may comprise a single disk 105 comprising a plurality of holes or apertures 110. A
28 plurality of integral vanes 120 is machined out of the same material as the disk 105 and partially

1 follows the contour or pattern of an outer ring of holes 115. Each integral vane 120 extends
2 upward from between two outer holes 115, thereby defining a substantially flat inwardly-facing
3 surface 125 and two curved sides 130, each curved side defined by and integral with part of the
4 circumference of an outer hole 115.

5 **[0045]** An optional flange 135 may surround a flow conditioner according to the present
6 invention, for example as illustrated in FIGS. 2A and 4A, or may be flush with an end (e.g., an
7 upstream end/face or a downstream end/face) of the flow conditioner, for example as illustrated
8 in FIG. 3A and 9A. The flange may provide a connection to a pipe within which the flow
9 conditioner is installed.

10 **[0046]** According to a specific embodiment of the present invention, a plurality of integral
11 vanes 120 may be on both sides of a flow conditioner, as illustrated in FIGS. 2A-2C and FIG. 7.
12 Alternatively, a plurality of integral vanes 120 may be on a downstream side of a flow
13 conditioner, as illustrated in FIGS. 3A-3C and FIG. 6, or may be on an upstream side of a flow
14 conditioner, as illustrated in FIGS. 4A-4C and FIG. 5.

15 **[0047]** According to a specific embodiment of the present invention, as shown in FIG. 8, a
16 flow conditioner 200 may comprise a single disk 205 comprising a plurality of holes or apertures
17 210, and having a plurality of integral vanes 215a, 215b that are machined out of the same
18 material as the disk. One set of integral vanes 215a follows at least part of the hole contour or
19 pattern of an outer ring of holes. In addition, another set of integral vanes 215b follows the hole
20 contour or pattern of an inner ring of holes.

21 **[0048]** Each integral vane 215b on the inner ring of holes extends upward between two
22 holes, thereby having 1) a first substantially inner flat surface 220 and an opposing second
23 curved surface 225, and 2) two curved sides 230 defined by and integral with part of the
24 circumference of a hole on either side. Each integral vane 215a on the outer ring of holes may
25 have a configuration as discussed above with respect to FIG. 1.

26 **[0049]** According to the present invention, the plurality of integral vanes 215a, 215b may be
27 on a downstream side of a flow conditioner, as illustrated in FIGS. 9A-9C and FIG. 11; on an
28 upstream side of a flow conditioner, as illustrated in FIG. 10; or on both sides of a flow
29 conditioner, as illustrated in FIG. 12.

1 **[0050]** According to another embodiment of the present invention, as illustrated in FIG. 13, a
2 flow conditioner may comprise a vane ring 300. The vane ring 300 may be a separate element
3 that may be used by itself in a pipeline or may be applied to or fit on an existing flow conditioner.
4 A vane ring 300, for example, may comprise a plurality of outer vanes 305 along a contour or
5 pattern of outer holes 310, with everything else corresponding to the flow conditioner drilled out.
6 The vane ring 300 may be installed in an upstream or downstream configuration, either by itself
7 or with an existing flow conditioner.

8 **[0051]** The vane ring 300 may have a flange. In a specific embodiment, the vane ring 300
9 may be clamped on or into a flange of an existing flow conditioner and sit immediately upstream
10 of a flow conditioner plate. The flange closing pressure will hold the vane ring onto the flow
11 conditioner, without the need for any weld or adhesive connection.

12 **[0052]** Suitable flow conditioners that may be modified to have at least one integral vane
13 according to the present invention include, but are not limited to, CPA TBR and CPA 50E flow
14 conditioners available from Canada Pipeline Accessories of Calgary, Canada; and the flow
15 conditioners described in U.S. Patent No. 5,341,848.

16 **[0053]** In specific embodiments, the flow conditioner (e.g., diameter; hole sizes, placement,
17 and configuration) may be sized to a pipe inside diameter ID (95% - 99% ID). In specific
18 embodiments, the flow conditioner width or thickness may be about 5% - 30% of Pipe ID. In
19 specific embodiments, the length of the at least one vane or a plurality of vanes may be about
20 5% - 500% of pipe ID. In specific embodiments, an outer ring of vanes may have a length of
21 between 70% - 95% of the pipe ID and an inner ring of vanes may have a length of between
22 about 35% to 65% of the pipe ID.

23 **[0054]** The flow conditioner according to the present invention may be utilized in existing
24 piping without making modifications. In specific embodiments, the flow conditioner may have a
25 flanged connection, which is frequently available in meter stations. Thus, it is very simple and
26 extremely compatible with meter station layouts.

27 **[0055]** FIG. 14 is a graph showing a flow profile in a straight pipe with the flow conditioner of
28 FIGS. 3A-C. All runs were done with natural gas as the fluid and with a 5 MPa outlet pressure.
29 For a fluid having an initial fluid velocity of 25 m/s, FIG. 14 shows the fluid flow profiles

1 measured horizontally (along a longitudinal axis of the length of the pipe in which the flow
2 conditioner is installed) and vertically (along a transverse or perpendicular axis of the pipe) at
3 distances downstream of the flow conditioner (i.e., 5D, 8D, and 15D, measured in inside or
4 internal pipe diameters). The vertical axis of the graph is the measured velocity in m/s and the
5 horizontal axis of the graph is the diameter across a pipe (i.e., 0.00 is the center of the pipe
6 having an approximately 12 inch cross section).

7 **[0056]** As shown in FIG. 14, the flow profile has a fully developed form at each measured
8 distance (5D, 8D, and 15D) and the illustrated flow lines substantially overlap.

9 **[0057]** FIG. 15 is a graph showing a flow profile in a straight pipe with the flow conditioner of
10 FIGS. 4A-C. Measurements were taken as described above with respect to FIG. 14. The flow
11 profile has a fully developed form at each measured distance (5D, 8D, and 15D) and the
12 illustrated flow lines substantially overlap.

13 **[0058]** FIG. 16 is a graph showing a flow profile in an empty pipe, the fluid having 30
14 degrees of swirl.

15 **[0059]** FIG. 17 is a graph showing a flow profile of the flow conditioner of FIGS. 3A-C, the
16 fluid having 30 degrees of swirl. Measurements were taken as described above with respect to
17 FIG. 14. The flow profile has a fully developed form at each measured distance (5D, 8D, and
18 15D) and the illustrated flow lines substantially overlap.

19 **[0060]** FIG. 18 is a graph showing the crossflow (swirl) significance with a flow conditioner
20 of FIGS. 3A-C, the fluid having 30 degrees of swirl. The vertical axis is the swirl/crossflow
21 significance (measured as a percentage of axial velocity) and the horizontal axis is the distance
22 from the flow conditioner (measured in inside pipe diameters). As shown in FIG. 18, the
23 swirl/crossflow significance substantially drops downstream of the flow conditioner, which is
24 installed at zero.

25 **[0061]** FIG. 19 is a graph showing flow profiles in an empty pipe having upstream piping
26 according to the International Organization of Legal Metrology (OIML) R137 standard. For a
27 fluid having an initial fluid velocity of 25 m/s, FIG. 19 shows the fluid flow profiles measured
28 horizontally and vertically at distances 1D and 2.5D upstream from the point where the flow
29 conditioner would be installed. The vertical axis of the graph is the measured velocity in m/s

1 and the horizontal axis of the graph is the diameter across a pipe (i.e., 0.00 is the center of the
2 pipe having an approximately 12 inch cross section).

3 **[0062]** FIG. 20 is a graph showing flow profiles in the pipe of FIG. 19 having a vane ring of
4 FIG. 13 installed in a downstream configuration. Fluid flow profiles were measured horizontally
5 and vertically at distances downstream of the vane ring (i.e., 5D, 8D, 10D, and 15D).

6 **[0063]** FIG. 21 is a graph showing the crossflow significance in the pipe of FIG. 19 having a
7 vane ring of FIG. 13 installed in a downstream configuration, the fluid having 30 degrees of
8 swirl. The vertical axis is the swirl/crossflow significance and the horizontal axis is the distance
9 from the flow conditioner. As shown in FIG. 21, the swirl/crossflow significance drops
10 downstream of the vane ring, which is installed at zero.

11 VI. Industrial Applicability

12 **[0064]** The present invention relates to a flow conditioner having at least one integral vane,
13 for example, a plurality of integral vanes. The integral vanes reduce fluid swirl entering and/or
14 leaving the flow conditioner, thereby improving flow conditioner performance without tearing or
15 ripping the integral vane from the flow conditioner due to pipeline forces.

16 **[0065]** Although the present invention has been described in terms of particular exemplary
17 and alternative embodiments, it is not limited to those embodiments. Alternative embodiments,
18 examples, and modifications which would still be encompassed by the invention may be made
19 by those skilled in the art, particularly in light of the foregoing teachings.

20 **[0066]** Those skilled in the art will appreciate that various adaptations and modifications of
21 the exemplary and alternative embodiments described above can be configured without
22 departing from the scope of the invention as outlined in the appended claims. Therefore, it is to
23 be understood that, within the scope of the appended claims, the invention may be practiced
24 other than as specifically described herein.

25

CLAIMS:

1. A flow conditioner, characterized by:
a single disk comprising a plurality of holes including an outer ring of holes; and
a plurality of integral vanes,
wherein each integral vane is defined by a substantially flat inwardly-facing surface
between two outer holes and two curved sides, each curved side defined by and integral with
part of the circumference of an outer hole.
2. The flow conditioner according to claim 1, wherein the flow conditioner includes a flange
that is flush with an upstream end or downstream end thereof.
3. The flow conditioner according to claim 1 or 2, characterized in that the plurality of vanes
is machined out of the same material as the single disk.
4. The flow conditioner according to claim 1 or 2, characterized in that the plurality of vanes
follows a contour or pattern of a hole from a first surface of the flow conditioner to a second
surface of the flow conditioner.
5. The flow conditioner according to claim 1 or 2, characterized in that the plurality of
integral vanes are on an upstream side of the flow conditioner.
6. The flow conditioner according to claim 1 or 2, characterized in that the plurality of
integral vanes are on a downstream side of the flow conditioner.
7. The flow conditioner according to claim 1 or 2, characterized in that the plurality of
integral vanes are on both sides of the flow conditioner.
8. The flow conditioner according to claim 1 or 2, characterized by:
a second set of integral vanes at least partially following a circumferential contour or
pattern of an inner ring of holes.

9. The flow conditioner according to claim 8, characterized in that each integral vane of the second set of integral vanes is defined by 1) a first substantially inner flat surface between two inner holes and an opposing second curved surface, and 2) two curved sides defined by and integral with part of the circumference of an inner hole on either side.
10. A flow conditioner, characterized by:
a single disk comprising a plurality of holes and a flange; and,
a vane ring clamped on or into the flange;
the vane ring consisting of:
a ring element having a hollow center; and
a plurality of integral vanes on said ring element;
characterized in that each integral vane is defined by a substantially flat inwardly-facing surface and two curved sides.
11. A pipe assembly for flow measurement, characterized by:
a fluid flow pipe;
a flow conditioner according to claim 1 or 2 disposed within said fluid flow pipe in an orientation substantially perpendicular to an axis of said fluid flow pipe.
12. A fluid flow measurement system, characterized by:
a fluid flow pipe;
a flow conditioner according to claim 1 or 2 disposed within said fluid flow pipe in an orientation substantially perpendicular to an axis of said fluid flow pipe; and
a flow meter downstream of the flow conditioner.

1/13

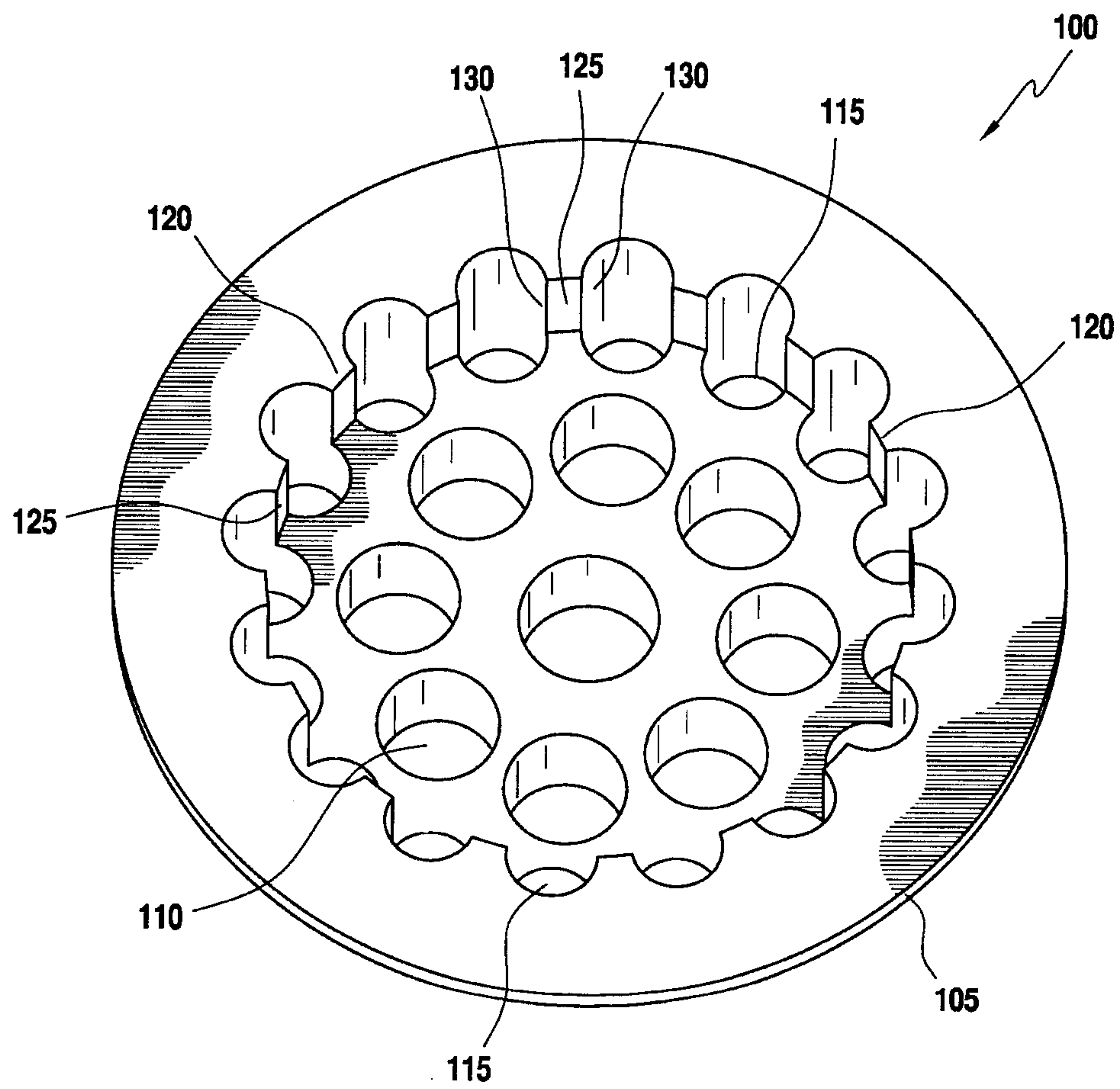


FIG. 1

2/13

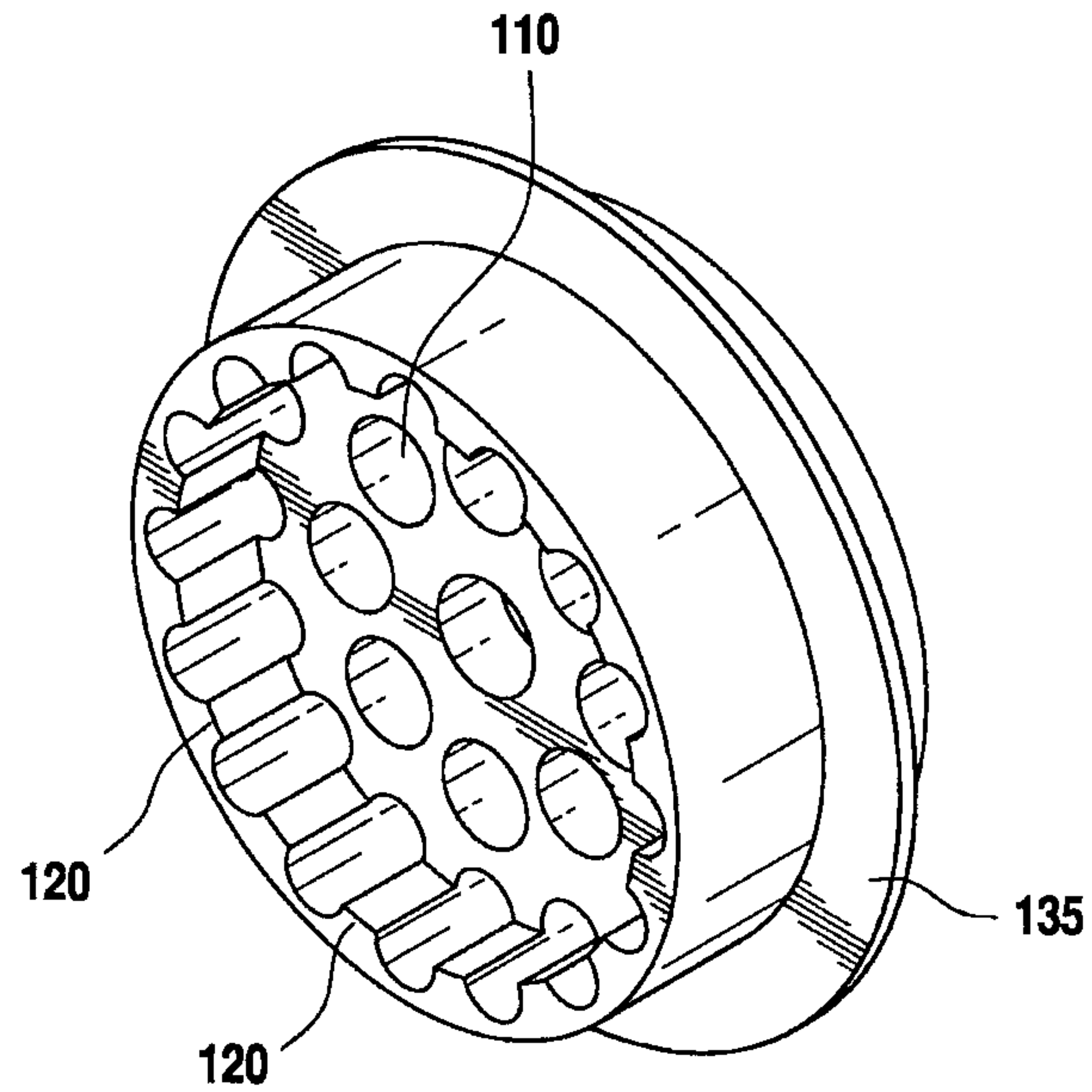


FIG. 2A

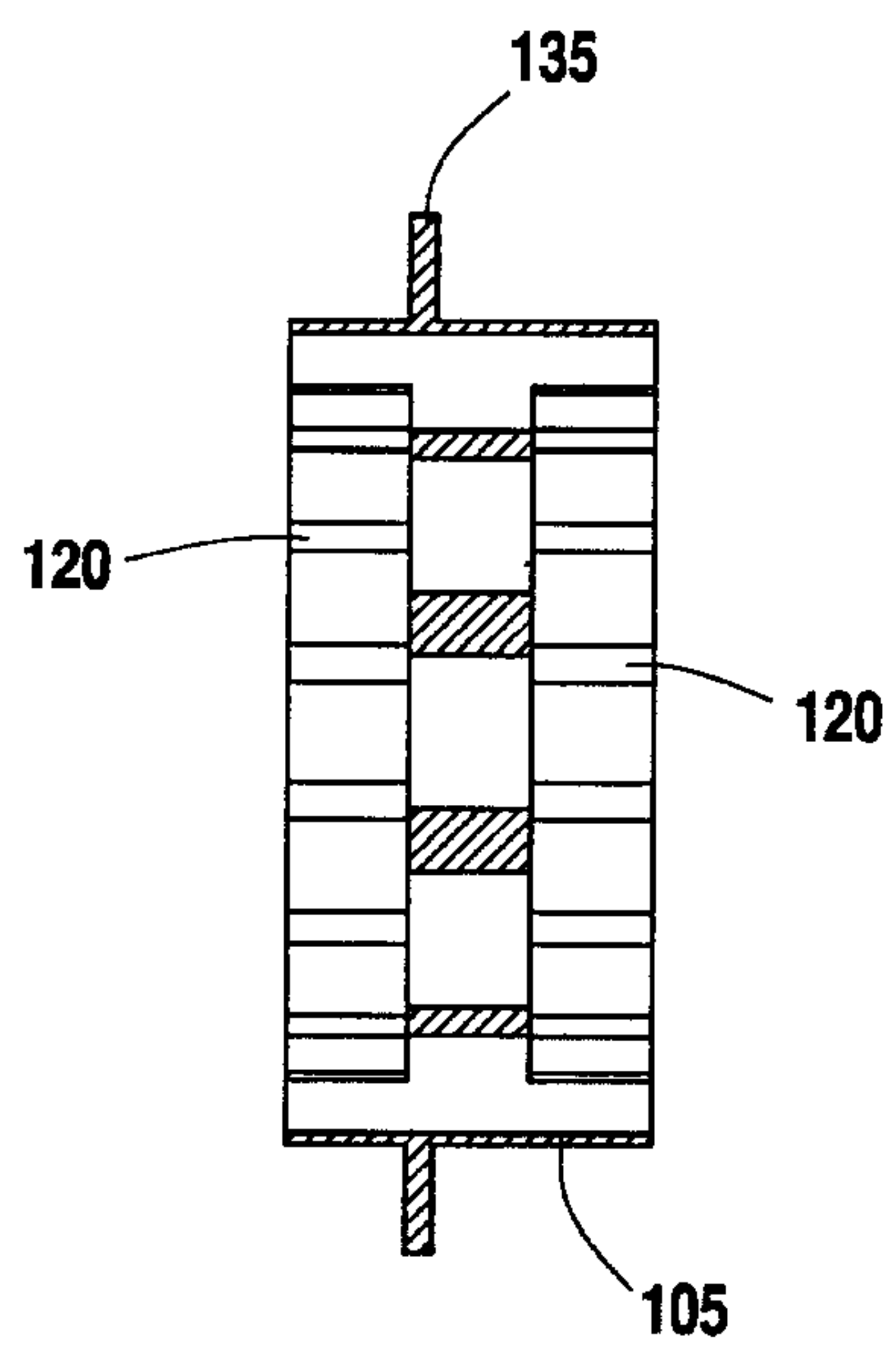


FIG. 2C

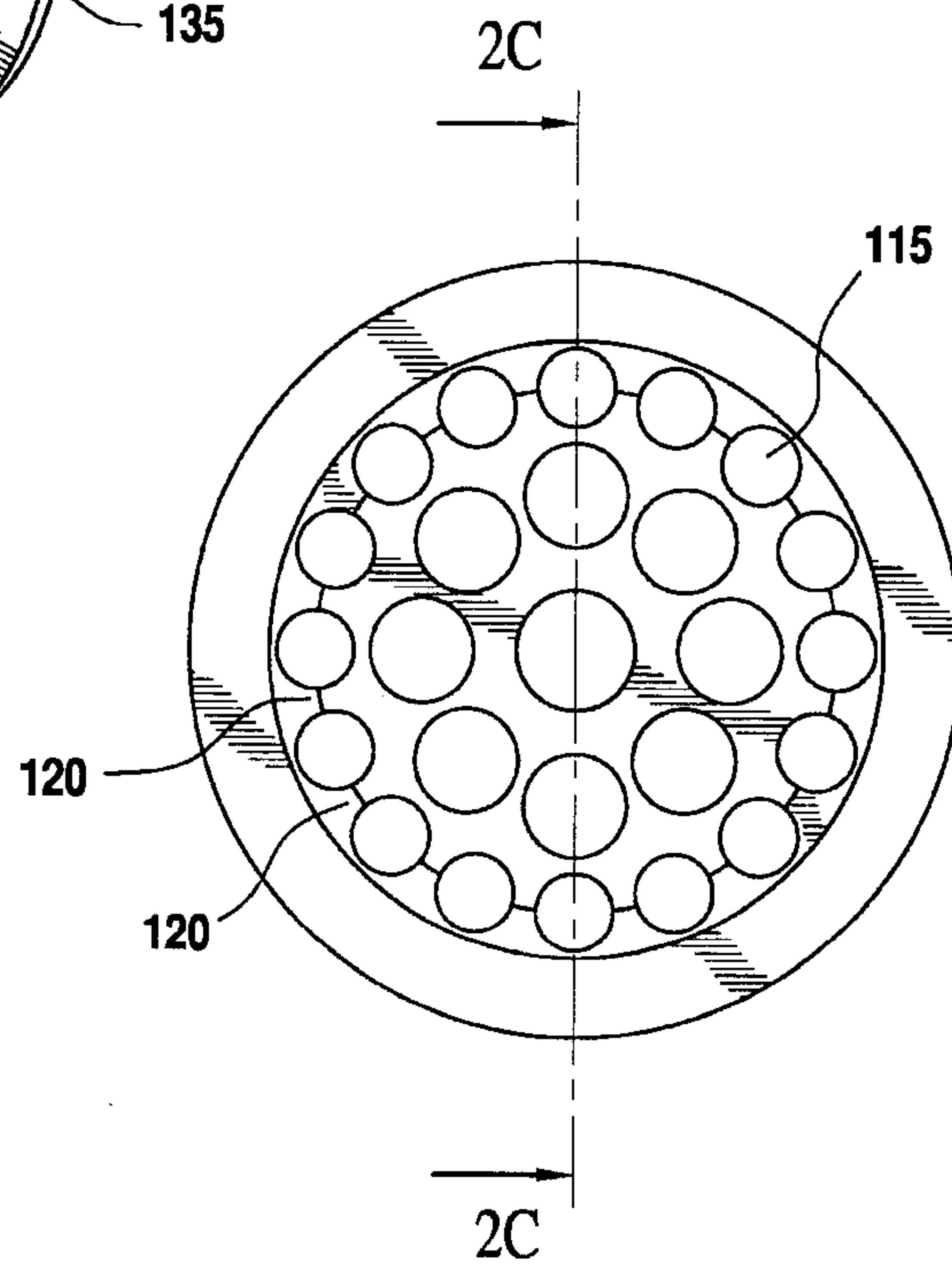


FIG. 2B

3/13

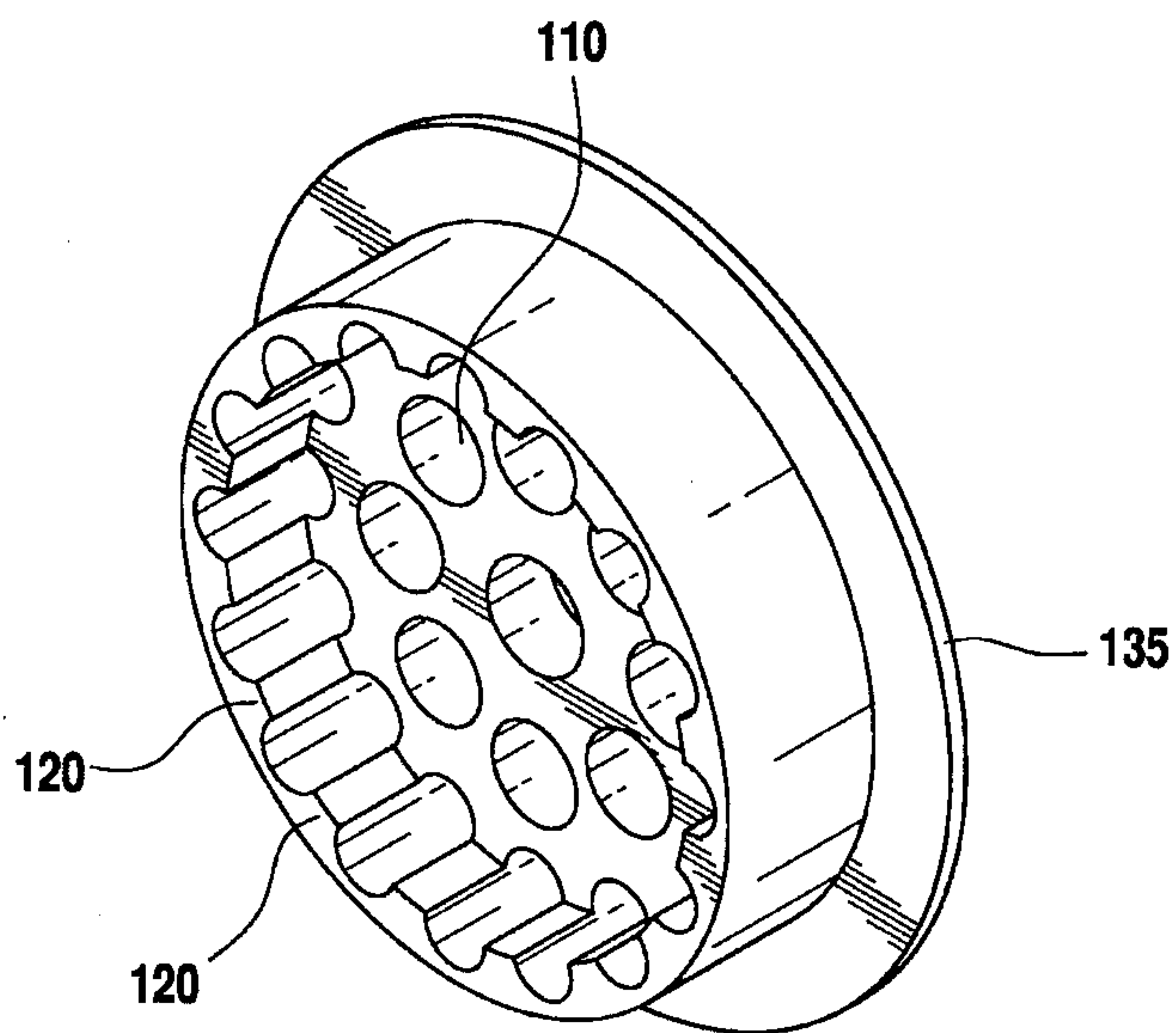


FIG. 3A

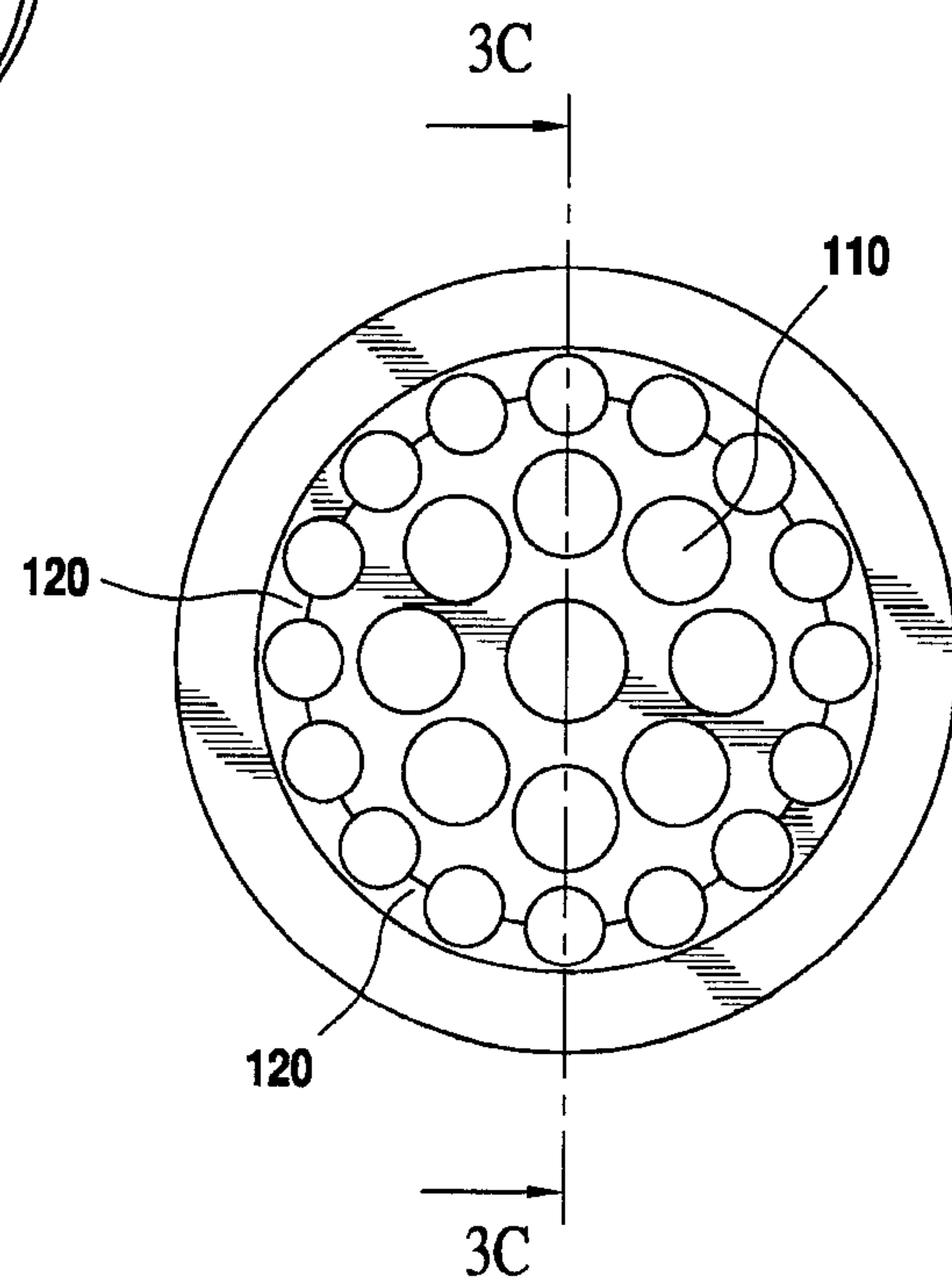


FIG. 3B

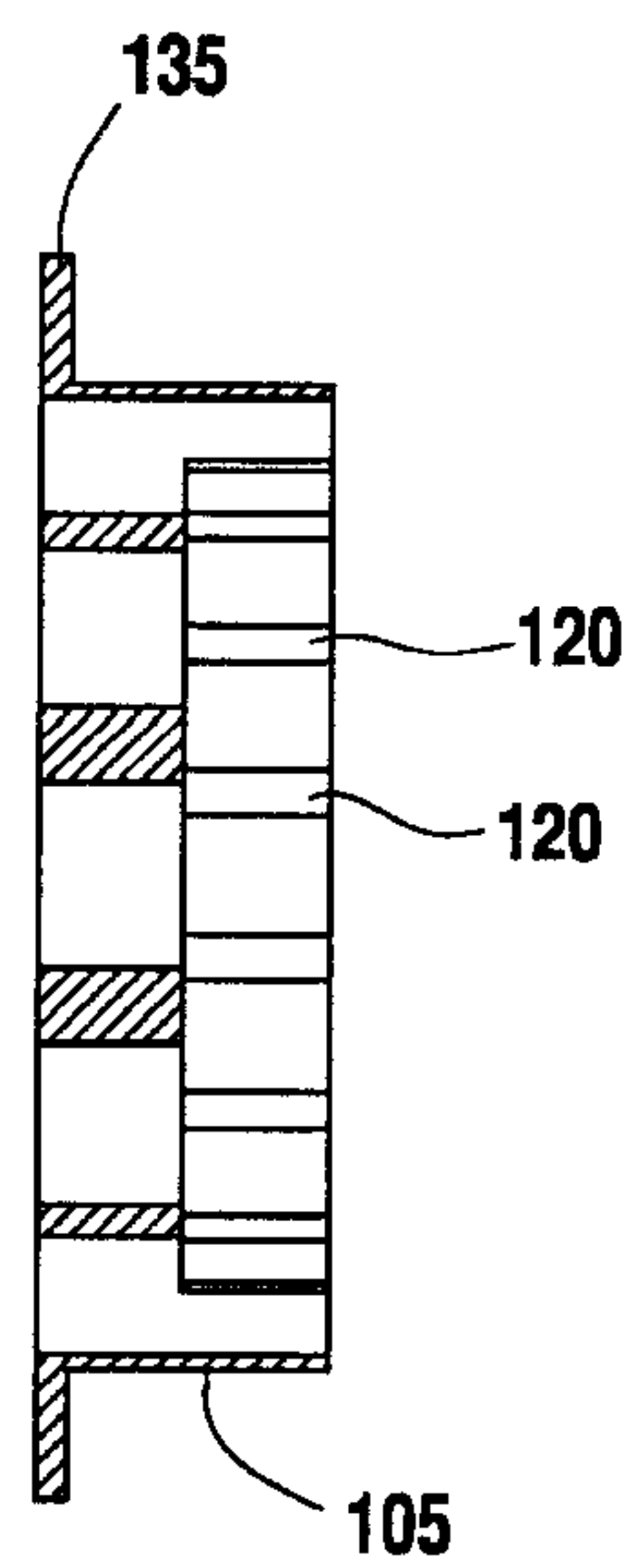


FIG. 3C

4/13

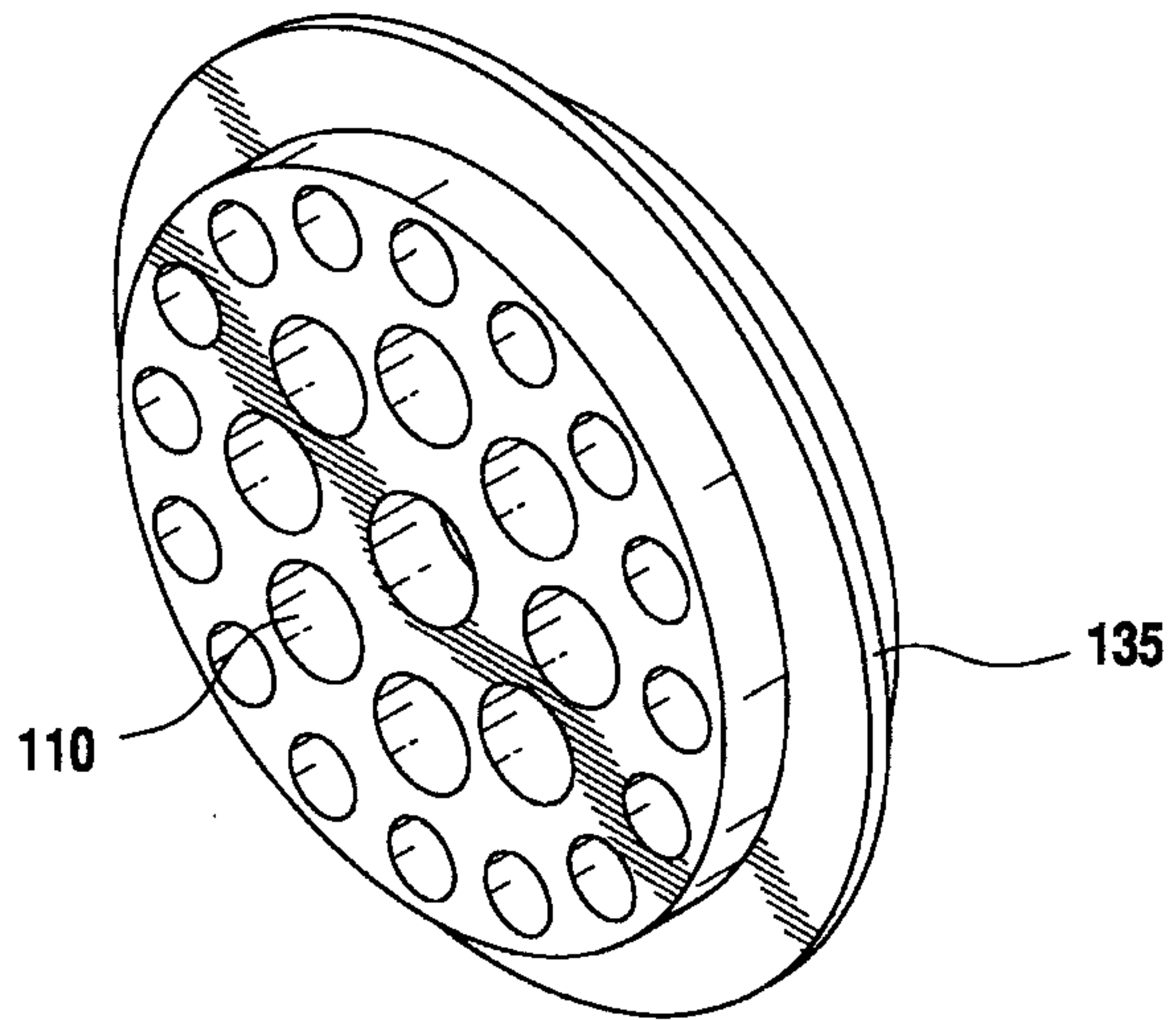


FIG. 4A

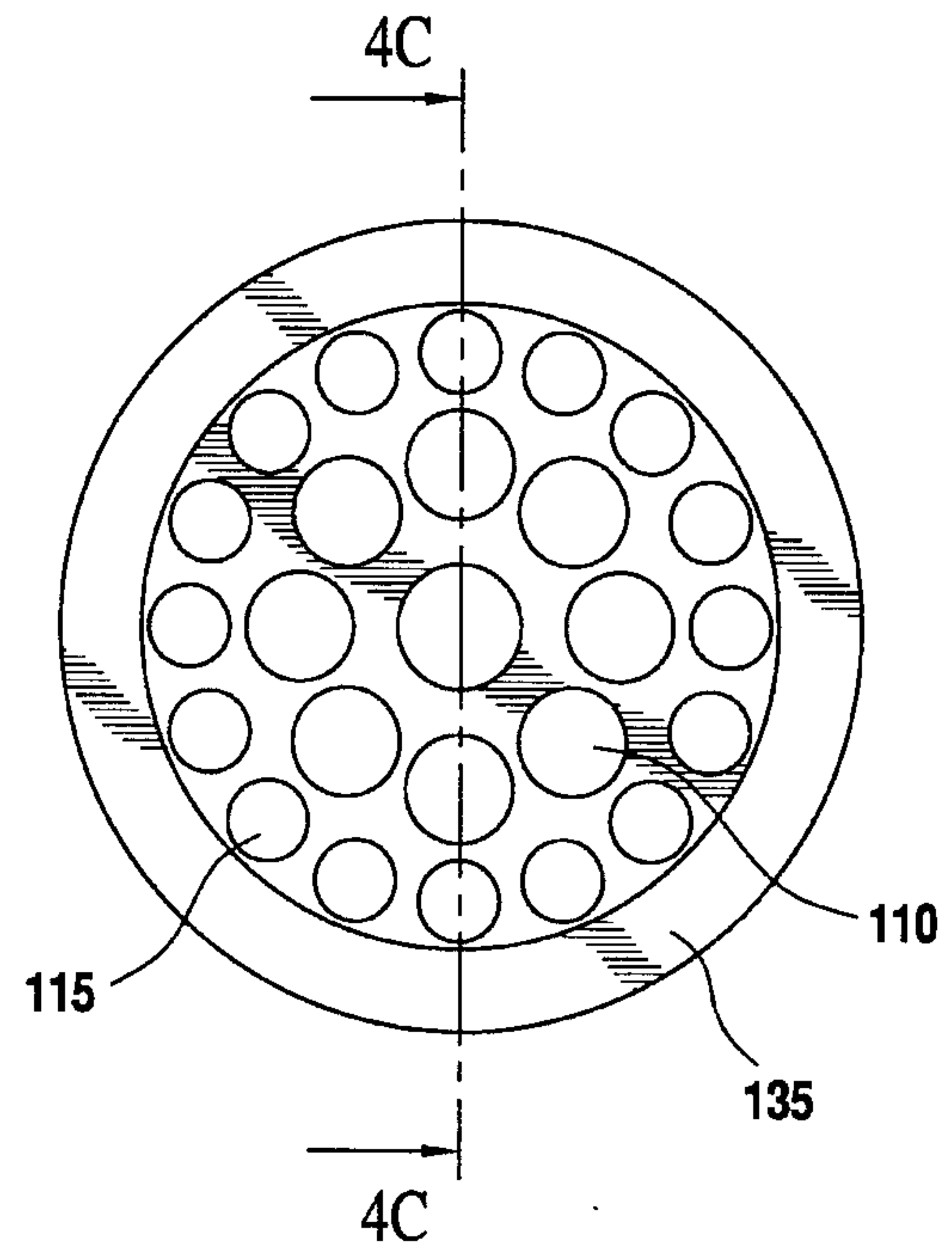


FIG. 4B

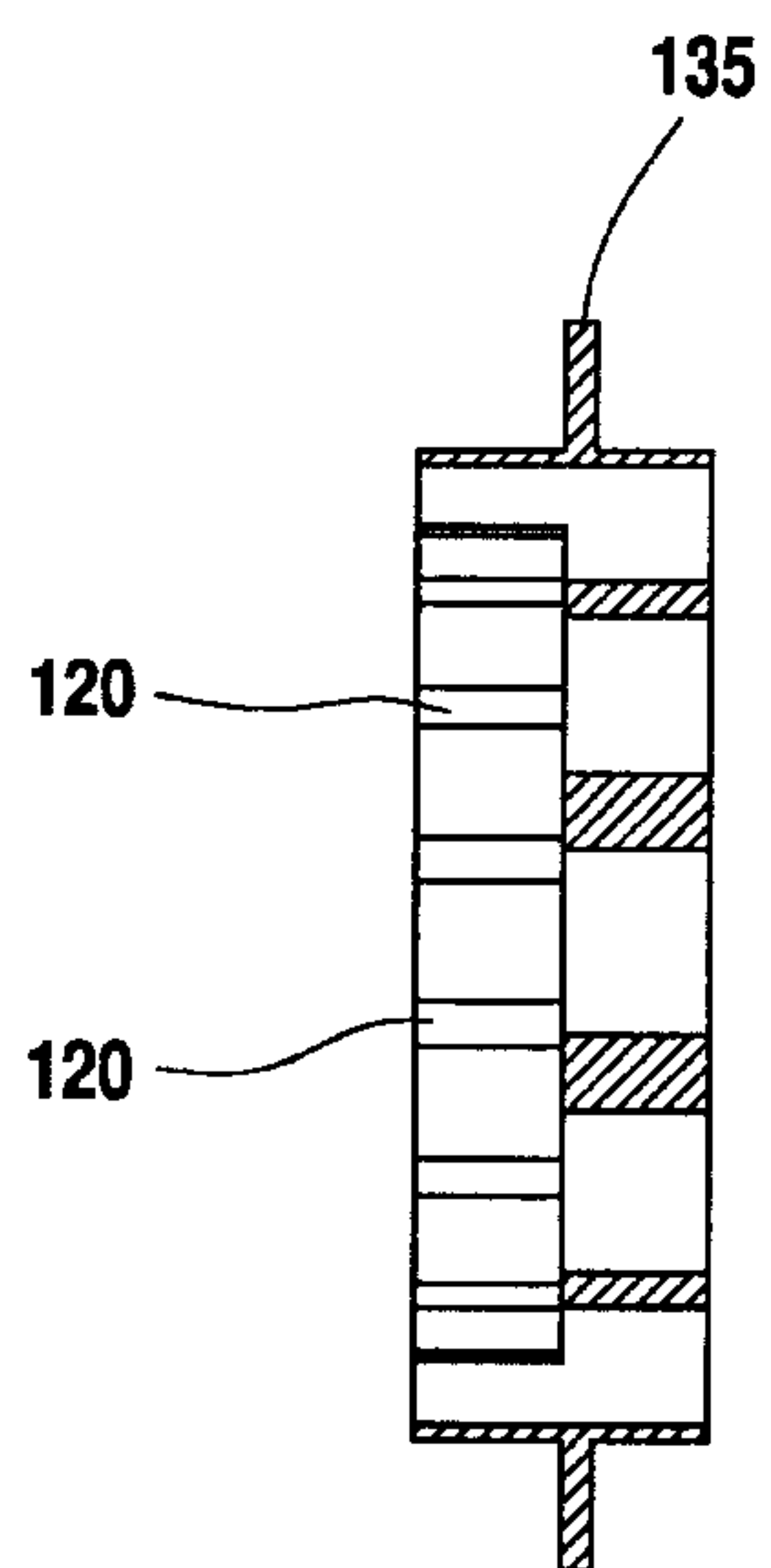
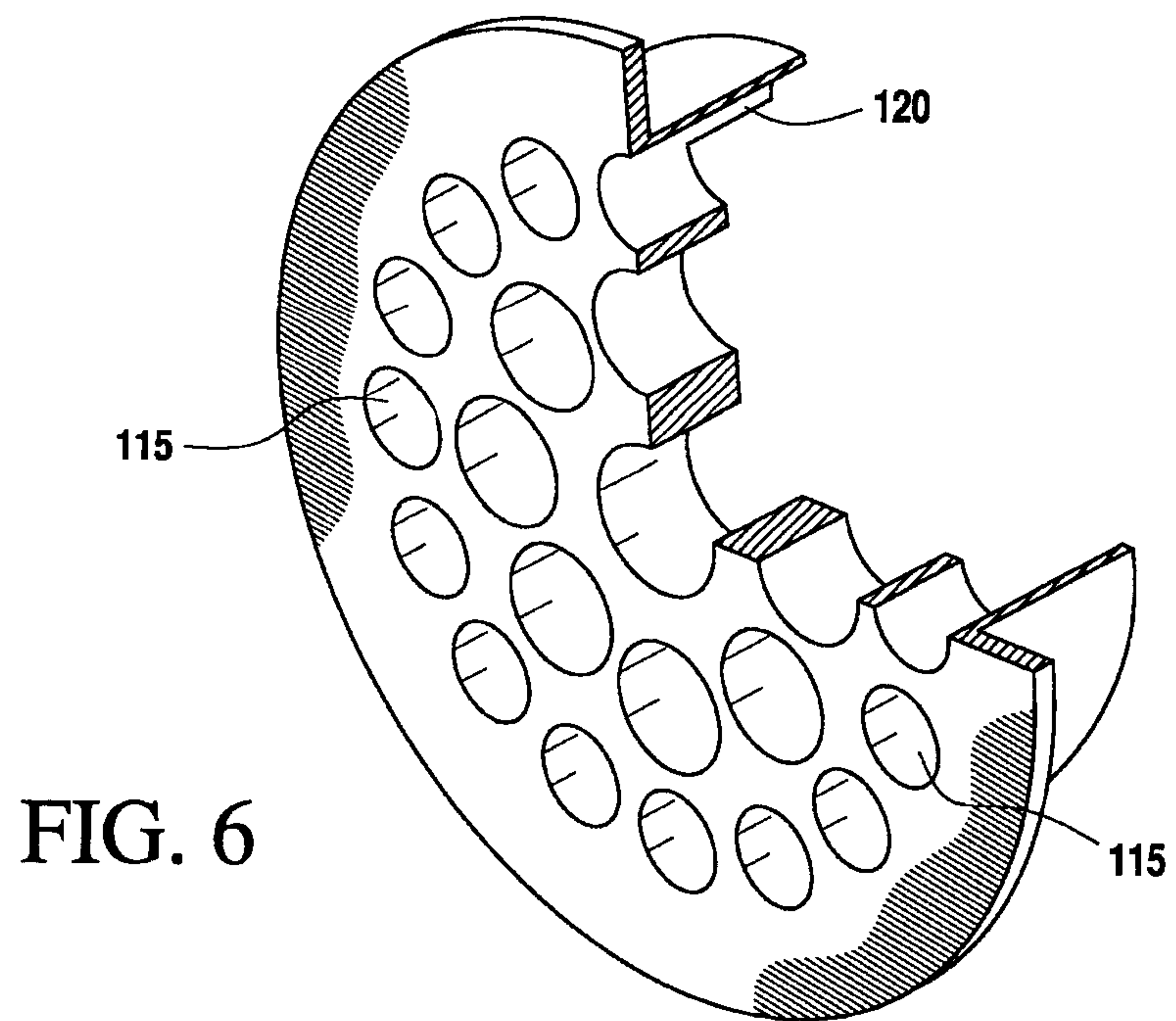
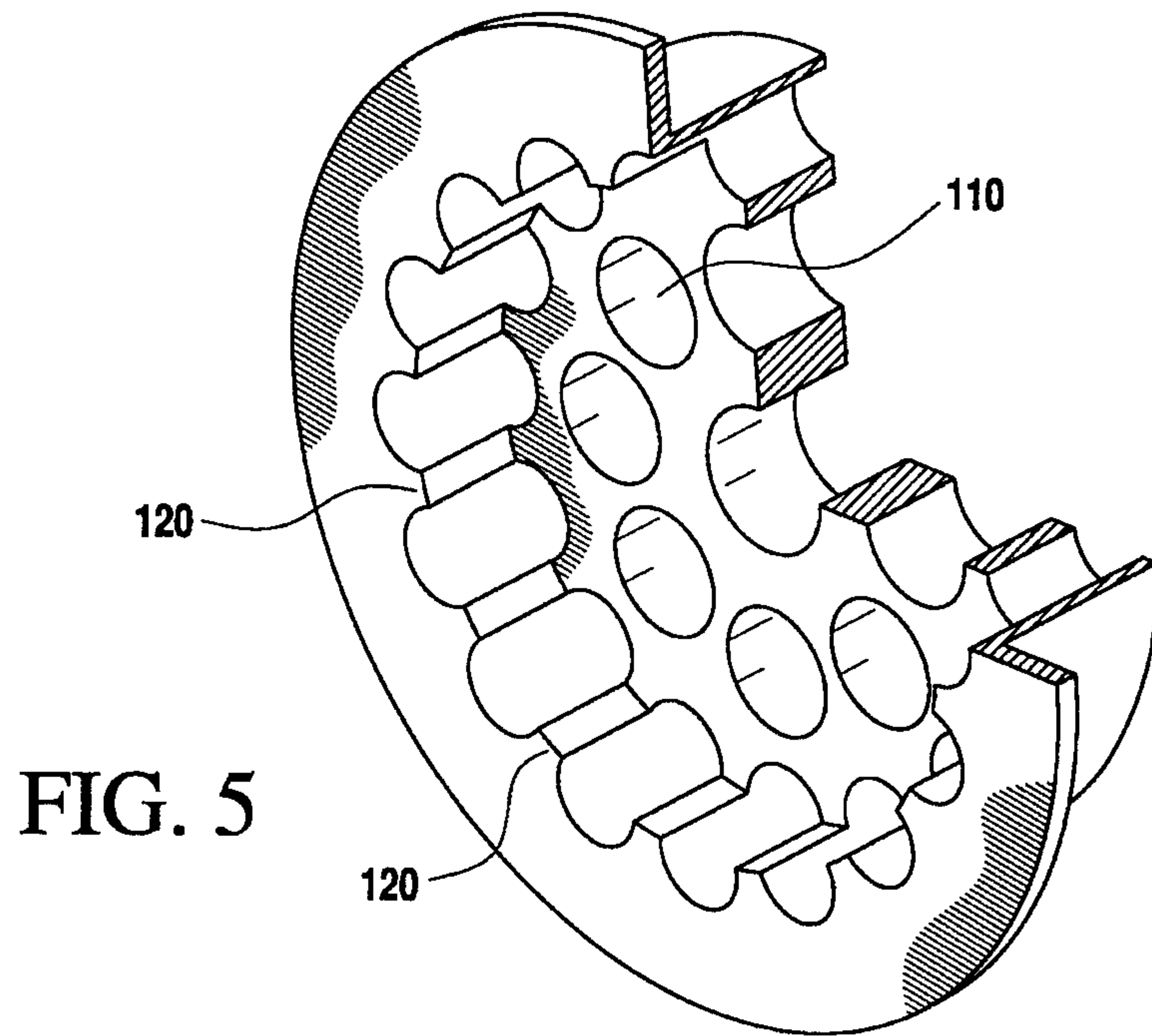
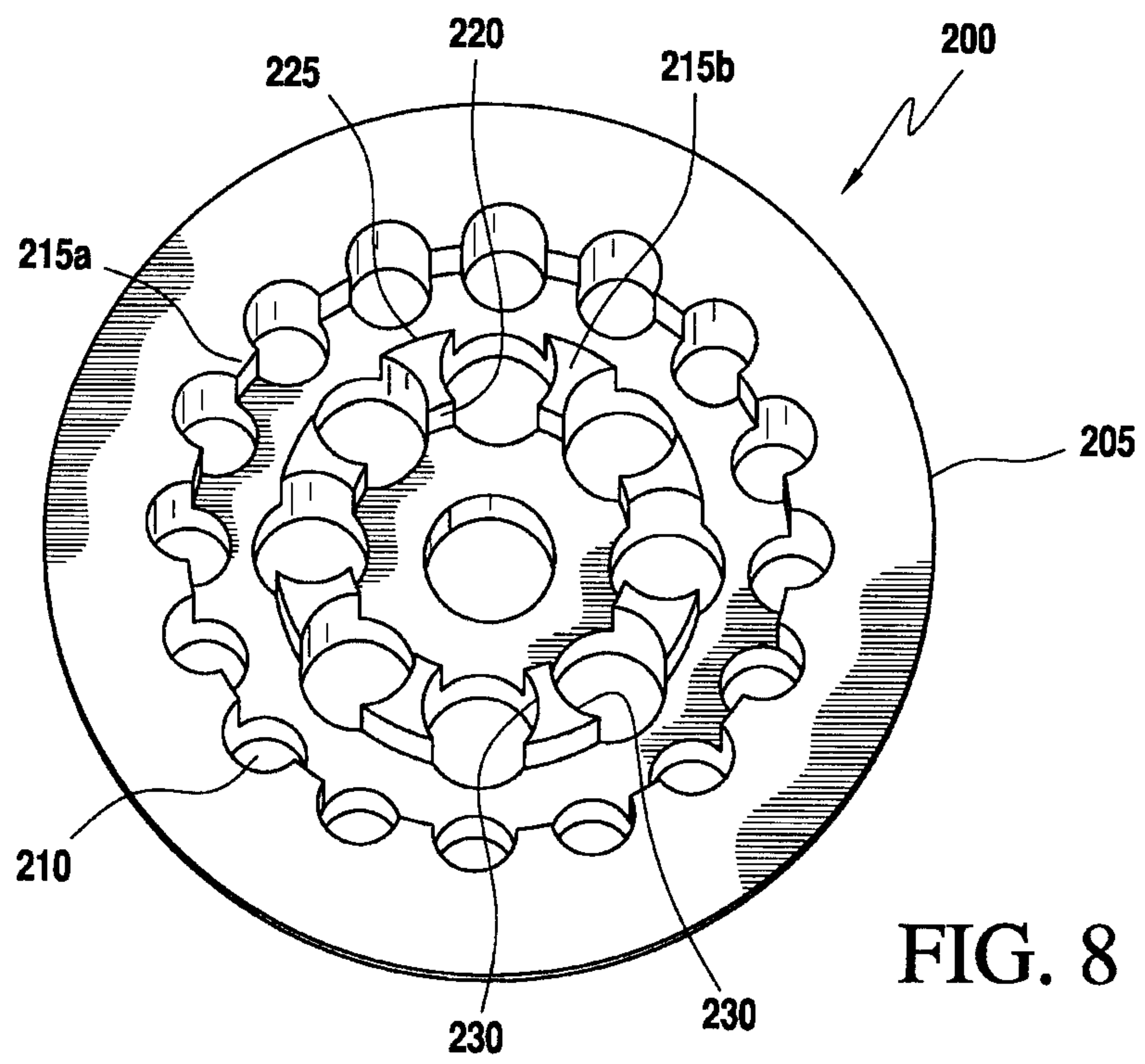
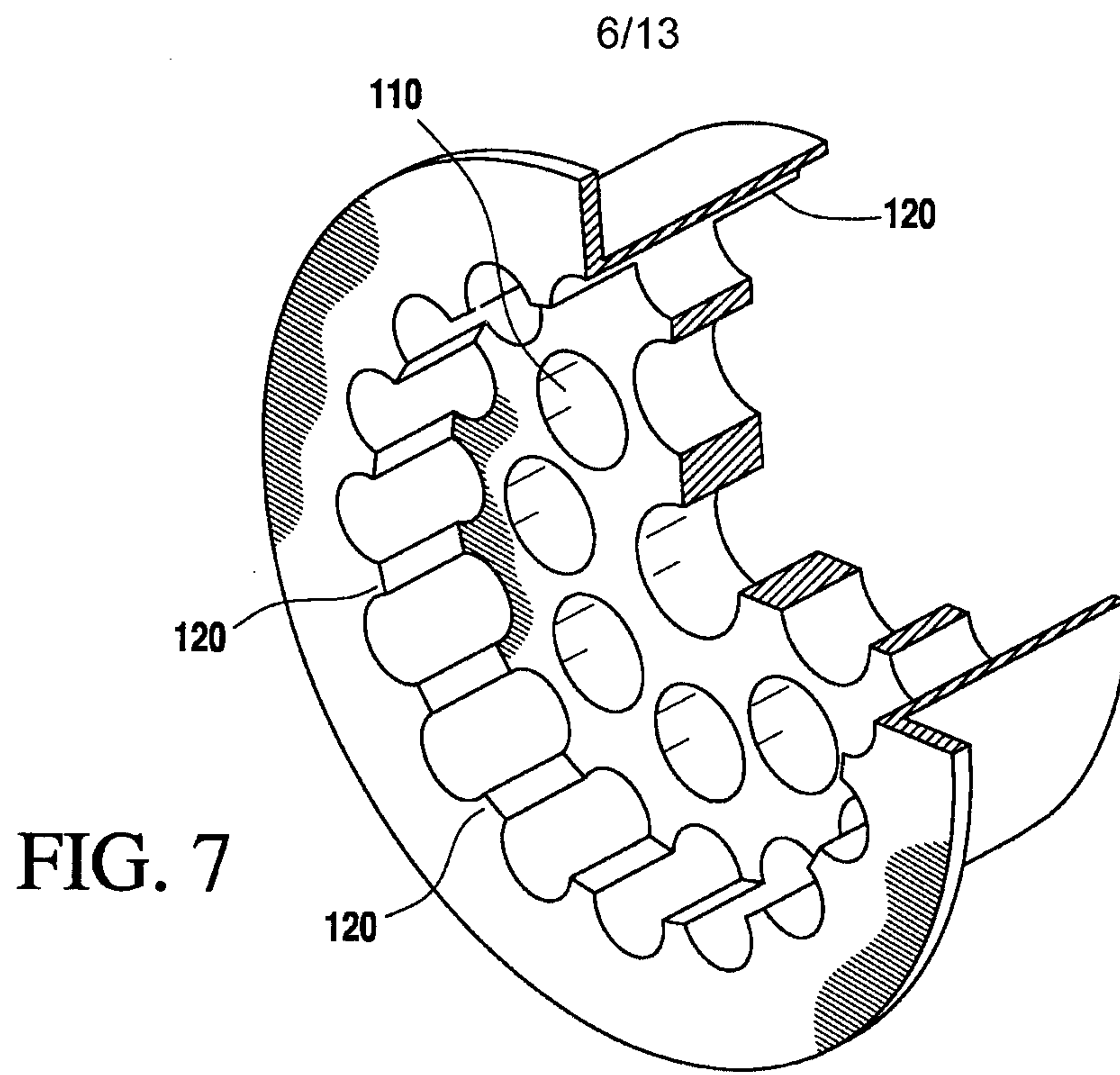


FIG. 4C

5/13





7/13

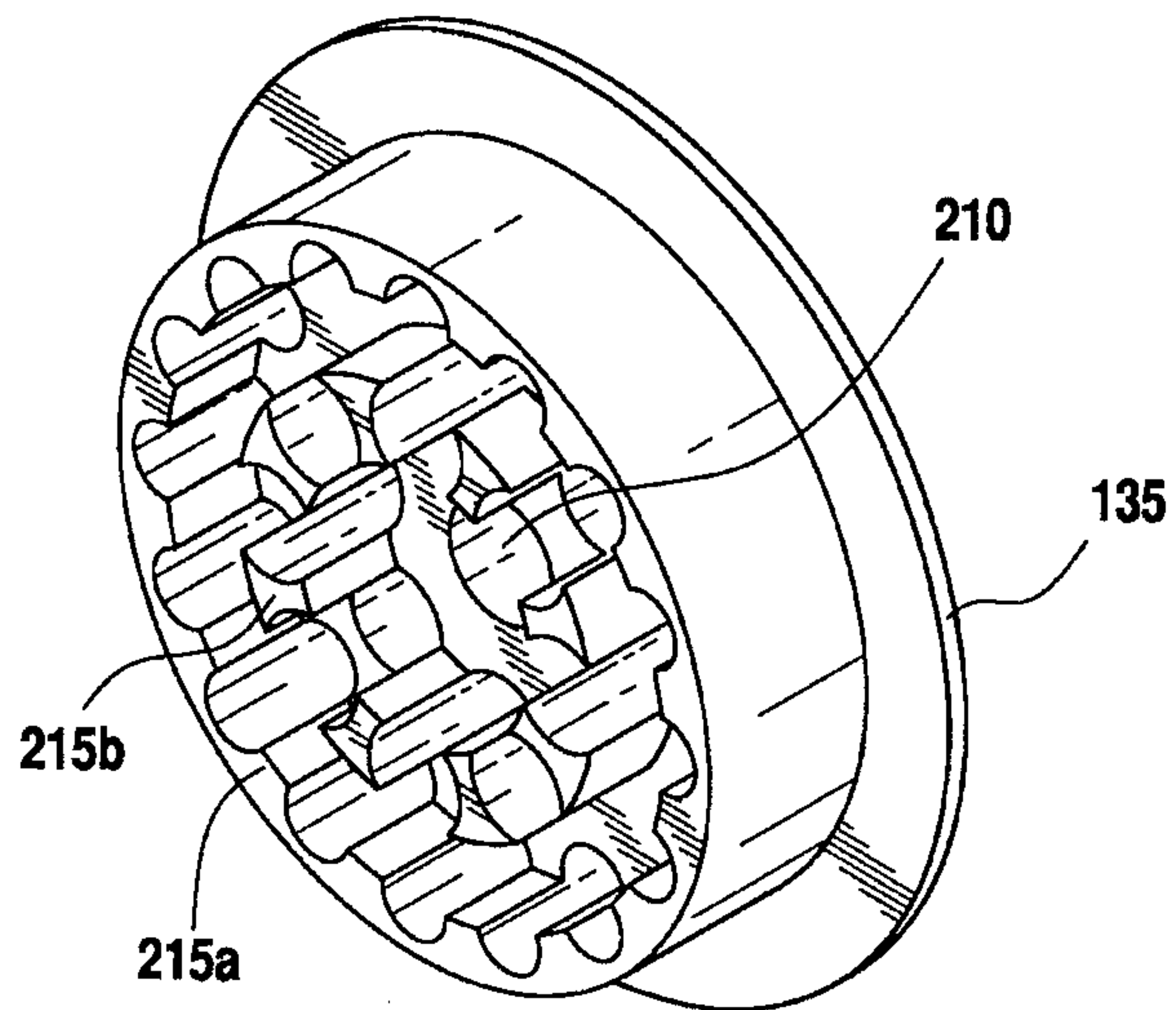


FIG. 9A

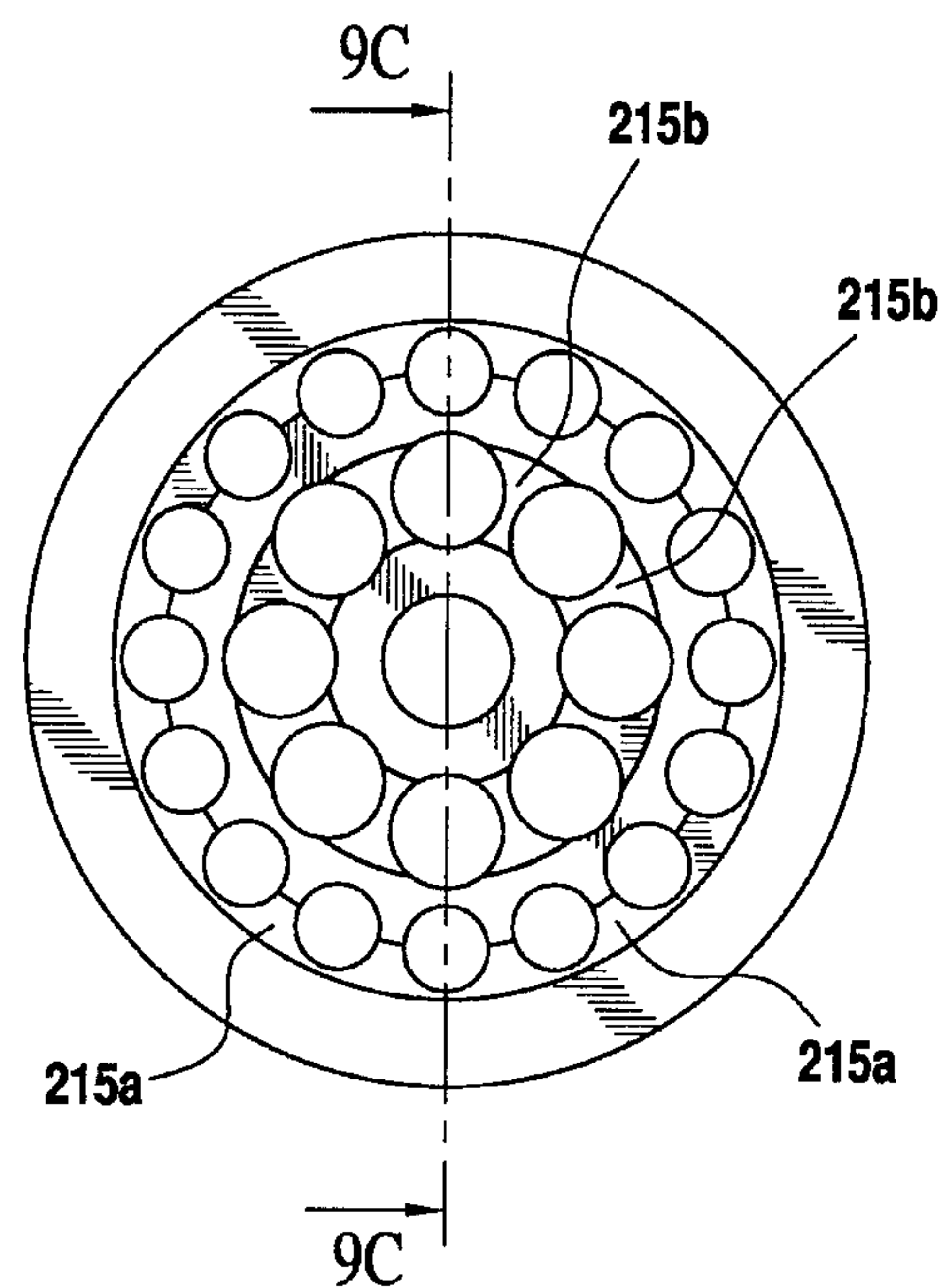


FIG. 9B

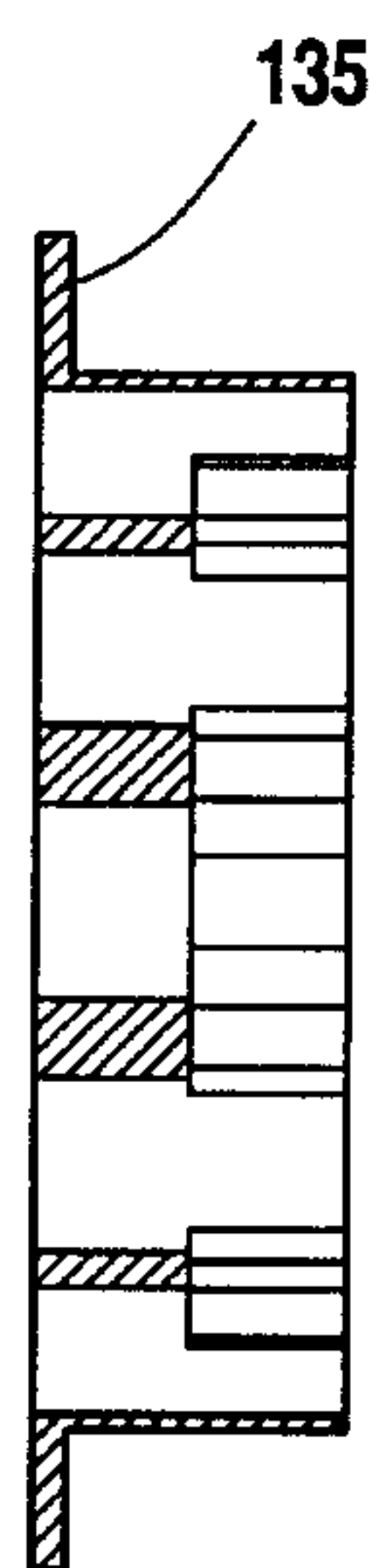
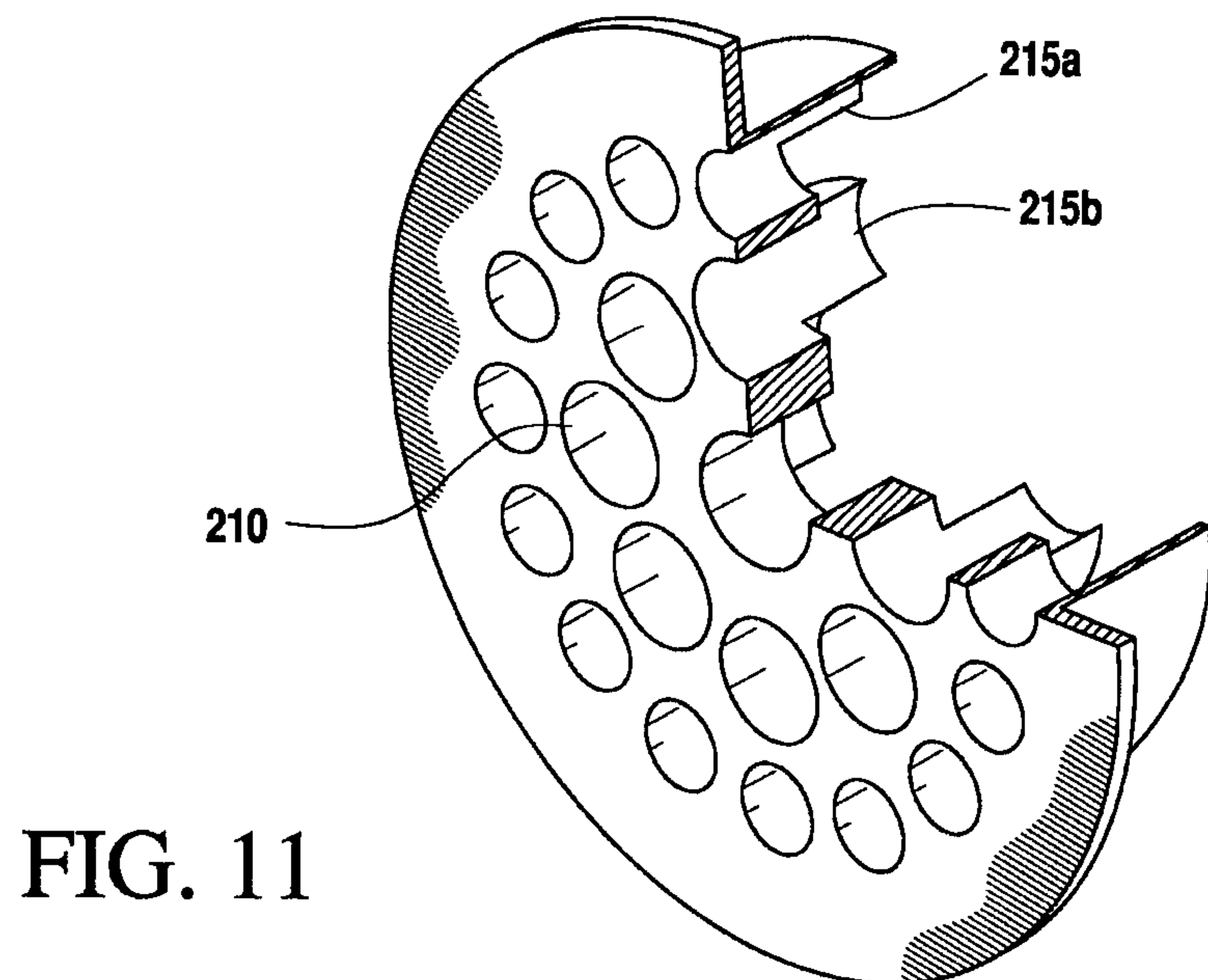
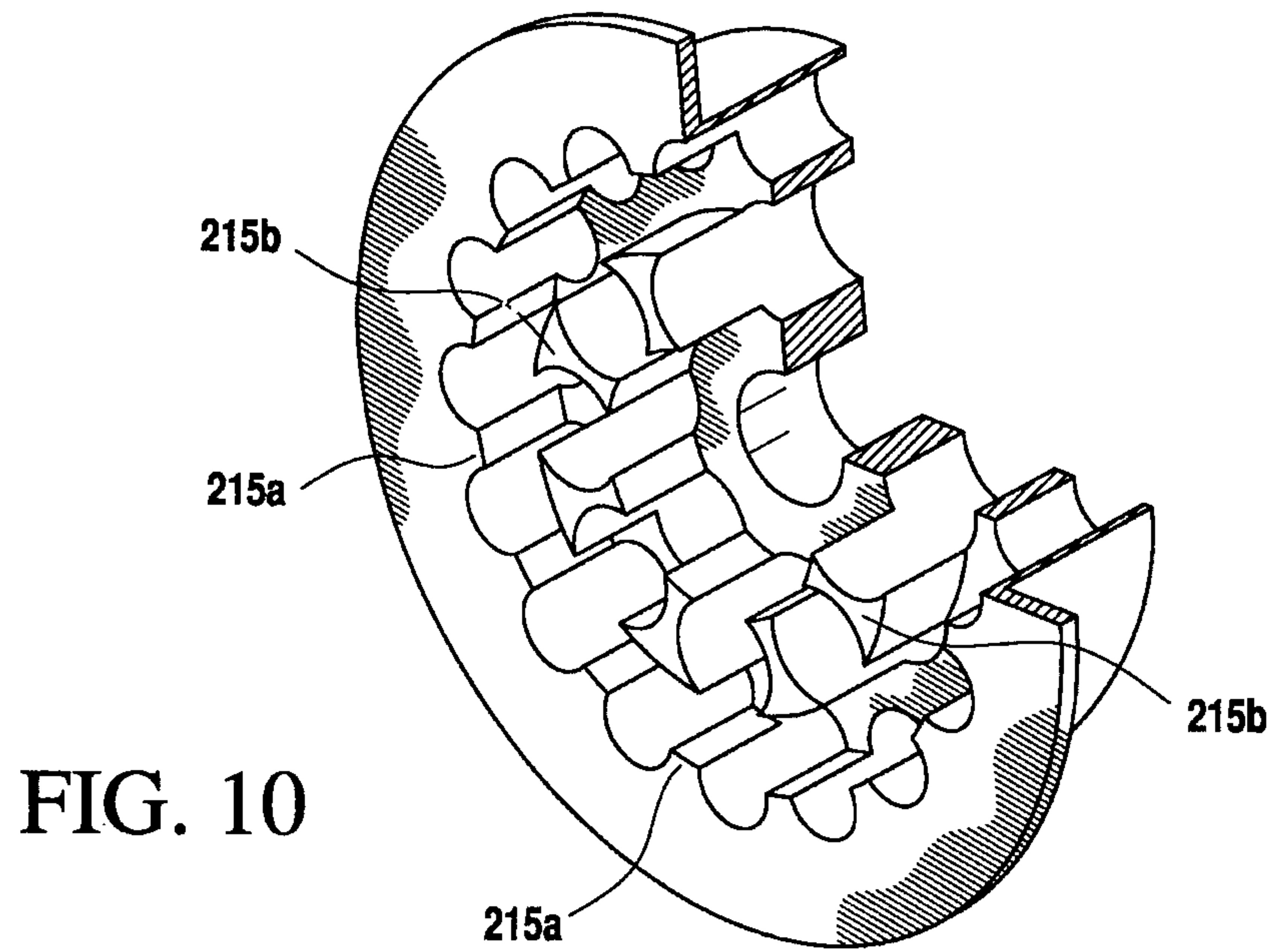


FIG. 9C

8/13



9/13

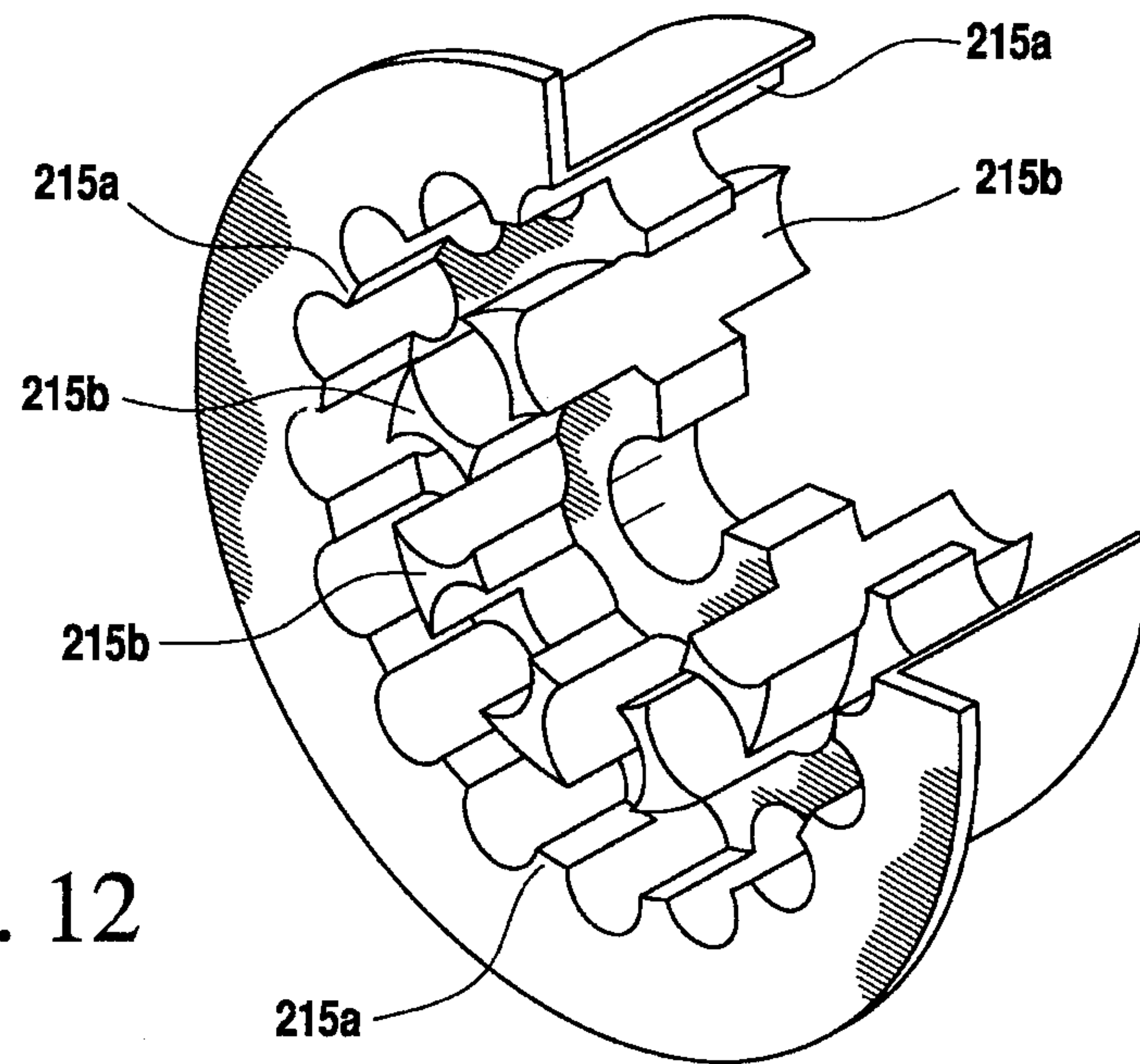


FIG. 12

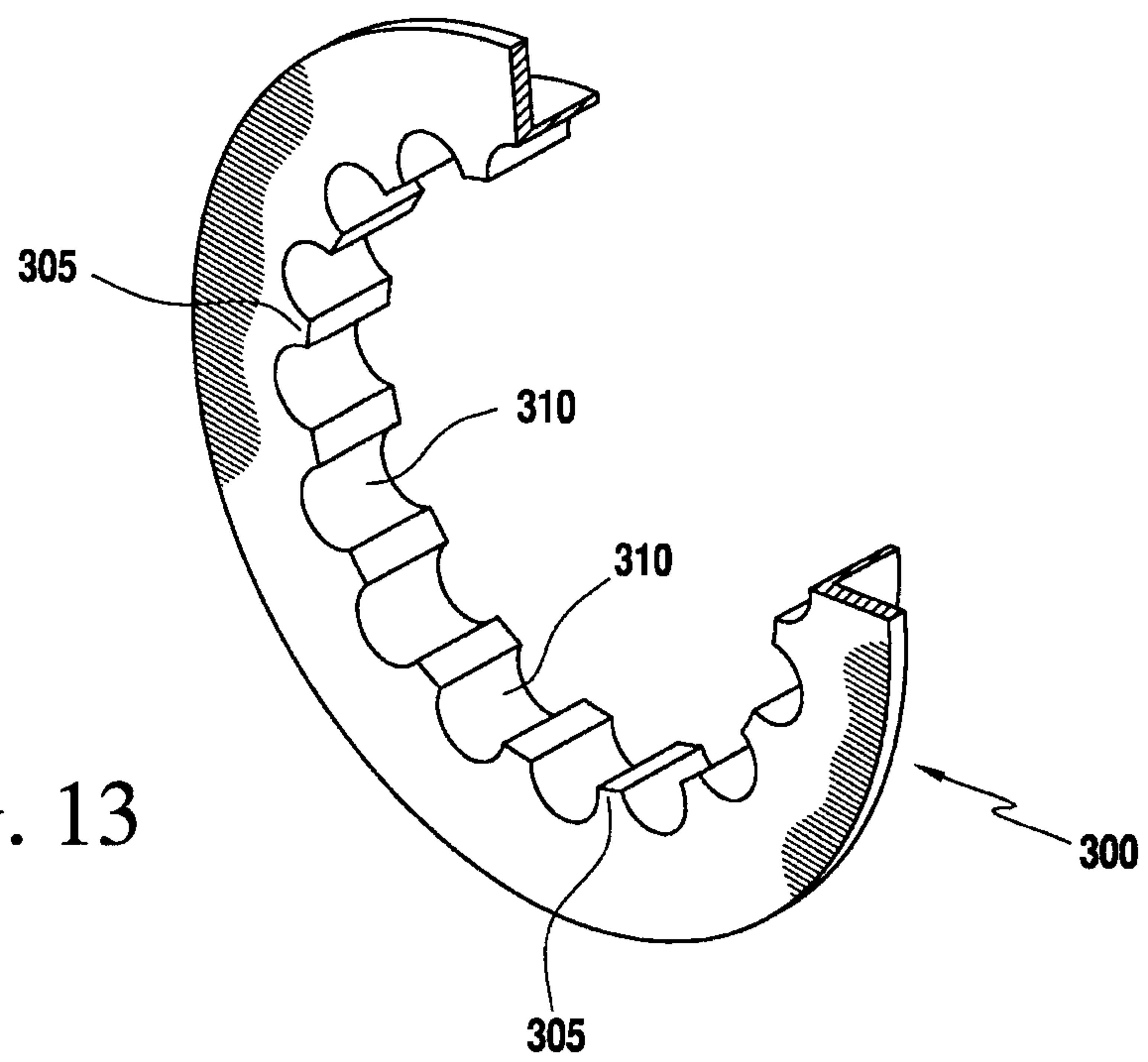


FIG. 13

10/13

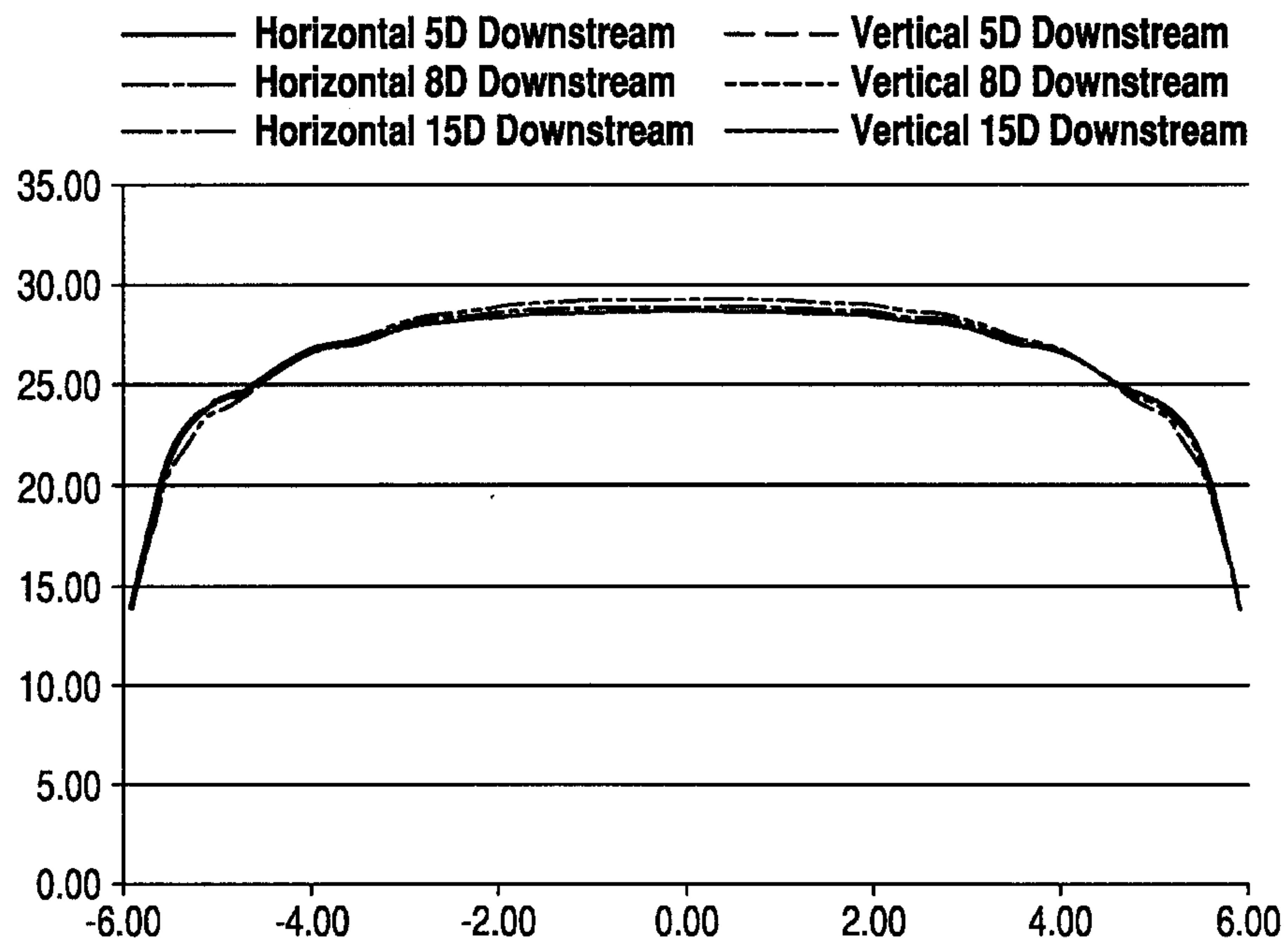


FIG. 14

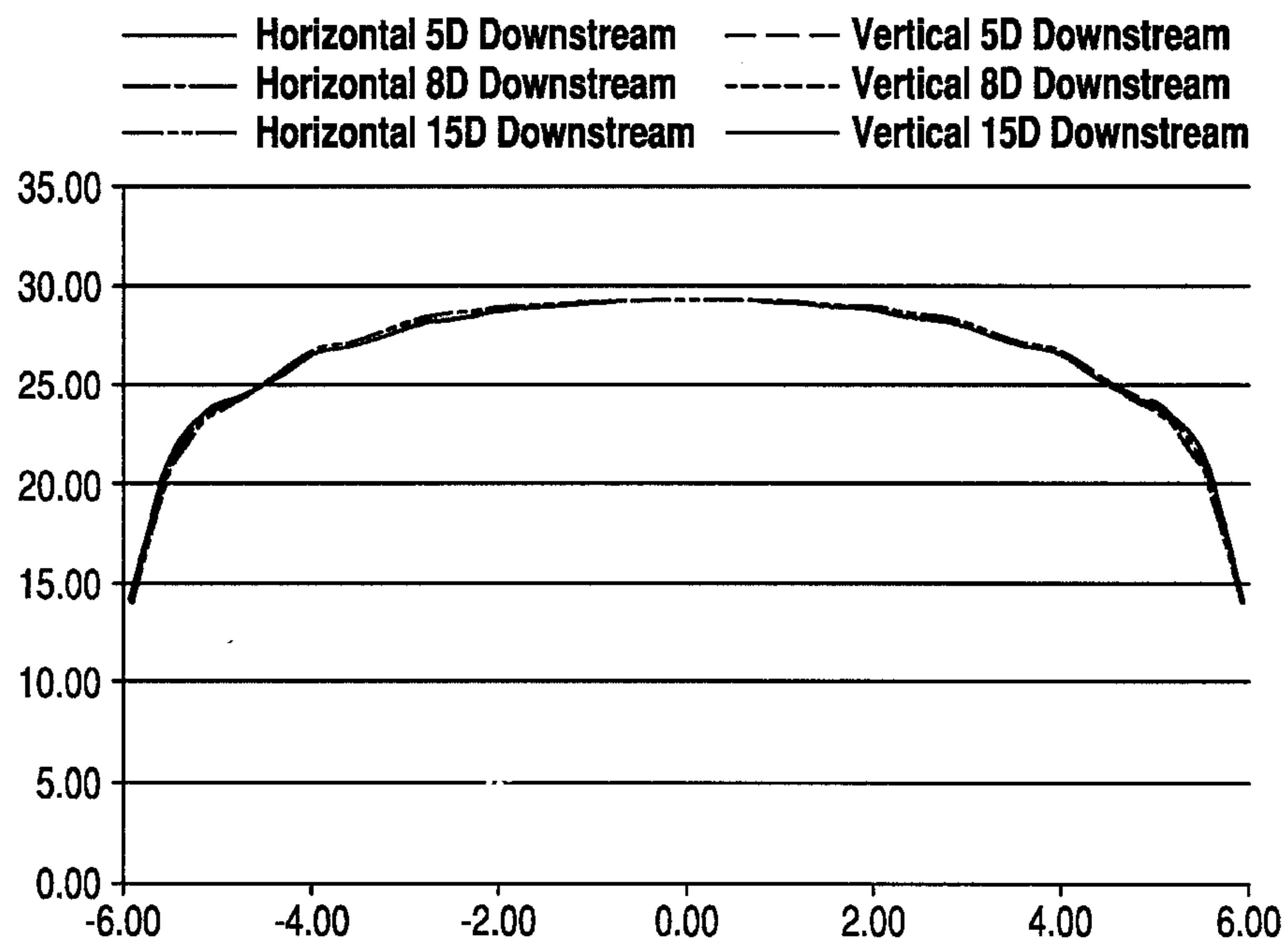


FIG. 15

11/13

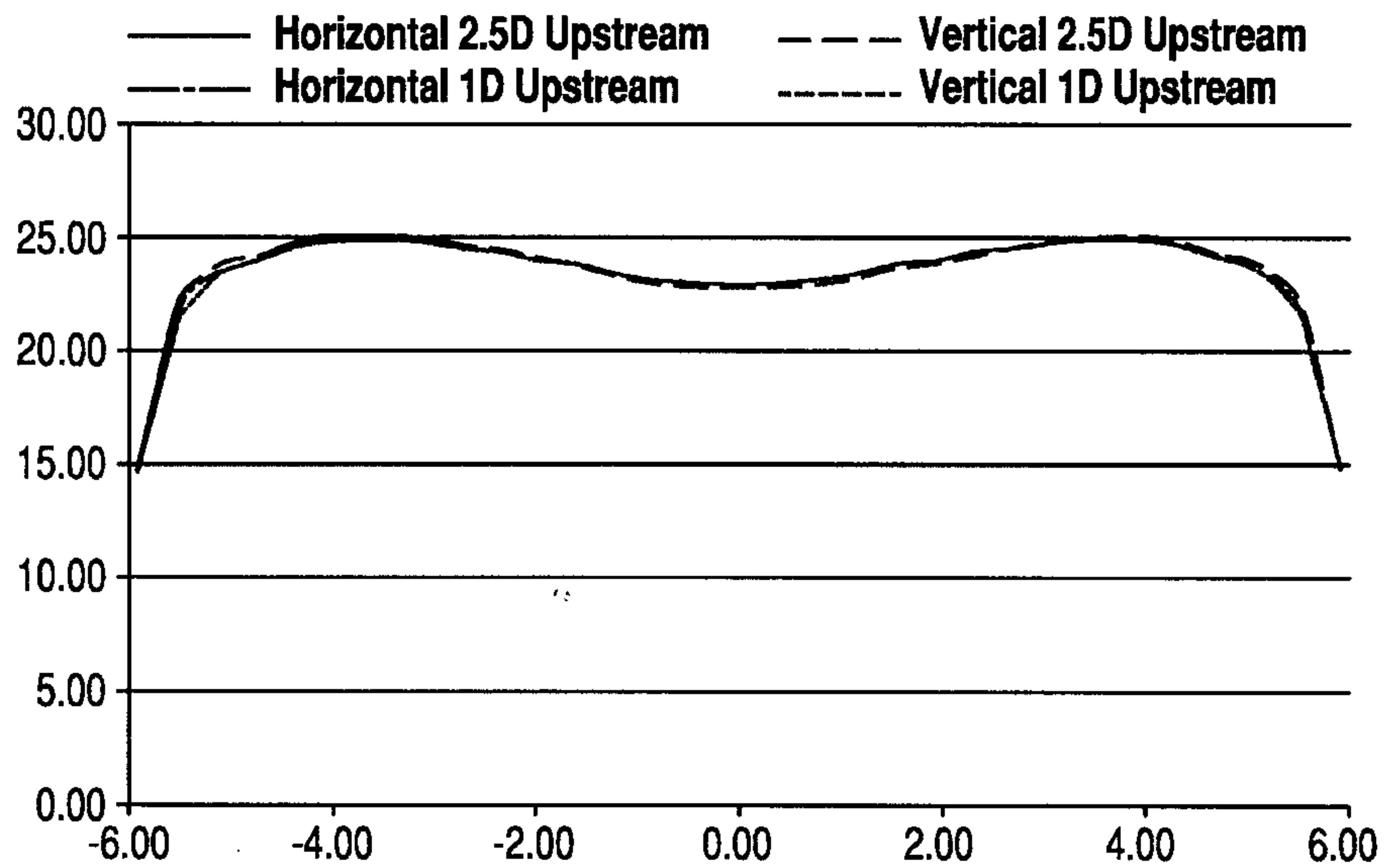


FIG. 16

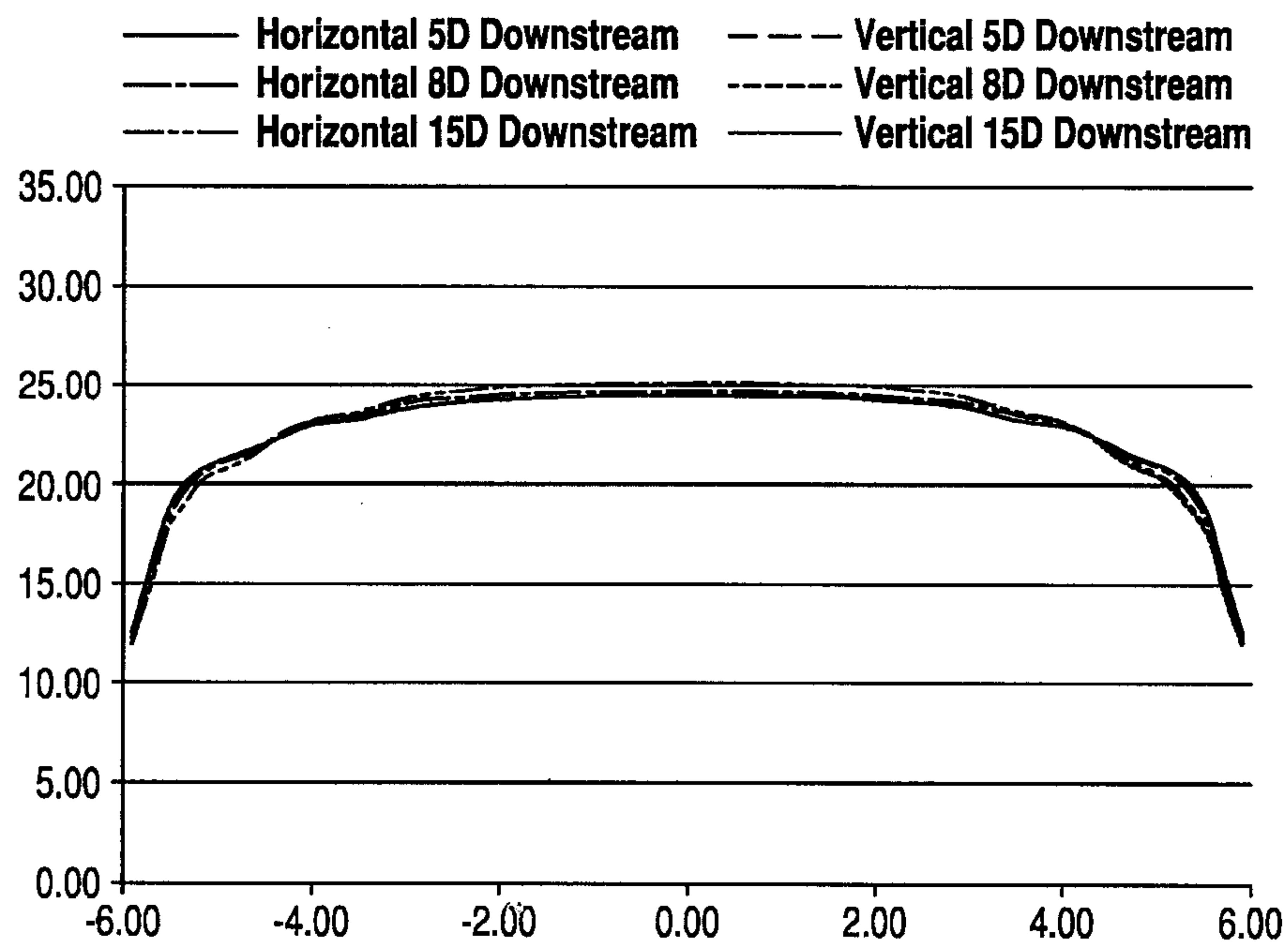


FIG. 17

12/13

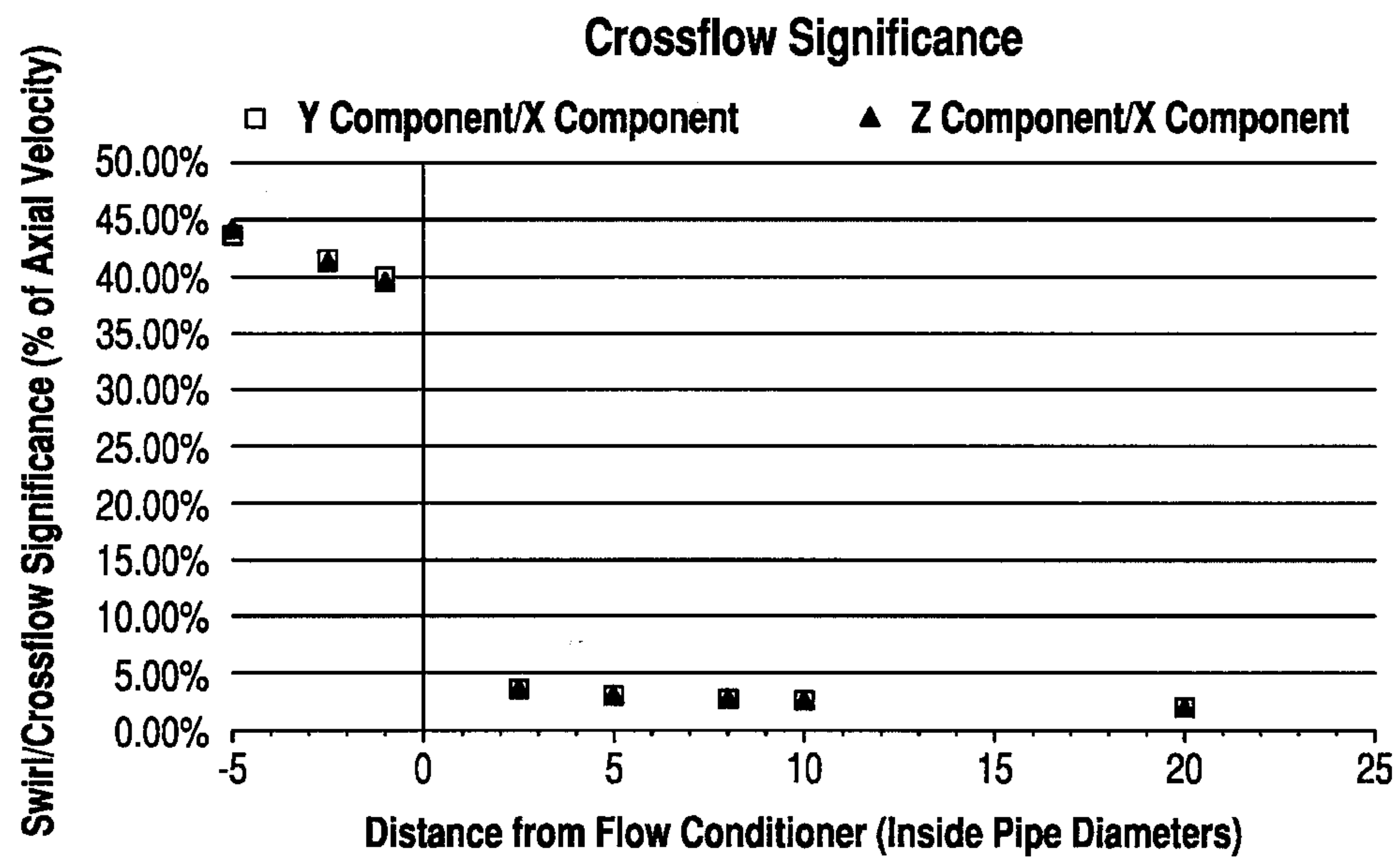


FIG. 18

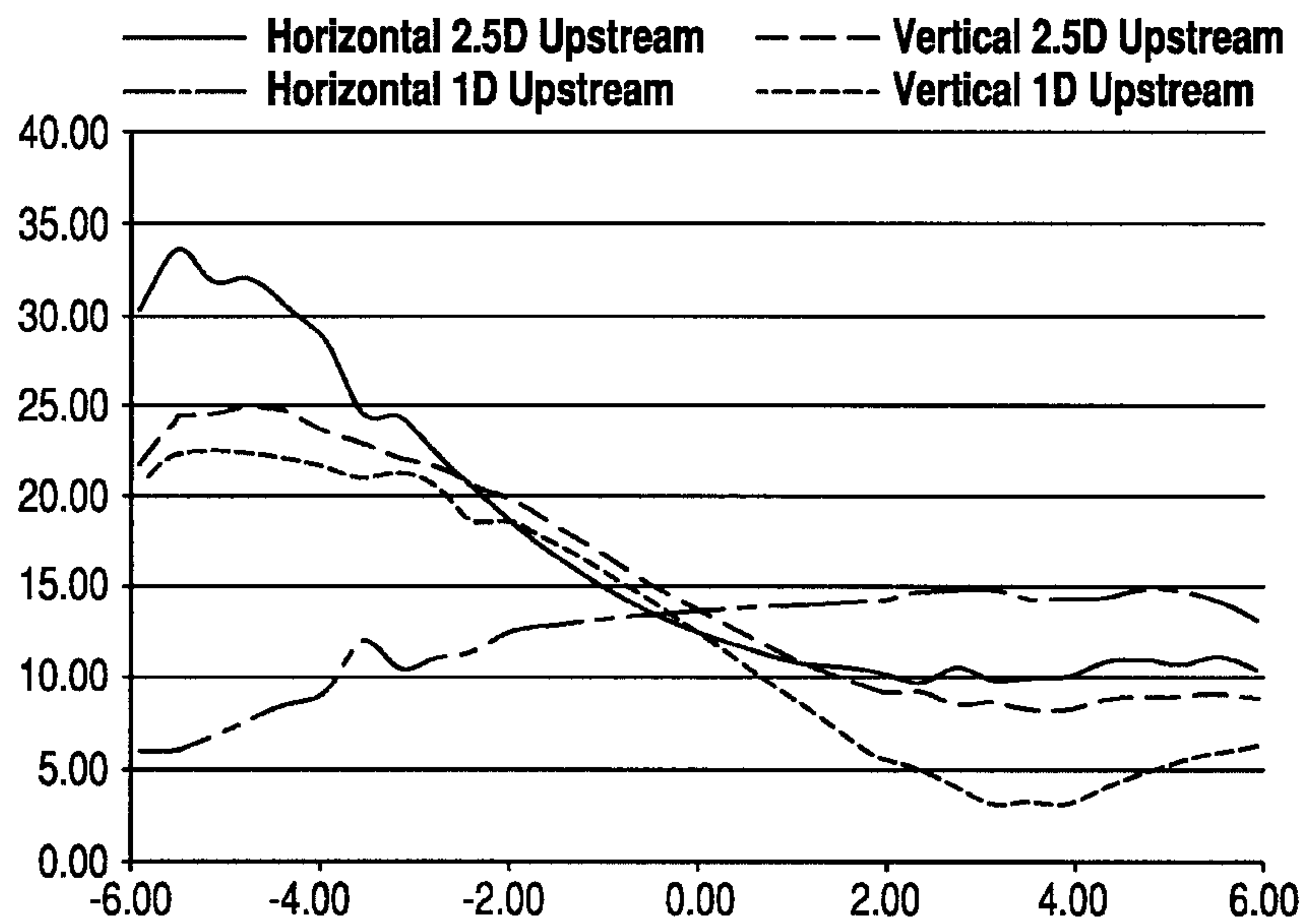


FIG. 19

13/13

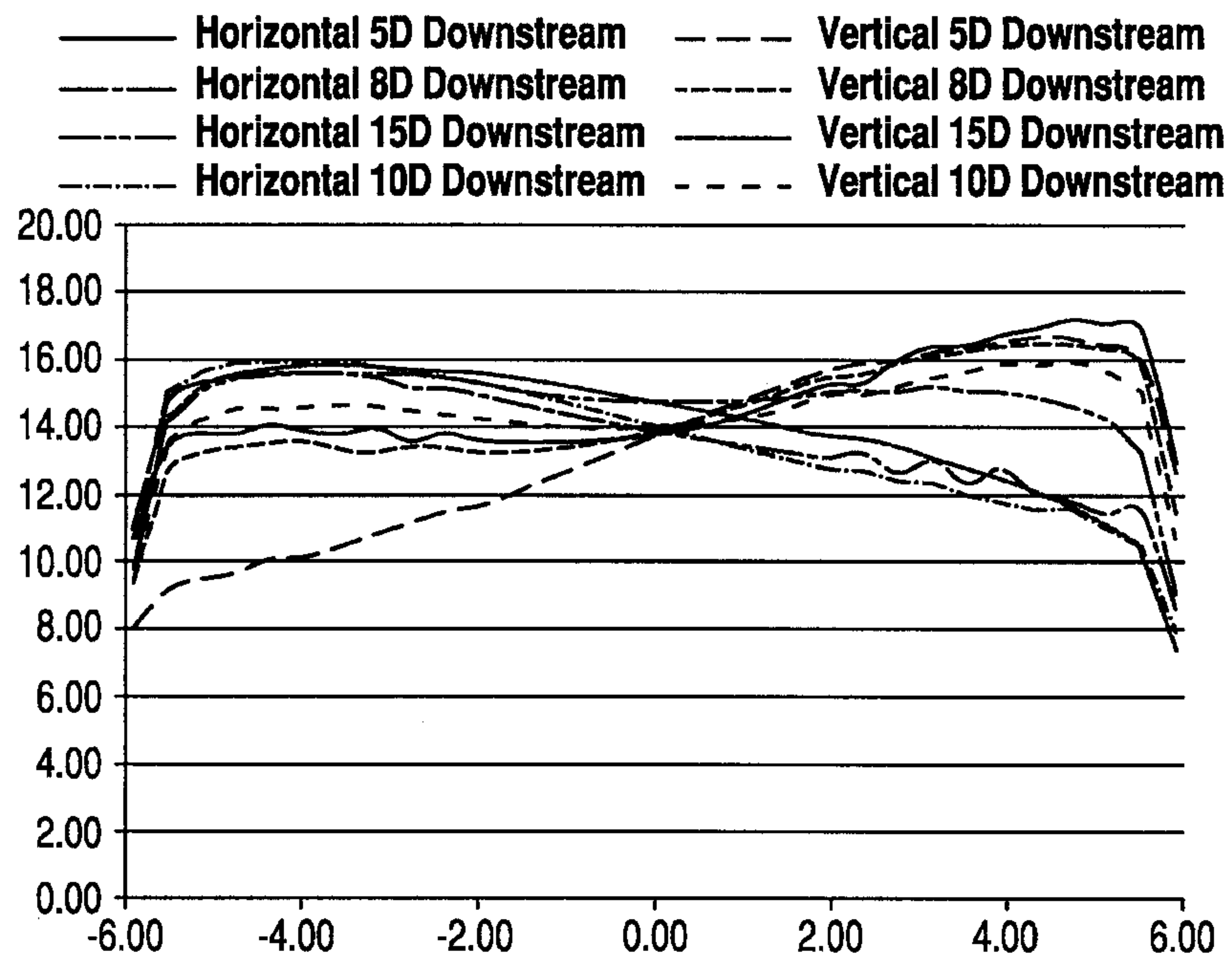


FIG. 20

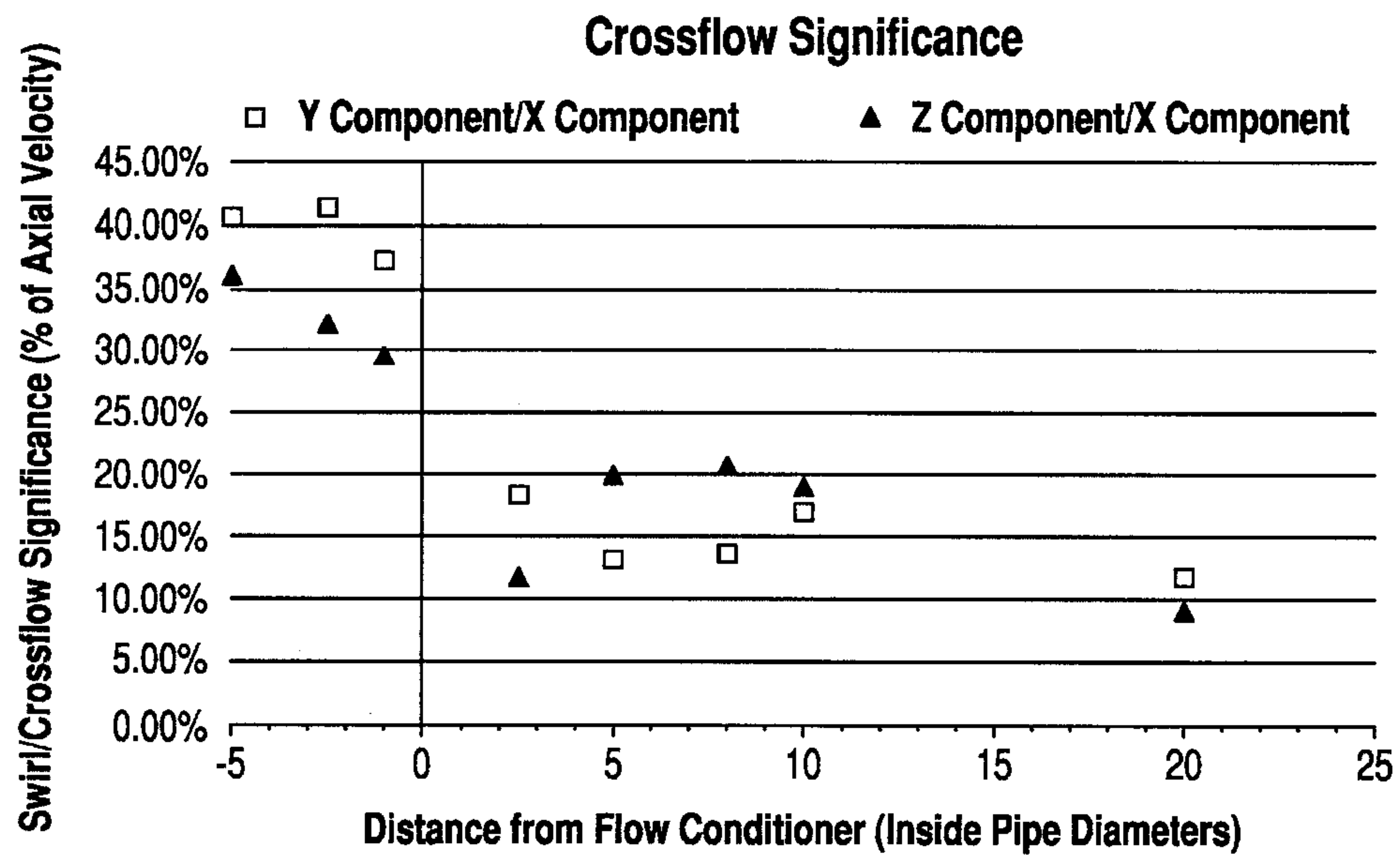


FIG. 21

